



Pre & Post Maintenance Document

Country: United Kingdom

Customer: Muller UK & Ireland Group LLP

Line: LIN-A

Service interval: 30000

Pre Service Date: 29/08/2016

Service date: 08/09/2016

No of service days : 2

Pre Service

Has a TP Lead engineer been identified for the Service event?

Yes: Graeme Young

Has a Customer Lead Technician been identified for the Service event?

Yes: Joe Bloggs

Summary of Work Orders to be performed

<u>Work Order</u>	<u>Machine</u>	<u>Responsible</u>	<u>Duration</u>	<u>Engineer</u>
S00123626	TT/3	TP	27:50	G Young, P Smith, J Bloggs, P Murphy
S00123676	TT/3	TP	08:30	G Young, P Smith
S00123567	TT/3	TP	08:30	G Young, P Smith
S00125546	TMS 62	CS	02:45	P Murphy
S00123654	TMS 62	CS	02:45	P Murphy

Are there any known issues with the line? Check with engineering, operators and line supervisor:

Yes

<u>Machine</u>	<u>Issue</u>
TT/3	Machine is not having intermittent faults during CIP. TI00235899 has been raised.

Is a physical Pre Inspection of the equipment planned?

Yes: Physical Pre Maintenance Checklist.xlsx

Have Section 1 Pre Maintenance Checks been completed on all Scheduled Work Orders?

No:

Were any additional tasks identified during Pre Service checks?

List them here including part numbers where applicable:

<u>Work Order</u>	<u>Task Description</u>	<u>Time</u>	<u>Timing</u>	<u>TP</u>	<u>CS</u>
N0044255	Change outfeeder timing belts. Belts are damaged due to cleaning fluid leaks from the filling platform.	01:30	During Service	Yes	
N0044536	Change gasket seals on all cleaning pipes Side 1 .	02:00	Before Service		Yes

Is the planned labour suitable in order to carry out the required work?

Yes:

Are there any specific Safety issues observed during the Pre Service visit?

Yes

<u>Machine</u>	<u>Safety observation</u>
TT/3	Door safety switch was bridged on the ASSU due to broken door hinge. New door hinge to be fitted this evening and door bridge has been removed.

MachineSafety observation**General Equipment Observations to be listed below:**MachineGeneral observation

TT/3

The machine is stopping with High tank level alarm Side 1 during CIP and has to be emptied and re started. TI00172772 is raised and a containment solution in place.

Are all required tools and Templates available on Site? If not, give details of missing tools and comment on actions required

Yes:

If tools and templates are available at site, specify the storage location below

Tools are stored in the Engineers workshop back wall. Bottom sealing templates are on site and will be required for this service event.

Review all Spare part requirements and delivery dates. Are all required parts on site or are the confirmed delivery dates on time?

Yes: All scheduled parts are on site. All corrective Work orders listed above have now been ordered with a delivery date of 01 September.

PLMS Summary report. Top 3 Stop Reasons

Stop Reason - Muller Wiseman East Kilbride line 3 Side 1	Down Time	Frequency
1. Queue on conveyor, S1	1:39:23	16
2. Paper slack out of range, S1	1:14:40	25
3. High temperature, internal cooling water	1:05:50	14

PLMS Summary report. MME for previous 4 week period

72.66 %

Are there any observations between the losses identified and the Service Task Lists to be carried out? Are there any tasks that should be prioritised? If so, list below

<u>Stop reason</u>	<u>Work Order</u>	<u>TPMS Task</u>	<u>Comment</u>
2.	S000127728	Change motor brushes	Should improve motor function and eradicate these alarms.
2	S000127728	Change water filter	The filter is badly blocked and a new filter should reduce alarms significantly.

Have Package Integrity checks been carried out and documented?

Yes: PI report form ver. 1.xlsx

Service Event Time Plan

<u>Day</u>	<u>Start</u>	<u>Finish</u>	<u>Production Start</u>
Day1	0800	1700	
Day2	0800	1500	2000

Start of Service

Will an operator be available for handover and production preparation at completion of Service work?

Yes:

Will a CIP be required following the Service work and prior to Production Start?

No:

Are all required spare parts available and located by the machine to be serviced?

Yes:

Are all Tools and Templates available and Located by the machine to be serviced?

Yes:

Are all TPMS Work Orders printed and available by the machine to be serviced?

Yes:

Have Reference packages from the last production been inspected?

No:

Update of additional work

<u>Work Order</u>	<u>Task Description</u>	<u>Time</u>	<u>Timing</u>	<u>TP</u>	<u>CS</u>
N0044255	Change outfeeder timing belts. Belts are damaged due to cleaning fluid leaks from the filling platform.	01:30	During Service	Yes	
N0044536	Change gasket seals on all cleaning pipes Side 1 .	02:00	Before Service		Yes

Post Service

Was the Service started at the agreed time?

Yes:

Was the service completed at the agreed time?

No:

Did Production start at the agreed time?

Yes:

Summary of Completed Work Orders

<u>Machine</u>	<u>Work Order</u>	<u>Responsible</u>	<u>Duration</u>	
	S00123626	TP	27:50	Completed
	S00123676	TP	08:30	Completed
	S00123567	TP	08:30	Completed
	S00125546	CS	02:45	Completed
	S00123654	CS	02:45	

Update of additional work. Include Follow Up Work Orders

<u>Work Order</u>	<u>Task Description</u>	<u>Time</u>	<u>Timing</u>	<u>TP</u>	<u>CS</u>
N0044255	Change outfeeder timing belts. Belts are damaged due to cleaning fluid leaks from the filling platform.	01:30		Yes	
N0044536	Change gasket seals on all cleaning pipes Side 1 .	02:00			Yes

Has the equipment been handed back to the customer in a satisfactory condition?

Yes: