|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **PUSH PULL PICKLING LINE** | | | | | | | | | | | |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** |
| **ENTRY SECTION** | | | | | | | | | | | |
| **A** | **ENTRY HYDRAULIC UNIT** | | | | | | | | | | |
| 1 | Oiling | | Oil Pressure | | X | |  | |  | |  |
| 2 | Oiling | | Oil Temperature | | X | |  | |  | |  |
| 3 | Strainer | | Service | | X | |  | |  | |  |
| 4 | Oiling | | Oil Level | | X | |  | |  | |  |
| 5 | Tank, Pump, Valve, Piping connection, etc. | | Leakage | | X | |  | |  | |  |
| 6 | Check Abrasion on Flexible Hose | | Visual Check | | X | |  | |  | |  |
| 7 | Abnormal Noise/Vibration | | Visual Check | | X | |  | |  | |  |
| 8 | Heat Exchanger | | Service | |  | | X | |  | |  |
| **B** | **ENTRY COIL REST** | | | | | | | | | | |
| 1 | Cradle | | Flaw | | X | |  | |  | |  |
| 2 | Gear Motor | | Noise | |  | | X | |  | |  |
| **C** | **ENTRY COIL SADDLE** | | | | | | | | | | |
| 1 | Plummer Block | | Greasing | |  | | X | |  | |  |
| 2 | Bearing | | Greasing | |  | | X | |  | |  |
| 3 | Pillow Block | | Greasing | |  | | X | |  | |  |
| 4 | Sprocket Shaft for Chain Tension | | Greasing | |  | | X | |  | |  |
| 5 | Roller Chain for Drive | | Greasing | |  | | X | |  | |  |
| 6 | Roller Chain for Cradle Roll | | Greasing | |  | | X | |  | |  |
| 7 | Gear Coupling | | Greasing | |  | | X | |  | |  |
| **D** | **ENTRY COIL CAR** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Oil Leakages | | X | |  | |  | |  |
| 2 | Wheels, Chain, Sprocket | | Wear | |  | | X | |  | |  |
| 3 | Gear Motor | | Noise | |  | | X | |  | |  |
| 4 | Guide Rod | | Greasing | |  | | X | |  | |  |
| 5 | Bearing | | Greasing | |  | | X | |  | |  |
| 6 | Bearing | | Greasing | |  | | X | |  | |  |
| 7 | Cam Follower | | Greasing | |  | | X | |  | |  |
| 8 | Gear & Luck for PLG | | Greasing | |  | | X | |  | |  |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** |
| 9 | Roller Chain for Drive | | Greasing | |  | | X | |  | |  |
| 10 | Cam Follower | | Greasing | |  | | X | |  | |  |
| **E** | **PAYOFF REEL** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Roll | | Condition | | X | |  | |  | |  |
| 4 | Slide Base, Liner | | Wear | |  | | X | |  | |  |
| 5 | Bearing | | Noise | |  | | X | |  | |  |
| 6 | Wheels, Chain, Sprocket | | Wear | |  | | X | |  | |  |
| 7 | Transfer Pump | | Inspection | |  | | X | |  | |  |
| 8 | Gear Motor | | Noise | |  | | X | |  | |  |
| 9 | Shifting Cylinder Liner | | Greasing | |  | | X | |  | |  |
| 10 | Mandrel Segment, Pin | | Greasing | |  | | X | |  | |  |
| 11 | Mandrel Sleeve, Pin | | Greasing | |  | | X | |  | |  |
| 12 | Mandrel Sleeve, Forward | | Greasing | |  | | X | |  | |  |
| 13 | Mandrel Sleeve | | Greasing | |  | | X | |  | |  |
| 14 | Mandrel Bearing Housing | | Greasing | |  | | X | |  | |  |
| **F** | **PAYOFF REEL SNUBBER ROLL** | | | | | | | | | | |
| 1 | Bearing Unit, Drive | | Greasing | |  | | X | |  | |  |
| 2 | Bearing Unit, Roll | | Greasing | |  | | X | |  | |  |
| 3 | Housing No. 2 - 3 | | Greasing | |  | | X | |  | |  |
| **G** | **PAYOFF REEL PRESSURE ROLL** | | | | | | | | | | |
| 1 | Shaft | | Greasing | |  | | X | |  | |  |
| 2 | Cover for Roll | | Greasing | |  | | X | |  | |  |
| 3 | Housing No. 26, No. 27 | | Greasing | |  | | X | |  | |  |
| **H** | **PAYOFF REEL OUTBOARD** | | | | | | | | | | |
| 1 | Shaft for Roller | | Greasing | |  | | X | |  | |  |
| 2 | Pin, No. 22, No. 27, No. 29, No. 30, No. 31 | | Greasing | |  | | X | |  | |  |
| **I** | **ENTRY PINCH ROLL & COIL PEELER** | | | | | | | | | | |
| 1 | Roll | | Condition | | X | |  | |  | |  |
| 2 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 3 | Bearing | | Noise | | X | |  | |  | |  |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** |
| 4 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 5 | Gear Motor | | Noise | |  | | X | |  | |  |
| 6 | Bearing for Pinch Roll | | Greasing | |  | | X | |  | |  |
| 7 | Chock Guide | | Greasing | |  | | X | |  | |  |
| 8 | Universal Joint, Upper & Bottom | | Greasing | |  | | X | |  | |  |
| **J** | **FLATTENER** | | | | | | | | | | |
| 1 | Bearing | | Noise | | X | |  | |  | |  |
| 2 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 3 | Roll | | Condition | | X | |  | |  | |  |
| 4 | Clutch | | Inspection | |  | | X | |  | |  |
| 5 | Gear Pump | | Inspection | |  | | X | |  | |  |
| 6 | Gear Motor | | Noise | |  | | X | |  | |  |
| 7 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 8 | Worm Jack | | Inspection | |  | | X | |  | |  |
| 9 | Worm Jack | | Greasing | |  | | X | |  | |  |
| 10 | Upper Roll Chock, Left & Right | | Greasing | |  | | X | |  | |  |
| 11 | Guide Roll & Bearing for Lower Roll, Left | | Greasing | |  | | X | |  | |  |
| 12 | Guide Roll & Bearing for Lower Roll, Right | | Greasing | |  | | X | |  | |  |
| 13 | Chain for Worm Jack | | Greasing | |  | | X | |  | |  |
| 14 | Universal Joint, (3) Upper & (3) Bottom | | Greasing | |  | | X | |  | |  |
| 15 | Gear Coupling | | Greasing | |  | | X | |  | |  |
| 16 | Grid Coupling | | Greasing | |  | | X | |  | |  |
| **K** | **ENTRY STRIP CENTERING DRVICE** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Gear Motor | | Noise | |  | | X | |  | |  |
| 4 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 5 | Pin/Spacer | | Greasing | |  | | X | |  | |  |
| 6 | Pillow Block | | Greasing | |  | | X | |  | |  |
| 7 | Guide Box | | Greasing | |  | | X | |  | |  |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** |
| 8 | Gear Coupling | | Greasing | |  | | X | |  | |  |
| **L** | **ENTRY SHEAR** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Booker Pin | | Inspection | | X | |  | |  | |  |
| 3 | Roll | | Condition | | X | |  | |  | |  |
| 4 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 5 | Gear Motor | | Noise | |  | | X | |  | |  |
| 6 | Knife | | Inspection, Clearance | |  | | X | |  | |  |
| 7 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 8 | Knife Holder | | Greasing | |  | | X | |  | |  |
| 9 | Arm | | Greasing | |  | | X | |  | |  |
| 10 | Bearing for Pinch Roll | | Greasing | |  | | X | |  | |  |
| 11 | Chock Guide | | Greasing | |  | | X | |  | |  |
| 12 | Universal Joint | | Greasing | |  | | X | |  | |  |
| **M** | **TAPER SHEAR** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Roll | | Condition | | X | |  | |  | |  |
| 3 | Knife | | Inspection, Clearance | |  | | X | |  | |  |
| 4 | Knife Holder | | Greasing | |  | | X | |  | |  |
| 5 | Arm | | Greasing | |  | | X | |  | |  |
| **N** | **ENTRY SCRAP DISPOSAL EQUIPMENT** | | | | | | | | | | |
| 1 | Roll | | Condition | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Gear Motor | | Noise | |  | | X | |  | |  |
| 4 | Wheels, Chain, Sprocket | | Wear | |  | | X | |  | |  |
| 5 | Pillow Block | | Greasing | |  | | X | |  | |  |
| 6 | Roller Chain for Drive | | Greasing | |  | | X | |  | |  |
| **O** | **TRANSFER TABLE WITH PINCH ROLL** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Roll | | Condition | | X | |  | |  | |  |
| 3 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 4 | Bearing | | Noise | |  | | X | |  | |  |
| 5 | Gear Motor | | Noise | |  | | X | |  | |  |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** |
| 6 | Bearing for Pinch Roll | | Greasing | |  | | X | |  | |  |
| 7 | Chock Guide | | Greasing | |  | | X | |  | |  |
| 8 | Universal Joint, Upper & Bottom | | Greasing | |  | | X | |  | |  |
| **CENTER SECTION** | | | | | | | | | | | |
| **P** | **RINSE TANK** | | | | | | | | | | |
| 1 | Header and Support | | Cleaning and replacement of damage nozzle | |  | | X | |  | |  |
| 2 | Granite Block | | Inspection | |  | | X | |  | |  |
| **Q** | **WRINGER ROLL # 01** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 4 | Roll | | Condition | |  | | X | |  | |  |
| 5 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 6 | Gear Motor | | Noise | |  | | X | |  | |  |
| 7 | Hand Grease Point | | Greasing | |  | | X | |  | |  |
| 8 | Universal Joint | | Greasing | |  | | X | |  | |  |
| **R** | **WRINGER ROLL # 02** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 4 | Roll | | Condition | |  | | X | |  | |  |
| 5 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 6 | Gear Motor | | Noise | |  | | X | |  | |  |
| 7 | Hand Grease Point | | Greasing | |  | | X | |  | |  |
| 8 | Universal Joint | | Greasing | |  | | X | |  | |  |
| **S** | **WRINGER ROLL # 03** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 4 | Roll | | Condition | |  | | X | |  | |  |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** |
| 5 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 6 | Gear Motor | | Noise | |  | | X | |  | |  |
| 7 | Hand Grease Point | | Greasing | |  | | X | |  | |  |
| 8 | Universal Joint | | Greasing | |  | | X | |  | |  |
| **T** | **WRINGER ROLL # 04** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 4 | Roll | | Condition | |  | | X | |  | |  |
| 5 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 6 | Gear Motor | | Noise | |  | | X | |  | |  |
| 7 | Hand Grease Point | | Greasing | |  | | X | |  | |  |
| 8 | Universal Joint | | Greasing | |  | | X | |  | |  |
| **U** | **WRINGER ROLL # 05** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 4 | Roll | | Condition | |  | | X | |  | |  |
| 5 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 6 | Gear Motor | | Noise | |  | | X | |  | |  |
| 7 | Hand Grease Point | | Greasing | |  | | X | |  | |  |
| 8 | Universal Joint | | Greasing | |  | | X | |  | |  |
| **V** | **WRINGER ROLL # 06** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 4 | Roll | | Condition | |  | | X | |  | |  |
| 5 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 6 | Gear Motor | | Noise | |  | | X | |  | |  |
| 7 | Hand Grease Point | | Greasing | |  | | X | |  | |  |
| 8 | Universal Joint | | Greasing | |  | | X | |  | |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| **W** | **WRINGER ROLL # 07** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 4 | Roll | | Condition | |  | | X | |  | |  |
| 5 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 6 | Gear Motor | | Noise | |  | | X | |  | |  |
| 7 | Hand Grease Point | | Greasing | |  | | X | |  | |  |
| 8 | Universal Joint | | Greasing | |  | | X | |  | |  |
| **X** | **WRINGER ROLL # 08** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 4 | Roll | | Condition | |  | | X | |  | |  |
| 5 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 6 | Gear Motor | | Noise | |  | | X | |  | |  |
| 7 | Hand Grease Point | | Greasing | |  | | X | |  | |  |
| 8 | Universal Joint | | Greasing | |  | | X | |  | |  |
| **Y** | **WRINGER ROLL # 09** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 4 | Roll | | Condition | |  | | X | |  | |  |
| 5 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 6 | Gear Motor | | Noise | |  | | X | |  | |  |
| 7 | Hand Grease Point | | Greasing | |  | | X | |  | |  |
| 8 | Universal Joint | | Greasing | |  | | X | |  | |  |
| **Z** | **WRINGER ROLL # 10** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 4 | Roll | | Condition | |  | | X | |  | |  |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** |
| 5 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 6 | Gear Motor | | Noise | |  | | X | |  | |  |
| 7 | Hand Grease Point | | Greasing | |  | | X | |  | |  |
| 8 | Universal Joint | | Greasing | |  | | X | |  | |  |
| **AA** | **WRINGER ROLL # 11** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 4 | Roll | | Condition | |  | | X | |  | |  |
| 5 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 6 | Gear Motor | | Noise | |  | | X | |  | |  |
| 7 | Hand Grease Point | | Greasing | |  | | X | |  | |  |
| 8 | Universal Joint | | Greasing | |  | | X | |  | |  |
| **AB** | **ACID CIRCULATION TANK 01** | | | | | | | | | | |
| 1 | Tank | | Inspection | |  | | X | |  | |  |
| **AC** | **ACID CIRCULATION TANK 02** | | | | | | | | | | |
| 1 | Tank | | Inspection | |  | | X | |  | |  |
| **AD** | **ACID CIRCULATION TANK 03** | | | | | | | | | | |
| 1 | Tank | | Inspection | |  | | X | |  | |  |
| **AE** | **ACID CIRCULATION PUMP # 101** | | | | | | | | | | |
| 1 | Strainer | | Cleaning | | X | |  | |  | |  |
| 2 | Tank, Pump, Valve, Piping connection, etc. | | Leakage | | X | |  | |  | |  |
| 3 | Abnormal Noise/Vibration | | Visual Check | | X | |  | |  | |  |
| **AF** | **ACID CIRCULATION PUMP # 102** | | | | | | | | | | |
| 1 | Strainer | | Cleaning | | X | |  | |  | |  |
| 2 | Tank, Pump, Valve, Piping connection, etc. | | Leakage | | X | |  | |  | |  |
| 3 | Abnormal Noise/Vibration | | Visual Check | | X | |  | |  | |  |
| **AG** | **ACID CIRCULATION PUMP # 103** | | | | | | | | | | |
| 1 | Strainer | | Cleaning | | X | |  | |  | |  |
| 2 | Tank, Pump, Valve, Piping connection, etc. | | Leakage | | X | |  | |  | |  |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** |
| 3 | Abnormal Noise/Vibration | | Visual Check | | X | |  | |  | |  |
| **AH** | **ACID CIRCULATION PUMP # 104** | | | | | | | | | | |
| 1 | Strainer | | Cleaning | | X | |  | |  | |  |
| 2 | Tank, Pump, Valve, Piping connection, etc. | | Leakage | | X | |  | |  | |  |
| 3 | Abnormal Noise/Vibration | | Visual Check | | X | |  | |  | |  |
| **AI** | **ACID CIRCULATION PUMP # 105** | | | | | | | | | | |
| 1 | Strainer | | Cleaning | | X | |  | |  | |  |
| 2 | Tank, Pump, Valve, Piping connection, etc. | | Leakage | | X | |  | |  | |  |
| 3 | Abnormal Noise/Vibration | | Visual Check | | X | |  | |  | |  |
| **AJ** | **RINSE PUMP 101** | | | | | | | | | | |
| 1 | Strainer | | Cleaning | | X | |  | |  | |  |
| 2 | Tank, Pump, Valve, Piping connection, etc. | | Leakage | | X | |  | |  | |  |
| 3 | Abnormal Noise/Vibration | | Visual Check | | X | |  | |  | |  |
| **AK** | **RINSE PUMP 102** | | | | | | | | | | |
| 1 | Strainer | | Cleaning | | X | |  | |  | |  |
| 2 | Tank, Pump, Valve, Piping connection, etc. | | Leakage | | X | |  | |  | |  |
| 3 | Abnormal Noise/Vibration | | Visual Check | | X | |  | |  | |  |
| **AL** | **RINSE PUMP 103** | | | | | | | | | | |
| 1 | Strainer | | Cleaning | | X | |  | |  | |  |
| 2 | Tank, Pump, Valve, Piping connection, etc. | | Leakage | | X | |  | |  | |  |
| 3 | Abnormal Noise/Vibration | | Visual Check | | X | |  | |  | |  |
| **AM** | **RINSE PUMP 104** | | | | | | | | | | |
| 1 | Strainer | | Cleaning | | X | |  | |  | |  |
| 2 | Tank, Pump, Valve, Piping connection, etc. | | Leakage | | X | |  | |  | |  |
| 3 | Abnormal Noise/Vibration | | Visual Check | | X | |  | |  | |  |
| **AN** | **RINSE PUMP 105** | | | | | | | | | | |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** |
| 1 | Strainer | | Cleaning | | X | |  | |  | |  |
| 2 | Tank, Pump, Valve, Piping connection, etc. | | Leakage | | X | |  | |  | |  |
| 3 | Abnormal Noise/Vibration | | Visual Check | | X | |  | |  | |  |
| **AO** | **RINSE PUMP 106** | | | | | | | | | | |
| 1 | Strainer | | Cleaning | | X | |  | |  | |  |
| 2 | Tank, Pump, Valve, Piping connection, etc. | | Leakage | | X | |  | |  | |  |
| 3 | Abnormal Noise/Vibration | | Visual Check | | X | |  | |  | |  |
| **AP** | **CONDENSATE COLLECTING TANK** | | | | | | | | | | |
| 1 | Tank, Pump, Valve, Piping connection, etc. | | Leakage | | X | |  | |  | |  |
| **AQ** | **SUMP PUMP** | | | | | | | | | | |
| 1 | NRV | | Cleaning | | X | |  | |  | |  |
| 2 | Tank, Pump, Valve, Piping connection, etc. | | Leakage | | X | |  | |  | |  |
| 3 | Abnormal Noise/Vibration | | Visual Check | | X | |  | |  | |  |
| **AR** | **FRESH ACID PUMP** | | | | | | | | | | |
| 1 | Tank, Pump, Valve, Piping connection, etc. | | Leakage | | X | |  | |  | |  |
| 2 | Abnormal Noise/Vibration | | Visual Check | | X | |  | |  | |  |
| **AS** | **COLLECTING PIT** | | | | | | | | | | |
| 1 | Pit | | Cleaning & Inspection | |  | | X | |  | |  |
| **AT** | **FUME EXHAUST SYSTEM** | | | | | | | | | | |
| 1 | FRP Line | | Inspection | | X | |  | |  | |  |
| 2 | Tank, Pump, Valve, Piping connection, etc. | | Leakage | | X | |  | |  | |  |
| 3 | Abnormal Noise/Vibration | | Visual Check | | X | |  | |  | |  |
| 4 | Belt | | Inspection | | X | |  | |  | |  |
| 5 | Bearing | | Noise | |  | | X | |  | |  |
| 6 | Expansion Bellow | | Inspection | |  | | X | |  | |  |
| **AU** | **STRIP DRYER SYSTEM** | | | | | | | | | | |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** |
| 1 | Abnormal Noise/Vibration | | Visual Check | | X | |  | |  | |  |
| 2 | Roll | | Condition | | X | |  | |  | |  |
| 3 | Bearing | | Noise | | X | |  | |  | |  |
| 4 | Expansion Bellow | | Inspection | |  | | X | |  | |  |
| 5 | Hand Grease Point | | Greasing | |  | | X | |  | |  |
| 6 | Roller Chain Coupling | | Greasing | |  | | X | |  | |  |
| **EXIT SECTION** | | | | | | | | | | | |
| **AV** | **EXIT STRIP CENTERING DEVICE** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Roll | | Condition | | X | |  | |  | |  |
| 3 | Bearing | | Noise | | X | |  | |  | |  |
| 4 | Gear Motor | | Noise | |  | | X | |  | |  |
| 5 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 6 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 7 | Pin / Spacer | | Greasing | |  | | X | |  | |  |
| 8 | Pillow Block | | Greasing | |  | | X | |  | |  |
| 9 | Guide Box | | Greasing | |  | | X | |  | |  |
| 10 | Gear Coupling | | Greasing | |  | | X | |  | |  |
| **AW** | **EXIT PINCH ROLL** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Roll | | Condition | | X | |  | |  | |  |
| 4 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 5 | Gear Motor | | Noise | |  | | X | |  | |  |
| 6 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 7 | Bearing for Pinch Roll | | Greasing | |  | | X | |  | |  |
| 8 | Chock Guide | | Greasing | |  | | X | |  | |  |
| 9 | Universal Joint, Upper & Bottom | | Greasing | |  | | X | |  | |  |
| **AX** | **STRIP TRANSFER TABLE** | | | | | | | | | | |
| 1 | Roll | | Condition | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| **AY** | **LOOPING PIT & CARRY OVER TABLE** | | | | | | | | | | |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Roll | | Condition | | X | |  | |  | |  |
| 4 | Pillow Block | | Greasing | |  | | X | |  | |  |
| **AZ** | **STRIP CENTERING DEVICE & HOLD DOWN ROLL** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Roll | | Condition | | X | |  | |  | |  |
| 4 | Gear Motor | | Noise | |  | | X | |  | |  |
| 5 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 6 | Bearing for Hold Down Roll | | Greasing | |  | | X | |  | |  |
| 7 | Pillow Block | | Greasing | |  | | X | |  | |  |
| 8 | Chock Guide | | Greasing | |  | | X | |  | |  |
| 9 | Gear Coupling | | Greasing | |  | | X | |  | |  |
| **BA** | **PINCH ROLL BEFORE SIDE TRIMMER** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Roll | | Condition | | X | |  | |  | |  |
| 4 | Gear Motor | | Noise | |  | | X | |  | |  |
| 5 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 6 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 7 | Bearing for Pinch Roll | | Greasing | |  | | X | |  | |  |
| 8 | Bearing | | Greasing | |  | | X | |  | |  |
| 9 | Chock Guide | | Greasing | |  | | X | |  | |  |
| 10 | Guide | | Greasing | |  | | X | |  | |  |
| 11 | Sliding Block | | Greasing | |  | | X | |  | |  |
| 12 | Universal Joint, Upper & Bottom | | Greasing | |  | | X | |  | |  |
| **BB** | **SIDE TRIMMER** | | | | | | | | | | |
| 1 | Bearing | | Noise | | X | |  | |  | |  |
| 2 | Roll | | Condition | | X | |  | |  | |  |
| 3 | Gear Motor | | Noise | |  | | X | |  | |  |
| 4 | Wheels, Chain, Sprocket | | Wear | |  | | X | |  | |  |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** |
| 5 | Knife | | Inspection, Clearance | |  | | X | |  | |  |
| 6 | Worm Jack | | Inspection | |  | | X | |  | |  |
| 7 | Slide Liner, WS-DS | | Greasing | |  | | X | |  | |  |
| 8 | Plummer Block, Bearing Case | | Greasing | |  | | X | |  | |  |
| 9 | Knife Shaft Bearing, Worm Wheel, Ball Screw Nut | | Greasing | |  | | X | |  | |  |
| 10 | Drive Shaft, WS-DS | | Greasing | |  | | X | |  | |  |
| 11 | Linipower Jack, WS-DS | | Greasing | |  | | X | |  | |  |
| 12 | Ball Joint, WS-DS | | Greasing | |  | | X | |  | |  |
| 13 | Chain & Sprocket | | Greasing | |  | | X | |  | |  |
| 14 | Pillow Block | | Greasing | |  | | X | |  | |  |
| 15 | Miter Gear | | Greasing | |  | | X | |  | |  |
| 16 | Gear Coupling | | Greasing | |  | | X | |  | |  |
| 17 | Gear Coupling | | Greasing | |  | | X | |  | |  |
| 18 | Gear Coupling | | Greasing | |  | | X | |  | |  |
| 19 | Gear Coupling | | Greasing | |  | | X | |  | |  |
| 20 | Thrust Bearing | | Greasing | |  | | X | |  | |  |
| **BC** | **EXIT BRIDLE ROLL** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Roll | | Rotating Condition | | X | |  | |  | |  |
| 4 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 5 | Roll | | Rotating Condition | |  | | X | |  | |  |
| 6 | Plummer Block for Snubber Roll | | Greasing | |  | | X | |  | |  |
| 7 | Plummer Block for No. 1 Roll | | Greasing | |  | | X | |  | |  |
| 8 | Chock | | Greasing | |  | | X | |  | |  |
| 9 | Bearing for No. 2 Roll | | Greasing | |  | | X | |  | |  |
| 10 | Chock | | Greasing | |  | | X | |  | |  |
| 11 | Plummer Block for No. 3 Roll | | Greasing | |  | | X | |  | |  |
| 12 | Universal Joint | | Greasing | |  | | X | |  | |  |
| 13 | Gear Coupling | | Greasing | |  | | X | |  | |  |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** |
| 14 | Gear Coupling | | Greasing | |  | | X | |  | |  |
| 15 | Gear Coupling | | Greasing | |  | | X | |  | |  |
| 16 | Gear Coupling | | Greasing | |  | | X | |  | |  |
| 17 | Gear Coupling | | Greasing | |  | | X | |  | |  |
| **BD** | **EXIT SHEAR** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Booker Pin | | Inspection | | X | |  | |  | |  |
| 3 | Roll | | Condition | | X | |  | |  | |  |
| 4 | Universal Joint Bolt | | Check & Tightening | |  | | X | |  | |  |
| 5 | Gear Motor | | Noise | |  | | X | |  | |  |
| 6 | Knife | | Inspection, Clearance | |  | | X | |  | |  |
| 7 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 8 | Knife Holder | | Greasing | |  | | X | |  | |  |
| 9 | Arm | | Greasing | |  | | X | |  | |  |
| 10 | Bearing for Pinch Roll | | Greasing | |  | | X | |  | |  |
| 11 | Universal Joint | | Greasing | |  | | X | |  | |  |
| **BE** | **SCRAP CHOPPER** | | | | | | | | | | |
| 1 | Slide Liner, WS-DS | | Greasing | |  | | X | |  | |  |
| 2 | Plummer Block, Bearing Case | | Greasing | |  | | X | |  | |  |
| 3 | Worm shaft bearing, Worm Wheel , Ball Screw Nut | | Greasing | |  | | X | |  | |  |
| 4 | Bush for Fly Wheel | | Greasing | |  | | X | |  | |  |
| 5 | Gear Coupling | | Greasing | |  | | X | |  | |  |
| 6 | Gear Coupling | | Greasing | |  | | X | |  | |  |
| **BF** | **EXIT SCRAP DISPOSAL EQUIPMENT** | | | | | | | | | | |
| 1 | Roll | | Condition | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Gear Motor | | Noise | |  | | X | |  | |  |
| 4 | Wheels, Chain, Sprocket | | Wear | |  | | X | |  | |  |
| 5 | Pillow Block | | Greasing | |  | | X | |  | |  |
| 6 | Roller Chain for Drive | | Greasing | |  | | X | |  | |  |
| **BG** | **OILER** | | | | | | | | | | |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** |
| 1 | Roll | | Condition | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 4 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 5 | Gear Pump | | Inspection | |  | | X | |  | |  |
| 6 | Strainer | | Service | |  | | X | |  | |  |
| 7 | Bearing for Pinch Roll | | Greasing | |  | | X | |  | |  |
| 8 | Chock Guide | | Greasing | |  | | X | |  | |  |
| **BH** | **DEFLECTOR ROLL** | | | | | | | | | | |
| 1 | Roll | | Condition | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 4 | Gear Motor | | Noise | |  | | X | |  | |  |
| 5 | Pillow Block for Hold Down Roll, O.P & D.S | | Greasing | |  | | X | |  | |  |
| 6 | Pillow Block for Pinch Roll, O.P & D.S | | Greasing | |  | | X | |  | |  |
| 7 | Threading Table, O.P & D.S | | Greasing | |  | | X | |  | |  |
| 8 | Plummer Block for Deflector Roll, O.P & D.S | | Greasing | |  | | X | |  | |  |
| 9 | Gear Coupling | | Greasing | |  | | X | |  | |  |
| **BI** | **TENSION REEL** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Bearing | | Noise | | X | |  | |  | |  |
| 3 | Roll | | Condition | | X | |  | |  | |  |
| 4 | Slide Base, Liner | | Wear | |  | | X | |  | |  |
| 5 | Transfer Pump | | Inspection | |  | | X | |  | |  |
| 6 | FRL Unit | | Drain, Regulator & Oil Level | |  | | X | |  | |  |
| 7 | Shifting Cylinder Liner | | Greasing | |  | | X | |  | |  |
| 8 | Stripper Housing | | Greasing | |  | | X | |  | |  |
| 9 | Stripper Claw | | Greasing | |  | | X | |  | |  |
| 10 | Mandrel Segment | | Greasing | |  | | X | |  | |  |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** |
| 11 | Mandrel Sub Gripper Segment | | Greasing | |  | | X | |  | |  |
| 12 | Mandrel Bearing Housing | | Greasing | |  | | X | |  | |  |
| **BJ** | **TENSION REEL SNUBBER ROLL** | | | | | | | | | | |
| 1 | Roll Pin | | Greasing | |  | | X | |  | |  |
| 2 | Housing | | Greasing | |  | | X | |  | |  |
| 3 | Bearing Unit | | Greasing | |  | | X | |  | |  |
| **BK** | **TENSION REEL OUTBOARD** | | | | | | | | | | |
| 1 | Shaft for Roller | | Greasing | |  | | X | |  | |  |
| 2 | Pin | | Greasing | |  | | X | |  | |  |
| **BL** | **EXIT COIL CAR** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | | Leakage | | X | |  | |  | |  |
| 2 | Roll | | Rotating Condition | |  | | X | |  | |  |
| 3 | Wheels, Chain, Sprocket | | Wear | |  | | X | |  | |  |
| 4 | Guide Rod | | Greasing | |  | | X | |  | |  |
| 5 | Bearing | | Greasing | |  | | X | |  | |  |
| 6 | Bearing | | Greasing | |  | | X | |  | |  |
| 7 | Cam Follower | | Greasing | |  | | X | |  | |  |
| 8 | Gear & Luck for PLG | | Greasing | |  | | X | |  | |  |
| 9 | Roller Chain for Drive | | Greasing | |  | | X | |  | |  |
| 10 | Cam Follower | | Greasing | |  | | X | |  | |  |
| **BM** | **EXIT COIL REST** | | | | | | | | | | |
| 1 | Cradle | | Flaw | | X | |  | |  | |  |
| **BN** | **EXIT HYDRAULIC UNIT** | | | | | | | | | | |
| 1 | Oiling | | Oil Pressure | | X | |  | |  | |  |
| 2 | Oiling | | Oil Temperature | | X | |  | |  | |  |
| 3 | Strainer | | Service | | X | |  | |  | |  |
| 4 | Oiling | | Oil Level | | X | |  | |  | |  |
| 5 | Tank, Pump, Valve, Piping connection, etc. | | Leakage | | X | |  | |  | |  |
| 6 | Check Abrasion on Flexible Hose | | Visual Check | | X | |  | |  | |  |
| 7 | Abnormal Noise/Vibration | | Visual Check | | X | |  | |  | |  |
| 8 | Heat Exchanger | | Service | |  | | X | |  | |  |

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| **COLD ROLLING SKINPASS MILL** | | | | | | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **A** | **PAYOFF REEL** | | | | | |
| 1 | Coil Car | Inspection of Wheel, Chain & Sprocket |  | X |  |  |
| 2 | Coil Skid | Liner Plate |  |  | X |  |
| 3 | Mandrel Gear Box | Inspection of Sliding Liner |  | X |  |  |
| 4 | Mandrel Gear Box | Clearance between Sliding Liner & Base |  |  | X |  |
| 5 | Mandrel Gear Coupling | Inspection |  |  | X |  |
| 6 | Hold Down Roll | Surface Condition & Rotation |  | X |  |  |
| 7 | Entry Pinch Roll | Surface Condition & Rotation |  | X |  |  |
| 8 | Entry Pinch Roll Screw Jack | Movement |  | X |  |  |
| 9 | Carry over Table | Inspection of Frame Pivot Bush |  | X |  |  |
| 10 | Entry Pinch Roll Gear Box | Abnormal Noise/Vibration |  |  | X |  |
| 11 | Entry Pinch Roll Screw Jack Coupling | Inspection |  |  | X |  |
| 12 | Mandrel Head (Segment) | Greasing | X |  |  |  |
| 13 | Mandrel Head (Sleeve) | Greasing | X |  |  |  |
| 14 | Gear Coupling | Greasing |  | X |  |  |
| 15 | Slide Gear Coupling | Greasing |  | X |  |  |
| 16 | Carry Over Table, Frame Pivot Bushing | Greasing |  | X |  |  |
| 17 | Hold Down Roll, Support Bushing | Greasing |  |  | X |  |
| 18 | Entry Pinch Roll Top Roll Bearing | Greasing |  | X |  |  |
| 19 | Entry Pinch Roll Leveling Roll Lift Drive Screw Jack | Greasing |  | X |  |  |
| 20 | Entry Pinch Roll Leveling Roll Bearing | Greasing |  | X |  |  |
| 21 | Entry Pinch Roll Leveling Roll Lift Guide Plate | Greasing |  | X |  |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| 22 | Entry Pinch Roll Top Roll Frame Pivot Bushing | Greasing |  | X |  |  |
| 23 | Entry Pinch Roll Top Roll Drive Gear Coupling | Greasing |  |  | X |  |
| 24 | Entry Pinch Roll Top Roll Drive Universal Joint | Greasing |  |  | X |  |
| 25 | Entry Pinch Roll Leveling Roll Lift Drive Gear Coupling | Greasing |  |  | X |  |
| 26 | Entry Pinch Roll Leveling Roll Lift Drive Gear Coupling | Greasing |  |  | X |  |
| 27 | POR Coil Car Lift Frame Guide Liner | Greasing |  | X |  |  |
| 28 | POR Coil Car Wheel | Greasing |  | X |  |  |
| 29 | POR Coil Car Pin Gear for Travelling | Greasing |  | X |  |  |
| 30 | POR Coil Car Chain & Sprocket for Drive | Greasing |  | X |  |  |
| **B** | **ENTRY TENSION REEL** | | | | | |
| 1 | Coil Car | Inspection of Wheel, Chain & Sprocket |  | X |  |  |
| 2 | Coil Car Cradle | Inspection of Chain & Sprocket |  | X |  |  |
| 3 | Coil Skid | Liner Plate |  |  | X |  |
| 4 | Mandrel Gear Box | Inspection of Sliding Liner |  | X |  |  |
| 5 | Mandrel Gear Box | Clearance between Sliding Liner & Base |  |  | X |  |
| 6 | Mandrel Gear Coupling | Inspection |  |  | X |  |
| 7 | Snubber Roll | Surface Condition & Rotation |  | X |  |  |
| 8 | Threading Table | Inspection of Frame Pivot Bush |  | X |  |  |
| 9 | Entry Deflector Roll | Surface Condition & Rotation |  | X |  |  |
| 10 | Mandrel Shaft Spline | Greasing | X |  |  |  |
| 11 | Mandrel Head Segment | Greasing | X |  |  |  |
| 12 | Mandrel Head Wedge | Greasing | X |  |  |  |
| 13 | Mandrel Head Segment | Greasing | X |  |  |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| 14 | Mandrel Head Support Bearing | Greasing | X |  |  |  |
| 15 | Outboard Swing Frame Support Roller Bearing | Greasing | X |  |  |  |
| 16 | Outboard Swing Frame Support Sheave | Greasing | X |  |  |  |
| 17 | Gear Coupling | Greasing |  | X |  |  |
| 18 | Slide Gear Coupling | Greasing |  | X |  |  |
| 19 | Entry Threading Table, Threading Table Pivot Bushing | Greasing |  | X |  |  |
| 20 | Entry Deflector Roll, Top Roll Bearing | Greasing |  | X |  |  |
| 21 | Entry Strip Guide, Screw Nut | Greasing |  | X |  |  |
| 22 | Entry Strip Guide | Greasing |  | X |  |  |
| 23 | Entry Strip Guide, Side Guide Adjust Sensor Pillow Block | Greasing |  |  | X |  |
| 24 | Entry Strip Guide, Chain & Sprocket for Drive | Greasing |  |  | X |  |
| 25 | Entry Strip Guide, Chain & Sprocket for Sensor | Greasing |  |  | X |  |
| 26 | Entry Deflector Roll, Top Roll Drive Universal Joint | Greasing |  |  | X |  |
| 27 | Car Wheel | Greasing |  | X |  |  |
| 28 | Lift Frame Guide Liner | Greasing |  | X |  |  |
| 29 | Cradle roll Bearing | Greasing |  | X |  |  |
| 30 | Pin Gear for Travelling | Greasing |  | X |  |  |
| 31 | Chain & Sprocket for Drive | Greasing |  | X |  |  |
| 32 | Cradle roll Chain & Sprocket for Drive | Greasing |  | X |  |  |
| 33 | Snubber Roll for Entry Tension Reel, Frame Pivot Bushing Greasing | Greasing |  | X |  |  |
| **C** | **MILL STAND** | | | | | |
| 1 | Entry Swivel Joint | Movement |  | X |  |  |
| 2 | Entry Strip Guide | Roll Movement |  | X |  |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| 3 | Entry Strip Guide | Inspection of Chain & Sprocket |  | X |  |  |
| 4 | Entry Strip Press | Liner Inspection |  |  | X |  |
| 5 | Pass Line Step Wedge | Movement |  |  | X |  |
| 6 | Pass Line Liner Wedge | Movement |  |  | X |  |
| 7 | Anti-Crimping Roll | Surface Condition & Rotation |  | X |  |  |
| 8 | Cross Brake Roll | Surface Condition & Rotation |  | X |  |  |
| 9 | Anti-Crimping Screw Jack | Movement |  | X |  |  |
| 10 | Cross Brake Screw Jack | Movement |  | X |  |  |
| 11 | Entry Cobble Guard | Movement |  |  | X |  |
| 12 | Delivery Cobble Guard | Movement |  |  | X |  |
| 13 | Coolant and Air Spray Nozzle | Inspection and Cleaning |  |  | X |  |
| 14 | Mill Top Drive Gear Coupling | Inspection |  |  | X |  |
| 15 | Mill Bottom Drive Gear Coupling | Inspection |  |  | X |  |
| 16 | Delivery Shear Knife | Clearance |  |  | X |  |
| 17 | Electric Shutter | Inspection of Chain & Sprocket |  |  | X |  |
| 18 | WR Bending Cylinder | Oil Leakage |  |  | X |  |
| 19 | BUR Balancing Cylinder | Oil Leakage |  |  | X |  |
| 20 | WR Keeper Plate | Oil Leakage |  |  | X |  |
| 21 | BUR Keeper Plate | Oil Leakage |  |  | X |  |
| 22 | WR Shifting Cylinder | Oil Leakage |  |  | X |  |
| 23 | Delivery Shear Knife | Inspection Cutting Edge |  | X |  |  |
| 24 | Delivery Shear | Inspection of Frame Slide Bush |  | X |  |  |
| 25 | Delivery Swivel Joint | Movement |  | X |  |  |
| 26 | Pass Line Adjust Screw Jack | Greasing |  | X |  |  |
| 27 | Mill Main Drive Universal Joint Slide Spline | Greasing |  | X |  |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| 28 | Mill Main Drive Universal Joint Roll Side | Greasing |  | X |  |  |
| 29 | Mill Main Drive Universal Joint Reducer Side | Greasing |  | X |  |  |
| 30 | Anti-Crimp Roll / Pivot Bearing | Greasing |  | X |  |  |
| 31 | Anti-Crimp Roll / 250 Roller Bearing | Greasing |  | X |  |  |
| 32 | Anti-Crimp Roll Ball Screw Jack | Greasing |  | X |  |  |
| 33 | Cross Brake Roll / Pivot Bearing | Greasing |  | X |  |  |
| 34 | Cross Brake Roll / 250 Roller Bearing | Greasing |  | X |  |  |
| 35 | Cross Brake Roll Ball Screw Jack | Greasing |  | X |  |  |
| 36 | Mill Main Drive Main Gear Coupling | Greasing |  | X |  |  |
| 37 | Mill Main Drive Main Gear Coupling | Greasing |  | X |  |  |
| 38 | Cold Rolling Skin pass Mill, Pass Line Adjust Gear Coupling | Greasing |  |  | X |  |
| **D** | **DELIVERY TENSION REEL** | | | | | |
| 1 | Delivery Deflector Roll | Surface Condition & Rotation |  | X |  |  |
| 2 | Threading Table | Inspection of Frame Pivot Bush |  | X |  |  |
| 3 | Mandrel Gear Coupling | Inspection |  |  | X |  |
| 4 | Coil Car | Inspection of Wheel, Chain & Sprocket |  | X |  |  |
| 5 | Coil Skid | Liner Plate |  |  | X |  |
| 6 | Mandrel Shaft Spline | Greasing | X |  |  |  |
| 7 | Mandrel Head Segment | Greasing | X |  |  |  |
| 8 | Mandrel Head Wedge | Greasing | X |  |  |  |
| 9 | Mandrel Head Segment | Greasing | X |  |  |  |
| 10 | Outboard Swing Frame Support Roller Bearing | Greasing | X |  |  |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| 11 | Delivery Deflector Roll, Top Roll Bearing | Greasing |  | X |  |  |
| 12 | Delivery Threading Table, Threading Table Pivot Bushing | Greasing |  | X |  |  |
| 13 | Delivery Tension Reel, Gear Coupling | Greasing |  | X |  |  |
| 14 | Delivery Shear, Top Knife Frame Slid Bushing | Greasing |  |  | X |  |
| 15 | Delivery Deflector Roll, Top Roll Drive Universal Joint | Greasing |  |  | X |  |
| 16 | Lift Frame Guide Liner | Greasing |  | X |  |  |
| 17 | Cradle roll Bearing | Greasing |  | X |  |  |
| 18 | Car Wheel | Greasing |  | X |  |  |
| 19 | Pin Gear for Travelling | Greasing |  | X |  |  |
| 20 | Chain & Sprocket for Drive | Greasing |  | X |  |  |
| **E** | **ROLL CHANGING DEVICE** | | | | | |
| 1 | Changing Car Drive | Inspection of Chain & Sprocket |  | X |  |  |
| 2 | Changing Car Drive Gear Coupling | Inspection |  |  | X |  |
| 3 | Changing Car Rack | Inspection |  |  | X |  |
| 4 | Push Puller | Inspection of Chain & Sprocket |  | X |  |  |
| 5 | Push Puller Rack | Inspection |  |  | X |  |
| 6 | Car Clamp | Greasing |  | X |  |  |
| 7 | WR Shift Frame Roller Way | Greasing |  | X |  |  |
| 8 | Push Puller Drive Shaft Support Bearing | Greasing |  | X |  |  |
| 9 | Changing Car Rack | Greasing |  | X |  |  |
| 10 | Push Puller Rack | Greasing |  | X |  |  |
| 11 | Changing Car Drive Gear Coupling | Greasing |  |  | X |  |
| 12 | Changing Car Wheel Plummer Block | Greasing |  |  | X |  |
| 13 | Push Puller Sensor Pillow Block | Greasing |  |  | X |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| 14 | Push Puller Power Cylinder | Greasing |  |  | X |  |
| 15 | Push Puller Wheel Cam Follower | Greasing |  |  | X |  |
| 16 | Changing Car Drive Chain & Sprocket | Greasing |  |  | X |  |
| 17 | Push Puller Sensor Chain & Sprocket | Greasing |  |  | X |  |
| **F** | **HYDRAULIC SYSTEM** | | | | | |
| 1 | AGC Pump # 01 | Abnormal Noise/Vibration |  | X |  |  |
| 2 | AGC Pump # 02 | Abnormal Noise/Vibration |  | X |  |  |
| 3 | AGC Heat Exchanger | Cleaning |  |  | X |  |
| 4 | AGC Tank | Cleaning |  |  | X |  |
| 5 | AGC Accumulator | Check Pressure |  |  | X |  |
| 6 | Auxiliary Pump # 01 | Abnormal Noise/Vibration |  | X |  |  |
| 7 | Auxiliary Pump # 02 | Abnormal Noise/Vibration |  | X |  |  |
| 8 | Auxiliary Pump # 03 | Abnormal Noise/Vibration |  | X |  |  |
| 9 | Auxiliary Heat Exchanger | Cleaning |  |  | X |  |
| 10 | Auxiliary Tank | Cleaning |  |  | X |  |
| 11 | Auxiliary Accumulator | Check Pressure |  |  | X |  |
| **G** | **CIRCULATION OIL SYSTEM** | | | | | |
| 1 | Pump # 01 | Abnormal Noise/Vibration |  | X |  |  |
| 2 | Pump # 02 | Abnormal Noise/Vibration |  | X |  |  |
| 3 | Filter # 01 | Cleaning |  | X |  |  |
| 4 | Filter # 02 | Cleaning |  | X |  |  |
| 5 | Flow Switch POR | Inspection |  | X |  |  |
| 6 | Flow Switch ETR | Inspection |  | X |  |  |
| 7 | Flow Switch Mill Main Drive | Inspection |  | X |  |  |
| 8 | Flow Switch DTR | Inspection |  | X |  |  |
| 9 | Heat Exchanger | Cleaning |  |  | X |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **H** | **ROLL COOLANT SYSTEM** | | | | | |
| 1 | Main Emulsion Tank Agitator # 01 | Inspection of Belt, Abnormal Sound |  | X |  |  |
| 2 | Main Emulsion Tank Agitator # 02 | Inspection of Belt, Abnormal Sound |  | X |  |  |
| 3 | Emulsion Pump # 01 | Abnormal Noise/Vibration |  | X |  |  |
| 4 | Emulsion Pump # 02 | Abnormal Noise/Vibration |  | X |  |  |
| 5 | Emulsion Pump # 03 | Abnormal Noise/Vibration |  | X |  |  |
| 6 | Emulsion Pump # 04 | Abnormal Noise/Vibration |  | X |  |  |
| 7 | Emulsion Return Tank Agitator | Inspection of Belt, Abnormal Sound |  | X |  |  |
| 8 | Return Pump # 01 | Abnormal Noise/Vibration |  | X |  |  |
| 9 | Return Pump # 02 | Abnormal Noise/Vibration |  | X |  |  |
| 10 | Return Pump # 03 | Abnormal Noise/Vibration |  | X |  |  |
| 11 | Wet Skin pass Tank Agitator | Inspection of Belt, Abnormal Sound |  | X |  |  |
| 12 | Wet Skin pass Pump # 01 | Abnormal Noise/Vibration |  | X |  |  |
| 13 | Wet Skin pass Pump # 02 | Abnormal Noise/Vibration |  | X |  |  |
| 14 | Celler Sump Pump # 01 | Abnormal Noise/Vibration |  | X |  |  |
| 15 | Celler Sump Pump # 02 | Abnormal Noise/Vibration |  | X |  |  |
| 16 | Coolant Yards Sump Pump # 01 | Abnormal Noise/Vibration |  | X |  |  |
| 17 | Coolant Yards Sump Pump # 02 | Abnormal Noise/Vibration |  | X |  |  |
| 18 | Mill Wash Pump # 01 | Abnormal Noise/Vibration |  | X |  |  |
| 19 | Mill Wash Pump # 02 | Abnormal Noise/Vibration |  | X |  |  |
| 20 | Magnetic Separator | Inspection of Chain & Sprocket |  | X |  |  |
| 21 | Flat Bed Filter Blower | Abnormal Noise/Vibration |  | X |  |  |
| 22 | Fume Exhaust System | Inspection of Filter |  | X |  |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| 23 | Fume Exhaust System | Cleaning of inside duct |  |  | X |  |
| 24 | Fume Exhaust System | Inspection of Steam Spray Nozzle |  |  | X |  |
| 25 | Celler Ventilation Fan | Inspection of Belt, Abnormal Sound |  | X |  |  |
| 26 | Roll Coolant System, Magnet Separator Drive Chain & Sprocket | Greasing |  |  | X |  |
| 27 | Roll Coolant System, Magnet Separator Plummer Block | Greasing |  |  | X |  |
| 28 | Roll Coolant System, Flat Bed Vacuum Filter Chain & Sprocket | Greasing |  |  | X |  |
| 29 | Roll Coolant System, Flat Bed Vacuum Filter Pillow Block | Greasing |  |  | X |  |
| 30 | Fume Exhaust System, Fan Drive Shaft Support Bearing | Greasing |  | X |  |  |
| 31 | Fume Exhaust System, Mist Eliminator Damper Bearing | Greasing |  | X |  |  |
| 32 | Fume Exhaust System, Fume Exhaust Fan Damper Bearing | Greasing |  | X |  |  |
| 33 | Cellar Ventilation System, Fan Drive Shaft Pillow Block | Greasing |  | X |  |  |

|  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **BATCH ANNEALING FURNACE** | | | | | | | | | | | | |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| 1 | Work Base # 01 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 01 | |  | |  | |  | | X | |
| Clamping Position # 02 | |  | |  | |  | | X | |
| Clamping Position # 03 | |  | |  | |  | | X | |
| Clamping Position # 04 | |  | |  | |  | | X | |
| Clamping Position # 05 | |  | |  | |  | | X | |
| Clamping Position # 06 | |  | |  | |  | | X | |
| Clamping Position # 07 | |  | |  | |  | | X | |
| Clamping Position # 08 | |  | |  | |  | | X | |
| 2 | Work Base # 02 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 09 | |  | |  | |  | | X | |
| Clamping Position # 10 | |  | |  | |  | | X | |
| Clamping Position # 11 | |  | |  | |  | | X | |
| Clamping Position # 12 | |  | |  | |  | | X | |
| Clamping Position # 13 | |  | |  | |  | | X | |
| Clamping Position # 14 | |  | |  | |  | | X | |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
|  |  | | Clamping Position # 15 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 16 | |  | |  | |  | | X | |
| 3 | Work Base # 03 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 17 | |  | |  | |  | | X | |
| Clamping Position # 18 | |  | |  | |  | | X | |
| Clamping Position # 19 | |  | |  | |  | | X | |
| Clamping Position # 20 | |  | |  | |  | | X | |
| Clamping Position # 21 | |  | |  | |  | | X | |
| Clamping Position # 22 | |  | |  | |  | | X | |
| Clamping Position # 23 | |  | |  | |  | | X | |
| Clamping Position # 24 | |  | |  | |  | | X | |
| 4 | Work Base # 04 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 25 | |  | |  | |  | | X | |
| Clamping Position # 26 | |  | |  | |  | | X | |
| Clamping Position # 27 | |  | |  | |  | | X | |
| Clamping Position # 28 | |  | |  | |  | | X | |
| Clamping Position # 29 | |  | |  | |  | | X | |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
|  |  | | Clamping Position # 30 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 31 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 32 | |  | |  | |  | | X | |
| 5 | Work Base # 05 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 33 | |  | |  | |  | | X | |
| Clamping Position # 34 | |  | |  | |  | | X | |
| Clamping Position # 35 | |  | |  | |  | | X | |
| Clamping Position # 36 | |  | |  | |  | | X | |
| Clamping Position # 37 | |  | |  | |  | | X | |
| Clamping Position # 38 | |  | |  | |  | | X | |
| Clamping Position # 39 | |  | |  | |  | | X | |
| Clamping Position # 40 | |  | |  | |  | | X | |
| 6 | Work Base # 06 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 41 | |  | |  | |  | | X | |
| Clamping Position # 42 | |  | |  | |  | | X | |
| Clamping Position # 43 | |  | |  | |  | | X | |
| Clamping Position # 44 | |  | |  | |  | | X | |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
|  |  | | Clamping Position # 45 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 46 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 47 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 48 | |  | |  | |  | | X | |
| 7 | Work Base # 07 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 49 | |  | |  | |  | | X | |
| Clamping Position # 50 | |  | |  | |  | | X | |
| Clamping Position # 51 | |  | |  | |  | | X | |
| Clamping Position # 52 | |  | |  | |  | | X | |
| Clamping Position # 53 | |  | |  | |  | | X | |
| Clamping Position # 54 | |  | |  | |  | | X | |
| Clamping Position # 55 | |  | |  | |  | | X | |
| Clamping Position # 56 | |  | |  | |  | | X | |
| 8 | Work Base # 08 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 57 | |  | |  | |  | | X | |
| Clamping Position # 58 | |  | |  | |  | | X | |
| Clamping Position # 59 | |  | |  | |  | | X | |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
|  |  | | Clamping Position # 60 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 61 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 62 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 63 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 64 | |  | |  | |  | | X | |
| 9 | Work Base # 09 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 65 | |  | |  | |  | | X | |
| Clamping Position # 66 | |  | |  | |  | | X | |
| Clamping Position # 67 | |  | |  | |  | | X | |
| Clamping Position # 68 | |  | |  | |  | | X | |
| Clamping Position # 69 | |  | |  | |  | | X | |
| Clamping Position # 70 | |  | |  | |  | | X | |
| Clamping Position # 71 | |  | |  | |  | | X | |
| Clamping Position # 72 | |  | |  | |  | | X | |
| 10 | Work Base # 10 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 73 | |  | |  | |  | | X | |
| Clamping Position # 74 | |  | |  | |  | | X | |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
|  |  | | Clamping Position # 75 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 76 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 77 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 78 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 79 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 80 | |  | |  | |  | | X | |
| 11 | Work Base # 11 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 81 | |  | |  | |  | | X | |
| Clamping Position # 82 | |  | |  | |  | | X | |
| Clamping Position # 83 | |  | |  | |  | | X | |
| Clamping Position # 84 | |  | |  | |  | | X | |
| Clamping Position # 85 | |  | |  | |  | | X | |
| Clamping Position # 86 | |  | |  | |  | | X | |
| Clamping Position # 87 | |  | |  | |  | | X | |
| Clamping Position # 88 | |  | |  | |  | | X | |
| 12 | Work Base # 12 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 89 | |  | |  | |  | | X | |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
|  |  | | Clamping Position # 90 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 91 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 92 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 93 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 94 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 95 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 96 | |  | |  | |  | | X | |
| 13 | Work Base # 13 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 97 | |  | |  | |  | | X | |
| Clamping Position # 98 | |  | |  | |  | | X | |
| Clamping Position # 99 | |  | |  | |  | | X | |
| Clamping Position # 100 | |  | |  | |  | | X | |
| Clamping Position # 101 | |  | |  | |  | | X | |
| Clamping Position # 102 | |  | |  | |  | | X | |
| Clamping Position # 103 | |  | |  | |  | | X | |
| Clamping Position # 104 | |  | |  | |  | | X | |
| 14 | Work Base # 14 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
|  |  | | Clamping Position # 105 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 106 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 107 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 108 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 109 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 110 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 111 | |  | |  | |  | | X | |
|  |  | | Clamping Position # 112 | |  | |  | |  | | X | |
| 15 | Work Base # 15 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 113 | |  | |  | |  | | X | |
| Clamping Position # 114 | |  | |  | |  | | X | |
| Clamping Position # 115 | |  | |  | |  | | X | |
| Clamping Position # 116 | |  | |  | |  | | X | |
| Clamping Position # 117 | |  | |  | |  | | X | |
| Clamping Position # 118 | |  | |  | |  | | X | |
| Clamping Position # 119 | |  | |  | |  | | X | |
| Clamping Position # 120 | |  | |  | |  | | X | |
| 16 | Work Base # 16 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 121 | |  | |  | |  | | X | |
| Clamping Position # 122 | |  | |  | |  | | X | |
| Clamping Position # 123 | |  | |  | |  | | X | |
| Clamping Position # 124 | |  | |  | |  | | X | |
| Clamping Position # 125 | |  | |  | |  | | X | |
| Clamping Position # 126 | |  | |  | |  | | X | |
| Clamping Position # 127 | |  | |  | |  | | X | |
| Clamping Position # 128 | |  | |  | |  | | X | |
| 17 | Work Base # 17 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 129 | |  | |  | |  | | X | |
| Clamping Position # 130 | |  | |  | |  | | X | |
| Clamping Position # 131 | |  | |  | |  | | X | |
| Clamping Position # 132 | |  | |  | |  | | X | |
| Clamping Position # 133 | |  | |  | |  | | X | |
| Clamping Position # 134 | |  | |  | |  | | X | |
| Clamping Position # 135 | |  | |  | |  | | X | |
| Clamping Position # 136 | |  | |  | |  | | X | |
| 18 | Work Base # 18 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 137 | |  | |  | |  | | X | |
| Clamping Position # 138 | |  | |  | |  | | X | |
| Clamping Position # 139 | |  | |  | |  | | X | |
| Clamping Position # 140 | |  | |  | |  | | X | |
| Clamping Position # 141 | |  | |  | |  | | X | |
| Clamping Position # 142 | |  | |  | |  | | X | |
| Clamping Position # 143 | |  | |  | |  | | X | |
| Clamping Position # 144 | |  | |  | |  | | X | |
| 19 | Work Base # 19 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 145 | |  | |  | |  | | X | |
| Clamping Position # 146 | |  | |  | |  | | X | |
| Clamping Position # 147 | |  | |  | |  | | X | |
| Clamping Position # 148 | |  | |  | |  | | X | |
| Clamping Position # 149 | |  | |  | |  | | X | |
| Clamping Position # 150 | |  | |  | |  | | X | |
| Clamping Position # 151 | |  | |  | |  | | X | |
| Clamping Position # 152 | |  | |  | |  | | X | |
| 20 | Work Base # 20 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 153 | |  | |  | |  | | X | |
| Clamping Position # 154 | |  | |  | |  | | X | |
| Clamping Position # 155 | |  | |  | |  | | X | |
| Clamping Position # 156 | |  | |  | |  | | X | |
| Clamping Position # 157 | |  | |  | |  | | X | |
| Clamping Position # 158 | |  | |  | |  | | X | |
| Clamping Position # 159 | |  | |  | |  | | X | |
| Clamping Position # 160 | |  | |  | |  | | X | |
| 21 | Work Base # 21 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 161 | |  | |  | |  | | X | |
| Clamping Position # 162 | |  | |  | |  | | X | |
| Clamping Position # 163 | |  | |  | |  | | X | |
| Clamping Position # 164 | |  | |  | |  | | X | |
| Clamping Position # 165 | |  | |  | |  | | X | |
| Clamping Position # 166 | |  | |  | |  | | X | |
| Clamping Position # 167 | |  | |  | |  | | X | |
| Clamping Position # 168 | |  | |  | |  | | X | |
| 22 | Work Base # 22 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 169 | |  | |  | |  | | X | |
| Clamping Position # 170 | |  | |  | |  | | X | |
| Clamping Position # 171 | |  | |  | |  | | X | |
| Clamping Position # 172 | |  | |  | |  | | X | |
| Clamping Position # 173 | |  | |  | |  | | X | |
| Clamping Position # 174 | |  | |  | |  | | X | |
| Clamping Position # 175 | |  | |  | |  | | X | |
| Clamping Position # 176 | |  | |  | |  | | X | |
| 23 | Work Base # 23 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 177 | |  | |  | |  | | X | |
| Clamping Position # 178 | |  | |  | |  | | X | |
| Clamping Position # 179 | |  | |  | |  | | X | |
| Clamping Position # 180 | |  | |  | |  | | X | |
| Clamping Position # 181 | |  | |  | |  | | X | |
| Clamping Position # 182 | |  | |  | |  | | X | |
| Clamping Position # 183 | |  | |  | |  | | X | |
| Clamping Position # 184 | |  | |  | |  | | X | |
| 24 | Work Base # 24 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 185 | |  | |  | |  | | X | |
| Clamping Position # 186 | |  | |  | |  | | X | |
| Clamping Position # 187 | |  | |  | |  | | X | |
| Clamping Position # 188 | |  | |  | |  | | X | |
| Clamping Position # 189 | |  | |  | |  | | X | |
| Clamping Position # 190 | |  | |  | |  | | X | |
| Clamping Position # 191 | |  | |  | |  | | X | |
| Clamping Position # 192 | |  | |  | |  | | X | |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| 25 | Work Base # 25 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 193 | |  | |  | |  | | X | |
| Clamping Position # 194 | |  | |  | |  | | X | |
| Clamping Position # 195 | |  | |  | |  | | X | |
| Clamping Position # 196 | |  | |  | |  | | X | |
| Clamping Position # 197 | |  | |  | |  | | X | |
| Clamping Position # 198 | |  | |  | |  | | X | |
| Clamping Position # 199 | |  | |  | |  | | X | |
| Clamping Position # 200 | |  | |  | |  | | X | |
| 26 | Work Base # 26 | | Cleaning Of Cooling Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Hydrogen Line | |  | |  | | X | |  | |
| Cleaning Of Filter of Natural Gas Line | |  | |  | | X | |  | |
| Cleaning of Outboard Burner | |  | |  | | X | |  | |
| Inspection of SH Flange Seal | |  | |  | | X | |  | |
| Clamping Position # 201 | |  | |  | |  | | X | |
| Clamping Position # 202 | |  | |  | |  | | X | |
| Clamping Position # 203 | |  | |  | |  | | X | |
| Clamping Position # 204 | |  | |  | |  | | X | |
| Clamping Position # 205 | |  | |  | |  | | X | |
| Clamping Position # 206 | |  | |  | |  | | X | |
| Clamping Position # 207 | |  | |  | |  | | X | |
| Clamping Position # 208 | |  | |  | |  | | X | |
| **S.NO.** | **LOCATION** | | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| 27 | Heating Bell # 01 | | Inspection of Braided Seal | |  | |  | | X | |  | |
| Inspection of Insulation | |  | |  | | X | |  | |
| 28 | Heating Bell # 02 | | Inspection of Braided Seal | |  | |  | | X | |  | |
| Inspection of Insulation | |  | |  | | X | |  | |
| 29 | Heating Bell # 03 | | Inspection of Braided Seal | |  | |  | | X | |  | |
| Inspection of Insulation | |  | |  | | X | |  | |
| 30 | Heating Bell # 04 | | Inspection of Braided Seal | |  | |  | | X | |  | |
| Inspection of Insulation | |  | |  | | X | |  | |
| 31 | Heating Bell # 05 | | Inspection of Braided Seal | |  | |  | | X | |  | |
| Inspection of Insulation | |  | |  | | X | |  | |
| 32 | Heating Bell # 06 | | Inspection of Braided Seal | |  | |  | | X | |  | |
| Inspection of Insulation | |  | |  | | X | |  | |
| 33 | Heating Bell # 07 | | Inspection of Braided Seal | |  | |  | | X | |  | |
| Inspection of Insulation | |  | |  | | X | |  | |
| 34 | Heating Bell # 08 | | Inspection of Braided Seal | |  | |  | | X | |  | |
| Inspection of Insulation | |  | |  | | X | |  | |
| 35 | Heating Bell # 09 | | Inspection of Braided Seal | |  | |  | | X | |  | |
| Inspection of Insulation | |  | |  | | X | |  | |
| 36 | Heating Bell # 10 | | Inspection of Braided Seal | |  | |  | | X | |  | |
| Inspection of Insulation | |  | |  | | X | |  | |
| 37 | Heating Bell # 11 | | Inspection of Braided Seal | |  | |  | | X | |  | |
| Inspection of Insulation | |  | |  | | X | |  | |
| 37 | Heating Bell # 12 | | Inspection of Braided Seal | |  | |  | | X | |  | |
| Inspection of Insulation | |  | |  | | X | |  | |
| 39 | Heating Bell # 13 | | Inspection of Braided Seal | |  | |  | | X | |  | |
| Inspection of Insulation | |  | |  | | X | |  | |
| 40 | Heating Bell # 14 | | Inspection of Braided Seal | |  | |  | | X | |  | |
| Inspection of Insulation | |  | |  | | X | |  | |
| 41 | Cooling Bell # 01 | | Inspection of Cooling Hoses | |  | |  | | X | |  | |
| Inspection of Blowers | |  | |  | | X | |  | |
| 42 | Cooling Bell # 02 | | Inspection of Cooling Hoses | |  | |  | | X | |  | |
| Inspection of Blowers | |  | |  | | X | |  | |
| 43 | Cooling Bell # 03 | | Inspection of Cooling Hoses | |  | |  | | X | |  | |
| Inspection of Blowers | |  | |  | | X | |  | |
| 44 | Cooling Bell # 04 | | Inspection of Cooling Hoses | |  | |  | | X | |  | |
| Inspection of Blowers | |  | |  | | X | |  | |
| 45 | Cooling Bell # 05 | | Inspection of Cooling Hoses | |  | |  | | X | |  | |
| Inspection of Blowers | |  | |  | | X | |  | |
| 46 | Cooling Bell # 06 | | Inspection of Cooling Hoses | |  | |  | | X | |  | |
| Inspection of Blowers | |  | |  | | X | |  | |
| 47 | Cooling Bell # 07 | | Inspection of Cooling Hoses | |  | |  | | X | |  | |
| Inspection of Blowers | |  | |  | | X | |  | |
| 48 | Cooling Bell # 08 | | Inspection of Cooling Hoses | |  | |  | | X | |  | |
| Inspection of Blowers | |  | |  | | X | |  | |
| 49 | Cooling Bell # 09 | | Inspection of Cooling Hoses | |  | |  | | X | |  | |
| Inspection of Blowers | |  | |  | | X | |  | |
| 50 | Cooling Bell # 10 | | Inspection of Cooling Hoses | |  | |  | | X | |  | |
| Inspection of Blowers | |  | |  | | X | |  | |
| 51 | Cooling Bell # 11 | | Inspection of Cooling Hoses | |  | |  | | X | |  | |
| Inspection of Blowers | |  | |  | | X | |  | |
| 52 | Cooling Bell # 12 | | Inspection of Cooling Hoses | |  | |  | | X | |  | |
| Inspection of Blowers | |  | |  | | X | |  | |
| 53 | Cooling Bell # 13 | | Inspection of Cooling Hoses | |  | |  | | X | |  | |
| Inspection of Blowers | |  | |  | | X | |  | |
| 54 | Cooling Bell # 14 | | Inspection of Cooling Hoses | |  | |  | | X | |  | |
| Inspection of Blowers | |  | |  | | X | |  | |
| **RE-COILING LINE** | | | | | | | | | | | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| **ENTRY SECTION** | | | | | | | | | | | |
| **A** | **POR HYDRAULIC UNIT** | | | | | | | | | | |
| 1 | Oiling | Oil Pressure | | X | |  | |  | |  | |
| 2 | Oiling | Oil Temperature | | X | |  | |  | |  | |
| 3 | Strainer | Service | | X | |  | |  | |  | |
| 4 | Oiling | Oil Level | | X | |  | |  | |  | |
| 5 | Tank, Pump, Valve, Piping connection, etc. | Leakage | | X | |  | |  | |  | |
| 6 | Check Abrasion on Flexible Hose | Visual Check | | X | |  | |  | |  | |
| 7 | Abnormal Noise/Vibration | Visual Check | | X | |  | |  | |  | |
| 8 | Heat Exchanger | Service | |  | | X | |  | |  | |
| **B** | **CPC HYDRAULIC UNIT** | | | | | | | | | | |
| 1 | Oiling | Oil Pressure | | X | |  | |  | |  | |
| 2 | Line Filter, Strainer | Service | | X | |  | |  | |  | |
| 3 | Oiling | Oil Level | | X | |  | |  | |  | |
| 4 | Tank, Pump, Valve, Piping connection, etc. | Leakage | | X | |  | |  | |  | |
| 5 | Check Abrasion on Flexible Hose | Visual Check | | X | |  | |  | |  | |
| 6 | Abnormal Noise/Vibration | Visual Check | | X | |  | |  | |  | |
| 7 | Heat Exchanger | Service | |  | | X | |  | |  | |
| **C** | **NO:1 COIL REST** | | | | | | | | | | |
| 1 | Cradle | Flaw | | X | |  | |  | |  | |
| **D** | **NO:1 COIL CAR** | | | | | | | | | | |
| 1 | Cradle | Flaw | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Oil Leakages | | X | |  | |  | |  | |
| 3 | Wheels, Chain, Sprocket | Wear | |  | | X | |  | |  | |
| 4 | Lift Frame Guide Liner | Greasing | |  | | X | |  | |  | |
| 5 | Car Wheel Bearing | Greasing | |  | | X | |  | |  | |
| 6 | Chain & Sprocket | Greasing | |  | | X | |  | |  | |
| 7 | Roller Bracket | Greasing | |  | | X | |  | |  | |
| **E** | **PAYOFF REEL** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| 2 | Oiling | Oil Level | | X | |  | |  | |  | |
| 3 | Slide Base, Liner | Wear | |  | | X | |  | |  | |
| 4 | Bearing | Noise | |  | | X | |  | |  | |
| 5 | Mandrel Bearing | Greasing | |  | | X | |  | |  | |
| 6 | Sliding Base | Greasing | |  | | X | |  | |  | |
| 7 | Pivot arm bush | Greasing | |  | | X | |  | |  | |
| 8 | Gear Coupling | Greasing | |  | | X | |  | |  | |
| 9 | Snubber Roll Coupling | Greasing | |  | | X | |  | |  | |
| 10 | Snubber Roll Chain & Sprocket | Greasing | |  | | X | |  | |  | |
| **F** | **COIL OPENER WITH PINCH ROLL** | | | | | | | | | | |
| 1 | Knife | Wear | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 3 | Bearing Unit UCT-320 | Greasing | |  | | X | |  | |  | |
| 4 | Bearing Unit | Greasing | |  | | X | |  | |  | |
| 5 | Universal Joint | Greasing | |  | | X | |  | |  | |
| 6 | Slides | Greasing | |  | | X | |  | |  | |
| **G** | **PINCH ROLL** | | | | | | | | | | |
| 1 | Roll | Rotating Condition | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| **H** | **FEED LEVELLER** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 2 | Oiling | Oil Level Pressure | | X | |  | |  | |  | |
| 3 | Roll | Rotating Condition | | X | |  | |  | |  | |
| 4 | Bearing | Noise | |  | | X | |  | |  | |
| 5 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 6 | Universal Joint | Greasing | |  | | X | |  | |  | |
| 7 | Bearing Pump | Greasing | |  | | X | |  | |  | |
| 8 | Slides, Pinion | Greasing | |  | | X | |  | |  | |
| 9 | Gear Coupling | Greasing | |  | | X | |  | |  | |
| **I** | **ENTRY SHEAR** | | | | | | | | | | |
| 1 | Roll | Rotating Condition | | X | |  | |  | |  | |
| 2 | Knife | Wear Edge Angle | | X | |  | |  | |  | |
| 3 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 4 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 5 | Pivot arm bush | Greasing | |  | | X | |  | |  | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| 6 | Bearing of roller | Greasing | |  | | X | |  | |  | |
| 7 | Gear Coupling | Greasing | |  | | X | |  | |  | |
| 8 | Slides | Greasing | |  | | X | |  | |  | |
| **J** | **SCRAP DISCHARGE** | | | | | | | | | | |
| 1 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 2 | Table Bearing Unit | Greasing | |  | | X | |  | |  | |
| 3 | Trolley Bearing Unit | Greasing | |  | | X | |  | |  | |
| 4 | Trolley Chain & Sprocket | Greasing | |  | | X | |  | |  | |
| **CENTER SECTION** | | | | | | | | | | | |
| **K** | **SIDE GUIDE** | | | | | | | | | | |
| 1 | Roll | Rotating Condition | | X | |  | |  | |  | |
| 2 | Liner | Wear | |  | | X | |  | |  | |
| 3 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 4 | Gear Coupling | Greasing | |  | | X | |  | |  | |
| 5 | Bearing of Roller | Greasing | |  | | X | |  | |  | |
| 6 | Leading Screw | Greasing | |  | | X | |  | |  | |
| **L** | **NO.1 PINCH ROLL** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | |  | |  | |  | |  | |
| 2 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 3 | Bearing Unit | Greasing | |  | | X | |  | |  | |
| 4 | Universal Joint | Greasing | |  | | X | |  | |  | |
| 5 | Slides | Greasing | |  | | X | |  | |  | |
| **M** | **SIDE TRIMMER** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | Leakage | |  | |  | |  | |  | |
| 2 | Knife | Wear | |  | |  | |  | |  | |
| 3 | Bearing | Noise | |  | | X | |  | |  | |
| 4 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 5 | Gear Coupling Bottom | Greasing | |  | | X | |  | |  | |
| 6 | Pillow Block with Motor Bottom | Greasing | |  | | X | |  | |  | |
| 7 | Leading Screw | Greasing | |  | | X | |  | |  | |
| 8 | Pillow Block Bottom | Greasing | |  | | X | |  | |  | |
| 9 | Screw Jack Bottom | Greasing | |  | | X | |  | |  | |
| 10 | Gear Coupling Lower | Greasing | |  | | X | |  | |  | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| 11 | Pillow Block with Motor Lower | Greasing | |  | | X | |  | |  | |
| 12 | Gear Coupling Lower Center | Greasing | |  | | X | |  | |  | |
| 13 | Pillow Block Lower Center | Greasing | |  | | X | |  | |  | |
| 14 | Slides | Greasing | |  | | X | |  | |  | |
| 15 | Screw Jack Upper | Greasing | |  | | X | |  | |  | |
| 16 | Ball Joint | Greasing | |  | | X | |  | |  | |
| 17 | Clearance Adjustment Block | Greasing | |  | | X | |  | |  | |
| **N** | **SCRAP WINDER** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | Leakage | |  | |  | |  | |  | |
| 2 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 3 | Chain & Sprocket | Greasing | |  | | X | |  | |  | |
| 4 | Pillow Block | Greasing | |  | | X | |  | |  | |
| **O** | **NO:2 PINCH ROLL** | | | | | | | | | | |
| 1 | Roll | Rotating Condition | |  | |  | |  | |  | |
| 2 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 3 | Universal Joint | Greasing | |  | |  | |  | |  | |
| **P** | **INSPECTION CONVEYOR** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | |  | |  | |  | |  | |
| 2 | Cylinder Piping | Leakage | |  | |  | |  | |  | |
| 3 | Idle Roller | Greasing | |  | | X | |  | |  | |
| **Q** | **MEASURING ROLL** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | |  | |  | |  | |  | |
| 2 | Bearing Unit | Greasing | |  | | X | |  | |  | |
| **R** | **NO:3 PINCH ROLL** | | | | | | | | | | |
| 1 | Roll | Rotating Condition | |  | |  | |  | |  | |
| 2 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 3 | Universal Joint | Greasing | |  | | X | |  | |  | |
| **S** | **OILER** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | |  | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | |  | |  | |  | |  | |
| 3 | Oiling | Oil Level Pressure | |  | |  | |  | |  | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| 4 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 5 | Slides | Greasing | |  | | X | |  | |  | |
| **EXIT SECTION** | | | | | | | | | | | |
| **T** | **EXIT SHEAR** | | | | | | | | | | |
| 1 | Roll | Rotating Condition | |  | |  | |  | |  | |
| 2 | Knife | Wear Edge Angle | |  | |  | |  | |  | |
| 3 | Cylinder Hose, Piping | Leakage | |  | |  | |  | |  | |
| 4 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 5 | Pivot arm bush | Greasing | |  | | X | |  | |  | |
| 6 | Bearing of roller | Greasing | |  | | X | |  | |  | |
| 7 | Shear Slides | Greasing | |  | | X | |  | |  | |
| 8 | Gear Coupling | Greasing | |  | | X | |  | |  | |
| **U** | **REEL DEFLECTOR ROLLER** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | |  | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | |  | |  | |  | |  | |
| 3 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 4 | Chain & Sprocket | Greasing | |  | | X | |  | |  | |
| **V** | **TENSION REEL** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | Leakage | |  | |  | |  | |  | |
| 2 | Oiling | Oil Level Pressure | |  | |  | |  | |  | |
| 3 | Bearing | Noise | |  | | X | |  | |  | |
| 4 | Mandrel Segments | Greasing | |  | | X | |  | |  | |
| 5 | Sliding Base | Greasing | |  | | X | |  | |  | |
| 6 | Main Drive Coupling | Greasing | |  | | X | |  | |  | |
| **W** | **BELT WRAPPER** | | | | | | | | | | |
| 1 | Roll | Rotating Condition | |  | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | |  | |  | |  | |  | |
| 3 | Belt Tension | Cylinder Pressure | |  | |  | |  | |  | |
| 4 | Pivot arm bush | Greasing | |  | | X | |  | |  | |
| **X** | **NO:2 COIL CAR** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | Leakage | |  | |  | |  | |  | |
| 2 | Roll | Rotating Condition | |  | | X | |  | |  | |
| 3 | Wheels, Chain, Sprocket | Wear | |  | | X | |  | |  | |
| 4 | Lift Frame Guide Liner | Greasing | |  | | X | |  | |  | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| 5 | Car Wheel Bearing | Greasing | |  | | X | |  | |  | |
| 6 | Cradle roll Bearing | Greasing | |  | | X | |  | |  | |
| 7 | Chain & Sprocket | Greasing | |  | | X | |  | |  | |
| 8 | Roller Bracket | Greasing | |  | | X | |  | |  | |
| **Y** | **NO:2 COIL REST** | | | | | | | | | | |
| 1 | Cradle | Flaw | |  | |  | |  | |  | |
| **Z** | **TR HYDRAULIC UNIT** | | | | | | | | | | |
| 1 | Oiling | Oil Pressure | |  | |  | |  | |  | |
| 2 | Oiling | Oil Temperature | |  | |  | |  | |  | |
| 3 | Strainer | Service | |  | |  | |  | |  | |
| 4 | Oiling | Oil Level | |  | |  | |  | |  | |
| 5 | Tank, Pump, Valve, Piping connection, etc. | Leakage | |  | |  | |  | |  | |
| 6 | Check Abrasion on Flexible Hose | Visual Check | |  | |  | |  | |  | |
| 7 | Abnormal Noise/Vibration | Visual Check | |  | |  | |  | |  | |
| 8 | Heat Exchanger | Service | |  | | X | |  | |  | |
| **AA** | **EPC HYDRAULIC UNIT** | | | | | | | | | | |
| 1 | Oiling | Oil Pressure | |  | |  | |  | |  | |
| 2 | Line Filter, Strainer | Service | |  | |  | |  | |  | |
| 3 | Oiling | Oil Level | |  | |  | |  | |  | |
| 4 | Tank, Pump, Valve, Piping connection, etc. | Leakage | |  | |  | |  | |  | |
| 5 | Check Abrasion on Flexible Hose | Visual Check | |  | |  | |  | |  | |
| 6 | Abnormal Noise/Vibration | Visual Check | |  | |  | |  | |  | |
| 7 | Heat Exchanger | Service | |  | | X | |  | |  | |
|  |  |  | |  | |  | |  | |  | |
| **ELECTROLYTIC CLEANING LINE** | | | | | | | | | | | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| **ENTRY SECTION** | | | | | | | | | | | |
| **A** | **POR HYDRAULIC UNIT** | | | | | | | | | | |
| 1 | Oiling | Oil Pressure | | X | |  | |  | |  | |
| 2 | Oiling | Oil Temperature | | X | |  | |  | |  | |
| 3 | Strainer | Service | | X | |  | |  | |  | |
| 4 | Oiling | Oil Level | | X | |  | |  | |  | |
| 5 | Tank, Pump, Valve, Piping connection, etc. | Leakage | | X | |  | |  | |  | |
| 6 | Check Abrasion on Flexible Hose | Visual Check | | X | |  | |  | |  | |
| 7 | Abnormal Noise/Vibration | Visual Check | | X | |  | |  | |  | |
| 8 | Heat Exchanger | Service | |  | | X | |  | |  | |
| **B** | **CPC HYDRAULIC UNIT** | | | | | | | | | | |
| 1 | Oiling | Oil Pressure | | X | |  | |  | |  | |
| 2 | Line Filter, Strainer | Service | | X | |  | |  | |  | |
| 3 | Oiling | Oil Level | | X | |  | |  | |  | |
| 4 | Tank, Pump, Valve, Piping connection, etc. | Leakage | | X | |  | |  | |  | |
| 5 | Check Abrasion on Flexible Hose | Visual Check | | X | |  | |  | |  | |
| 6 | Abnormal Noise/Vibration | Visual Check | | X | |  | |  | |  | |
| 7 | Heat Exchanger | Service | |  | | X | |  | |  | |
| **C** | **NO:1 COIL REST** | | | | | | | | | | |
| 1 | Cradle | Flaw | | X | |  | |  | |  | |
| **D** | **NO:1 COIL CAR** | | | | | | | | | | |
| 1 | Cradle | Flaw | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Oil Leakages | | X | |  | |  | |  | |
| 3 | Wheels, Chain, Sprocket | Wear | |  | | X | |  | |  | |
| 4 | Lift Frame Guide Liner | Greasing | |  | | X | |  | |  | |
| 5 | Car Wheel Bearing | Greasing | |  | | X | |  | |  | |
| 6 | Chain & Sprocket | Greasing | |  | | X | |  | |  | |
| 7 | Roller Bracket | Greasing | |  | | X | |  | |  | |
| **E** | **PAYOFF REEL** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| 2 | Oiling | Oil Level | | X | |  | |  | |  | |
| 3 | Slide Base, Liner | Wear | |  | | X | |  | |  | |
| 4 | Bearing | Noise | |  | | X | |  | |  | |
| 5 | Mandrel Bearing | Greasing | |  | | X | |  | |  | |
| 6 | Sliding Base | Greasing | |  | | X | |  | |  | |
| 7 | Pivot arm bush | Greasing | |  | | X | |  | |  | |
| 8 | Gear Coupling | Greasing | |  | | X | |  | |  | |
| 9 | Snubber Roll Coupling | Greasing | |  | | X | |  | |  | |
| 10 | Snubber Roll Chain & Sprocket | Greasing | |  | | X | |  | |  | |
| **F** | **COIL OPENER WITH PINCH ROLL** | | | | | | | | | | |
| 1 | Knife | Wear | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 3 | Bearing Unit UCT-320 | Greasing | |  | | X | |  | |  | |
| 4 | Universal Joint | Greasing | |  | | X | |  | |  | |
| 5 | Slides | Greasing | |  | | X | |  | |  | |
| **G** | **PINCH ROLL** | | | | | | | | | | |
| 1 | Roll | Rotating Condition | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| **H** | **FEED LEVELLER** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 2 | Oiling | Oil Level Pressure | | X | |  | |  | |  | |
| 3 | Roll | Rotating Condition | | X | |  | |  | |  | |
| 4 | Bearing | Noise | |  | | X | |  | |  | |
| 5 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 6 | Universal Joint | Greasing | |  | | X | |  | |  | |
| 7 | Bearing Pump | Greasing | |  | | X | |  | |  | |
| 8 | Slides, Pinion | Greasing | |  | | X | |  | |  | |
| 9 | Gear Coupling | Greasing | |  | | X | |  | |  | |
| **I** | **ENTRY SHEAR** | | | | | | | | | | |
| 1 | Roll | Rotating Condition | | X | |  | |  | |  | |
| 2 | Knife | Wear Edge Angle | | X | |  | |  | |  | |
| 3 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 4 | Cylinder Hose, Piping | Leakage | |  | | X | |  | |  | |
| 5 | Pivot arm bush | Greasing | |  | | X | |  | |  | |
| 6 | Bearing of roller | Greasing | |  | | X | |  | |  | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| 7 | Gear Coupling | Greasing | |  | | X | |  | |  | |
| 8 | Slides | Greasing | |  | | X | |  | |  | |
| **J** | **SCRAP DISCHARGE** | | | | | | | | | | |
| 1 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 2 | Table Bearing Unit | Greasing | |  | | X | |  | |  | |
| 3 | Trolley Bearing Unit | Greasing | |  | | X | |  | |  | |
| 4 | Trolley Chain & Sprocket | Greasing | |  | | X | |  | |  | |
| **K** | **WELDER** | | | | | | | | | | |
| 1 | Welding Tip | Inspection & Cleaning | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 3 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 4 | Slides | Greasing | |  | | X | |  | |  | |
| **L** | **NO.1 PINCH ROLL** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | | X | |  | |  | |  | |
| 2 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 3 | Bearing Unit | Greasing | |  | | X | |  | |  | |
| 4 | Universal Joint | Greasing | |  | | X | |  | |  | |
| 5 | Slides | Greasing | |  | | X | |  | |  | |
| **CENTER SECTION** | | | | | | | | | | | |
| **M** | **WRINGER ROLL # 01** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 3 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 4 | Universal joint | Greasing | |  | | X | |  | |  | |
| 5 | Bearing Unit | Greasing | |  | | X | |  | |  | |
| 6 | Slides | Greasing | |  | | X | |  | |  | |
| **N** | **WRINGER ROLL # 02** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 3 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 4 | Universal joint | Greasing | |  | | X | |  | |  | |
| 5 | Bearing Unit | Greasing | |  | | X | |  | |  | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| 6 | Slides | Greasing | |  | | X | |  | |  | |
| **O** | **ALKALI BRUSH ROLL** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 3 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 4 | Universal joint | Greasing | |  | | X | |  | |  | |
| 5 | Screw Jack | Greasing | |  | | X | |  | |  | |
| 6 | Coupling | Greasing | |  | | X | |  | |  | |
| **P** | **WRINGER ROLL # 03** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 3 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 4 | Universal joint | Greasing | |  | | X | |  | |  | |
| 5 | Bearing Unit | Greasing | |  | | X | |  | |  | |
| 6 | Slides | Greasing | |  | | X | |  | |  | |
| **Q** | **WRINGER ROLL # 04** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 3 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 4 | Universal joint | Greasing | |  | | X | |  | |  | |
| 5 | Bearing Unit | Greasing | |  | | X | |  | |  | |
| 6 | Slides | Greasing | |  | | X | |  | |  | |
| **R** | **HOT WATER BRUSH ROLL** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 3 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 4 | Universal joint | Greasing | |  | | X | |  | |  | |
| 5 | Screw Jack | Greasing | |  | | X | |  | |  | |
| 6 | Coupling | Greasing | |  | | X | |  | |  | |
| **S** | **WRINGER ROLL # 05** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| 3 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 4 | Universal joint | Greasing | |  | | X | |  | |  | |
| 5 | Bearing Unit | Greasing | |  | | X | |  | |  | |
| 6 | Slides | Greasing | |  | | X | |  | |  | |
| **T** | **WRINGER ROLL # 06** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 3 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 4 | Universal joint | Greasing | |  | | X | |  | |  | |
| 5 | Bearing Unit | Greasing | |  | | X | |  | |  | |
| 6 | Slides | Greasing | |  | | X | |  | |  | |
| **U** | **WRINGER ROLL # 07** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 3 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 4 | Universal joint | Greasing | |  | | X | |  | |  | |
| 5 | Bearing Unit | Greasing | |  | | X | |  | |  | |
| 6 | Slides | Greasing | |  | | X | |  | |  | |
| **V** | **EDGE WEDGE** | | | | | | | | | | |
| 1 | Trapezoidal Screw | Abnormal Sound, Vibration | | X | |  | |  | |  | |
| **W** | **SUPPORT ROLL, DRYER, SUPPORT ROLL** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | | X | |  | |  | |  | |
| **X** | **ROLL CHANGING CAR** | | | | | | | | | | |
| 1 | Wheels | Greasing | |  | | X | |  | |  | |
| 2 | Arm | Greasing | |  | | X | |  | |  | |
| 3 | Chains | Greasing | |  | | X | |  | |  | |
| **Y** | **ALKALI CIRCULATION SYSTEM** | | | | | | | | | | |
| 1 | Tank, Pump, Valve, Piping connection,etc. | Leakage | | X | |  | |  | |  | |
| 2 | Pump | Inspection of Coupling pad Alignment & Pressure | | X | |  | |  | |  | |
| 3 | Heat Exchanger | Service | |  | | X | |  | |  | |
| **Z** | **HOT WATER CIRCULATION SYSTEM** | | | | | | | | | | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| 1 | Tank, Pump, Valve, Piping connection, etc. | Leakage | | X | |  | |  | |  | |
| 2 | Pump | Inspection of Coupling pad Alignment & Pressure | | X | |  | |  | |  | |
| 3 | Heat Exchanger | Service | |  | | X | |  | |  | |
| **AA** | **WEAK ALKALI PUMP** | | | | | | | | | | |
| 1 | Tank, Pump, Valve, Piping connection, etc. | Leakage | | X | |  | |  | |  | |
| 2 | Pump | Inspection of Coupling pad Alignment & Pressure | | X | |  | |  | |  | |
| 3 | Heat Exchanger | Service | |  | | X | |  | |  | |
| **AB** | **RAW ALKALI FEEDING SYSTEM** | | | | | | | | | | |
| 1 | Tank, Pump, Valve, Piping connection, etc. | Leakage | | X | |  | |  | |  | |
| 2 | Pump | Inspection of Coupling pad Alignment & Pressure | | X | |  | |  | |  | |
| 3 | Heat Exchanger | Service | |  | | X | |  | |  | |
| **AC** | **ADDITIVE FEEDING SYSTEM** | | | | | | | | | | |
| 1 | Tank, Pump, Valve, Piping connection, etc. | Leakage | | X | |  | |  | |  | |
| 2 | Pump | Inspection of Coupling pad Alignment & Pressure | | X | |  | |  | |  | |
| 3 | Heat Exchanger | Service | |  | | X | |  | |  | |
| **AD** | **BRIDLE ROLL** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 3 | Oiling | Oil Level Pressure | | X | |  | |  | |  | |
| 4 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 5 | Coupling | Greasing | |  | | X | |  | |  | |
| **AE** | **OILER** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 3 | Oiling | Oil Level Pressure | | X | |  | |  | |  | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| 4 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 5 | Slides | Greasing | |  | | X | |  | |  | |
| **EXIT SECTION** | | | | | | | | | | | |
| **AF** | **EXIT SHEAR** | | | | | | | | | | |
| 1 | Roll | Rotating Condition | | X | |  | |  | |  | |
| 2 | Knife | Wear Edge Angle | | X | |  | |  | |  | |
| 3 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 4 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 5 | Slides | Greasing | |  | | X | |  | |  | |
| 6 | Pivot arm bush | Greasing | |  | | X | |  | |  | |
| **AG** | **REEL DEFLECTOR ROLLER** | | | | | | | | | | |
| 1 | Roll | Rotating Condition, Flaw | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 3 | FRL Unit | Drain, Regulator & Oil Level | |  | | X | |  | |  | |
| 4 | Chain & Sprocket | Greasing | |  | | X | |  | |  | |
| **AH** | **TENSION REEL** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 2 | Oiling | Oil Level Pressure | | X | |  | |  | |  | |
| 3 | Bearing | Noise | |  | | X | |  | |  | |
| 4 | Mandrel | Greasing | |  | | X | |  | |  | |
| 5 | Slides | Greasing | |  | | X | |  | |  | |
| **AI** | **BELT WRAPPER** | | | | | | | | | | |
| 1 | Roll | Rotating Condition | | X | |  | |  | |  | |
| 2 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 3 | Belt Tension | Cylinder Pressure | | X | |  | |  | |  | |
| 4 | Pivot arm bush | Greasing | |  | | X | |  | |  | |
| **AJ** | **NO:2 COIL CAR** | | | | | | | | | | |
| 1 | Cylinder Hose, Piping | Leakage | | X | |  | |  | |  | |
| 2 | Roll | Rotating Condition | |  | | X | |  | |  | |
| 3 | Wheels, Chain, Sprocket | Wear | |  | | X | |  | |  | |
| 4 | Lift Frame Guide Liner | Greasing | |  | | X | |  | |  | |
| 5 | Car Wheel Bearing | Greasing | |  | | X | |  | |  | |
| 6 | Cradle roll Bearing | Greasing | |  | | X | |  | |  | |
| 7 | Chain & Sprocket | Greasing | |  | | X | |  | |  | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| 8 | Roller Bracket | Greasing | |  | | X | |  | |  | |
| **AK** | **NO:2 COIL REST** | | | | | | | | | | |
| 1 | Cradle | Flaw | | X | |  | |  | |  | |
| **AL** | **TR HYDRAULIC UNIT** | | | | | | | | | | |
| 1 | Oiling | Oil Pressure | | X | |  | |  | |  | |
| 2 | Oiling | Oil Temperature | | X | |  | |  | |  | |
| 3 | Strainer | Service | | X | |  | |  | |  | |
| 4 | Oiling | Oil Level | | X | |  | |  | |  | |
| 5 | Tank, Pump, Valve, Piping connection, etc. | Leakage | | X | |  | |  | |  | |
| 6 | Check Abrasion on Flexible Hose | Visual Check | | X | |  | |  | |  | |
| 7 | Abnormal Noise/Vibration | Visual Check | | X | |  | |  | |  | |
| 8 | Heat Exchanger | Service | |  | | X | |  | |  | |
| **AM** | **EPC HYDRAULIC UNIT** | | | | | | | | | | |
| 1 | Oiling | Oil Pressure | | X | |  | |  | |  | |
| 2 | Line Filter, Strainer | Service | | X | |  | |  | |  | |
| 3 | Oiling | Oil Level | | X | |  | |  | |  | |
| 4 | Tank, Pump, Valve, Piping connection, etc. | Leakage | | X | |  | |  | |  | |
| 5 | Check Abrasion on Flexible Hose | Visual Check | | X | |  | |  | |  | |
| 6 | Abnormal Noise/Vibration | Visual Check | | X | |  | |  | |  | |
| 7 | Heat Exchanger | Service | |  | | X | |  | |  | |
|  |  |  | |  | |  | |  | |  | |
| **ROLL GRINDING LINE** | | | | | | | | | | | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| **A** | **WORK HEAD** | Bolts Tightening | |  | | X | |  | |  | |
| Oil Level | |  | | X | |  | |  | |
| Abnormal Noise & Vibration | |  | | X | |  | |  | |
| Inspection of Belt & Tension | |  | | X | |  | |  | |
| **B** | **WHEEL HEAD** | Bolts Tightening | |  | | X | |  | |  | |
| Belts | |  | | X | |  | |  | |
| Pulleys Wear & Tear | |  | | X | |  | |  | |
| Lubrication Oil Level | |  | | X | |  | |  | |
| Abnormal Noise & Vibration | |  | | X | |  | |  | |
| Bellow Cover Condition | |  | | X | |  | |  | |
| Slides Bearing Noise | |  | | X | |  | |  | |
| **C** | **TAIL STOCK** | Bolts Tightening | |  | | X | |  | |  | |
| Inspection of Lubrication Line & Oil Level | |  | | X | |  | |  | |
| Abnormal Noise & Vibration | |  | | X | |  | |  | |
| **D** | **STEADY REST BRACKETS** | Inspection of Lubrication Line & Oil Level | |  | | X | |  | |  | |
| **E** | **MAIN BED CARRIAGE** | Bolts Tightening | |  | | X | |  | |  | |
| Abnormal Noise & Vibration | |  | | X | |  | |  | |
| Rack & Pinion Condition | |  | | X | |  | |  | |
| Bellow Cover Condition | |  | | X | |  | |  | |
| **F** | **COOLING SYSTEM** | Leakages | |  | | X | |  | |  | |
| Abnormal Noise & Vibration | |  | | X | |  | |  | |
| **G** | **HYDROSTATIC LUBRICATION HYDRAULIC SYSTEM** | | | | | | | | | | |
| Tank | Leakages | |  | | X | |  | |  | |
| Pump | Abnormal Noise & Vibration | |  | | X | |  | |  | |
| Accumulator | Pressure Test | |  | | X | |  | |  | |
| Filter | Inspection | |  | | X | |  | |  | |
| Return Pump | Abnormal Noise & Vibration | |  | | X | |  | |  | |
| **SHOT BLASTING MACHINE** | | | | | | | | | | | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| **A** | **BLAST CABINET** | | | | | | | | | | |
| 1 | Cabinet | Inspection of Rubber Line | |  | | X | |  | |  | |
| 2 | Nozzle Reciprocating System | Abnormal Sound & Vibration | |  | | X | |  | |  | |
| 3 | Blasting Hose | Condition | |  | | X | |  | |  | |
| 4 | Vision Window | Glass Inspection | |  | | X | |  | |  | |
| 5 | Nozzle | Inspection | |  | | X | |  | |  | |
| **B** | **WORK CAR** | | | | | | | | | | |
| 1 | Roll Rotating System | Abnormal Sound & Vibration | |  | | X | |  | |  | |
| 2 | Travel System Gear Motor | Abnormal Sound & Vibration | |  | | X | |  | |  | |
| 3 | Tail Stock Pulley & Spindle | Abnormal Sound & Vibration | |  | | X | |  | |  | |
| **C** | **CLASSIFIER** | | | | | | | | | | |
| 1 | Classifier | Inspection of Rubber Line | |  | | X | |  | |  | |
| 2 | Mesh | Inspection | |  | | X | |  | |  | |
| 3 | Shaker Motor | Abnormal Sound & Vibration | |  | | X | |  | |  | |
| 4 | Spring | Inspection | |  | | X | |  | |  | |
| 5 | Hose | Condition | |  | | X | |  | |  | |
| **D** | **DUST COLLECTOR** | | | | | | | | | | |
| 1 | Dust Collector | Inspection of Rubber Line | |  | | X | |  | |  | |
| 2 | Filter | Inspection | |  | | X | |  | |  | |
| 3 | Hose | Condition | |  | | X | |  | |  | |
| 4 | Shaker Motor | Abnormal Sound & Vibration | |  | | X | |  | |  | |
| 5 | Damper | Inspection | |  | | X | |  | |  | |
| 6 | Exhaust Fan | Abnormal Sound & Vibration | |  | | X | |  | |  | |
|  |  |  | |  | |  | |  | |  | |
| **ROLL ASSEMBLY LINE** | | | | | | | | | | | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | | **FREQUENCY** | | | | | | | |
| **WEEKLY** | | **MONTHLY** | | **QUARTERLY** | | **HALF YEARLY** | |
| A | Drive Side Tank | Pump | |  | | X | |  | |  | |
| Valve Stand | |  | | X | |  | |  | |
| Heat Exchanger | |  | | X | |  | |  | |
| Oil Level | |  | | X | |  | |  | |
| B | Short Travel Gear Box | Abnormal Noise & Vibration | |  | | X | |  | |  | |
| C | Long Travel Gear Box | Abnormal Noise & Vibration | |  | | X | |  | |  | |
| D | Up/Down Hydraulic System | Inspection | |  | | X | |  | |  | |
| E | Chain | Inspection | |  | | X | |  | |  | |
| F | Skid | Inspection | |  | | X | |  | |  | |
| G | Operator Side Tank | Pump | |  | | X | |  | |  | |
| Valve Stand | |  | | X | |  | |  | |
| Heat Exchanger | |  | | X | |  | |  | |
| Oil Level | |  | | X | |  | |  | |
| H | Short Travel Gear Box | Abnormal Noise & Vibration | |  | | X | |  | |  | |
| I | Long Travel Gear Box | Abnormal Noise & Vibration | |  | | X | |  | |  | |
| J | Up/Down Hydraulic System | Inspection | |  | | X | |  | |  | |
| K | Chain | Inspection | |  | | X | |  | |  | |
| L | Skid | Inspection | |  | | X | |  | |  | |
|  |  |  | |  | |  | |  | |  | |

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| **ROLL GRINDING LINE HERKULES GI COMPLEX** | | | | | | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **A** | **GENERAL** | Check Cooling Equipment & Air Passages (If Necessary Clean) |  | X |  |  |
| Visual Check of Cable, Hoses & Connection For Damages & Abrasion |  | X |  |  |
| Check Noise & Fan Filters (If Necessary Clean/Replace) |  | X |  |  |
| Check Wipers (If Necessary Renew) |  | X |  |  |
| **B** | **HEADSTOCK** | Check Pretension of Belts (If Necessary Adjust & Clean When Dirty) |  | X |  |  |
| Belt Tensioner Greasing |  | X |  |  |
| Check Faceplate Drive Oil Level |  | X |  |  |
| **C** | **TAILSTOCK** | Greasing of Manual Longitudinal Z-Axis |  | X |  |  |
| **D** | **GRINDING CARRIAGE** | Drain Off Oil From X-Axis Collecting Vessels |  | X |  |  |
| Central Lubrication Unit X, C-Axis (If Necessary Refill) |  | X |  |  |
| Check Oil Flow Monitor of Grinding Spindle Lubrication |  | X |  |  |
| Check Splash Water Guard (If Necessary Clean) |  | X |  |  |
| Clean Grinding Cover |  | X |  |  |
| Check Pretension of Belts (If Necessary Adjust & Clean When Dirty) |  | X |  |  |
| Lubrication of Hinge of Grinding Cover |  | X |  |  |
| Oil & Filter Change of Grinding Spindle Lubrication (Conditional to Hourly Running) |  | X |  |  |
| Belt Tensioner Greasing |  | X |  |  |
| **E** | **STEADY RESTS** | Remove Old Grease |  | X |  |  |
| Greasing of Manual Longitudinal Z-Axis |  | X |  |  |
| **F** | **CARRIAGE BED** | Check Level (If Necessary Refill) |  | X |  |  |
| Change Oil (2 Years Conditional to Hourly Running) |  | X |  |  |
| **G** | **FILTERING BED** | Check Float Switch, If Necessary Readjust |  | X |  |  |
| Check Combined Belt For Wear |  | X |  |  |
| General Bolt Tightening & Lubrication |  | X |  |  |
| Check Oil Level of Combined Belt Gearbox of magnetic Roll |  | X |  |  |

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| **COIL TRANSFER CAR** | | | | | | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **A** | **Chassis** | Inspection |  | X |  |  |
| **B** | **Wire Winder** | Abnormal Sound & Vibration |  | X |  |  |
| Chain & Sprocket |  | X |  |  |
| **C** | **Block** | Inspection |  | X |  |  |
| **D** | **Driven Wheels** | Abnormal Sound & Vibration |  | X |  |  |
| **E** | **Guide Wheel** | Inspection |  | X |  |  |
| **F** | **Axle** | Inspection |  | X |  |  |
| **G** | **Gasket** | Condition |  | X |  |  |
| **H** | **Pin** | Inspection |  | X |  |  |
| **I** | **Drive Mechanism** | Belts Condition |  | X |  |  |
| Brake Condition |  | X |  |  |
| Gear Box |  | X |  |  |
| Greasing |  | X |  |  |
| **J** | **Saddle** | Condition |  | X |  |  |

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| **PUSH PULL PICKLING LINE (G.I Complex)** | | | | | | |
| **S.NO** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **HYDRAULIC UNIT** | | | | | | |
| 1 | Oiling | Oil Pressure | X |  |  |  |
| 2 | Oiling | Oil Temperature | X |  |  |  |
| 3 | Strainer | Service | X |  |  |  |
| 4 | Oiling | Oil Level | X |  |  |  |
| 5 | Tank, Pump, Valve, Piping connection, etc. | Leakage | X |  |  |  |
| 6 | Check Abrasion on Flexible Hose | Visual Check | X |  |  |  |
| 7 | Abnormal Noise/Vibration | Visual Check | X |  |  |  |
| 8 | Heat Exchanger | Service |  | X |  |  |
| 9 | Accumulator | Inspection |  | X |  |  |
| **ENTRY SECTION** | | | | | | |
| **A** | **ENTRY COIL SADDLE / TRACK** | | | | | |
| 1 | Cradle Roll | Condition | X |  |  |  |
| 2 | Hydraulic Motor | Inspection | X |  |  |  |
| 3 | Hydraulic Motor Hose | Leakage/Condition | X |  |  |  |
| 4 | Plummer Block | Condition |  | X |  |  |
| 5 | Bearing | Greasing |  | X |  |  |
| 6 | Coil Seat Panel | Condition |  | X |  |  |
| 7 | Rail Track | Condition |  | X |  |  |
| 8 | Moving Plates Wheel | Greasing |  | X |  |  |
| 9 | Moving Plates Track | Inspection |  | X |  |  |
| **B** | **ENTRY COIL CAR** | | | | | |
| 1 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 2 | Hose/Piping | Leakage/Condition | X |  |  |  |
| 3 | Wheels | Wear |  | X |  |  |
| 4 | Gear Box | Oil Level |  | X |  |  |
| 5 | Gear Motor | Noise |  | X |  |  |
| 6 | Guide Rod | Greasing |  | X |  |  |
| 7 | Bearings | Noise | X |  |  |  |
| 8 | Bearings | Greasing |  | X |  |  |
| **S.NO** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **C** | **PAYOFF REEL** | | | | | |
| 1 | Mandrel | Overhauling |  |  | X |  |
| 2 | Mandrel | Greasing |  | X |  |  |
| 3 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 4 | Hose/Piping | Leakage/Damage | X |  |  |  |
| 5 | Bearing | Noise | X |  |  |  |
| 6 | Bearing | Greasing |  | X |  |  |
| 7 | Slide Base, Liner | Wear |  | X |  |  |
| 8 | Gear Box | Inspection |  | X |  |  |
| 9 | Lubrication Pump | Inspection | X |  |  |  |
| 10 | Gear Box | Oil Level | X |  |  |  |
| 11 | Gear Motor | Noise |  | X |  |  |
| 12 | Mandrel Sleeve | Greasing |  | X |  |  |
| 13 | Brake Pads | Condition |  | X |  |  |
| 14 | Mandrel Bearing Housing | Greasing |  | X |  |  |
| 15 | Fittings/Valves | Inspection | X |  |  |  |
| **D** | **PAYOFF REEL ANTIBOW ROLL** | | | | | |
| 1 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 2 | Roll | Condition |  | X |  |  |
| 3 | Frame Pin | Condition |  | X |  |  |
| 4 | Bearings | Greasing |  | X |  |  |
| 5 | Bearings | Noise | X |  |  |  |
| 6 | Hose/Piping | Leakage/Condition | X |  |  |  |
| 7 | Fittings/Valves | Inspection | X |  |  |  |
| **E** | **PAYOFF REEL PRESSURE ROLL** | | | | | |
| 1 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 2 | Hose/Piping | Leakage/Condition | X |  |  |  |
| 3 | Roll | Condition |  | X |  |  |
| 4 | Bearings | Greasing |  | X |  |  |
| 5 | Bearings | Noise | X |  |  |  |
| 6 | Frame Pin | Condition |  | X |  |  |
| **S.NO** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **F** | **PAYOFF REEL OUTBOARD** | | | | | |
| 1 | Mandrel Support Rollers | Condition |  | X |  |  |
| 2 | Bearings, Mandrel Support Rollers | Greasing |  | X |  |  |
| 3 | Bearing , OBB Frame | Greasing |  | X |  |  |
| 4 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 5 | Hose/Piping | Leakage/Condition | X |  |  |  |
| **G** | **ENTRY PINCH ROLL & COIL PEELER** | | | | | |
| 1 | Rolls | Condition |  | X |  |  |
| 2 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 3 | All Bearings | Noise | X |  |  |  |
| 4 | Bearings for Pinch Roll | Greasing |  | X |  |  |
| 5 | Bearing for Deflector Roll | Greasing |  | X |  |  |
| 6 | Peeler Table Guide Rail | Greasing |  | X |  |  |
| 7 | Chock Guide | Greasing |  | X |  |  |
| 8 | Pinch Roll Hydraulic Motor | Inspection |  | X |  |  |
| 9 | Hose/Piping | Leakage/Damage | X |  |  |  |
| 10 | Fittings/Valves | Inspection | X |  |  |  |
| **H** | **SIDE GUIDE NO.1** | | | | | |
| 1 | Gear Rack | Inspection/Greasing |  | X |  |  |
| 2 | Gear Rack Pin | Inspection |  | X |  |  |
| 3 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 4 | Hose/Piping | Leakage/Damage | X |  |  |  |
| 5 | Guide Rod | Greasing |  | X |  |  |
| 6 | Shaft Sleeve | Inspection |  | X |  |  |
| 7 | Pinion | Greasing |  | X |  |  |
| 8 | Pinion Pin | Inspection |  | X |  |  |
| 9 | Rolls | Inspection/Greasing |  | X |  |  |
| **I** | **FLATTENER** | | | | | |
| 1 | Bearings | Noise | X |  |  |  |
| 2 | Cylinder/Pin/Bolts | Inspection/Condition | X |  |  |  |
| 3 | Hose/Piping | Leakage/Damage | X |  |  |  |
| 4 | Cylinder Pins | Greasing |  | X |  |  |
| 5 | Rolls | Condition |  | X |  |  |
| **S.NO** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| 6 | Clutch | Inspection |  | X |  |  |
| 7 | Brake Pads | Condition |  | X |  |  |
| 8 | Lubrication Pumps | Inspection |  | X |  |  |
| 9 | Gear Box | Level Check | X |  |  |  |
| 10 | Gear Box | Wear |  | X |  |  |
| 11 | Gear Motor | Noise |  | X |  |  |
| 12 | Universal Joint Bolts | Check & Tightening | X |  |  |  |
| 13 | Universal Joints | Greasing |  | X |  |  |
| 14 | Spring Assembly | Inspection |  | X |  |  |
| 15 | Bearing For Upper Rolls | Greasing |  | X |  |  |
| 16 | Bearing For Lower Rolls | Greasing |  | X |  |  |
| 17 | Upper Roll Adjustment Blocks | Greasing |  | X |  |  |
| **J** | **ENTRY CROP SHEAR** | | | | | |
| 1 | Cylinder/Pin/Bolts | Inspection/Condition | X |  |  |  |
| 2 | Hose/Piping | Leakage | X |  |  |  |
| 3 | Booker Pins | Inspection |  | X |  |  |
| 4 | Knife | Inspection, Clearance |  | X |  |  |
| 5 | Pneumatic Cylinder | Inspection | X |  |  |  |
| 6 | FRL Unit | Drain, Regulator & Oil Level |  | X |  |  |
| 7 | Knife Holder | Greasing |  | X |  |  |
| 8 | Arms | Greasing |  | X |  |  |
| 9 | Bottom Plate Spring | Inspection |  | X |  |  |
| 10 | Shaft Sleeve | Inspection |  | X |  |  |
| 11 | Fittings/Valves | Inspection | X |  |  |  |
| **K** | **TAPER SHEAR** | | | | | |
| 1 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 2 | Hose/Piping | Leakage/Damage | X |  |  |  |
| 3 | Knife | Inspection, Clearance |  | X |  |  |
| 4 | Knife Holder | Greasing |  | X |  |  |
| 5 | Arm | Greasing |  | X |  |  |
| 6 | Bottom Plate Springs | Inspection |  | X |  |  |
| **L** | **ENTRY SCRAP DISPOSAL EQUIPMENT** | | | | | |
| 1 | Track/Rail | Condition |  | X |  |  |
| **S.NO** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| 2 | Bearing | Noise | X |  |  |  |
| 3 | Bearings | Greasing |  | X |  |  |
| 4 | Gear Motor | Noise |  | X |  |  |
| 5 | Gear Box | Oil Level | X |  |  |  |
| 6 | Wheels, Chain, Sprocket, Driving Shaft | Wear/Condition |  | X |  |  |
| 7 | Roller Chain for Drive | Greasing |  | X |  |  |
| **CENTER SECTION** | | | | | | |
| **M** | **PINCKLING TANK AND RINSE TANK** | | | | | |
| 1 | Header and Support | Cleaning and replacement of damage nozzle |  | X |  |  |
| 2 | Granite Block | Inspection |  | X |  |  |
| 3 | Tap For Fume Dilution | Damage |  | X |  |  |
| 4 | PPH Cover | Condition |  | X |  |  |
| **N** | **WRINGER ROLL # 01 to #15** | | | | | |
| 1 | Pneumatic Cylinder | Leakage | X |  |  |  |
| 2 | Bearings | Noise | X |  |  |  |
| 3 | Bearings | Greasing |  | X |  |  |
| 4 | Universal Joint Bolt | Check & Tightening | X |  |  |  |
| 5 | Rolls | Condition |  | X |  |  |
| 6 | FRL Unit | Drain, Regulator & Oil Level |  | X |  |  |
| 7 | Fittings/Valves | Inspection | X |  |  |  |
| 8 | Gear Motor | Noise |  | X |  |  |
| 9 | Hand Grease Point | Greasing |  | X |  |  |
| 10 | Universal Joint | Greasing |  | X |  |  |
| **O** | **PRE-CLEANING TANK** | | | | | |
| 1 | Tank | Inspection |  | X |  |  |
| **P** | **ACID RE-CIRCULATION TANK 01 TO 05** | | | | | |
| 1 | Tank | Inspection |  | X |  |  |
| **Q** | **CONDENSATE COLLECTING TANK** | | | | | |
| 1 | Tank | Inspection |  | X |  |  |
| **R** | **RINSE WASTE WATER TANK** | | | | | |
| 1 | Tank | Inspection |  | X |  |  |
| **S.NO** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **S** | **SUMP PIT** | | | | | |
| 1 | Pit | Cleaning & Inspection |  | X |  |  |
| **T** | **PRE-CLEANING PUMP (PCP-101 AND PCP-102)** | | | | | |
| 1 | Tank, Pump, Valve, Piping connection, etc. | Leakage | X |  |  |  |
| 2 | Abnormal Noise/Vibration | Visual Check | X |  |  |  |
| **U** | **ACID CIRCULATION PUMP (ACP-101 TO ACP-109)** | | | | | |
| 1 | Strainer | Cleaning | X |  |  |  |
| 2 | Tank, Pump, Valve, Piping connection, etc. | Leakage | X |  |  |  |
| 3 | Abnormal Noise/Vibration | Visual Check | X |  |  |  |
| **V** | **RINSE PUMP 101 TO 108 (RCP-101 TO RCP-108)** | | | | | |
| 1 | Strainer | Cleaning | X |  |  |  |
| 2 | Tank, Pump, Valve, Piping connection, etc. | Leakage | X |  |  |  |
| 3 | Abnormal Noise/Vibration | Visual Check | X |  |  |  |
| **W** | **WASTE ACID DISCHARGE PUMP (WADP-101 AND WADP-102)** | | | | | |
| 2 | Tank, Pump, Valve, Piping connection, etc. | Leakage | X |  |  |  |
| 3 | Abnormal Noise/Vibration | Visual Check | X |  |  |  |
| **X** | **CONDENSATE WATER PUMP (CWP-101 AND CWP-102)** | | | | | |
| 1 | Tank, Pump, Valve, Piping connection, etc. | Leakage | X |  |  |  |
| 2 | Abnormal Noise/Vibration | Visual Check | X |  |  |  |
| **Y** | **RINSE WASTE WATER PUMP (RWWP-101 AND RWWP-102)** | | | | | |
| 1 | Tank, Pump, Valve, Piping connection, etc. | Leakage | X |  |  |  |
| 2 | Abnormal Noise/Vibration | Visual Check | X |  |  |  |
| **Z** | **SUMP PIT PUMP (SPP-101 AND SPP-102)** | | | | | |
| 1 | Tank, Pump, Valve, Piping connection, etc. | Leakage | X |  |  |  |
| **S.NO** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| 2 | Abnormal Noise/Vibration | Visual Check | X |  |  |  |
| 3 | Bucket | Inspection | X |  |  |  |
| **AA** | **FAT AREA** | | | | | |
| 1 | Greasing (Acid Protection From Corrosion) | Grease By Hand |  | X |  |  |
| 2 | Tanks | Inspection |  | X |  |  |
| 3 | Level Sensors | Inspection |  | X |  |  |
| **AB** | **FRESH ACID PUMP (FAP-101 AND FAP-102)** | | | | | |
| 1 | Tank, Pump, Valve, Piping connection, etc. | Leakage | X |  |  |  |
| 2 | Abnormal Noise/Vibration | Visual Check | X |  |  |  |
| **AC** | **ACID MIST WASHING TOWER PUMP (AMWTP-101 AND AMWTP-102)** | | | | | |
| 1 | Tank, Pump, Valve, Piping connection, etc. | Leakage | X |  |  |  |
| 2 | Abnormal Noise/Vibration | Visual Check | X |  |  |  |
| **AD** | **WASTE ACID PUMP (WAP-101 AND WAP-102)** | | | | | |
| 1 | Tank, Pump, Valve, Piping connection, etc. | Leakage | X |  |  |  |
| 2 | Abnormal Noise/Vibration | Visual Check | X |  |  |  |
| **AE** | **ACID PREPARATION PUMP (APP-101 AND APP-102)** | | | | | |
| 1 | Tank, Pump, Valve, Piping connection, etc. | Leakage | X |  |  |  |
| 2 | Abnormal Noise/Vibration | Visual Check | X |  |  |  |
| **AF** | **NEW ACID TANK PUMP (NATP-101 AND NATP-102)** | | | | | |
| 1 | Tank, Pump, Valve, Piping connection, etc. | Leakage | X |  |  |  |
| 2 | Abnormal Noise/Vibration | Visual Check | X |  |  |  |
| **S.NO** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **AG** | **RINSE WASTE WATER (FAT) (RWWP-103 AND RWWP-104)** | | | | | |
| 1 | Tank, Pump, Valve, Piping connection, etc. | Leakage | X |  |  |  |
| 2 | Abnormal Noise/Vibration | Visual Check | X |  |  |  |
| **AH** | **FUME EXHAUST SYSTEM** | | | | | |
| 1 | Tank, Pump, Valve, Piping connection, etc. | Leakage | X |  |  |  |
| 2 | Washing Tower | Inspection |  | X |  |  |
| 3 | Abnormal Noise/Vibration | Visual Check | X |  |  |  |
| 4 | Belt | Inspection | X |  |  |  |
| 5 | Bearing | Noise |  | X |  |  |
| 6 | Bearing | Oil Level Check |  | X |  |  |
| 7 | Expansion Bellow | Inspection |  | X |  |  |
| **AI** | **STRIP DRYER SYSTEM** | | | | | |
| 1 | Abnormal Noise/Vibration | Visual Check | X |  |  |  |
| 2 | Bearing Housing | Oil Level |  | X |  |  |
| 3 | Roll | Condition | X |  |  |  |
| 4 | Bearing | Noise | X |  |  |  |
| 5 | Expansion Bellow | Inspection |  | X |  |  |
| 6 | Hand Grease Point | Greasing |  | X |  |  |
| 7 | Fittings/Valves | Inspection |  | X |  |  |
| 8 | Blower | Inspection |  | X |  |  |
| 9 | Motor Coupling | Inspection |  | X |  |  |
| **EXIT SECTION** | | | | | | |
| **AJ** | **PINCH ROLL NO.2** | | | | | |
| 1 | Rolls | Condition |  | X |  |  |
| 2 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 3 | Bearings | Noise | X |  |  |  |
| 4 | Bearings | Greasing |  | X |  |  |
| 5 | Hoses/Piping | Leakage/Damage | X |  |  |  |
| 6 | Fittings/Valves. | Inspection | X |  |  |  |
| 7 | Universal Joints | Greasing |  | X |  |  |
| **S.NO** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| 8 | Universal Joint Bolts | Check & Tightening | X |  |  |  |
| 9 | Brake Pads | Inspection |  | X |  |  |
| 10 | Gear Motor | Noise |  | X |  |  |
| 11 | Gear Box | Oil Level | X |  |  |  |
| **AK** | **LOOPING PIT & CARRY OVER TABLE** | | | | | |
| 1 | Cylinder/Pins/Bolts | Inspection | X |  |  |  |
| 2 | Bearing | Noise | X |  |  |  |
| 3 | Bearing | Greasing |  | X |  |  |
| 4 | Roll | Condition |  | X |  |  |
| 5 | Pillow Block | Greasing |  | X |  |  |
| 6 | FRL Unit | Drain, Regulator & Oil Level |  | X |  |  |
| 7 | Fittings/Valves | Inspection | X |  |  |  |
| **AL** | **SIDE GUIDE NO.2** | | | | | |
| 1 | Gear Rack | Inspection/Greasing |  | X |  |  |
| 2 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 3 | Hose / Piping | Leakage/Damage | X |  |  |  |
| 4 | Guide Rod | Greasing |  | X |  |  |
| 5 | Shaft Sleeve | Inspection |  | X |  |  |
| 6 | Pinion | Greasing |  | X |  |  |
| 7 | Pinion Pin | Inspection |  | X |  |  |
| 8 | Rolls | Inspection/Greasing |  | X |  |  |
| **AM** | **PINCH ROLL NO.3** | | | | | |
| 1 | Rolls | Condition |  | X |  |  |
| 2 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 3 | Bearings | Noise | X |  |  |  |
| 4 | Bearings | Greasing |  | X |  |  |
| 5 | Hose/Piping | Inspection | X |  |  |  |
| 6 | Fittings/Valves/Etc. | Inspection | X |  |  |  |
| 7 | Universal Joints | Greasing |  | X |  |  |
| 8 | Universal Joint Bolts | Check & Tightening | X |  |  |  |
| 9 | Brake Pads | Condition |  | X |  |  |
| 10 | Gear Motor | Noise |  | X |  |  |
| 11 | Gear Box | Oil Level | X |  |  |  |
| 12 | Bed Movement | Greasing |  | X |  |  |
| **S.NO** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| 13 | Bed Adjustment Bolts | Inspection |  | X |  |  |
| **AN** | **SIDE TRIMMER** | | | | | |
| 1 | Blades | Inspection | X |  |  |  |
| 2 | Gear Box | Oil Level | X |  |  |  |
| 3 | Gear Motor | Noise |  | X |  |  |
| 4 | Pneumatic Cylinder | Inspection/Condition | X |  |  |  |
| 5 | Lead Screw | Greasing |  | X |  |  |
| 6 | Lead Screw | Inspection |  | X |  |  |
| 7 | Lead Screw Coupling | Inspection | X |  |  |  |
| 8 | Bed Rails | Greasing |  | X |  |  |
| 9 | Bearings | Greasing |  | X |  |  |
| 10 | Bearings | Noise | X |  |  |  |
| 11 | Linear Bearing | Noise |  | X |  |  |
| 12 | Linear Bearing | Greasing |  | X |  |  |
| 13 | Motor Coupling | Inspection |  | X |  |  |
| **AO** | **SCRAP BALLER** | | | | | |
| 1 | Strip Directing Rollers | Greasing |  | X |  |  |
| 2 | Pneumatic Brake | Inspection |  | X |  |  |
| 3 | FRL Unit | Drain, Regulator & Oil Level |  | X |  |  |
| 4 | Fittings/Valves/Etc. | Inspection | X |  |  |  |
| 5 | Gear Box | Oil Level | X |  |  |  |
| 6 | Gear Box | Inspection |  | X |  |  |
| **S.NO** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| 7 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 8 | Hose/Piping | Leakage/Damage | X |  |  |  |
| 9 | Bearing | Noise | X |  |  |  |
| 10 | Bearing | Greasing |  | X |  |  |
| 11 | Bed Movement | Greasing |  | X |  |  |
| **AP** | **SCRAP BALLER SCRAP SYSTEM** | | | | | |
| 1 | Track/Rail | Condition |  | X |  |  |
| 2 | Bearing | Noise | X |  |  |  |
| 3 | Bearings/Pillow Block | Greasing |  | X |  |  |
| 4 | Gear Motor | Noise |  | X |  |  |
| 5 | Gear Box | Oil Level | X |  |  |  |
| 6 | Wheels, Chain, Sprocket, Driving Shaft | Wear/Condition |  | X |  |  |
| 7 | Roller Chain for Drive | Greasing |  | X |  |  |
| **AQ** | **THREE ROLL TENSION DEVICE** | | | | | |
| 1 | Bridle Press Roll No.1 | Condition |  | X |  |  |
| 2 | Bridle Press Roll No.2 | Condition |  | X |  |  |
| 3 | Bridle Roll No.1 | Condition |  | X |  |  |
| 4 | Bridle Roll No.2 | Condition |  | X |  |  |
| 5 | Bridle Roll No.3 | Condition |  | X |  |  |
| 6 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 7 | Bearings | Noise | X |  |  |  |
| 8 | Bearings | Greasing |  | X |  |  |
| 9 | Hose/Piping | Leakage/Damage | X |  |  |  |
| 10 | Fittings/Valves | Inspection | X |  |  |  |
| 11 | Universal Joints | Greasing |  | X |  |  |
| 12 | Universal Joint Bolts | Check & Tightening | X |  |  |  |
| 13 | Gear Boxes | Oil Level/ Inspection | X |  |  |  |
| 14 | Brake Pads | Condition |  | X |  |  |
| **S.NO** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **AR** | **CHECKING MIRRORS AND INSPECTION TABLE** | | | | | |
| 1 | Pneumatic Cylinder | Inspection | X |  |  |  |
| 2 | FRL Unit | Drain, Regulator & Oil Level |  | X |  |  |
| 3 | Fittings/Valves | Inspection | X |  |  |  |
| **AS** | **EXIT SHEAR PINCH ROLL** | | | | | |
| 1 | Hydraulic Motor | Inspection | X |  |  |  |
| 2 | Pneumatic Cylinder | Inspection | X |  |  |  |
| 3 | FRL Unit | Drain, Regulator & Oil Level |  | X |  |  |
| 4 | Fittings/Valves | Inspection | X |  |  |  |
| 5 | Bearing | Noise | X |  |  |  |
| 6 | Bearing | Greasing |  | X |  |  |
| 7 | Rolls | Condition |  | X |  |  |
| **AT** | **EXIT CROP SHEAR** | | | | | |
| 1 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 2 | Hose / Piping | Leakage/Damage | X |  |  |  |
| 3 | Booker Pins | Inspection |  | X |  |  |
| 4 | Knife | Inspection, Clearance |  | X |  |  |
| 5 | Pneumatic Cylinder | Inspection | X |  |  |  |
| 6 | FRL Unit | Drain, Regulator & Oil Level |  | X |  |  |
| 7 | Knife Holder | Greasing |  | X |  |  |
| 8 | Arms | Greasing |  | X |  |  |
| 9 | Bottom Plate Spring | Inspection |  | X |  |  |
| 10 | Fittings/Valve/Etc. | Inspection | X |  |  |  |
| 11 | Shaft Sleeve | Inspection |  | X |  |  |
| **AU** | **EXIT SCRAP DISPOSAL SYSTEM** | | | | | |
| 1 | Track/Rail | Condition |  | X |  |  |
| 2 | Bearing | Noise | X |  |  |  |
| 3 | Bearings/Pillow Block | Greasing |  | X |  |  |
| 4 | Gear Motor | Noise |  | X |  |  |
| 5 | Gear Box | Oil Level | X |  |  |  |
| 6 | Wheels, Chain, Sprocket, Driving  Shaft | Wear/Condition |  | X |  |  |
| 7 | Roller Chain for Drive | Greasing |  | X |  |  |
| **S.NO** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **AV** | **OILER** | | | | | |
| 1 | Pneumatic Cylinder | Inspection | X |  |  |  |
| 2 | FRL Unit | Drain, Regulator & Oil Level |  | X |  |  |
| 3 | Hose/Piping | Leakage/Damage | X |  |  |  |
| 4 | Fittings/Valve/Etc. | Inspection | X |  |  |  |
| 5 | Gear Pumps | Inspection | X |  |  |  |
| 6 | Strainer | Service |  | X |  |  |
| **AW** | **SIDE GUIDE NO.3** | | | | | |
| 1 | Gear Rack | Inspection/Greasing |  | X |  |  |
| 2 | Cylinder/Pin/Bolts | Inspection/Condition | X |  |  |  |
| 3 | Hose / Piping | Leakage/Damage | X |  |  |  |
| 4 | Guide Rod | Greasing |  | X |  |  |
| 5 | Shaft Sleeve | Inspection |  | X |  |  |
| 6 | Pinion | Greasing |  | X |  |  |
| 7 | Pinion Pin | Inspection |  | X |  |  |
| 8 | Rolls | Inspection/Greasing |  | X |  |  |
| **AX** | **PINCH ROLL NO.4** | | | | | |
| 1 | Rolls | Condition |  | X |  |  |
| 2 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 3 | Bearings | Noise | X |  |  |  |
| 4 | Bearings | Greasing |  | X |  |  |
| 5 | Hose/Piping | Inspection | X |  |  |  |
| 6 | Fittings/Valves/Etc. | Inspection | X |  |  |  |
| 7 | Universal Joints | Greasing |  | X |  |  |
| 8 | Universal Joint Bolts | Check & Tightening | X |  |  |  |
| 10 | Gear Motor | Noise |  | X |  |  |
| 11 | Gear Box | Oil Level | X |  |  |  |
| **AY** | **TENSION REEL ANTIBOW ROLL** | | | | | |
| 1 | Roll | Condition |  | X |  |  |
| 2 | Cylinder/ Pins/Bolts | Inspection | X |  |  |  |
| 3 | Bearings | Noise | X |  |  |  |
| 4 | Bearings | Greasing |  | X |  |  |
| 5 | Hose/Piping | Inspection | X |  |  |  |
| **S.NO** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **AZ** | **THREADING TABLE** | | | | | |
| 1 | Cylinder/Pins/Bolts | Inspection | X |  |  |  |
| 2 | Hose/Piping | Inspection | X |  |  |  |
| **BA** | **TENSION REEL** | | | | | |
| 1 | Mandrel | Overhauling |  |  | X |  |
| 2 | Mandrel | Greasing |  | X |  |  |
| 3 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 4 | Hose/Piping | Leakage/Damage | X |  |  |  |
| 5 | Bearing | Noise | X |  |  |  |
| 6 | Bearing | Greasing |  | X |  |  |
| 7 | Slide Base, Liner | Wear |  | X |  |  |
| 8 | Gear Box | Inspection |  | X |  |  |
| 9 | Lubrication Pump | Inspection |  | X |  |  |
| 10 | Gear Box | Oil Level | X |  |  |  |
| 11 | Gear Motor | Noise |  | X |  |  |
| 12 | Mandrel Sleeve | Greasing |  | X |  |  |
| 13 | Brake Pads | Condition |  |  |  |  |
| 14 | Mandrel Bearing Housing | Greasing |  | X |  |  |
| 15 | Fittings/Valves/Etc. | Inspection | X |  |  |  |
| 16 | Pusher Plate Guides | Greasing |  | X |  |  |
| **BB** | **TENSION REEL TOP PRESS ROLL** | | | | | |
| 1 | Roll | Condition |  | X |  |  |
| 2 | Frame Pin | Inspection |  | X |  |  |
| 3 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 4 | Hose/Piping | Leakage | X |  |  |  |
| 5 | Bearings | Noise | X |  |  |  |
| 6 | Bearings | Greasing |  | X |  |  |
| **BC** | **TENSION REEL BOTTOM PRESS ROLL** | | | | | |
| 1 | Roll | Condition |  | X |  |  |
| 2 | Frame Pin | Inspection |  | X |  |  |
| 3 | Cylinder/Pin/Bolts | Inspection | X |  |  |  |
| 4 | Hose/Piping | Leakage | X |  |  |  |
| 5 | Bearings | Noise | X |  |  |  |
| 6 | Bearings | Greasing |  | X |  |  |
| **BD** | **TENSION REEL OUTBOARD** | | | | | |
| 1 | Mandrel Support Rollers | Condition |  | X |  |  |
| **S.NO** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| 2 | Bearings, Mandrel Support Rollers | Greasing |  | X |  |  |
| 3 | Bearing , OBB Frame | Greasing |  | X |  |  |
| 4 | Cylinder/Pin/Bolts | Condition | X |  |  |  |
| 5 | Hose/Piping | Leakage/Condition | X |  |  |  |
| **BE** | **EXIT COIL CAR** | | | | | |
| 1 | Cylinder/Pin/Bolts | Condition | X |  |  |  |
| 2 | Hose/Piping | Leakage/Damage | X |  |  |  |
| 3 | Rolls | Condition |  | X |  |  |
| 4 | Wheels, Chain, Sprocket | Wear |  | X |  |  |
| 5 | Guide Rod | Greasing |  | X |  |  |
| 6 | Bearing | Greasing |  | X |  |  |
| 7 | Bearing | Noise | X |  |  |  |
| **BF** | **EXIT COIL REST / TRACK** | | | | | |
| 1 | Plummer Block | Condition |  | X |  |  |
| 2 | Moving Plate Bearing | Greasing |  | X |  |  |
| 3 | Coil Seat Panel | Condition |  | X |  |  |
| 4 | Rail Track | Condition |  | X |  |  |
| 5 | Moving Plates Wheel | Greasing/Service |  | X |  |  |
| 6 | Moving Plates Track | Inspection |  | X |  |  |
| **BG** | **CPC HYDRAULIC UNIT** | | | | | |
| 1 | Tank | Inspection |  | X |  |  |
| 2 | Fitting/Valve/Etc. | Leakage/Inspection |  | X |  |  |
| 3 | Filter | Cleaning |  | X |  |  |
| 4 | Heat Exchanger | Cleaning |  | X |  |  |
| **BH** | **EPC HYDRAULIC UNIT** | | | | | |
| 1 | Tank | Inspection |  | X |  |  |
| 2 | Fitting/Valve/Etc. | Leakage/Inspection |  | X |  |  |
| 3 | Filter | Cleaning |  | X |  |  |
| 4 | Heat Exchanger | Cleaning |  | X |  |  |

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| **OVERHEAD CRANE** | | | | | | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **A** | **Load Hook** | | | | | |
| **1** | Load Hook | Inspection | X |  |  |  |
| **2** | Load Hook | Crack Detection | X |  |  |  |
| **B** | **Pulleys (Top & Bottom)** | | | | | |
| **1** | Pulleys (All) | Inspection | X |  |  |  |
| **2** | Pulley (Top) | Note groove depth |  | X |  |  |
| **3** | Pulley (Top) | Note wall thickness |  | X |  |  |
| **4** | Pulley (Bottom) | Inspection |  | X |  |  |
| **C** | **Steel Wire Rope** | | | | | |
| **1** | Wire rope | Inspection | X |  |  |  |
| **2** | Wire rope | Check Diameter | X |  |  |  |
| **3** | Wire rope | Cleaning / Lubrication |  | X |  |  |
| **D** | **Rope Guide** | | | | | |
| **1** | Rope Guide | Inspection | X |  |  |  |
| **2** | Rope Guide | Note groove depth |  | X |  |  |
| **E** | **Long Travel Drive Wheel (BB Side)** | | | | | |
| **1** | Wheel | Inspection | X |  |  |  |
| **2** | Wheel | Check radial / axial play | X |  |  |  |
| **3** | Gears | Backlash | X |  |  |  |
| **4** | Motor | Rotor | X |  |  |  |
| **F** | **Long Travel Drive Wheel (NBB Side)** | | | | | |
| **1** | Wheel | Inspection | X |  |  |  |
| **2** | Wheel | Check radial / axial play | X |  |  |  |
| **3** | Gears | Backlash | X |  |  |  |
| **4** | Motor | Rotor | X |  |  |  |
| **G** | **Long Travel Non Drive Wheel (BB Side)** | | | | | |
| **1** | Wheel | Inspection | X |  |  |  |
| **2** | Wheel | Check radial / axial play | X |  |  |  |
| **3** | Gears | Backlash | X |  |  |  |
| **4** | Motor | Rotor | X |  |  |  |
| **H** | **Long Travel Non Drive Wheel (NBB Side)** | | | | | |
| **1** | Wheel | Inspection | X |  |  |  |
| **2** | Wheel | Check radial / axial play | X |  |  |  |
| **3** | Gears | Backlash | X |  |  |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **4** | Motor | Rotor | X |  |  |  |
| **I** | **Transverse Travel Drive Wheel (Panel Side)** | | | | | |
| **1** | Wheel | Inspection |  | X |  |  |
| **2** | Wheel | Check radial / axial play |  | X |  |  |
| **3** | Gears | Backlash |  | X |  |  |
| **4** | Motor | Rotor |  | X |  |  |
| **J** | **Transverse Travel Drive Wheel (Cabin Side)** | | | | | |
| **1** | Wheel | Inspection |  | X |  |  |
| **2** | Wheel | Check radial / axial play |  | X |  |  |
| **3** | Gears | Backlash |  | X |  |  |
| **4** | Motor | Rotor |  | X |  |  |
| **K** | **Transverse Travel Non Drive Wheel (Panel Side)** | | | | | |
| **1** | Wheel | Inspection |  | X |  |  |
| **2** | Wheel | Check radial / axial play |  | X |  |  |
| **3** | Gears | Backlash |  | X |  |  |
| **4** | Motor | Rotor |  | X |  |  |
| **L** | **Transverse Travel Non Drive Wheel (Cabin Side)** | | | | | |
| **1** | Wheel | Inspection |  | X |  |  |
| **2** | Wheel | Check radial / axial play |  | X |  |  |
| **3** | Gears | Backlash |  | X |  |  |
| **4** | Motor | Rotor |  | X |  |  |
| **M** | **Long Travel System Motors** | | | | | |
| **1** | Brakes | Inspection | X |  |  |  |
| **N** | **Transverse Travel System Motors** | | | | | |
| **1** | Brakes | Inspection | X |  |  |  |
| **O** | **Long Travel System Guide roll Assemblies (All)** | | | | | |
| **1** | Bearings | Inspection | X |  |  |  |
| **2** | Bearings | Lubrication | X |  |  |  |
| **P** | **Transverse Travel System Guide roll Assemblies (All)** | | | | | |
| **1** | Bearings | Inspection | X |  |  |  |
| **2** | Bearings | Lubrication | X |  |  |  |
| **Q** | **Main Hoist** | | | | | |
| **1** | Gear Box | Oil Level | X |  |  |  |
| **2** | Gear Box | Oil Leakages | X |  |  |  |
| **R** | **Trolley** | | | | | |
| **1** | Structure | Inspection |  | X |  |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **2** | Structure | Crack Detection |  | X |  |  |
| **S** | **End Carriages & Girders** | | | | | |
| **1** | Nut / Bolts / Dowel Pins | Tightening |  | X |  |  |
| **2** | Structure | Inspection |  | X |  |  |
| **3** | Structure | Crack Detection |  | X |  |  |
| **T** | **C-Hook** | | | | | |
| **1** | Welded Joints | Crack Detection |  | X |  |  |
| **2** | Teflon / PU Pads | Inspection |  | X |  |  |
| **U** | **Buffer / End Stopper (Both Long Travel & Transverse Travel System)** | | | | | |
| **1** | Buffer / End Stopper | Inspection |  | X |  |  |
|  |  |  |  |  |  |  |
| **OVERHEAD CRANE** | | | | | | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **A** | **Load Hook** | | | | | |
| **1** | Load Hook | Inspection | X |  |  |  |
| **2** | Load Hook | Crack Detection | X |  |  |  |
| **B** | **Pulleys (Top & Bottom)** | | | | | |
| **1** | Pulleys (All) | Inspection | X |  |  |  |
| **2** | Pulley (Top) | Note groove depth |  | X |  |  |
| **3** | Pulley (Top) | Note wall thickness |  | X |  |  |
| **4** | Pulley (Top) | Inspection |  | X |  |  |
| **5** | Pulley (Bottom) | Note groove depth |  | X |  |  |
| **6** | Pulley (Bottom) | Note wall thickness |  | X |  |  |
| **7** | Pulley (Bottom) | Inspection |  | X |  |  |
| **C** | **Steel Wire Rope** | | | | | |
| **1** | Wire rope | Inspection | X |  |  |  |
| **2** | Wire rope | Check Diameter | X |  |  |  |
| **3** | Wire rope | Cleaning/Lubrication |  | X |  |  |
| **E** | **Long Travel Drive Wheel (BB Side)** | | | | | |
| **1** | Wheel | Inspection | X |  |  |  |
| **2** | Wheel | Check collars | X |  |  |  |
| **F** | **Long Travel Drive Wheel (NBB Side)** | | | | | |
| **1** | Wheel | Inspection | X |  |  |  |
| **2** | Wheel | Check collars | X |  |  |  |
| **G** | **Long Travel Non Drive Wheel - Both (BB Side)** | | | | | |
| **1** | Wheel | Inspection | X |  |  |  |
| **2** | Wheel | Check collars | X |  |  |  |
| **G** | **Long Travel Non Drive Wheel - Both (NBB Side)** | | | | | |
| **1** | Wheel | Inspection | X |  |  |  |
| **2** | Wheel | Check collars | X |  |  |  |
| **I** | **Transverse Travel Drive Wheel (Panel Side)** | | | | | |
| **1** | Wheel | Inspection |  | X |  |  |
| **2** | Wheel | Check collars |  | X |  |  |
| **J** | **Transverse Travel Drive Wheel (Power Cabin Side)** | | | | | |
| **1** | Wheel | Inspection |  | X |  |  |
| **2** | Wheel | Check collars |  | X |  |  |
| **K** | **Transverse Travel Non Drive Wheel (Panel Side)** | | | | | |
| **1** | Wheel | Inspection |  | X |  |  |
| **2** | Wheel | Check collars |  | X |  |  |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **L** | **Transverse Travel Non Drive Wheel (Power Cabin Side)** | | | | | |
| **1** | Wheel | Inspection |  | X |  |  |
| **2** | Wheel | Check collars |  | X |  |  |
| **M** | **Long Travel System Motors** | | | | | |
| **1** | Brakes | Inspection | X |  |  |  |
| **N** | **Transverse Travel System Motors** | | | | | |
| **1** | Brakes | Inspection | X |  |  |  |
| **O** | **Lubrication** | | | | | |
| **1** | Drum | Lubrication | X |  |  |  |
| **2** | Pulleys | Lubrication | X |  |  |  |
| **3** | Wheels | Lubrication | X |  |  |  |
| **4** | Couplings | Lubrication | X |  |  |  |
| **Q** | **Hydraulic Unit** | | | | | |
| **1** | Coupling | Inspection | X |  |  |  |
| **R** | **Trolley** | | | | | |
| **1** | Structure | Inspection |  | X |  |  |
| **2** | Structure | Crack Detection |  | X |  |  |
| **S** | **End Carriages & Girders** | | | | | |
| **1** | Nut / Bolts / Dowel Pins | Tightening |  | X |  |  |
| **2** | Structure | Inspection |  | X |  |  |
| **3** | Structure | Crack Detection |  | X |  |  |
| **T** | **C-Hook** | | | | | |
| **1** | Welded Joints | Crack Detection |  | X |  |  |
| **2** | Teflon / PU Pads | Inspection |  | X |  |  |
| **U** | **Buffer / End Stopper (Both Long Travel & Transverse Travel System)** | | | | | |
| **1** | Buffer / End Stopper | Inspection |  | X |  |  |
| **Q** | **Main Hoist** | | | | | |
| **1** | Gear Box | Oil Level | X |  |  |  |
| **2** | Gear Box | Oil Leakages | X |  |  |  |
| **3** | Gear Box | Note Vibration |  | X |  |  |

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| --- | --- | --- | --- | --- | --- | --- |
| **PEB** | | | | | | |
| **S.NO.** | **LOCATION** | **ACTIVITIES** | **FREQUENCY** | | | |
| **WEEKLY** | **MONTHLY** | **QUARTERLY** | **HALF YEARLY** |
| **A** | **Crane Track Beam (Top)** | | | | | |
| **1** | Bay-1 | Bolts tightening | X |  |  |  |
| **2** | Bay-2 | Bolts tightening | X |  |  |  |
| **3** | Bay-3 | Bolts tightening | X |  |  |  |
| **B** | **Crane Track Beam (Bottom)** | | | | | |
| **1** | Bay-1 | Bolts tightening | X |  |  |  |
| **2** | Bay-2 | Bolts tightening | X |  |  |  |
| **3** | Bay-3 | Bolts tightening | X |  |  |  |
| **C** | **Billet / Runway** | | | | | |
| **1** | Bay-1 | Inspection | X |  |  |  |
| **2** | Bay-2 | Inspection | X |  |  |  |
| **3** | Bay-3 | Inspection | X |  |  |  |
| **D** | **Lifeline** | | | | | |
| **1** | Bay-1 | Inspection | X |  |  |  |
| **2** | Bay-2 | Inspection | X |  |  |  |
| **3** | Bay-3 | Inspection | X |  |  |  |
| **E** | **Rollup Door (All)** | | | | | |
| **1** | Bay-1 | Inspection / Mandatory Repairs | X |  |  |  |
| **2** | Bay-2 | Inspection / Mandatory Repairs | X |  |  |  |
| **3** | Bay-3 | Inspection / Mandatory Repairs | X |  |  |  |

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| **COMPACT COLD MILL** | | | | | | |
| **S.NO.** | **LOCATION** | **ACTIVITIES/CHECK FOR** | **FREQUENCY** | | | |
| **DAILY** | **WEEKLY** | **MONTHLY** | **YEARLY** |
| **PREPARATION SECTION** | | | | | | |
| **A** | **POR WITH SHIFTING FRAME** | | | | | |
| 1 | Lubrication | Working of Lubrication | X |  |  |  |
| 2 | Lubrication | Lubrication status on gears, bearings and sliding parts |  | X |  |  |
| 3 | Bearings | Temperature, noise, vibration on bearing parts | X |  |  |  |
| 4 | Bolts | tight/loose check |  | X |  |  |
| 5 | Media | Check leakage of Oil, Air, Water etc. |  | X |  |  |
| 6 | Bush/Sliding liners | Check for wear. |  |  | X |  |
| 7 | Hoses/Fittings | Check for leakage/wear |  |  | X |  |
| 8 | Brakes | Check Operations |  |  | X |  |
| 9 | Oil Seals | Wear of Oil seals/packing |  |  | X |  |
| 10 | Gripper | Operations |  | X |  |  |
| 11 | Lubricants | Viscosity of Lubricants |  |  | X |  |
| 15 | Couplings | Alignment of coupling parts |  |  | X |  |
| **B** | **SNUBBER ROLL** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Drive | Function (repair/replace) | X |  |  |  |
| 8 | Lubrication System (Top up/ adjust/Adapt) |  |  | X |  |
| 9 | Seal | Check for leakage/wear |  |  | 3M |  |
| 10 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| 11 | Roller/barrel surface | Damages/corrosion/wear |  |  | X |  |
| 12 | Couplings | Function |  |  |  | X |
| 13 | Lubrication System (Top up/ adjust/Adapt) |  | X |  |  |
| 14 | Bearings | Assembly Function |  |  | 6M |  |
| 15 | Centralized Lubrication |  | X |  |  |
| 16 | Toothing | Wear/Contact pattern |  |  | 6M |  |
| 17 | Centralized Lubrication | Oil Volume/Temperature/Quality |  | X |  |  |
| 18 | Cylinder | Function | X |  |  |  |
| 19 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 20 | Sealing |  |  | 3M |  |
| **C** | **OUTBOARD BEARING SUPPORT** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| 8 | Roller Support | Position/Damage/Wear |  |  | X |  |
| 9 | Sleeves in lever | Function/Wear |  |  | 3M |  |
| 10 | Cylinder | Function | X |  |  |  |
| 11 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 12 | Sealing |  |  | X |  |
| **D** | **PIVOTING TELESCOPIC TABLE** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Rolls (Deflector roll) | Damages/corrosion/wear |  |  | 3M |  |
| 8 | Cylinder | Function | X |  |  |  |
| 9 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 10 | Sealing |  |  | X |  |
| 11 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **E** | **P. TABLE WITH COIL PEELER** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Peeler Knife | Visual Check | X |  |  |  |
| 8 | wear |  |  | X |  |
| 9 | Cylinder | Function | X |  |  |  |
| 10 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 11 | Sealing |  |  | X |  |
| 12 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| 13 | Guide Clearance | Tolerances (Readjust, replace) |  |  | 6M |  |
| 14 | Table Surface | Contamination(clean) | X |  |  |  |
| 15 | Damages/corrosion/wear |  |  | 3M |  |
| **F** | **3-ROLL PINCH** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Deflector roll/ pinch roll/ bending roll | Condition/wear |  | X |  |  |
| 8 | Bearings | Assembly Function |  |  | 6M |  |
| 9 | Wear/Sealing |  |  | 6M |  |
| 10 | Cylinder | Function | X |  |  |  |
| 11 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 12 | Sealing |  |  | X |  |
| 13 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **G** | **BASEFRAME** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **H** | **STRIP CENTER DETECTION** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Light Barrier/Sensor | Contamination/Dirt |  | X |  |  |
| 8 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **I** | **STRIP GUIDE UNIT** | | | | | |
| 1 | Guide rollers | Check for damage and wear |  | X |  |  |
| 2 | Wear liners | Check wear |  |  | 3M |  |
| 3 | Synchronizing Equipment | Tooth break, damage/wear |  |  | 3M |  |
| 4 | Function |  |  | 3M |  |
| 5 | Cylinder | Function | X |  |  |  |
| 6 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 7 | Sealing |  |  | X |  |
| 8 | Connections for Hydraulics, pipelines, hoses, fittings, valves | Check for damage and wear |  |  | X |  |
| 9 | Guide Plates | Volumetric Flow rate |  |  | X |  |
| 10 | Check for damage and wear |  |  | X |  |
| 11 | Bearing Assembly | Centralized Lubrication |  | X |  |  |
| 12 | Lubrication of Sliding Liners |  |  | X |  |
| **TENSION REEL 1** | | | | | | |
| **J** | **4-SEGMENT TENSION REEL** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear of segments |  |  |  | X |
| 6 | Check wedge surfaces of mandrel for wear |  |  | 6M |  |
| 7 | Contamination/Dirt |  |  | X |  |
| 8 | Guide | Function |  |  |  | X |
| 9 | Wear of sliding plate |  |  | X |  |
| 10 | Bearing Assembly | Function(Clearance/working) |  |  | 3M |  |
| 11 | Lubrication(Top up/Adjust/Adapt) |  |  | 3M |  |
| 12 | Bearing Temperature(must be <80C) |  | X |  |  |
| 13 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| 14 | Hollow Shaft's Bushes | Contaminations |  |  | 6M |  |
| 15 | Wear of bushes |  |  |  | X |
| 16 | Wear of toothing |  |  |  | X |
| 17 | Couplings | Function |  |  |  | X |
| 18 | Lubrication System (Top up/ adjust/Adapt) |  |  | 6M |  |
| 19 | Leaks |  |  | 3M |  |
| 20 | Brakes | Check for brake damages after every sudden brake |  |  | X |  |
| 21 | Gear Unit | Function | X |  |  |  |
| 22 | Lubrication(Top up/Adjust/Adapt) | X |  |  |  |
| 23 | Toothing | Wear/Contact pattern |  |  | 3M |  |
| 24 | Cylinder | Function | X |  |  |  |
| 25 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 26 | Sealing |  |  | X |  |
| 37 | Strip Gripper Segment | Function |  | X |  |  |
| 38 | Leaks |  |  | X |  |
| 39 | Wear of Bending Ledges |  |  | 6M |  |
| **K** | **DRIVEN SNUBBER ROLL** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear of segments |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Swivel Drive | Function |  |  | 6M |  |
| 8 | Lubrication |  |  | X |  |
| 9 | Wear |  |  |  | X |
| 10 | Bearing Assembly | Function |  |  | 6M |  |
| 11 | Centralized Lubrication |  | X |  |  |
| 12 | Wear |  |  |  | X |
| 13 | Cylinder | Function | X |  |  |  |
| 14 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 15 | Sealing |  |  | 3M |  |
| 16 | Fluid lines/Connections | Leakages |  |  | 3M |  |
| 17 | Flow Rate |  |  | X |  |
| **L** | **STRIPPER PLATE** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear of segments |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Sliding blocks, springs, rolls | Damage/Spring force/wear |  |  | 3M |  |
| 13 | Cylinder | Function | X |  |  |  |
| 14 | Bearing Assembly(Fasten/replace/repair) |  |  | 6M |  |
| 15 | Sealing |  |  | 3M |  |
| 16 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **ENTRY SECTION** | | | | | | |
| **M** | **MANDREL SUPPORT** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear of segments |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Support | Wear |  |  | X |  |
| 8 | Marks and Scores |  |  | X |  |
| 9 | Centering Device |  |  | 6M |  |
| 10 | Bearing Assembly | Function |  |  | 6M |  |
| 11 | Centralized Lubrication |  | X |  |  |
| 12 | Wear |  |  |  | X |
| 13 | Sleeves in lever | Function/Wear |  |  | 3M |  |
| 14 | Cylinder | Function | X |  |  |  |
| 15 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 16 | Sealing |  |  | 3M |  |
| 17 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **N** | **PIVOTING TELESCOPIC TABLE** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear of segments |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Front table and pivoting table surface | Damage/wear | X |  |  |  |
| 8 | Guide ledges | Damage/wear |  |  | X |  |
| 9 | Bearing Assembly | Function |  |  |  | X |
| 10 | Cylinder | Function | X |  |  |  |
| 11 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 12 | Sealing | X |  |  |  |
| 13 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **O** | **BASEFRAME** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **P** | **BENDING ROLLS** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Pinch and Bending roll | Function/wear |  |  | 3M |  |
| 8 | Scoring |  | X |  |  |
| 9 | Cylinder | Function | X |  |  |  |
| 10 | Bearing Assembly(Fasten/replace/repair) |  |  | 6M |  |
| 11 | Sealing |  | X |  |  |
| 12 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **Q** | **DIVIDING SHEAR** | | | | | |
| 1 | Frame Guide | Damage |  |  | 3M |  |
| 2 | Wear |  |  | 3M |  |
| 3 | Clearance |  |  |  | X |
| 4 | Knife | Wear/Damage, especially cutting edge |  | X |  |  |
| 5 | Sled Guide | Damage(smooth surface) |  |  |  | Y |
| 6 | Cylinder | Function |  |  | X |  |
| 7 | Fastening |  |  | X |  |
| 8 | Sealing |  |  | X |  |
| 9 | Wear |  |  |  | X |
| 10 | Synchronizing Shaft (gearwheel, bearing) | Condition/damage |  |  | 3M |  |
| 11 | Connections for Hydraulics, pipelines, hoses, fittings, valves | Fastening |  |  | X |  |
| 12 | Sealing |  |  | X |  |
| 13 | Condition/damage |  |  |  | X |
| **R** | **STRIP PRESS** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Guide Plates | Damage/wear |  |  | 3M |  |
| 8 | Wear liners | Damage |  |  | 3M |  |
| 9 | Wear |  |  |  | X |
| 10 | Synchronizing Equipment | Damage |  |  | 3M |  |
| 11 | Wear/Tooth break |  |  |  | X |
| 12 | Noise | X |  |  |  |
| 10 | Cylinder | Function | X |  |  |  |
| 11 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 12 | Sealing |  |  | X |  |
| 12 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **MILL STAND 1** | | | | | | |
| **S** | **DRY STRIP SYSTEM** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Cylinder | Function | X |  |  |  |
| 8 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 9 | Sealing |  | X |  |  |
| 10 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| 11 | Nozzles | Spray pattern |  | X |  |  |
| 12 | Suction Force | Passage/Cleanliness |  | X |  |  |
| **T** | **BED PLATES** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | 3M |  |
| 7 | Leak tightness |  |  | 6M |  |
| 8 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **U** | **MILL HOUSING WITH ACCESSORIES** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| 8 | Guide | Function |  |  |  | X |
| 9 | Lubrication of Sliding Liners |  |  | X |  |
| 10 | Centralized Lubrication | Oil Volume/Temperature/Quality | X |  |  |  |
| 11 | Cylinder | Function | X |  |  |  |
| 12 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 13 | Sealing |  |  | X |  |
| **V** | **HYDRAULIC ADJUSTMENTS (SONY TRANSDUCER)** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| 11 | Cylinder | Function | X |  |  |  |
| 12 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 13 | Sealing |  |  | X |  |
| **W** | **CYINDER/ BENDING BLOCKS** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| 8 | WR Bending blocks with guide bars | Function, Ease of movement |  |  | X |  |
| 9 | WR Keeper system Locking pin | Wear |  |  | 3M |  |
| 10 | Cylinder | Function | X |  |  |  |
| 11 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 12 | Sealing |  |  | X |  |
| 13 | Wiper and seals | Visual check, replace if damaged |  |  | 3M |  |
| 14 | Drain bore in bending block | Check for clogging, clean at regular intervals |  |  | X |  |
| **X** | **CVC SHIFTING** | | | | | |
| 1 | General (CVC Shifting Cylinder) | Fastening |  | X |  |  |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function |  | X |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  |  | X |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Retracting Rails/ Sliding liners | Wear |  |  |  | X |
| 8 | Interlocking Cylinders | Function |  | X |  |  |
| 9 | Fastening |  | X |  |  |
| 10 | Wear |  |  |  | X |
| 11 | Seal |  | X |  |  |
| 12 | Locking pins | Wear |  |  | 3M |  |
| 13 | Cylinder | Function | X |  |  |  |
| 14 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 15 | Sealing |  |  | X |  |
| 16 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **Y** | **WEDGE ADJUSTMENT SYSTEM** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| 8 | Guide | Function |  |  |  | X |
| 9 | Lubrication of Sliding Liners |  |  | X |  |
| 10 | Stripper | Wear/Contamination |  |  | X |  |
| 11 | Cylinder | Function | X |  |  |  |
| 12 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 13 | Sealing |  |  | X |  |
| **Z** | **SPINDLE HEAD SUPPORT** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  | X |  |  |
| 6 | Contamination/Dirt |  | X |  |  |
| 7 | Guide | Centralized Lubrication |  | X |  |  |
| 8 | Wear |  | X |  |  |
| 9 | Bushes | Wear |  | X |  |  |
| 10 | Hydraulic Cylinders | Function | X |  |  |  |
| 11 | Seal |  | X |  |  |
| **AA** | **EMULSION SPRAYING SYSTEM** | | | | | |
| 1 | Flat-jet nozzles | Spray pattern | X |  |  |  |
| 2 | Pipework | Leaks | X |  |  |  |
| **AB** | **MULTIZONE COOLING SYSTEM** | | | | | |
| 1 | Flat-jet nozzles | Spray pattern | X |  |  |  |
| 2 | Pipework | Leaks | X |  |  |  |
| **AC** | **BUR CHANGING DEVICE** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  | X |  |  |
| 6 | Contamination/Dirt |  | X |  |  |
| 7 | Cylinder | Function | X |  |  |  |
| 8 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 9 | Sealing |  |  | X |  |
| 10 | Rails and Wheels | Wear, Contaminate |  |  | 3M |  |
| 11 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **WORK ROLL CHANGING DEVICE** | | | | | | |
| **AD** | **UNDER CARRIAGE** | | | | | |
| 1 | Keeper system | Function |  | X |  |  |
| 2 | Track Wheels surface and bearing assembly | Fastening, Conditioning, Sealing, |  |  | 6M |  |
| 3 | Wear |  |  |  | X |
| 4 | Gear Wheels | Wear |  |  |  | X |
| 5 | Inching Drive | Function |  | X |  |  |
| 6 | Fastening |  |  | 6M |  |
| 7 | Sealing |  | X |  |  |
| 8 | Wear |  |  |  | X |
| 9 | Guides | Condition |  | X |  |  |
| 10 | Wear |  |  |  | X |
| **AE** | **SIDE SHIFTER DRIVE** | | | | | |
| 1 | Universal Joint Shaft | Function |  | X |  |  |
| 2 | Condition |  |  | 6M |  |
| 3 | Wear |  |  |  | X |
| 4 | Bearing Assembly | Wear |  |  |  | X |
| 5 | Travel Drive | Function |  | X |  |  |
| 6 | fastening |  |  | 6M |  |
| 7 | Sealing |  | X |  |  |
| 8 | Wear |  |  |  | X |
| 9 | Track Wheels surface and bearing assembly | Fastening, Conditioning, Sealing, |  |  | 6M |  |
| 10 | Wear |  |  |  | X |
| 11 | Guides | Condition/Align |  | X |  |  |
| 12 | Wear |  |  |  | X |
| 13 | Gear Rack | Wear |  |  |  | X |
| 14 | Guide rollers | Function/position |  |  | X |  |
| **AF** | **TONG CAR** | | | | | |
| 1 | Travel Drive | Function |  | X |  |  |
| 2 | fastening |  |  | 6M |  |
| 3 | Sealing |  | X |  |  |
| 4 | Wear |  |  |  | X |
| 5 | Gear Wheels | Wear |  |  |  | X |
| 6 | Inching Drive | Function |  | X |  |  |
| 7 | Fastening |  |  | 6M |  |
| 8 | Sealing |  | X |  |  |
| 9 | Wear |  |  |  | X |
| 10 | Tong Head | Functioning |  | X |  |  |
| 11 | Fastening |  |  | 6M |  |
| 12 | Condition |  |  | 6M |  |
| 13 | Wear |  |  |  | X |
| 14 | Spring Force Buffer | Function |  |  | X |  |
| 15 | Track Wheel Clearance in Track rails | Function |  |  | X |  |
| **INTERSTAND** | | | | | | |
| **AG** | **STRIP DEFLECTOR** | | | | | |
| 1 | Peeler Knife | Function | X |  |  |  |
| 2 | Surface |  |  |  | X |
| **AH** | **HOLD DOWN ROLL** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  | X |  |  |
| 6 | Contamination/Dirt |  | X |  |  |
| 7 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| 8 | Roll/Barrel Function | Damage/Corrosion/Wear |  |  | X |  |
| 9 | Bearing Assembly | Function |  |  | X |  |
| 10 | Lubrication System (Top up/ adjust/Adapt) |  | X |  |  |
| 11 | Cylinder | Function | X |  |  |  |
| 12 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 13 | Sealing |  |  | X |  |
| **AI** | **BASEFRAME** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  | X |  |  |
| 6 | Contamination/Dirt |  | X |  |  |
| 7 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **AJ** | **STRIP TENSIOMETER** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  | X |  |  |
| 6 | Contamination/Dirt |  | X |  |  |
| 7 | Roll Barrel Surface | Damage/Corrosion/Wear |  | X |  |  |
| 8 | Bearing Assembly | Function |  |  |  | X |
| 9 | Shaft seal | Grease/Condition |  |  | 3M |  |
| **AK** | **PASSLINE ROLL** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  | X |  |  |
| 6 | Contamination/Dirt |  | X |  |  |
| 7 | Roll Barrel Surface | Damage/Corrosion/Wear |  | X |  |  |
| 8 | Bearing Assembly | Function |  |  |  | X |
| 9 | Shaft seal | Grease/Condition |  |  | 3M |  |
| **BUR CHANGE DEVICE** | | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  | X |  |  |
| 6 | Contamination/Dirt |  | X |  |  |
| 7 | Cylinder | Function | X |  |  |  |
| 8 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 9 | Sealing |  |  | X |  |
| 10 | Rails and Wheels | Wear/Contamination |  |  | 3M |  |
| 11 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
|  |  |  |  |  |  |  |
| **MILL STAND 2** | | | | | | |
| **AL** | **DRY STRIP SYSTEM** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Cylinder | Function | X |  |  |  |
| 8 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 9 | Sealing |  | X |  |  |
| 10 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| 11 | Nozzles | Spray pattern |  | X |  |  |
| 12 | Suction Force | Passage/Cleanliness |  | X |  |  |
| **AM** | **BED PLATES** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | 3M |  |
| 7 | Leak tightness |  |  | 6M |  |
| 8 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **AN** | **MILL HOUSING WITH ACCESSORIES** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| 8 | Guide | Function |  |  |  | X |
| 9 | Lubrication of Sliding Liners |  |  | X |  |
| 10 | Centralized Lubrication | Oil Volume/Temperature/Quality | X |  |  |  |
| 11 | Cylinder | Function | X |  |  |  |
| 12 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 13 | Sealing |  |  | X |  |
| **AO** | **HYDRAULIC ADJUSTMENTS (SONY TRANSDUCER)** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| 11 | Cylinder | Function | X |  |  |  |
| 12 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 13 | Sealing |  |  | X |  |
| **AP** | **CYINDER/ BENDING BLOCKS** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| 8 | WR Bending blocks with guide bars | Function, Ease of movement |  |  | X |  |
| 9 | WR Keeper system Locking pin | Wear |  |  | 3M |  |
| 10 | Cylinder | Function | X |  |  |  |
| 11 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 12 | Sealing |  |  | X |  |
| 13 | Wiper and seals | Visual check, replace if damaged |  |  | 3M |  |
| 14 | Drain bore in bending block | Check for clogging, clean at regular intervals |  |  | X |  |
| **AQ** | **CVC SHIFTING** | | | | | |
| 1 | General (CVC Shifting Cylinder) | Fastening |  | X |  |  |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function |  | X |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  |  | X |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Retracting Rails/ Sliding liners | Wear |  |  |  | X |
| 8 | Interlocking Cylinders | Function |  | X |  |  |
| 9 | Fastening |  | X |  |  |
| 10 | Wear |  |  |  | X |
| 11 | Seal |  | X |  |  |
| 12 | Locking pins | Wear |  |  | 3M |  |
| 13 | Cylinder | Function | X |  |  |  |
| 14 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 15 | Sealing |  |  | X |  |
| 16 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **AR** | **WEDGE ADJUSTMENT SYSTEM** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| 8 | Guide | Function |  |  |  | X |
| 9 | Lubrication of Sliding Liners |  |  | X |  |
| 10 | Stripper | Wear/Contamination |  |  | X |  |
| 11 | Cylinder | Function | X |  |  |  |
| 12 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 13 | Sealing |  |  | X |  |
| **AS** | **SPINDLE HEAD SUPPORT** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  | X |  |  |
| 6 | Contamination/Dirt |  | X |  |  |
| 7 | Guide | Centralized Lubrication |  | X |  |  |
| 8 | Wear |  | X |  |  |
| 9 | Bushes | Wear |  | X |  |  |
| 10 | Hydraulic Cylinders | Function | X |  |  |  |
| 11 | Seal |  | X |  |  |
| **AT** | **EMULSION SPRAYING SYSTEM** | | | | | |
| 1 | Flat-jet nozzles | Spray pattern | X |  |  |  |
| 2 | Pipework | Leaks | X |  |  |  |
| **AU** | **MULTIZONE COOLING SYSTEM** | | | | | |
| 1 | Flat-jet nozzles | Spray pattern | X |  |  |  |
| 2 | Pipework | Leaks | X |  |  |  |
| **AV** | **BUR CHANGING DEVICE** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  | X |  |  |
| 6 | Contamination/Dirt |  | X |  |  |
| 7 | Cylinder | Function | X |  |  |  |
| 8 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 9 | Sealing |  |  | X |  |
| 10 | Rails and Wheels | Wear, Contaminate |  |  | 3M |  |
| 11 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **FUME EXHAUST SYSTEM** | | | | | | |
| 1 | Conditioning Unit | Cleanliness |  |  | X |  |
| 2 | Fan | Function/Leaks | X |  |  |  |
| 3 | Impeller |  |  | X |  |
| 4 | Fluid lines/Connections | Leakages, Flow rate | X |  |  |  |
| **EXIT SECTION** | | | | | | |
| **AW** | **DRY STRIP SYSTEM** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  | X |  |  |
| 6 | Contamination/Dirt |  | X |  |  |
| 7 | Cylinder | Function | X |  |  |  |
| 8 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 9 | Sealing |  |  | X |  |
| 10 | Fluid lines/Connections | Leakages, Flow rate | X |  |  |  |
| 11 | Nozzles | Spray pattern |  | X |  |  |
| 12 | Suction Force | Passage/Cleanliness |  | X |  |  |
| **AX** | **MANDREL SUPPORT** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear of segments |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Support | Wear |  |  | X |  |
| 8 | Marks and Scores |  |  | X |  |
| 9 | Centering Device |  |  | 6M |  |
| 10 | Bearing Assembly | Function |  |  | 6M |  |
| 11 | Centralized Lubrication |  | X |  |  |
| 12 | Wear |  |  |  | X |
| 13 | Sleeves in lever | Function/Wear |  |  | 3M |  |
| 14 | Cylinder | Function | X |  |  |  |
| 15 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 16 | Sealing |  |  | 3M |  |
| 17 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **AY** | **PIVOTING TELESCOPIC TABLE** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear of segments |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Front table and pivoting table surface | Damage/wear | X |  |  |  |
| 8 | Guide ledges | Damage/wear |  |  | X |  |
| 9 | Bearing Assembly | Function |  |  |  | X |
| 10 | Cylinder | Function | X |  |  |  |
| 11 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 12 | Sealing | X |  |  |  |
| 13 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **AZ** | **BASEFRAME** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **AAA** | **BENDING ROLLS** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Pinch and Bending roll | Function/wear |  |  | 3M |  |
| 8 | Scoring |  | X |  |  |
| 9 | Cylinder | Function | X |  |  |  |
| 10 | Bearing Assembly(Fasten/replace/repair) |  |  | 6M |  |
| 11 | Sealing |  | X |  |  |
| 12 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **AAB** | **DIVIDING SHEAR** | | | | | |
| 1 | Frame Guide | Damage |  |  | 3M |  |
| 2 | Wear |  |  | 3M |  |
| 3 | Clearance |  |  |  | X |
| 4 | Knife | Wear/Damage, especially cutting edge |  | X |  |  |
| 5 | Sled Guide | Damage(smooth surface) |  |  |  | Y |
| 6 | Cylinder | Function |  |  | X |  |
| 7 | Fastening |  |  | X |  |
| 8 | Sealing |  |  | X |  |
| 9 | Wear |  |  |  | X |
| 10 | Synchronizing Shaft (gearwheel, bearing) | Condition/damage |  |  | 3M |  |
| 11 | Connections for Hydraulics, pipelines, hoses, fittings, valves | Fastening |  |  | X |  |
| 12 | Sealing |  |  | X |  |
| 13 | Condition/damage |  |  |  | X |
| **AAC** | **STRIP PRESS** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Guide Plates | Damage/wear |  |  | 3M |  |
| 8 | Wear liners | Damage |  |  | 3M |  |
| 9 | Wear |  |  |  | X |
| 10 | Synchronizing Equipment | Damage |  |  | 3M |  |
| 11 | Wear/Tooth break |  |  |  | X |
| 12 | Noise | X |  |  |  |
| 10 | Cylinder | Function | X |  |  |  |
| 11 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 12 | Sealing |  |  | X |  |
| 12 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **TENSION REEL 2** | | | | | | |
| **AAD** | **STRIP PRESS** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  | X |  |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear |  |  | 3M |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Roller Bearing Assembly | Function |  |  | 6M |  |
| 8 | Wear |  |  |  | X |
| 9 | Swivel Drive | Function |  |  | 6M |  |
| 10 | Wear |  |  |  | 2Y |
| 11 | Pivoting Arm, bearing assembly | Function |  |  | 6M |  |
| 12 | Wear |  |  |  | 2Y |
| 13 | Fluid lines/ Connections | Leakages |  |  | 3M |  |
| 14 | Flow Rate |  |  | X |  |
| 15 | Cylinder | Function | X |  |  |  |
| 16 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 17 | Sealing |  |  | X |  |
| **AAE** | **4-SEGMENT TENSION REEL** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear of segments |  |  |  | X |
| 6 | Check wedge surfaces of mandrel for wear |  |  | 6M |  |
| 7 | Contamination/Dirt |  |  | X |  |
| 8 | Guide | Function |  |  |  | X |
| 9 | Wear of sliding plate |  |  | X |  |
| 10 | Bearing Assembly | Function(Clearance/working) |  |  | 3M |  |
| 11 | Lubrication(Top up/Adjust/Adapt) |  |  | 3M |  |
| 12 | Bearing Temperature(must be <80C) |  | X |  |  |
| 13 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| 14 | Hollow Shaft's Bushes | Contaminations |  |  | 6M |  |
| 15 | Wear of bushes |  |  |  | X |
| 16 | Wear of toothing |  |  |  | X |
| 17 | Couplings | Function |  |  |  | X |
| 18 | Lubrication System (Top up/ adjust/Adapt) |  |  | 6M |  |
| 19 | Leaks |  |  | 3M |  |
| 20 | Brakes | Check for brake damages after every sudden brake |  |  | X |  |
| 21 | Gear Unit | Function | X |  |  |  |
| 22 | Lubrication(Top up/Adjust/Adapt) | X |  |  |  |
| 23 | Toothing | Wear/Contact pattern |  |  | 3M |  |
| 24 | Cylinder | Function | X |  |  |  |
| 25 | Bearing Assembly(Fasten/replace/repair) |  |  |  | X |
| 26 | Sealing |  |  | X |  |
| 37 | Strip Gripper Segment | Function |  | X |  |  |
| 38 | Leaks |  |  | X |  |
| 39 | Wear of Bending Ledges |  |  | 6M |  |
| **AAF** | **STRIPPER PLATE** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear of segments |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Sliding blocks, springs, rolls | Damage/Spring force/wear |  |  | 3M |  |
| 8 | Cylinder | Function | X |  |  |  |
| 9 | Bearing Assembly(Fasten/replace/repair) |  |  | 6M |  |
| 10 | Sealing |  |  | 3M |  |
| 11 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| **COIL HANDLING** | | | | | | |
| **AAG** | **GENERAL** | | | | | |
| 1 | General | Fastening |  |  |  | X |
| 2 | Condition(damage) |  |  | X |  |
| 3 | Function | X |  |  |  |
| 4 | Unusual Noise |  |  | X |  |
| 5 | Wear of segments |  |  | X |  |
| 6 | Contamination/Dirt |  |  | X |  |
| 7 | Lifting Mechanism | Lifting/seals/wear (cylinder /connections/ guides/rollers) |  |  | X |  |
| 8 | Travel Gear | Track wheels (Movement/condition/wear) |  |  |  | X |
| 9 | Rubber buffer |  |  | 6M |  |
| 10 | Warehouse |  |  | 6M |  |
| 11 | Gear Unit |  |  |  | X |
| 12 | Coupling lining |  |  |  | X |
| 13 | Track rails | Condition/ wear |  |  |  | X |
| 14 | Power Track | Seal |  |  | 3M |  |
| 15 | Condition/wear |  |  | 6M |  |
| 16 | Fluid lines/Connections | Leakages, Flow rate |  |  | X |  |
| 17 | Supporting Plates | Fastening |  |  | 3M |  |
| **MEDIA SYSTEMS** | | | | | | |
| **AAH** | **HYDRAULIC SYSTEMS** | | | | | |
| 1 | Fluid | Chemical analysis for contamination |  |  | X |  |
| 2 | Tank | Leaks | X |  |  |  |
| 3 | Corrosion |  |  | X |  |
| 4 | Level | X |  |  |  |
| 5 | Temperature | X |  |  |  |
| 6 | Clogging of Air filters |  | X |  |  |
| 7 | HP Pump package | Pump running noises | X |  |  |  |
| 8 | Housing temperature | X |  |  |  |
| 9 | Pressure setting | X |  |  |  |
| 10 | Leak oil quantity |  |  | 3M |  |
| 11 | Circulation pump package | Housing temperature | X |  |  |  |
| 12 | Pressure setting | X |  |  |  |
| 13 | Pump running noises | X |  |  |  |
| 14 | Filters | Pressure filter (inspection for clogging) |  | X |  |  |
| 15 | Circulating filters (inspection for clogging) |  | X |  |  |
| 16 | Return line filters (inspection for clogging) |  | X |  |  |
| 17 | Cooling Systems (Heat exchangers/ valves/ filters) | Leaks |  | X |  |  |
| 18 | Contamination in heat exchangers |  |  |  | X |
| 19 | Clogging of Water filters |  | X |  |  |
| 20 | Switching of valves |  | X |  |  |
| 21 | Accumulator | Switching operations of shutoff valves/ pressure relief valves etc. |  | X |  |  |
| 22 | Nitrogen charging pressure |  |  | X |  |
| 23 | Corrosion |  |  | 3M |  |
| 24 | Directional Control Valves | Switching operations |  | X |  |  |
| 25 | Proportional Valves | Operation |  | X |  |  |
| 26 | Servo Valves | Housing temperature |  | X |  |  |
| 27 | Leak oil quantity |  |  | 3M |  |
| 28 | Pressure Valve | Operation |  |  | X |  |
| 29 | Throttle Valves/ Flow Control Valves | Operation |  |  | X |  |
| 30 | Pipework | Leaks | X |  |  |  |
| 31 | Corrosion |  |  | X |  |
| 32 | Fastening |  | X |  |  |
| 33 | Hoses/Rubber expansion joints | Damage/ Chafe marks/ tightening | X |  |  |  |
| 34 | Cylinders/ Tilting/ Motors | Collars/ wipers | X |  |  |  |
| 35 | Seals | X |  |  |  |
| 36 | Piston rods | X |  |  |  |
| 37 | cushioning |  |  | X |  |
| 38 | Leak Oil Trays, retention system | Corrosion/ Tightness/ Function |  | X |  |  |
| **AAI** | **PNEUMATIC SYSTEMS** | | | | | |
| 1 | Accumulator condensate drain | Condensate in Tank |  | X |  |  |
| 2 | Filter with automatic condensate drain | Filter Clogging |  | X |  |  |
| 3 | Automatic draining of condensate |  |  | X |  |
| 4 | Filter with manual condensate drain | Filter Clogging |  | X |  |  |
| 5 | Condensate drain | 3D |  |  |  |
| 6 | Oiler | Oil Level |  | X |  |  |
| 7 |  | Drop rate |  |  | X |  |
| 8 | Directional Control Valves | Switching Operations |  |  | X |  |
| 9 | Pipework | Leaks | X |  |  |  |
| 10 | Corrosion |  |  | X |  |
| 11 | Fastening |  | X |  |  |
| 12 | Hoses | Damage | X |  |  |  |
| 13 | Chafe marks | X |  |  |  |
| 14 | Proper attachments / Fastening | X |  |  |  |
| 15 | Cylinders/ Tilting/ Motors | Collars/ wipers | X |  |  |  |
| 16 | Seals | X |  |  |  |
| 17 | Piston rods | X |  |  |  |
| 18 | cushioning |  | X |  |  |