

 <p><b>AISHA STEEL MILLS LIMITED</b> SHAPING THE ECONOMY</p>	<h2>Maintenance Check List</h2>	<p>DOC.#ASML-ENGMECH-FORM-03</p> <p>Revision No. 00</p> <p>Effective Date: 01-Apr-2017</p>
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COMPACT COLD MILL				
WEEKLY CHECKLIST				
Year: _____		MONTHLY: _____	____ WEEK	Date: _____
S.NO.	LOCATION	ACTIVITIES	STATUS	REMARKS
<b>PREPARATION SECTION</b>				
<b>A</b>	<b>POR WITH SHIFTING FRAME</b>			
1	Lubrication	Working of Lubrication		
2	Lubrication	Lubrication status on gears, bearings and sliding parts		
3	Bearings	Temperature, noise, vibration on bearing parts		
4	Bolts	Tight/loose check		
5	Media	Check leakage of Oil, Air, Water, etc.		
6	Gripper	Operations		
<b>B</b>	<b>SNUBBER ROLL</b>			
1	Couplings	Lubrication System (Top up/ Adjust/Adapt)		
2	Bearings	Centralized Lubrication		
3	Centralized Lubrication	Oil Volume/Temperature/Quality		
<b>C</b>	<b>PIVOTING TABLE WITH COIL PEELER</b>			
1	Peeler Knife	Visual Check		
2	Table Surface	Contamination(Clean)		
<b>D</b>	<b>3-ROLL PINCH</b>			
1	Deflector Roll/ Pinch Roll/ Bending Roll	Condition/Wear		
<b>E</b>	<b>STRIP CENTER DETECTION</b>			
1	Light Barrier/Sensor	Contamination/Dirt		
<b>F</b>	<b>STRIP GUIDE UNIT</b>			
1	Guide Rollers	Check for Damage and Wear		
2	Bearing Assembly	Centralized Lubrication		
<b>TENSION REEL 1</b>				
<b>G</b>	<b>4-SEGMENT TENSION REEL</b>			
1	Bearing Assembly	Bearing Temperature (must be <80C)		
2	Gear Unit	Lubrication (Top up/Adjust/Adapt)		
3	Strip Gripper Segment	Function		
<b>H</b>	<b>DRIVEN SNUBBER ROLL</b>			
1	Bearing Assembly	Centralized Lubrication		
<b>ENTRY SECTION</b>				
<b>I</b>	<b>MANDREL SUPPORT</b>			
1	Bearing Assembly	Centralized Lubrication		
<b>J</b>	<b>BENDING ROLLS</b>			
1	Pinch and Bending Roll	Scoring		
2	Cylinder	Sealing		

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S.NO.	LOCATION	ACTIVITIES	STATUS	REMARKS
<b>K DIVIDING SHEAR</b>				
1	Knife	Wear/Damage, Especially Cutting Edge		
<b>MILL STAND 1</b>				
<b>L DRY STRIP SYSTEM</b>				
1	Cylinder	Sealing		
2	Nozzles	Spray Pattern		
3	Suction Force	Passage/Cleanliness		
<b>M MILL HOUSING WITH ACCESSORIES</b>				
1	Centralized Lubrication	Oil Volume/Temperature/Quality		
<b>N CVC SHIFTING</b>				
1	General (CVC Shifting Cylinder)	Fastening		
2	General (CVC Shifting Cylinder)	Function		
3	Interlocking Cylinders	Function		
4	Interlocking Cylinders	Fastening		
5	Interlocking Cylinders	Seal		
<b>O SPINDLE HEAD SUPPORT</b>				
1	General	Wear		
2	General	Contamination/Dirt		
3	Guide	Centralized Lubrication		
4	Guide	Wear		
5	Bushes	Wear		
6	Cylinders	Seal		
<b>P EMULSION SPRAYING SYSTEM</b>				
1	Flat-Jet Nozzles	Spray Pattern		
2	Pipework	Leaks		
<b>Q MULTIZONE COOLING SYSTEM</b>				
1	Flat-Jet Nozzles	Spray Pattern		
2	Pipework	Leaks		
<b>R BUR CHANGING DEVICE</b>				
1	General	Wear		
2	General	Contamination/Dirt		
<b>WORK ROLL CHANGING DEVICE</b>				
<b>S UNDER CARRIAGE</b>				
1	Keeper System	Function		
2	Inching Drive	Function		
3	Inching Drive	Sealing		
4	Guides	Condition		
<b>T SIDE SHIFTER DRIVE</b>				
1	Universal Joint Shaft	Function		

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S.NO.	LOCATION	ACTIVITIES	STATUS	REMARKS
2	Travel Drive	Function		
3	Travel Drive	Sealing		
4	Guides	Condition/Align		
<b>U</b>	<b>TONG CAR</b>			
1	Travel Drive	Function		
2	Travel Drive	Sealing		
3	Inching Drive	Function		
4	Inching Drive	Sealing		
5	Tong Head	Function		
<b>INTERSTAND</b>				
<b>V</b>	<b>HOLD DOWN ROLL</b>			
1	General	Wear		
2	General	Contamination/Dirt		
3	Bearing Assembly	Lubrication System (Top up/ Adjust/Adapt)		
<b>W</b>	<b>BASE FRAME</b>			
1	General	Wear		
2	General	Contamination/Dirt		
<b>X</b>	<b>STRIP TENSIO METER</b>			
1	General	Wear		
2	General	Contamination/Dirt		
3	Roll Barrel Surface	Damage/Corrosion/Wear		
<b>Y</b>	<b>PASSLINE ROLL</b>			
1	General	Wear		
2	General	Contamination/Dirt		
3	Roll Barrel Surface	Damage/Corrosion/Wear		
<b>BUR CHANGE DEVICE</b>				
1	General	Wear		
2	General	Contamination/Dirt		
<b>MILL STAND 2</b>				
<b>Z</b>	<b>DRY STRIP SYSTEM</b>			
1	Cylinder	Sealing		
2	Nozzles	Spray Pattern		
3	Suction Force	Passage/Cleanliness		
<b>AA</b>	<b>MILL HOUSING WITH ACCESSORIES</b>			
1	Centralized Lubrication	Oil Volume/Temperature/Quality		
<b>AB</b>	<b>CVC SHIFTING</b>			
1	General (CVC Shifting Cylinder)	Fastening		
2	General (CVC Shifting Cylinder)	Function		
3	Interlocking Cylinders	Function		

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S.NO.	LOCATION	ACTIVITIES	STATUS	REMARKS
4	Interlocking Cylinders	Fastening		
5	Interlocking Cylinders	Seal		
<b>AC</b>	<b>SPINDLE HEAD SUPPORT</b>			
1	General	Wear		
2	General	Contamination/Dirt		
3	Guide	Centralized Lubrication		
4	Guide	Wear		
5	Bushes	Wear		
6	Cylinders	Seal		
<b>AD</b>	<b>EMULSION SPRAYING SYSTEM</b>			
1	Flat-Jet Nozzles	Spray Pattern		
2	Pipework	Leaks		
<b>AE</b>	<b>MULTIZONE COOLING SYSTEM</b>			
1	Flat-Jet Nozzles	Spray Pattern		
2	Pipework	Leaks		
<b>AF</b>	<b>BUR CHANGING DEVICE</b>			
1	General	Wear		
2	General	Contamination/Dirt		
<b>EXIT SECTION</b>				
<b>AG</b>	<b>DRY STRIP SYSTEM</b>			
1	General	Wear		
2	General	Contamination/Dirt		
3	Nozzles	Spray Pattern		
4	Suction Force	Passage/Cleanliness		
<b>AH</b>	<b>MANDREL SUPPORT</b>			
1	Bearing Assembly	Centralized Lubrication		
<b>AI</b>	<b>BENDING ROLLS</b>			
1	Pinch and Bending Roll	Scoring		
2	Cylinder	Sealing		
<b>AJ</b>	<b>DIVIDING SHEAR</b>			
1	Knife	Wear/Damage, Especially Cutting Edge		
<b>TENSION REEL 2</b>				
<b>AK</b>	<b>STRIP PRESS</b>			
1	General	Condition (Damage)		
<b>AL</b>	<b>4-SEGMENT TENSION REEL</b>			
1	Bearing Assembly	Bearing Temperature (must be <80C)		
2	Strip Gripper Segment	Function		
<b>MEDIA SYSTEMS</b>				
<b>AM</b>	<b>HP - HYDRAULIC SYSTEMS</b>			
1	Tank	Leaks		

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S.NO.	LOCATION	ACTIVITIES	STATUS	REMARKS
2	Tank	Level		
3	Tank	Temperature		
4	Tank	Clogging of Air Filters		
5	HP Pump Package	Pump Running Noises		
6	HP Pump Package	Housing Temperature		
7	HP Pump Package	Pressure Setting		
8	Circulation Pump Package	Housing Temperature		
9	Circulation Pump Package	Pressure Setting		
10	Circulation Pump Package	Pump Running Noises		
11	Filters	Pressure filter (Inspection for Clogging)		
12	Filters	Circulating filters (Inspection for Clogging)		
13	Filters	Return line Filters (Inspection for Clogging)		
14	Cooling Systems (Heat exchangers/ valves/ filters)	Leaks		
15	Cooling Systems (Heat exchangers/ valves/ filters)	Clogging of Water Filters		
16	Cooling Systems (Heat exchangers/ valves/ filters)	Switching of Valves		
17	Accumulator	Switching Operations of Shutoff Valves/ Pressure Relief Valves etc.		
18	Directional Control Valves	Switching Operations		
19	Propositional Valves	Operation		
20	Servo Valves	Housing Temperature		
21	Pipework	Fastening		
22	Cylinders/ Tilting/ Motors	Collars/ Wipers		
23	Cylinders/ Tilting/ Motors	Seal		
24	Cylinders/ Tilting/ Motors	Piston Rods		
25	Leak Oil Trays, Retension System	Corrosion/ Tightness/ Function		
<b>AN</b>	<b>LP - HYDRAULIC SYSTEMS</b>			
1	Tank	Leaks		
2	Tank	Level		
3	Tank	Temperature		
4	Tank	Clogging of Air Filters		
5	HP Pump Package	Pump Running Noises		
6	HP Pump Package	Housing Temperature		
7	HP Pump Package	Pressure Setting		
8	Circulation Pump Package	Housing Temperature		
9	Circulation Pump Package	Pressure Setting		
10	Circulation Pump Package	Pump Running Noises		
11	Filters	Pressure filter (Inspection for Clogging)		

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S.NO.	LOCATION	ACTIVITIES	STATUS	REMARKS
12	Filters	Circulating filters (Inspection for Clogging)		
13	Filters	Return line Filters (Inspection for Clogging)		
14	Cooling Systems (Heat exchangers/ valves/ filters)	Leaks		
15	Cooling Systems (Heat exchangers/ valves/ filters)	Clogging of Water Filters		
16	Cooling Systems (Heat exchangers/ valves/ filters)	Switching of Valves		
17	Accumulator	Switching Operations of Shutoff Valves/ Pressure Relief Valves etc.		
18	Directional Control Valves	Switching Operations		
19	Propositional Valves	Operation		
20	Servo Valves	Housing Temperature		
21	Pipework	Fastening		
22	Cylinders/ Tilting/ Motors	Collars/ Wipers		
23	Cylinders/ Tilting/ Motors	Seal		
24	Cylinders/ Tilting/ Motors	Piston Rods		
25	Leak Oil Trays, Retension System	Corrosion/ Tightness/ Function		
<b>AO</b>	<b>PNEUMATIC SYSTEMS</b>			
1	Accumulator Condensate Drain	Condensate in Tank		
2	Filter with Automatic Condensate Drain	Filter Clogging		
3	Filter with Manual Condensate Drain	Filter Clogging		
4	Filter with Manual Condensate Drain	Condensate Drain		
5	Oiler	Oil Level		
6	Pipework	Fastening		
7	Hoses	Chafe Marks		
8	Hoses	Proper Attachments / Fastening		
9	Cylinders/ Tilting/ Motors	Collars/ Wipers		
10	Cylinders/ Tilting/ Motors	Seal		
11	Cylinders/ Tilting/ Motors	Piston Rods		
12	Cylinders/ Tilting/ Motors	Cushioning		
<b>AP</b>	<b>LUBRICATION SYSTEM</b>			
1	Tank	Leaks		
2	Tank	Level		
3	Tank	Temperature		
4	Pump Package	Pump Running Noises		
5	Pump Package	Housing temperature		
6	Pump package	Pressure setting		
7	Pipework	Leaks		

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S.NO.	LOCATION	ACTIVITIES	STATUS	REMARKS
8	Hoses/Rubber expansion joints	Damage/Chafe marks/ Tightening		
9	Tank	Clogging of Air Filters		
10	Filters	Filter (Inspection for Clogging)		
11	Cooling Systems (Heat Exchangers/ Valves/Filters)	Leaks		
12	Cooling Systems (Heat exchangers/ valves/Filters)	Clogging of Water Filters		
13	Cooling Systems (Heat exchangers/ valves/Filters)	Switching of Valves		
14	Pipework	Fastening		
AAS	<b>EMULSION SYSTEM</b>			
1	Tank	Leaks		
2	Tank	Level		
3	Tank	Temperature		
4	Tank	Clogging of Air Filters		
5	Pump Package	Pump Running Noises		
6	Pump Package	Housing temperature		
7	Filters	Circulation Line Strainer Cleaning		
8	Filters	Backwash Filter Operation		
9	Filters	Inclined Bed Filter's Operation		
10	Pipework	Leaks		
11	Pipework	Fastening		
12	Hoses/Rubber Expansion Joints	Damage/ Chafe Marks/ Tightening		
13	Cooling Systems (Heat Exchangers/ Valves/Filters)	Leaks		
14	Cooling Systems (Heat Exchangers/ Valves/Filters)	Clogging of Water Filters		
15	Cooling Systems (Heat Exchangers/ Valves/Filters)	Switching of Valves		
16	Valves	Butterfly Valves Check for Passing		
17	Valves	Globe Valve Operations.		

\_\_\_\_\_  
Supervisor

\_\_\_\_\_  
Sr. Assistant Manager/  
Engineer

\_\_\_\_\_  
Manager

**Note:** C: Checked, D: Checked & Repair, R: Checked & Replaced, X: Not Checked