7.1 Maintenance schedule

Area	Inspection	Action	OC	TI
Backup roll bearings	▪ Oil level	▪ Fill in oil – see 7.1.1 ▪ Drain oil – see 7.1.2 ▪ Oil level inspection – see 7.1.3	S	M M *
Rotary shaft seal and V-rings	▪ Wear ▪ Damage	▪ Replace ▪ Replace	S	M
Oil-air cartridge assemblies (TURBOLUB)	▪ Visual check (observe Subsuppliers' Operating Instructions Part 3 - Messrs. Rebs)	▪ Repair	S	B1
Couplings for oil-air lubrication	▪ Wear ▪ Damage ▪ Contamination ▪ Leaks	▪ Repair, replace ▪ Repair, replace ▪ Clean ▪ Tighten, re-seal	S	M
Wear liners	▪ Wear ▪ Damage	▪ Repair, replace ▪ Repair, replace	S	M
Backup roll	▪ Wear marks on roll barrel ▪ Damage	▪ Roll change ▪ Replace	P	S
Backup roll wiper	▪ Wear ▪ Damage	▪ Repair, replace ▪ Repair, replace	P	3M

Operating condition (OC)

S Special operating mode (roll change)

P Stop (maintenance, troubleshooting)

Time interval (TI)

S every shift (8 hours)

****)M** every month

B1 According to supplier's specifications

**) Intervals combined with numbers denote for example:

3M= every three months

*) Automatic level control: A valve opens at each work roll change and allows surplus oil to flow off.

7.1.1 Fill in oil

See also the drawing of the *thrust bearing housing.*

Chapter *Description/Arrangement*

Screw off the plug screw in the top of the thrust bearing cover. Through this opening the oil for the radial and thrust bearings is filled in. The oil levels of the radial and thrust bearings can be checked through an oil-level inspection opening, which is also used for the automatic level control. This means that oil must be filled in until it flows out of the oil-level inspection opening (or out of the hose connected there). During filling in it should be taken into account that the oil must first be distributed between the roll bodies. For this reason, more oil than actually required should initially be filled in and the excessive quantity be drained through the inspection opening after some minutes.

7.1.2 Drain oil

See also the drawing of the *thrust bearing housing.*

Chapter *Description/Arrangement*

The oil volumes of the radial and thrust bearings can be drained by means of the plug screws installed in the thrust bearing covers.

7.1.3 Oil level inspection

See also the drawing of the *thrust bearing housing.*

Chapter *Description/Arrangement*

The backup roll bearing assembly is equipped with a level control unit. In the process surplus oil is discharged via a valve. This valve opens automatically at each work roll change for max. 3 min. It can also be actuated manually. Here it is important that this valve must be actuated only during shutdown periods. Otherwise too much oil might flow out of the bearing. This would lead to damage of the bearing.