

Work Order

Work Order	10040490983	Scheduled Start Date	10/26/2025
	AMER-TRANSNORM TS1500-140 V2-090 4 WEEK	Scheduled End Date	10/26/2025
Status	Open	Date Started	10/05/2025 05:32
Created By	R5	Date Completed	
Created	10/05/2025		
WO Type	PM	Parent WO	
	Preventive maintenance	Class	
Department	RME	Priority	5
	Reliability Maintenance Engineering (RME)	Warranty	
PM Schedule	MED.TRA.TS1500290.4W	Safety	
	AMER-TRANSNORM TS1500-140	Equipment Criticality	1
	V2-090 4 WEEK		
Problem Code	N.A.	Assigned To	ERWOMACK
	Not Applicable (not allowed to be used in Breakdowns and Corrective)	Reported By	

Equipment

Equipment	MNL.PCK.P5.TA.625085	Manufacturer	TRANSNORM
	MANUAL PACKING, P5, P2R	Model	TS.1600-105FH2.BA
	TAKEAWAY TO SLAM 502, 625085	Serial Number	5052085-1

Activity List

Activity	Task Plan Description	Trade	Start Date	End Date	Supplier
1	LOTO Evidence	TECH	10/05/2025	10/05/2025	

Checklist

Sequence	Equipment	Description	Result
10	MNL.PCK.P5.TA.625085	Does this task require LOTO to one or more energy sources?	Yes: _____ No: _____
20	MNL.PCK.P5.TA.625085	Are photos of applied LOTO devices uploaded to this check (comment if not)?	Yes: _____ No: _____

Task Plan Instructions

R5 [02/13/2023 13:46]:

Photographic Evidence of applied LOTO

"10 - Does the task require LOTO to one or more energy source?"

Confirm if this task requires a LOTO procedure to any energy source by selecting 'Yes'. If the task does not require LOTO select 'No'.

"20 - Are photos of applied LOTO devices uploaded to this check (comment if not)?"

In case LOTO is required for this task photographic evidence should be uploaded to this check (sequence 20). In case there are multiple energy sources to be isolated, upload a photo of every isolation point showing the applied LOTO device.

Steps to upload LOTO photos on APM:

- select the checklist item (sequence 20),
- click 'Actions' on the bottom of the checklist tab,
- select 'Add/Edit Checklist Items Documents'
- select 'Actions' > Create/Upload Document'

Steps to upload LOTO photos on APM Mobile:

- select the checklist item (sequence 20),

Activity List					
Activity	Task Plan Description	Trade	Start Date	End Date	Supplier
Task Plan Instructions					
- click the camera symbol, - take a photo directly or navigate to saved photos on your device					
Booked Hours					
Employee	Date	Time On	Time Off	Total Time	Type of Hours

Activity	Task Plan Description	Trade	Start Date	End Date	Supplier
10	AMER-TRANSNORM CURVE 4 WEEK PM	TECH	10/26/2025	10/26/2025	

Checklist

Sequence	Equipment	Description	Result
10	MNL.PCK.P5.TA. 625085	I have completed all tasks referenced on the task list of this PM	Yes: _____ No: _____
20	MNL.PCK.P5.TA. 625085	I have Inspected guide bearings for wear and missing dust shields	Yes: _____ No: _____
30	MNL.PCK.P5.TA. 625085	I have Inspected belt bead for wear (excessive wear on one side indicates poor tracking)	Yes: _____ No: _____
40	MNL.PCK.P5.TA. 625085	I have Inspected the lace and lace pin for wear and ensured that the lacing is not beginning to pull through the lace pin.	Yes: _____ No: _____
50	MNL.PCK.P5.TA. 625085	I have Inspected conveyor and it is clear of debris	Yes: _____ No: _____
60	MNL.PCK.P5.TA. 625085	I have check gearbox for leaks and clean bottom pan	Yes: _____ No: _____
70	MNL.PCK.P5.TA. 625085	I have verify alignment of photo eyes	Yes: _____ No: _____
80	MNL.PCK.P5.TA. 625085	I have created a follow-up work order for any issues found during this PM	Completed: _____

Task Plan Instructions

R5 [10/21/2025 17:43]:

Apply LOTO if needed FOLLOW ALL INSTRUCTIONS IN ATTACHED DOCUMENT. Ensure equipment is cleaned after repairs are completed and prior to handing over to Operations







Booked Hours

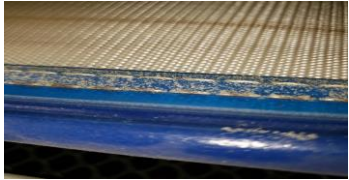




Employee	Date	Time On	Time Off	Total Time	Type of Hours
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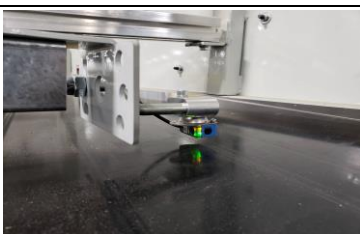

Maintenance Job Planning/Estimating Worksheet









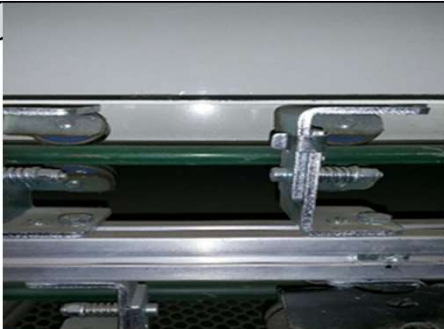

Planner:	WO#:	Date:
Job Contact:	Location:	Asset ID#:
Job Description: Transnorm Model TS4100-150 13 WK PM Job Plan. The purpose of this PM Job Plan is to go through the steps and process needed to complete a thorough PM on the conveyor.		

Job Scope

Job Plan Seq.	Task Description	Task Duration	Number of Resources Required	Total Estimated Labor Hours	Reference Pictures
10	Always remember to fill out your LOTO and MTHA form before performing work	0.10	1	0.10	
20	"Take 2 for Safety"	0.05	1	0.02	
30	Use the required PPE that is needed for the job.	0.02	1	0.02	
40	Lockout transnorm and ensure 2nd person Verification	0.10	2	0.20	
50	Remove side covers from both sides to access bearings and bead using 13mm socket	0.30	1	0.30	
60	Inspect guide bearings for wear and missing dust shields	0.20	1	0.20	

70	Inspect belt bead for wear (excessive wear on one side indicates poor tracking)	0.10	1	0.10	
80	Remove bottom cover to access bottom of belt and guide bearings by turning the plastic fasteners 90° using a 13mm wrench	0.05	1	0.05	
90	Inspect guide bearings for wear and missing dust shields	0.10	1	0.10	
100	Inspect lace and lace pin for wear. Ensure that the lacing is not beginning to pull through the lace pin.	0.10	1	0.10	
110	Make sure conveyor is clear of debris	0.10	1	0.10	
120	Reinstall all covers	0.30	1	0.30	
130	Clean conveyor, motor, VFD and braking resistor using a blower	0.15	1	0.15	

					<table><caption>NEW TORX PLUS** AND TORX** SCREW TORQUE RATINGS</caption><tr><th>TORX SIZE</th><th>TORX PLUS** SIZE</th><th>TORX** SIZE</th><th>NEW DESIGN TORQUE LBS IN</th><th>OLD DESIGN TORQUE FT LBS</th></tr><tr><td>R6-24</td><td>27P</td><td>1/8"</td><td>1.25</td><td>90</td></tr><tr><td>S1A-20</td><td>SDP</td><td>1/8"</td><td>1.00</td><td>70</td></tr></table> 	TORX SIZE	TORX PLUS** SIZE	TORX** SIZE	NEW DESIGN TORQUE LBS IN	OLD DESIGN TORQUE FT LBS	R6-24	27P	1/8"	1.25	90	S1A-20	SDP	1/8"	1.00	70
TORX SIZE	TORX PLUS** SIZE	TORX** SIZE	NEW DESIGN TORQUE LBS IN	OLD DESIGN TORQUE FT LBS																
R6-24	27P	1/8"	1.25	90																
S1A-20	SDP	1/8"	1.00	70																
140	Ensure all hardware is in place and tight (bearing hardware, tension bolts, and wall fasteners) Visually inspect all bearings and validate shafts are not walking. Use the following torque guide to ceck for the correct torque on the lock collar set screws. Look for metallic (silver, black, or red) dust that indicates a slipping shaft damage or bearing damage.	0.10	1	0.10																
150	Check gearbox for leaks and clean bottom pan	0.05	1	0.05																
160	Verify alignment of photo eyes (adjust using 4mm allen wrench)	0.05	1	0.05																
170	Ensure "waterfall" from transition to conveyor belt(transition plate should be minimum 1/4 inch above transnorm belt)	0.10	1	0.10																
180	Remove LOTO and return to operation	0.10	1	0.10																
Total Job Plan Duration:		2.07	Total Backlog Labor Hours:		2.14															
Materials Required																				
Seq#	Material Description/Specification	Quantity	Price/Unit	Total Cost	SKU#															
	13mm wrench	1	\$0.00	\$ -																
	19mm wrench	1	\$0.00	\$ -																
	blower	1	\$0.00	\$ -																
	tape measure	1	\$0.00	\$ -																
	4mm allen wrench	1	\$0.00	\$ -																
	shop towel	1	\$0.00	\$ -																
			\$0.00	\$ -																
			\$0.00	\$ -																
			\$0.00	\$ -																
			\$0.00	\$ -																
			\$0.00	\$ -																
			\$0.00	\$ -																
			\$	-																
			\$	-																
			\$	-																
Total Material Cost:			\$	-																
Safety Requirements																				
Permits:	Confined Space Entry	Hot Work	X	Lockout/Tagout																
PPE:	Safety Glasses, Safety Shoes, Gloves, Hard Hat																			
Additional Comments:																				
Special Tools Needed: You may need an Aerial lift to complete this PM if the bed is elevated.																				

PMV Title:		PMV_Transnorm_Weekly_Visual_Checklist				 amazonfulfillment
ID #		Revision #	1	ID Barcode	Required PPE	
FC(s)	All	Revision Date	9/21/17			
Owner	SME	Cycle Time				
Safety Requirements					Tools Required	
A. Proper PPE must be worn					D. Verify LOTO – test start to verify	
B. Identify potential hazards					1. Flashlight	
C. Perform all necessary LOTO					2. Strobe Light	
					3. IR Gun	
1		2			3	
						
Visually inspect the Transnorm for damage and debris in perforated netting, side guards and transition brushes		Visually inspect inside radius of the bed for fine grey dust. If you see dust, we need to track the belt correctly and if the drive pulley is worn deeper than the thickness of the belt, replace the drive pulley in the next scheduled downtime (non-emergency). Please refer for the PMV for replacement of the drive pulley and for belt tensioning			Visually inspect the belt driven drive timing belt and pulley guard for alignment and damages to it. Replace or realign as necessary	
4		5			6	
						
Visually inspect the gearbox input and output shaft for oil leak		Use an IR gun to inspect the inner and outer pulley bearings for temperature higher than 110 F			During a 30 minute operational break, follow proper LOTO procedures and remove the outside radius perforated guard. Visually inspect for urethane dust build up. If dust is present, note locations to inspect bearings.	
7		8			9 (Only for 180 degree Transnorm)	
						

PROCESS AUDIT FORM



INSTRUCTIONS (if copying / using 2 pages vs. double sided format)

1. This form is used in conjunction with a printed copy of the Process Map Visual (PMV) to be audited.
2. Print a black and white one page version of the PMV (slide #1).
3. Once all audit actions are complete, make sure this form is attached to the PMV used for the audit and turned in to the FC's Training Console Administrator.
4. **COACH & RETRAIN:** can ONLY be utilized on an associates FIRST audit in the function and when AUDIT TYPE is "Training Aid".

COMPLIANCE Audits

Administer

1. Approach the associate being audited and explain the audit process and form.
2. Observe the associate performing the normal job.
3. Place a Checkmark beside each:
 - Step in the Process as the associate is observed
 - Safety requirement observed
 - Critical to Quality item observed
4. For exceptions to the normal process that do not occur during the audit, ask the associate the steps they would take to resolve the problem and compare their responses to the Safety and Critical to Quality content in the PMV. Place a check next to the content the associate describes.

Score

5. Determine the audit score
Pass: ALL Safety, ALL Quality items are checked AND the associate was able to complete the entire procedure in the correct sequence without asking for help.
Non-Compliant: If any ONE item, Safety or Quality item is left unchecked, or the associate was not able to perform or describe the entire procedure in sequence, the associate is non-compliant.

Actions

6. Complete the Audit Tracking Information to the right of this form.
7. For associates in non-compliance, provide coaching/retraining on the process as needed. When possible, have the associate demonstrate back to you to verify understanding.
8. Ask the associate to sign and acknowledge the score and any non-compliance action plan.
9. Put your own signature on the Auditor line.

Track

10. Review the associate's score with his or her Area Manager (unless you are the AM).
11. Turn the form in to your FC's Training Console Administrator. Record audit as "Fail" in the Training Console if score is marked "Non-compliant/Fail" or "Coach and Retrain".
12. Schedule and perform a full compliance audit on the associate within 10-20 hours if this audit was failed.

BLIND Audits

1. Observe the associate from a distance performing the process.
2. Place a Checkmark beside each:
 - Step in the Process as the associate is observed
 - Safety requirement observed
 - Critical to Quality item observed
- **If the associate could not perform the item because there was no opportunity, mark the item as N/A
3. If an associate does not display every behavior listed every time they have the opportunity, they have failed the audit.
4. Complete the Audit Tracking Information to the right.
5. Review the Associate's score with his/her Area Manager.
6. Turn the form in to your FC's Training Console Administrator.
7. Schedule and perform a full compliance audit on the associate within 10-20 hours if this audit was failed.

PMV INFORMATION

TITLE OF PMV: _____

REVISION #: _____ REVISION DATE: _____

PLEASE PRINT
all information

AUDIT TRACKING INFORMATION

Audit Type:
(check one)

☐ Compliance

☐ Blind

☐ Training Aid
(can ONLY be utilized
on associates FIRST
audit in the function)

Associate Home Dept: Yes ☐ No ☐

Today's Date: _____

Associate Name: _____

Associate Login: _____

Auditor Name: _____

Auditor Login: _____

Auditor Title:
(check one)

☐ Ambassador

☐ Trainer

☐ PA/Lead

☐ AM

☐ Other: _____

Score:

(check one)

☐ Compliant/Pass

☐ Non-compliant/Fail

☐ Non-compliant / Coach & Retrain

(Can only be used if Audit Type "Training Aid" is selected above)

Validation:

Auditor Signature: _____

Associate Signature: _____
(N/A for Blind Audit)

Manager Signature: _____

NOTES / ACTION PLAN:

TURN COMPLETED FORM IN TO TRAINING CONSOLE ADMINISTRATOR

Work Order

Work Order	10040772333	Scheduled Start Date	10/26/2025
	AMER-AR FLOOR WITH INVENTORY POD SEGMENT 12 WEEK	Scheduled End Date	10/26/2025
Status	Open	Date Started	10/09/2025 05:29
Created By	R5	Date Completed	
Created	10/09/2025		
WO Type	PM	Parent WO	
	Preventive maintenance	Class	
Department	RME	Priority	5
	Reliability Maintenance Engineering (RME)	Warranty	
PM Schedule	MED.AMZ.FLR04.12W	Safety	
	AMER-AR FLOOR WITH INVENTORY POD SEGMENT 12 WEEK	Equipment Criticality	3
Problem Code	N.A.	Assigned To	ERWOMACK
	Not Applicable (not allowed to be used in Breakdowns and Corrective)	Reported By	

Equipment

Equipment	AR.ZONE.5.A.SECTION.53	Manufacturer	AMAZON
	TPA4-paKivaA05 SECTION 12 35	Model	AR FLOOR SECTION
		Serial Number	53

Activity List

Activity	Task Plan Description	Trade	Start Date	End Date	Supplier
1	LOTO Evidence	TECH	10/05/2025	10/05/2025	

Checklist

Sequence	Equipment	Description	Result
10	AR.ZONE.5.A.SECTION.53	Does this task require LOTO to one or more energy sources?	Yes: _____ No: _____
20	AR.ZONE.5.A.SECTION.53	Are photos of applied LOTO devices uploaded to this check (comment if not)?	Yes: _____ No: _____

Task Plan Instructions

R5 [02/13/2023 13:46]:

Photographic Evidence of applied LOTO

"10 - Does the task require LOTO to one or more energy source?"

Confirm if this task requires a LOTO procedure to any energy source by selecting 'Yes'. If the task does not require LOTO select 'No'.

"20 - Are photos of applied LOTO devices uploaded to this check (comment if not)?"

In case LOTO is required for this task photographic evidence should be uploaded to this check (sequence 20). In case there are multiple energy sources to be isolated, upload a photo of every isolation point showing the applied LOTO device.

Steps to upload LOTO photos on APM:

- select the checklist item (sequence 20),
- click 'Actions' on the bottom of the checklist tab,
- select 'Add/Edit Checklist Items Documents'
- select 'Actions' > Create/Upload Document'

Steps to upload LOTO photos on APM Mobile:

Activity List					
Activity	Task Plan Description	Trade	Start Date	End Date	Supplier

Task Plan Instructions

- select the checklist item (sequence 20),
- click the camera symbol,
- take a photo directly or navigate to saved photos on your device

Booked Hours

Employee	Date	Time On	Time Off	Total Time	Type of Hours
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Activity	Task Plan Description	Trade	Start Date	End Date	Supplier
10	AMER-AR FLOOR WITH INVENTORY POD SEGMENT 12 WEEK	TECH	10/26/2025	10/26/2025	

Checklist

Sequence	Equipment	Description	Result
10	AR.ZONE. 5.A.SECTION. 53	I have completed all tasks referenced on the task list of this PM	Yes: _____ No: _____
20	AR.ZONE. 5.A.SECTION. 53	I have created a follow-up work order for any issues found during this PM	Completed: _____

Task Plan Instructions**R5 [03/28/2024 13:50]:**

Apply LOTO if neededIf you would like to request any changes to these tasks please enter a Trouble Ticket using the following CTI RCM>PM Change>RCM-FC

****Attention!**** Only individuals holding a valid ARU Certification Badge may perform this task list. If you are not holding a valid ARU Certification Badge for this task STOP! Do not perform this task and escalate to your manager immediately. By completing this PM you are stating that you are ARU PM certified and have followed all steps for the 12 week floor health PM listed on the AR Knowledge Center (link below). Failure to comply may result in corrective action.

- ☐ 1. Copy and paste this web address into your internet browser:
<https://share.amazon.com/sites/aru/SitePages1/kc/preventative-maintenance/floor-health/sortNonQuickDeploy-proc.html>
- ☐ 2. Click the Safety and PPE section. All safety and PPE requirements must be followed at all times.
- ☐ 3. Before performing floor cleaning check floor scrubber brushes to ensure the correct soft nylon brushes are installed, the brushes have not worn down past the wear indicator and brushes are clean. Replace or clean if necessary.
- ☐ 4. Ensure the squeegee is in good working order, replace if necessary. If floor scrubber leaves a trail of water while in use, this is indicative of a faulty squeegee.
- ☐ 5. Click the 12 week floor health PM and follow all procedures without deviation.
- ☐ 6. If any issues are found other than those addressed by this PM, please create a new Work From PM Work order to make the correction.

****CLEAN UP AREA****

- ☐ 1. Put away all equipment and tools used
- ☐ 2. Ensure floor area is clean and dry
- ☐ 3. Ensure any fiducials replaced have been inspected and the floor is in a normal state before releasing Ensure equipment is cleaned after repairs are completed and prior to handing over to Operations

R5 [10/21/2025 17:41]:

Apply LOTO if neededThe following link is the new website for the floor cleaning instructions. The previous link is no longer functional.

<https://share.amazon.com/sites/aru/SitePages1/kc/preventative-maintenance/floor-health/sortNonQuickDeploy-proc.html>

Activity List						
Activity	Task Plan Description	Trade	Start Date	End Date	Supplier	
	Task Plan Instructions					
	Ensure equipment is cleaned after repairs are completed and prior to handing over to Operations					
	Booked Hours					
	Employee	Date	Time On	Time Off	Total Time	Type of Hours

Work Order

Work Order	10040772334	Scheduled Start Date	10/26/2025
	AMER-AR FLOOR WITH INVENTORY POD SEGMENT 12 WEEK	Scheduled End Date	10/26/2025
Status	Open	Date Started	10/09/2025 05:29
Created By	R5	Date Completed	
Created	10/09/2025		
WO Type	PM Preventive maintenance	Parent WO	
Department	RME Reliability Maintenance Engineering (RME)	Class	
		Priority	5
PM Schedule	MED.AMZ.FLR04.12W AMER-AR FLOOR WITH INVENTORY POD SEGMENT 12 WEEK	Warranty	
		Safety	
Problem Code	N.A. Not Applicable (not allowed to be used in Breakdowns and Corrective)	Equipment Criticality	3
		Assigned To	ERWOMACK
		Reported By	

Equipment

Equipment	AR.ZONE.5.A.SECTION.54 TPA4-paKivaA05 SECTION 12 36	Manufacturer	AMAZON
		Model	AR FLOOR SECTION
		Serial Number	54

Activity List

Activity	Task Plan Description	Trade	Start Date	End Date	Supplier
1	LOTO Evidence	TECH	10/05/2025	10/05/2025	

Checklist

Sequence	Equipment	Description	Result
10	AR.ZONE. 5.A.SECTION. 54	Does this task require LOTO to one or more energy sources?	Yes: _____ No: _____
20	AR.ZONE. 5.A.SECTION. 54	Are photos of applied LOTO devices uploaded to this check (comment if not)?	Yes: _____ No: _____

Task Plan Instructions

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Photographic Evidence of applied LOTO

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Checklist

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Task Plan Instructions

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	Task Plan Instructions					
	Ensure equipment is cleaned after repairs are completed and prior to handing over to Operations					
	Booked Hours					
	Employee	Date	Time On	Time Off	Total Time	Type of Hours

Work Order

Work Order	10040918793	Scheduled Start Date	10/26/2025
	AMER-USS ARSTOW 1 WEEK PM	Scheduled End Date	10/26/2025
Status	Open	Date Started	10/11/2025 05:30
Created By	R5	Date Completed	
Created	10/11/2025		
WO Type	SC	Parent WO	
	System Check	Class	
Department	RME	Priority	5
	Reliability Maintenance Engineering (RME)	Warranty	
PM Schedule	MIN.USS.ARSTOW.01W	Safety	
	AMER-USS ARSTOW 1 WEEK PM	Equipment Criticality	3
Problem Code	N.A.	Assigned To	ERWOMACK
	Not Applicable (not allowed to be used in Breakdowns and Corrective)	Reported By	

Equipment

Equipment	AR.ZONE.5.A.STN.AS.RC0512	Manufacturer	AR
	TPA4-paKivaA05 ARSTOW RC0512	Model	ARSTOW STATION
		Serial Number	

Activity List

Activity	Task Plan Description	Trade	Start Date	End Date	Supplier
1	LOTO Evidence	TECH	10/05/2025	10/05/2025	

Checklist

Sequence	Equipment	Description	Result
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- select the checklist item (sequence 20),
- click 'Actions' on the bottom of the checklist tab,
- select 'Add/Edit Checklist Items Documents'
- select 'Actions' > Create/Upload Document'

Steps to upload LOTO photos on APM Mobile:

Activity List					
Activity	Task Plan Description	Trade	Start Date	End Date	Supplier
Task Plan Instructions					

- select the checklist item (sequence 20),
- click the camera symbol,
- take a photo directly or navigate to saved photos on your device

Booked Hours					
Employee	Date	Time On	Time Off	Total Time	Type of Hours

Activity	Task Plan Description	Trade	Start Date	End Date	Supplier
10	AMER-ARSTOW WEEKLY PM	TECH	10/26/2025	10/26/2025	



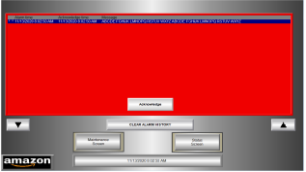

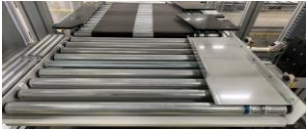

Checklist			
Sequence	Equipment	Description	Result
10	AR.ZONE.	I have completed all tasks referenced on the task list of this PM	Yes: _____
	5.A.STN.AS.RC0512		No: _____
20	AR.ZONE.	I have created a follow-up work order for any issues found during this PM	Completed: _____
	5.A.STN.AS.RC0512		

Task Plan Instructions

R5 [10/21/2025 17:47]:

Apply LOTO if neededSEE ATTACHED DOCUMENT FOR TASK INSTRUCTIONS. Ensure equipment is cleaned after repairs are completed and prior to handing over to Operations

Booked Hours					
Employee	Date	Time On	Time Off	Total Time	Type of Hours

Maintenance Job Planning/Estimating Worksheet					
Planner:		WO#:		Date:	
Job Contact:		Location:		Asset ID#:	
Job Description: Weekly PM Technicians required: 1 Elapsed time: 1 Hour					
Job Scope					
Job Plan Seq.	Task Description	Task Duration	Number of Resources Required	Total Estimated Labor Hours	
10	Is the site using the correct PM Schedule for this asset. PM Schedule activated should be USS.ARSTOW.02	0	1	0	
20	Always follow OSHA, LOTO, PTP, NFPA, and Amazon Safety Policies before placing hands on equipment.	0	1	0	
30	"Take 2 for Safety". Review the area you will be working in, inspect for potential barriers or unsafe conditions.	0	1	0	
40	Use required PPE as needed to complete the job. Gloves, safety glasses, etc.	0	1	0	
Visual Inspection					
50	Listen for any abnormal noise/vibration.	0.02	1	0.02	
60	Verify Safety Equipment (E-Stops, Door Safety Switches, Etc.) for functionality.	0.02	1	0.02	
70	Document any repeat alarms or warnings from Alarms Menu in HMI.	0.02	1	0.02	
Lock Out Tag Out					
80	Clean the ARSTOW's structural system. Use broom and dust pan to collect debris.	0.1	1	0.1	
90	Check the machine for the following items: Loose fasteners Physical damage Guide rails for secure attachment and alignment	0.1	1	0.1	
Air Actuators & Pneumatic System					
100	Check for leaks and secure air fittings	0.03	1	0.02	
110	Check air pressure regulator setting. Recommended pressure is 80 psi or 5.5 Bar	0.02	1	0.02	
120	Clean all cylinders with a dry, clean rag	0.05	1	0.05	
130	Clean any debris from cylinder guide rods	0.03	1	0.03	
140	Check mounting bolts	0.02	1	0.02	
150	Check set screws are tight for cylinder guide rods	0.02	1	0.02	
160	Check pop-up stop actuates vertically (90deg. to conveyor) and bracket is not bent	0.02	1	0.02	
170	Check sheet metal mount brackets for cylinders do not have cracks	0.02	1	0.02	
180	Check timing belts for wear, tracking, pulley set screw tightness	0.02	1	0.02	
Conveyors & Belts					
190	Check for damage	0.02	1	0.02	
200	Check belt tracking and alignment	0.02	1	0.02	
210	Check for loose or missing drive bands	0.02	1	0.02	
Photoeyes					
220	Check for damage	0.02	1	0.02	
230	Clean photoeyes and reflectors	0.05	1	0.05	
240	Check for tightness	0.02	1	0.02	
250	Check alignment with reflectors	0.02	1	0.02	
260	Check cables for tightness	0.02	1	0.02	
Proximity Switches					
270	Clean and check for damage	0.05	1	0.05	
280	Check for tightness	0.02	1	0.02	

290	Check alignment with metal target	0.02	1	0.02
Return To Operations				
300	Before returning machine to operation, ensure all guards are in place and all safety devices are functioning properly. Ensure none of these were removed or damaged during machine service.	0.02	1	0.02
310	Remove all tools from area and ensure they are all accounted for	0.02	1	0.02
320	Make sure the area is clean and free of any debris	0.02	1	0.02
330	Remove Lock Out/Tag Out	0.02	1	0.02
340	Restart equipment, verify proper operation, no unusual noises or vibrations	0.02	1	0.02
Total Job Plan Duration:		1.0 Hours		Total Backlog Hours:
				1
Safety Requirements				
Permits:	Confined Space Entry	Hot Work	X	Lockout/Tagout
PPE:	Safety Glasses, Safety Shoes, Gloves			
Additional Comments: There are no grease points to maintain as all bearings are sealed. Weekly maintenance events per below are recommended. Do not use spray lubricant (i.e. WD40) on any part of the machine.				
Special Tools Needed:				