|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| The checks performed are inspect and report unless otherwise stated, secondary corrective maintenance work orders should be submitted on Maximo for any faults identified. Unless the fault found is safety critical, quality related or could impact production, in which case a repair should be carried out immediately and reported as reactive breakdown maintenance. The Shift Supervisor must be informed prior to any work commencing. Add the details of any additional work orders raised, to the log of the pre-run work request. | | | | | | | |
| The pre-run checks must be done in stages. Tip and crosshead internal/external checks must be completed prior to the crosshead being connected. Heater Band and Thermocouple Controller checks must be completed when switched off, and then when switched on and at the required temperature. | | | | | | | |
| **Work Order Number:** | | | | | | **Date:** | |
| **Parent Asset Description / Checks** | | | **Asset #(s)** | **Okay 🗸 / 🗴 / ?** | | **Comments (? In Okay column indicates check unable to be performed, state reason, i.e. product in the machine).** | |
| **Pay Off Rim Drive** | | | **1269** |  | |  | |
| Function check all controls. | | | **2064, 2065** |  | |  | |
| *Re-torque all the bolts on each of the four rim wheel faceplates: M12 = 75Nm, M16 = 180Nm. Ensure all dowels (T01431) are fully located.* | | | **2066, 2067, 2208, 2209** |  | |  | |
| Visually inspect all electrical cords and control cables for damage. | | |  |  | |  | |
| Check the overtravel switches and resolver wire are in good working order | | |  |  | |  | |
| Check the operation of the light curtain by physically breaking the light beam and monitoring the LED’s. Visually inspect the light emitter & receiver for scratches & dirt. | | | **2210** |  | |  | |
| **Entry Caterpuller** | | | **4696** |  | |  | |
| Check & clear any faults on the alarm page. Check the HPU status is ‘Healthy’ on the main HMI page. | | | **4848** |  | |  | |
| Visually check the hydraulic fluid level. | | | **4839** |  | |  | |
| Check the operation of the tracks – open & close function with no pipe in. | | | **4841, 4842, 4843** |  | |  | |
| **Extruder** | | | **1275** |  | |  | |
| Visually inspect the barrel for damage. Reduce the heat set point to less than the current value and visually check the cooling fans are working. | | | **2571** |  | |  | |
| Santasalo Gearbox: visually inspect hoses and lines for leaks on the oil pump and check the oil level, *top up with Shell Omala 320 as required.* | | | **2570** |  | |  | |
| Check the cooling fan is working and change the filter material on the main drive DC motor. | | | **2579** |  | |  | |
| **Parent Asset Description / Checks** | | | **Asset #(s)** | **Okay 🗸 / 🗴 / ?** | | **Comments (? In Okay column indicates check unable to be performed, state reason, i.e. product in the machine).** | |
| Function check the control system operation for all heaters and thermocouples on the main control console. | | | **2576** |  | |  | |
| Clean database on Nomos screen (if required use guidelines located in the maintenance workshop). | | |  |  | |  | |
| Visually inspect the catenary arm and carry out a function check on the main control console. | | | **2576** |  | |  | |
| Check the throat chiller water level. | | | **2580** |  | |  | |
| Check the throat chiller for leaks. | | | **2580** |  | |  | |
| Check the throat chiller valves are in the correct positions. | | | **2580** |  | |  | |
| Check the indicator lamps on the throat chiller. | | | **2580** |  | |  | |
| Check the in-line water filter. | | | **2580** |  | |  | |
| Run the throat chiller and check the water flow entering and exiting the throat. | | | **2580** |  | |  | |
| **Loading System** | | | **1276** |  | |  | |
| Check the hopper for air leaks. | | |  |  | |  | |
| **Heater Band and Thermocouple Controller Checks. Asset = Extruder (1275)** | | | | | | | |
| **Heater Band** | **Current = 0 Amps When Switched Off 🗸 / 🗴(Specify Reading)** | **Current = Amps 2, Per Crosshead Specification Sheet When Switched On** | | | | | **Comments, State Maximo work order number(s):** |
| **Z1** |  |  | | | | |  |
| **Z2** |  |  | | | | |  |
| **Z3** |  |  | | | | |  |
| **Z4** |  |  | | | | |  |
| **Z5** |  |  | | | | |  |
| **H1** |  |  | | | | |  |
| **H1.1** |  |  | | | | |  |
| **H2** |  |  | | | | |  |
| **H3** |  |  | | | | |  |
| **H4** |  |  | | | | |  |
| **H5** |  |  | | | | |  |
| **H6** |  |  | | | | |  |
| **H7** |  |  | | | | |  |
| **H8** |  |  | | | | |  |
| **H9** |  |  | | | | |  |
| **H10** |  |  | | | | |  |
| **H11** |  |  | | | | |  |
| **H12** |  |  | | | | |  |
| **H13** |  |  | | | | |  |
| **H14** |  |  | | | | |  |
| **H15** |  |  | | | | |  |
| **H16** |  |  | | | | |  |
| **H17** |  |  | | | | |  |
| **H18** |  |  | | | | |  |
| **H19** |  |  | | | | |  |
| **H20** |  |  | | | | |  |
| **H21** |  |  | | | | |  |
| **H22** |  |  | | | | |  |
| **H23** |  |  | | | | |  |
| **H24** |  |  | | | | |  |
| **H25** |  |  | | | | |  |
| **H26** |  |  | | | | |  |
| **H27** |  |  | | | | |  |
| **Checks performed by (name and SSO):** | | | | | | | |
| **Parent Asset Description / Checks** | | | **Asset #(s)** | **Okay 🗸 / 🗴 / ?** | | **Comments (? In Okay column indicates check unable to be performed, state reason, i.e. product in the machine).** | |
| **Chiller and Water System** | | | **1291** |  | |  | |
| Check all filter screens on the pumps. | | | **2552, 2554, 2555, 2557, 2558, 2560, 2561, 2563, 2565, 2567** |  | |  | |
| **Exit Caterpuller** | | | **1293** |  | |  | |
| Checkthe drive universals for excessive backlash. | | | **2350** |  | |  | |
| Visually check the hydraulic fluid level. | | | **2338** |  | |  | |
| Visually check all hoses & lines for damage and leaks. | | |  |  | |  | |
| Check the operation of the tracks – open & close function with no pipe in. | | | **2339, 2340, 2341** |  | |  | |
| Tracks - rotate & inspect all bearings. | | |  | |  | |
| **Void Detector** | | | **3458 / 3459** |  | |  | |
| Ensure the HV warning sign is displayed on the cage. | | |  |  | |  | |
| Check the security of all earth fixings. | | |  |  | |  | |
| **Parent Asset Description / Checks** | | | **Asset #(s)** | **Okay 🗸 / 🗴 / ?** | | **Comments (? In Okay column indicates check unable to be performed, state reason, i.e. product in the machine).** | |
| Check the earth continuity from the terminal on the back of the asset to the roller bed frame and earth stud. | | |  |  | |  | |
| Check the earth continuity from the test wand to the earth stud. | | |  |  | |  | |
| Check the condition of the HV lead / probe and relevant connections. | | |  |  | |  | |
| **Take Up Rim Drive** | | | **1296** |  | |  | |
| Function check all controls. | | | **2048, 2049** |  | |  | |
| *Re-torque all the bolts on each of the four rim wheel faceplates: M12 = 75Nm, M16 = 180Nm. Ensure all dowels (T01431) are fully located.* | | | **2050, 2051, 2205, 2206** |  | |  | |
| Visually inspect all electrical cords and control cables for damage. | | |  |  | |  | |
| Check the operation of the light curtain by physically breaking the light beam and monitoring the LED’s. Visually inspect the light emitter & receiver for scratches & dirt. | | | **2207** |  | |  | |
| **Checks completed by (maintenance technician(s) initials):** | | | | | | | |
| **Reel Checks / Reel #** | | |  |  |  | | |
| Check saddles/dividers where fitted are secure & will not damage the product. | | |  |  |  | | |
| Internal - check for side plate damage and any sharp edges. | | |  |  |  | | |
| Inspect pans for damage and cracks. | | |  |  |  | | |
| Check the condition of lifting ring. | | |  |  |  | | |
| Check for any other external damage. | | |  |  |  | | |
| Check the security of the internal bolts. | | |  |  |  | | |
| **Checks completed by (fabrication technician(s) initials):** | | | | | | | |