

# Maintenance Schedule for TS-101

## Care and Maintenance

Any maintenance work must be undertaken by Technical Systems Engineers or suitably trained personnel.

When removing safety guards or safety equipment for maintenance work, the machine must be shut down as described in the Operator's Manual.

All safety guards or safety devices must be reassembled immediately after maintenance work completed.

It is very important to follow the procedures below when carrying out any maintenance work.

1. Stop machine and conveyors.
2. Switch off main switch and isolate.
3. Double check that no electricity is running through the machine.
4. Remove any necessary guards to gain access to carry out maintenance work.
5. After work is completed, ensure all guards are refitted.
6. Make sure the area of the machine is clear of all personnel before switching the machine back on.

Lubricant type - mineral oil based - multi purpose lubricant e.g. WD40.

Grease type - Lithium based e.g. Castrol Spheerol.

The linear carriage blocks are to be lubricated with lithium-based grease with a mineral-oil base. Viscosity 17 (100 C) cSt, 180 (40 C) cSt. If standard grease is used it could result in damage to the seals. I recommend you wipe the rail once a month with WD40 oil. I would recommend you change the up acceleration to 800.

Take care to avoid injuries from the knife or injury caused by any moving parts when the compressor is switched back on.

**Please note:** These recommendations are based on production of approx. 1.5 million cycles per year. You may find it necessary to increase or decrease regularity of the service, dependant on higher or lower numbers.

Once a week, the machine must be cleaned of film and residues in addition to dust. These impurities can cause the safety photocells to malfunction. The tooth drive belt should also be cleaned once a week and the tension checked and tightened if necessary	Daily	Weekly	3 Monthly	6 Monthly	1 Year	2 Year	As needed
Air pressure regulator filter - drained of any water collected.	X						X
Element wire - clean, check and replaced if broken.			X				X
Heat resistant tape - clean, replacement if burned through.		X					X
Check air cylinders for air leaks					X	X	
Gripper arms bearing blocks and slide - clean and grease.			X		X	X	
Knife, check replace if necessary. <b>Note:</b> If the cut is not straight, the knives are no longer sharp.				X	X	X	
Gripper arm rubbers - examine and replace where necessary.				X			X
Welding station rubbers check - replace if necessary			X		X	X	
Check mechanical linkages, clean and lubricate.			X		X	X	
Carriage Drive belt - check condition and adjust where necessary.				X	X	X	
Poly motor drive belt - check condition and tension.				X	X	X	
Poly slack bearing block - clean slide and lubricate				X			
Optical Fibre sensor - clean and check cable for kinks.	X				X	X	
Loader feed belt - check tension.			X		X	X	
Bag opening spring - check for sharp edges, correctly adjusted.		X			X	X	
Knife linkages assembly - check for wear, adjust and lubricate				X	X	X	
Proximity switches - check for sensitivity and correct adjustment					X	X	
Carriage Bearing block - check and lubricate.			X		X	X	
Safety equipment - all equipment is present and functional	X				X	X	
Clean off loading rail and wax.	X						X
Poly rollers - clean and lubricate			X		X	X	
Terminal connections - check and retighten			X				
Electrical components - check for damaged cables / insulation					X	X	
Poly drive wheels rubbers - check for wear				X	X		
Poly front wheels - lubricate			X				
Welding station bearing and channels - lubricate.				X	X		
Bag opening bearing - check and clean.			X				