



Technical Sales and Service Processing

Service Report

For Tetra Tebel Block former TV

Customer data

Name:

Site:

Asset description:

Equipment data

Machine:

Serial Number:

Performed on:

Job number:

Performed by:

Service Description

Tetra Pak conducted a 12,000-hour service to Blockformer 1.

The Service was carried out in accordance to the recommendation's and procedures outlined in the Technical manual.

As part of the service provided our certified Engineers inspect, assess and identify ways to improve the reliability of the equipment which will be outlined below in recommendation.

Conclusions

Tetra Pak has performed an equipment assessment on completion of the service performed:

Assessment conclusions

☐ **Good condition:**

All parts are in good condition and no further need for servicing exists at this moment.

☐ **Service advice:**

One or more assessed items shows signs of wear, or are for other reasons advised to be scheduled for maintenance (e.g. at next planned service).

☐ **Service alert:**

Immediate action is recommended for one or more assessed items (e.g. replacing a part due to wear).

*See comments for the affected service task in the section Service Task Overview and also listed in notes and recommendations.

Service task overview

- Complete JSA before commencing work
- Perform Isolations
- Perform 12,000-hour Service as part of the SLA
- Revalidate equipment on start up
- Provide Service Report

1. Guillotine:

Service Guillotine Cylinder ☐

Service Seal Gland ☐

Inspect Guillotine Cutting Edge and Clearance ☐

Inspect Guillotine Guide Strips ☐

Comments:

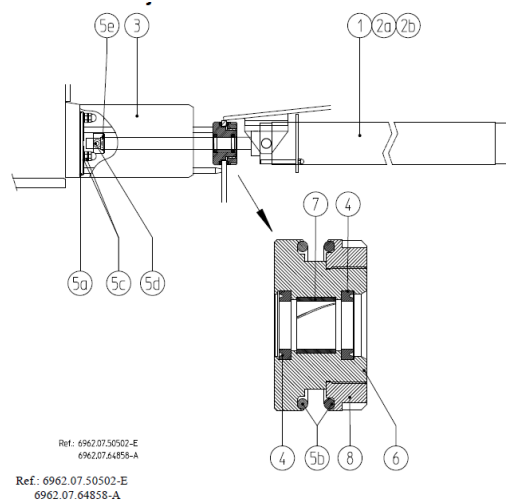
2. Ejector:

Service Ejector Cylinder ☐

Service Seal Gland ☐

Service Ejector Block ☐

Comments:



Ejector Block Assembly: Taken from the Technical Manual this is showing the correct assembly for the ejector block. The ejector block assembly is critical as this is a product contact surface. Nuts, Dome nuts, bolts and O-rings should always be genuine Tetra Pak Parts.

3. Lowering Device (Elevator):

Serviced Elevator Cylinder ☐

Serviced Elevator Plate ☐

Serviced Seal Gland ☐

Serviced Worm Gear ☐

Serviced Air Motor ☐

Inspected Blocking Cylinder ☐

Comments:

4. Door

Serviced Door Cylinders ☐

Serviced Door Seal ☐

Comments:

5. Bagspread Unit

Serviced Bag Spread Cylinder ☒

Comments:

6. Tower

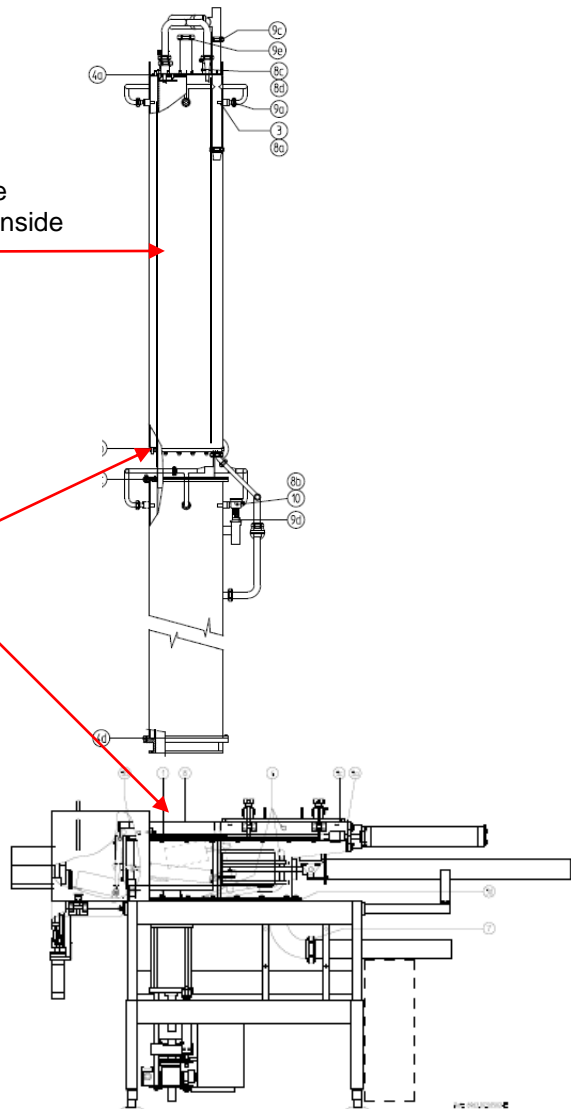
- Inspected Top Plate ☐
- Replaced Top Plate Gasket ☐
- Replaced Intermediate Single Flange Gasket ☐
- Replaced Intermediate Double Flange Gasket ☐
- Replace Bottom Tower Gasket ☐
- Replaced Base Unit to Tower Gasket ☐

Comments:

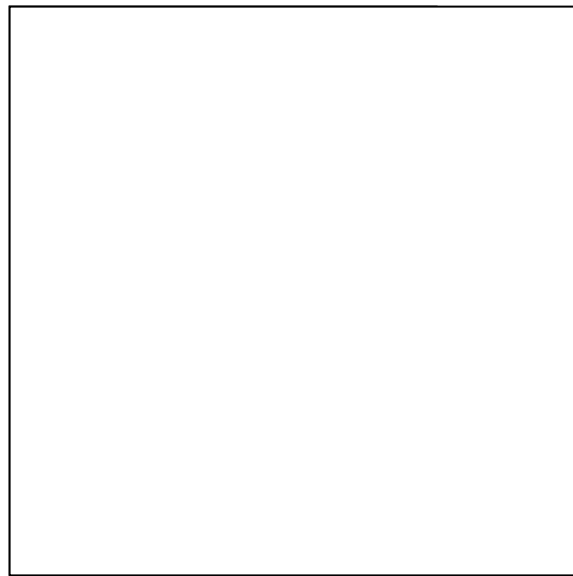
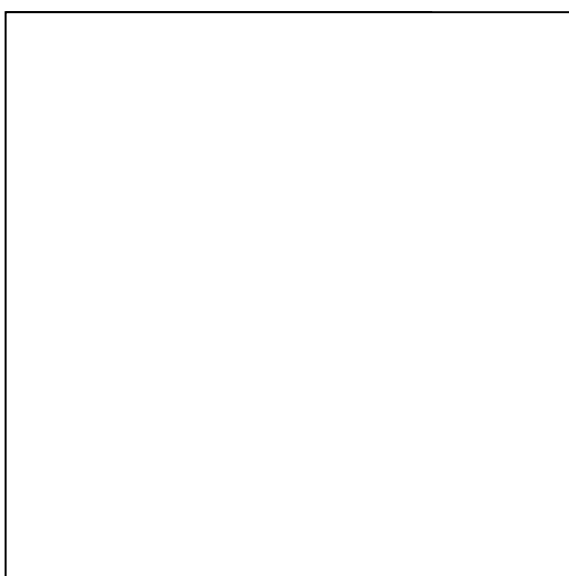
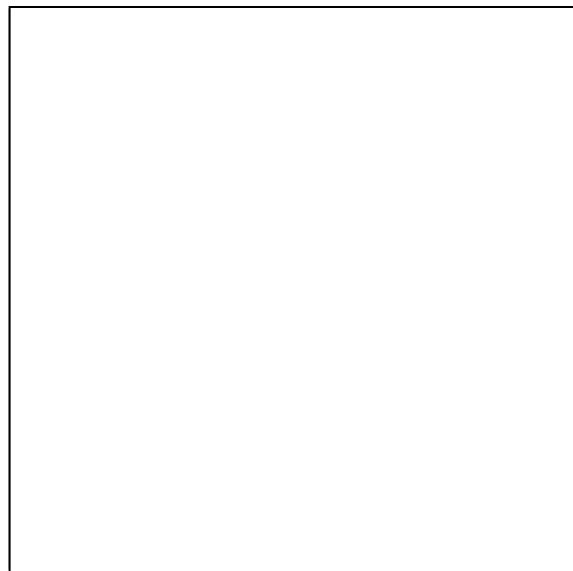
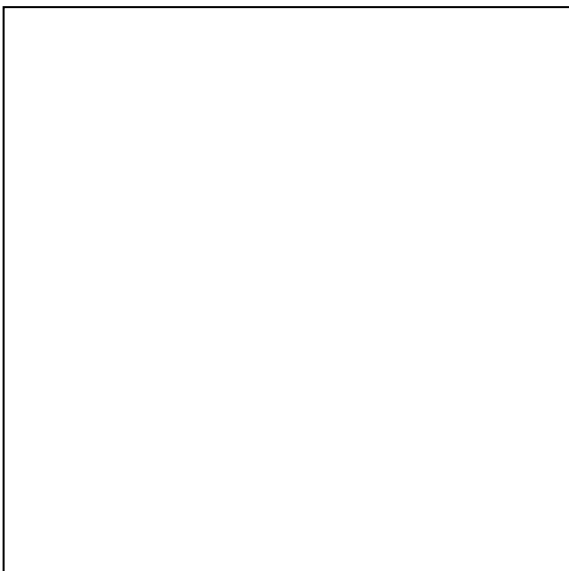
Block Former Tower

- Inner column could potentially be cracked anywhere along this inside edge.

- Gaskets not yet replaced.



Photos:



Routine Maintenance Recommendations:

- Weekly – Check guillotine clearance.
- Weekly – Check the tension on all flange bolts.
- Weekly – Check condition of air lines and fittings.
- Monthly – Check condition of elevator bolt.
- Monthly – Check condition of Dome Nuts and O-rings on the Ejector block assembly.
- Monthly – Inspect spray balls.
- Monthly – Replace all union O-rings on the top plate of the Blockformer.

Recommendations for Next Service:

- Replace all glands on the PLC cabinet
- Replace all air lines.
- Replace the transfer plate on the bag spread unit.
- Always replace the magnet in Elevator Cylinder.
- Replace magnets in both Ejector and Guillotine Cylinder.

Upgrade Recommendations:

- Elevator Plate Upgrade
- Elevator Cylinder Upgrade
- Tetra Pak to audit and assist Bega with the stocking of critical spare parts.

Parts Used for 12k Service:

Part Number	Parts Description	QTY
90515-4707	Seal Gland 25x35x6 S01P H-Ecopur	2
90515-4708	Set of seals	1
90515-4709	O ring 25x3.53 viton	2
90515-4710	O ring 61.6x2.62 viton	2
90515-4711	Bearing strip 10x2x83 PTFE 561	1
90515-4712	Seal Gland 25x35x6 S01P H-Ecopur	2
90515-4713	O ring 120.32x2.62 viton	1
90515-4714	O ring 75.56x5.33 viton	2
90515-4715	Bearing strip 20x2x83 PTFE	1
90515-4716	O ring 14x2.62 viton	6
90515-4717	O ring 7.65x1.78 viton	1
90515-4718	O ring 25.07x2.62 viton	1
90515-4719	Set of Seals	1
90515-4720	Plug 9.25x13 pa6	4
90515-4721	Rod Seal S001P H-ECOPUR 35x45x6mm	1
90515-4722	O ring 34.6x2.62 viton	1
90515-4723	O ring 61.6x2.62 viton	1
90515-4724	O-ring 72,62x3,53 EPDM FDA-approved	1
90515-4725	O ring 7.65x1.78 viton	2
6-9624707787	Bolt ss	1
90511-6278	Bearing strip 15x2x114 PTFE 561	1
6-9620007911	Set of seals TEB: TNS-160	1
6-9620018085	O-ring 28.3x1.78	2
6-9620018086	Quad ring 12.42x1.78 viton	2
6-9620018171	Set of seals TVS-40	1
6-9620018170	Cylinder TEC: TVS-40x55	2
6-9620015484	Set of seals for cylinder P1S-C50M-S250	2
6-9620011704	Bearing bush IGU: AFM-1622-12	2
6-9620009720	Bearing bush IGU: AFM-1218-10	2
6-9620016369	Bearing bush IGU: AFM-1016-20	2

6-9620016370	Bearing bush IGU: AFM-1218-16	2
6-9620760267	Gasket 300x222x8 nbr	1
90115-0186	Swivel joint IGU: KJ-16 ss	2
90115-0131	Swivel joint IGU: KA-10 ss	2
6-9620015484	Seal kit PAR: P1S-050	1
6-9624704427	Bearing bush 26.2/19.2x25 peuhm	2
6-9623704850	GASKET TOP JACKET BF	1
6-9627700021	TOP JACKET BOTTOM GASKET	1
6-9627700023	LOWER JACKET TOP GASKET	1
6-9620007727	TOWERJACKET PAKK.A3 3515	1
6-9611923035	Service kit Q LKB ISO	2
6-9611923021	Service kit LKLA-T/85	2
6-9620017507	O-ring 18,64x 3,53	8
6-9620011699	ring 29.74x 3.53	2
6-9620016441	O-ring viton D16x2,5	1
6-9620000854	O-ring 37.77x 2.62	1
6-3131703753	Seal SMS 25/32x5.5 AL113 3025-86 EPDM	8
6-3131703772	Seal SMS 38/48x5.5 AL113 3025-86 EPDM	3
6-3131703785	Seal SMS 51/61x5.5 AL113 3025-86 EPDM	1
6-9611991360	Seal CL51 48.80/66.20x5.50 EPDM	3
6-3131703793	Seal SMS 63.5/73.5x5.5 AL1133025-86 EPD	1

Additional Parts Used for 12k Service:

Part Number	Parts Description:	QTY
6-9624702686	Striker Plate Gasket 70x40x2mm NBR	2
6-9624704234	Guillotine Mounting Plate Gasket 362x125x2mm	1
6-9620006510	Elevator Cylinder Magnet	1

Service Engineer

Date