

LIFT CHAIN MAINTENANCE/LUBRICATION/INSPECTION

Since lift chains are subjected to constant flexing and shock loading, it is recommended that periodic maintenance, lubrication and inspection be performed by maintenance personnel. Because of a wide variety of operating loads and conditions it is difficult to predict the life of the lift chains. It is strongly recommended that inspections be performed with a frequency that will insure proper performance and that will accurately predict chain replacement life.

Periodic Inspections

After every fourteen days of operation the lift chains should be inspected and lubricated. Inspections should focus on the following:

Elongation

The lifts utilize a 0.75 inch pitch chain size which means there are 17 chain pins per foot. A new chain will measure twelve inches from the center of the first pin to the center of the seventieth pin. When the chain has elongated to measure a length of 12.360 inches (see figure 1), it should be replaced. *It is important to measure the chain in the smaller radius sheaves where the most frequent articulation occurs.*

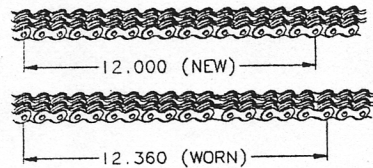


Figure 1

Edge Wear

Check the chain for wear on the link plate edges caused by running back and forth over the sheaves. The maximum reduction of material should not exceed 5%. This can be compared to a normal link plate height by measuring a portion of chain that does not run over the sheave.

Lubrication

The leaf chain requires a film of oil between mating parts to prevent accelerated wear. Generally, the heaviest (highest viscosity) oil that will penetrate the joint is best. Tests have shown this to be about # 40.

| DESCRIPTION | PROCEDURE | SPECIAL INSTRUCTIONS | INTERVAL |
|---|---|---|---|
| Hydraulic Units | Inspect Inspect | Check Couplings & Tighten Set Screws Maintain Fluid Levels & Check for Leaks | Monthly |
| Lifts: Liner Box Compression Platen Press | Inspect/Lubricate Inspect/Lubricate Inspect/Lubricate Inspect/Lubricate | Refer to Lift Chain Sheet No. M1 Refer to Lift Chain Sheet No. M1 Refer to Lift Chain Sheet No. M1 MAXIMUM USE LIFT! Refer to Lift Chain Sheet No. M1 | Bi-Monthly Bi-Monthly Bi-Monthly Bi-Monthly |
| Sissor lifts Make-Up Station and Down Stacker | Inspect Inspect | Leg Rollers, Center Pivot Bushings, Pins, Cylinder Clevis Pins. Check Hydraulic Fittings & Hoses | Monthly Bi-Monthly |
| Liner Feedroll Overrunning Clutch | Inspect Grease | Recommended Greases: Texaco Regal AFB2 Mobilux No. 2 Shell Alvania No. 2 <i>Do Not Use Other Greases</i> | Bi-Monthly Monthly |
| Gluer: Rubber Roll Journals & Bearings Operating Control Bar End Seals | Inspect Inspect, Grease Inspect Inspect | Inspect for Checks, Wear, Gouges, Grooves and Hardened Areas Inspect for Excessive Wear Detent Will Hold Bar Forward, Must Be Held in Reverse Clean/Adjust or Replace if Leaking | Monthly Monthly Monthly Daily |
| Backstop Couplings FRL Units | Inspect, Grease Inspect Refill & Drain | Bearings Tighten Refill w/Turbine oil Class 1 ISO VG32, Drain Water | Bi-Monthly Bi-Monthly Bi-Monthly |
| Compression Station FRL Units | Inspect Refill & Drain | Tighten Couplings Refill w/Turbine oil Class 1 ISO VG32, Drain Water | Bi-Monthly Bi-Monthly |
| In-Feed Conveyor | Inspect, Grease | Inspect Belts for Wear, Bearings | Bi-Monthly |
| Score Section Servo Motor Score Profiles | Inspect, Grease Inspect Inspect | Pull Guards, Inspect Servo Drive Belt, Bearings, Register Rolls Only refill w/ Synthetic Oil /SHC 630/ ISO VG 220 Clean Off Glue Buildup, Tighten 3/8 Socket Heads on Score Profile DO NOT REMOVE PROFILES WITHOUT HOIST OR CRANE ASSIST-SEE NOTE * | Bi-Monthly Bi-Monthly Bi-Monthly |
| Out-Feed Conveyor | Inspect, Grease | Inspect Belts for Wear, Bearings | Bi-Monthly |
| Folder Couplings FRL Units Vacuum Units | Inspect, Grease Inspect Refill & Drain Inspect | Bearings Tighten Refill w/Turbine oil Class 1 ISO VG32, Drain Water Tighten Fasteners and Inspect or Clean Impeller | Bi-Monthly Bi-Monthly Bi-Monthly Yearly |
| Down Stacker | Inspect, Grease | See Sissor Lift Above | <i>MAIN.DOC</i> Bi-Monthly |