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| **COLD ROLLING SKINPASS MILL**  **WEEKLY CHECKLIST** | | | | |
|
| **Year:\_\_\_\_\_\_\_ MONTHLY:\_\_\_\_\_\_\_** | | | **Date:\_\_\_\_\_\_\_\_\_\_** | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **\_\_\_\_WEEK** | **REMARKS** |
| **A** | **PAYOFF REEL** | | | |
| 1 | Mandrel Head (Segment) | Greasing |  |  |
| 2 | Mandrel Head (Sleeve) | Greasing |  |  |
| **B** | **ENTRY TENSION REEL** | | | |
| 1 | Mandrel Shaft Spline | Greasing |  |  |
| 2 | Mandrel Head Segment | Greasing |  |  |
| 3 | Mandrel Head Wedge | Greasing |  |  |
| 4 | Mandrel Head Segment | Greasing |  |  |
| 5 | Mandrel Head Support Bearing | Greasing |  |  |
| 6 | Outboard Swing Frame Support Roller Bearing | Greasing |  |  |
| 7 | Outboard Swing Frame Support Sheave | Greasing |  |  |
| **C** | **DELIVERY TENSION REEL** | | | |
| 1 | Mandrel Shaft Spline | Greasing |  |  |
| 2 | Mandrel Head Segment | Greasing |  |  |
| 3 | Mandrel Head Wedge | Greasing |  |  |
| 4 | Mandrel Head Segment | Greasing |  |  |
| 5 | Outboard Swing Frame Support Roller Bearing | Greasing |  |  |

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Supervisor Sr. Assistant Manager/ Manager

Engineer

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

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| **COLD ROLLING SKINPASS MILL**  **MONTHLY CHECKLIST** | | | | |
|
| **Year:\_\_\_\_\_\_\_ MONTHLY:\_\_\_\_\_\_\_\_\_\_** | | | **Date:\_\_\_\_\_\_\_\_\_\_\_** | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **STATUS** | **REMARKS** |
| **A** | **PAYOFF REEL** | | | |
| 1 | Coil Car | Inspection of Wheel, Chain & Sprocket |  |  |
| 2 | Mandrel Gear Box | Inspection of Sliding Liner |  |  |
| 3 | Hold Down Roll | Surface Condition & Rotation |  |  |
| 4 | Entry Pinch Roll | Surface Condition & Rotation |  |  |
| 5 | Entry Pinch Roll Screw Jack | Movement |  |  |
| 6 | Carry over Table | Inspection of Frame Pivot Bush |  |  |
| 7 | Gear Coupling | Greasing |  |  |
| 8 | Slide Gear Coupling | Greasing |  |  |
| 9 | Carry Over Table, Frame Pivot Bushing | Greasing |  |  |
| 10 | Entry Pinch Roll Top Roll Bearing | Greasing |  |  |
| 11 | Entry Pinch Roll Leveling Roll Lift Drive Screw Jack | Greasing |  |  |
| 12 | Entry Pinch Roll Leveling Roll Bearing | Greasing |  |  |
| 13 | Entry Pinch Roll Leveling Roll Lift Guide Plate | Greasing |  |  |
| 14 | Entry Pinch Roll Top Roll Frame Pivot Bushing | Greasing |  |  |
| 15 | POR Coil Car Lift Frame Guide Liner | Greasing |  |  |
| 16 | POR Coil Car Wheel | Greasing |  |  |
| 17 | POR Coil Car Pin Gear for Travelling | Greasing |  |  |
| 18 | POR Coil Car Chain & Sprocket for Drive | Greasing |  |  |
| **B** | **ENTRY TENSION REEL** | | | |
| 1 | Coil Car | Inspection of Wheel, Chain & Sprocket |  |  |
| 2 | Coil Car Cradle | Inspection of Chain & Sprocket |  |  |
| 3 | Mandrel Gear Box | Inspection of Sliding Liner |  |  |
| 4 | Snubber Roll | Surface Condition & Rotation |  |  |
| 5 | Threading Table | Inspection of Frame Pivot Bush |  |  |
| 6 | Entry Deflector Roll | Surface Condition & Rotation |  |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **STATUS** | **REMARKS** |
| 7 | Gear Coupling | Greasing |  |  |
| 8 | Slide Gear Coupling | Greasing |  |  |
| 9 | Entry Threading Table, Threading Table Pivot Bushing | Greasing |  |  |
| 10 | Entry Deflector Roll, Top Roll Bearing | Greasing |  |  |
| 11 | Entry Strip Guide, Screw Nut | Greasing |  |  |
| 12 | Entry Strip Guide | Greasing |  |  |
| 13 | Car Wheel | Greasing |  |  |
| 14 | Lift Frame Guide Liner | Greasing |  |  |
| 15 | Cradle roll Bearing | Greasing |  |  |
| 16 | Pin Gear for Travelling | Greasing |  |  |
| 17 | Chain & Sprocket for Drive | Greasing |  |  |
| 18 | Cradle roll Chain & Sprocket for Drive | Greasing |  |  |
| 19 | Snubber Roll for Entry Tension Reel, Frame Pivot Bushing Greasing | Greasing |  |  |
| **C** | **MILL STAND** | | | |
| 1 | Entry Swivel Joint | Movement |  |  |
| 2 | Entry Strip Guide | Roll Movement |  |  |
| 3 | Entry Strip Guide | Inspection of Chain & Sprocket |  |  |
| 4 | Anti-Crimping Roll | Surface Condition & Rotation |  |  |
| 5 | Cross Brake Roll | Surface Condition & Rotation |  |  |
| 6 | Anti-Crimping Screw Jack | Movement |  |  |
| 7 | Cross Brake Screw Jack | Movement |  |  |
| 8 | Delivery Shear Knife | Inspection Cutting Edge |  |  |
| 9 | Delivery Shear | Inspection of Frame Slide Bush |  |  |
| 10 | Delivery Swivel Joint | Movement |  |  |
| 11 | Pass Line Adjust Screw Jack | Greasing |  |  |
| 12 | Mill Main Drive Universal Joint Slide Spline | Greasing |  |  |
| 13 | Mill Main Drive Universal Joint Roll Side | Greasing |  |  |
| 14 | Mill Main Drive Universal Joint Reducer Side | Greasing |  |  |
| 15 | Anti-Crimp Roll / Pivot Bearing | Greasing |  |  |
| 16 | Anti-Crimp Roll / 250 Roller Bearing | Greasing |  |  |
| 17 | Anti-Crimp Roll Ball Screw Jack | Greasing |  |  |
| 18 | Cross Brake Roll / Pivot Bearing | Greasing |  |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **STATUS** | **REMARKS** |
| 19 | Cross Brake Roll / 250 Roller Bearing | Greasing |  |  |
| 20 | Cross Brake Roll Ball Screw Jack | Greasing |  |  |
| 21 | Mill Main Drive Main Gear Coupling | Greasing |  |  |
| 22 | Mill Main Drive Main Gear Coupling | Greasing |  |  |
| **D** | **DELIVERY TENSION REEL** | | | |
| 1 | Delivery Deflector Roll | Surface Condition & Rotation |  |  |
| 2 | Threading Table | Inspection of Frame Pivot Bush |  |  |
| 3 | Coil Car | Inspection of Wheel, Chain & Sprocket |  |  |
| 4 | Delivery Deflector Roll, Top Roll Bearing | Greasing |  |  |
| 5 | Delivery Threading Table, Threading Table Pivot Bushing | Greasing |  |  |
| 6 | Delivery Tension Reel, Gear Coupling | Greasing |  |  |
| 7 | Lift Frame Guide Liner | Greasing |  |  |
| 8 | Cradle roll Bearing | Greasing |  |  |
| 9 | Car Wheel | Greasing |  |  |
| 10 | Pin Gear for Travelling | Greasing |  |  |
| 11 | Chain & Sprocket for Drive | Greasing |  |  |
| **E** | **ROLL CHANGING DEVICE** | | | |
| 1 | Changing Car Drive | Inspection of Chain & Sprocket |  |  |
| 2 | Push Puller | Inspection of Chain & Sprocket |  |  |
| 3 | Car Clamp | Greasing |  |  |
| 4 | Roll Changing Device, WR Shift Frame Roller Way | Greasing |  |  |
| 5 | Roll Changing Device, Push Puller Drive Shaft Support Bearing | Greasing |  |  |
| 6 | Roll Changing Device, Changing Car Rack | Greasing |  |  |
| 7 | Roll Changing Device, Push Puller Rack | Greasing |  |  |
| **F** | **HYDRAULIC SYSTEM** | | | |
| 1 | AGC Pump # 01 | Abnormal Noise/Vibration |  |  |
| 2 | AGC Pump # 02 | Abnormal Noise/Vibration |  |  |
| 3 | Auxiliary Pump # 01 | Abnormal Noise/Vibration |  |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **STATUS** | **REMARKS** |
| 4 | Auxiliary Pump # 02 | Abnormal Noise/Vibration |  |  |
| 5 | Auxiliary Pump # 03 | Abnormal Noise/Vibration |  |  |
| **G** | **CIRCULATION OIL SYSTEM** | | | |
| 1 | Pump # 01 | Abnormal Noise/Vibration |  |  |
| 2 | Pump # 02 | Abnormal Noise/Vibration |  |  |
| 3 | Filter # 01 | Cleaning |  |  |
| 4 | Filter # 02 | Cleaning |  |  |
| 5 | Flow Switch POR | Inspection |  |  |
| 6 | Flow Switch ETR | Inspection |  |  |
| 7 | Flow Switch Mill Main Drive | Inspection |  |  |
| 8 | Flow Switch DTR | Inspection |  |  |
| **H** | **ROLL COOLANT SYSTEM** | | | |
| 1 | Main Emulsion Tank Agitator # 01 | Inspection of Belt, Abnormal Sound |  |  |
| 2 | Main Emulsion Tank Agitator # 02 | Inspection of Belt, Abnormal Sound |  |  |
| 3 | Emulsion Pump # 01 | Abnormal Noise/Vibration |  |  |
| 4 | Emulsion Pump # 02 | Abnormal Noise/Vibration |  |  |
| 5 | Emulsion Pump # 03 | Abnormal Noise/Vibration |  |  |
| 6 | Emulsion Pump # 04 | Abnormal Noise/Vibration |  |  |
| 7 | Emulsion Return Tank Agitator | Inspection of Belt, Abnormal Sound |  |  |
| 8 | Return Pump # 01 | Abnormal Noise/Vibration |  |  |
| 9 | Return Pump # 02 | Abnormal Noise/Vibration |  |  |
| 10 | Return Pump # 03 | Abnormal Noise/Vibration |  |  |
| 11 | Wet Skin pass Tank Agitator | Inspection of Belt, Abnormal Sound |  |  |
| 12 | Wet Skin pass Pump # 01 | Abnormal Noise/Vibration |  |  |
| 13 | Wet Skin pass Pump # 02 | Abnormal Noise/Vibration |  |  |
| 14 | Cellar Sump Pump # 01 | Abnormal Noise/Vibration |  |  |
| 15 | Cellar Sump Pump # 02 | Abnormal Noise/Vibration |  |  |
| 16 | Coolant Yards Sump Pump # 01 | Abnormal Noise/Vibration |  |  |
| 17 | Coolant Yards Sump Pump # 02 | Abnormal Noise/Vibration |  |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **STATUS** | **REMARKS** |
| 18 | Mill Wash Pump # 01 | Abnormal Noise/Vibration |  |  |
| 19 | Mill Wash Pump # 02 | Abnormal Noise/Vibration |  |  |
| 20 | Magnetic Separator | Inspection of Chain & Sprocket |  |  |
| 21 | Flat Bed Filter Blower | Abnormal Noise/Vibration |  |  |
| 22 | Fume Exhaust System | Inspection of Filter |  |  |
| 23 | Cellar Ventilation Fan | Inspection of Belt, Abnormal Sound |  |  |
| 24 | Fume Exhaust System, Fan Drive Shaft Support Bearing | Greasing |  |  |
| 25 | Fume Exhaust System, Mist Eliminator Damper Bearing | Greasing |  |  |
| 26 | Fume Exhaust System, Fume Exhaust Fan Damper Bearing | Greasing |  |  |
| 27 | Cellar Ventilation System, Fan Drive Shaft Pillow Block | Greasing |  |  |

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Supervisor Sr. Assistant Manager/ Manager

Engineer

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| **COLD ROLLING SKINPASS MILL**  **QUARTERLY CHECKLIST** | | | | |
|
| **Year:\_\_\_\_\_\_\_ MONTHLY:\_\_\_\_\_\_\_\_** | | | **Date:\_\_\_\_\_\_\_\_\_** | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **STATUS** | **REMARKS** |
| **A** | **PAYOFF REEL** | | | |
| 1 | Coil Skid | Liner Plate |  |  |
| 2 | Mandrel Gear Box | Clearance between Sliding Liner & Base |  |  |
| 3 | Mandrel Gear Coupling | Inspection |  |  |
| 4 | Entry Pinch Roll Gear Box | Abnormal Noise/Vibration |  |  |
| 5 | Entry Pinch Roll Screw Jack Coupling | Inspection |  |  |
| 6 | Hold Down Roll, Support Bushing | Greasing |  |  |
| 7 | Entry Pinch Roll Top Roll Drive Gear Coupling | Greasing |  |  |
| 8 | Entry Pinch Roll Top Roll Drive Universal Joint | Greasing |  |  |
| 9 | Entry Pinch Roll Leveling Roll Lift Drive Gear Coupling | Greasing |  |  |
| 10 | Entry Pinch Roll Leveling Roll Lift Drive Gear Coupling | Greasing |  |  |
| **B** | **ENTRY TENSION REEL** | | | |
| 1 | Coil Skid | Liner Plate |  |  |
| 2 | Mandrel Gear Box | Clearance between Sliding Liner & Base |  |  |
| 3 | Mandrel Gear Coupling | Inspection |  |  |
| 4 | Entry Strip Guide, Side Guide Adjust Sensor Pillow Block | Greasing |  |  |
| 5 | Entry Strip Guide, Chain & Sprocket for Drive | Greasing |  |  |
| 6 | Entry Strip Guide, Chain & Sprocket for Sensor | Greasing |  |  |
| 7 | Entry Deflector Roll, Top Roll Drive Universal Joint | Greasing |  |  |
| **C** | **MILL STAND** | | | |
| 1 | Entry Strip Press | Liner Inspection |  |  |
| 2 | Pass Line Step Wedge | Movement |  |  |
| 3 | Pass Line Liner Wedge | Movement |  |  |
| 4 | Entry Cobble Guard | Movement |  |  |
| 5 | Delivery Cobble Guard | Movement |  |  |
| 6 | Coolant and Air Spray Nozzle | Inspection and Cleaning |  |  |
| 7 | Mill Top Drive Gear Coupling | Inspection |  |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **STATUS** | **REMARKS** |
| 8 | Mill Bottom Drive Gear Coupling | Inspection |  |  |
| 9 | Delivery Shear Knife | Clearance |  |  |
| 10 | Electric Shutter | Inspection of Chain & Sprocket |  |  |
| 11 | WR Bending Cylinder | Oil Leakage |  |  |
| 12 | BUR Balancing Cylinder | Oil Leakage |  |  |
| 13 | WR Keeper Plate | Oil Leakage |  |  |
| 14 | BUR Keeper Plate | Oil Leakage |  |  |
| 15 | WR Shifting Cylinder | Oil Leakage |  |  |
| 16 | Cold Rolling Skin pass Mill, Pass Line Adjust Gear Coupling | Greasing |  |  |
| **D** | **DELIVERY TENSION REEL** | | | |
| 1 | Mandrel Gear Coupling | Inspection |  |  |
| 2 | Coil Skid | Liner Plate |  |  |
| 3 | Delivery Shear, Top Knife Frame Slid Bushing | Greasing |  |  |
| 4 | Delivery Deflector Roll, Top Roll Drive Universal Joint | Greasing |  |  |
| **E** | **ROLL CHANGING DEVICE** | | | |
| 1 | Changing Car Drive Gear Coupling | Inspection |  |  |
| 2 | Changing Car Rack | Inspection |  |  |
| 3 | Push Puller Rack | Inspection |  |  |
| 4 | Roll Changing Device, Changing Car Drive Gear Coupling | Greasing |  |  |
| 5 | Roll Changing Device, Changing Car Wheel Plummer Block | Greasing |  |  |
| 6 | Roll Changing Device, Push Puller Sensor Pillow Block | Greasing |  |  |
| 7 | Roll Changing Device, Push Puller Power Cylinder | Greasing |  |  |
| 8 | Roll Changing Device, Push Puller Wheel Cam Follower | Greasing |  |  |
| 9 | Roll Changing Device, Changing Car Drive Chain & Sprocket | Greasing |  |  |
| 10 | Roll Changing Device, Push Puller Sensor Chain & Sprocket | Greasing |  |  |
| **F** | **HYDRAULIC SYSTEM** | | | |
| 1 | AGC Heat Exchanger | Cleaning |  |  |
| 2 | AGC Tank | Cleaning |  |  |
| 3 | AGC Accumulator | Check Pressure |  |  |
| 4 | Auxiliary Heat Exchanger | Cleaning |  |  |
| 5 | Auxiliary Tank | Cleaning |  |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **STATUS** | **REMARKS** |
| 6 | Auxiliary Accumulator | Check Pressure |  |  |
| **G** | **CIRCULATION OIL SYSTEM** | | | |
| 1 | Heat Exchanger | Cleaning |  |  |
| **H** | **ROLL COOLANT SYSTEM** | | | |
| 1 | Fume Exhaust System | Cleaning of inside duct |  |  |
| 2 | Fume Exhaust System | Inspection of Steam Spray Nozzle |  |  |
| 3 | Roll Coolant System, Magnet Separator Drive Chain & Sprocket | Greasing |  |  |
| 4 | Roll Coolant System, Magnet Separator Plummer Block | Greasing |  |  |
| 5 | Roll Coolant System, Flat Bed Vacuum Filter Chain & Sprocket | Greasing |  |  |
| 6 | Roll Coolant System, Flat Bed Vacuum Filter Pillow Block | Greasing |  |  |

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Supervisor Sr. Assistant Manager/ Manager

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