

3 Preventative Maintenance

The PLC has been programmed to provide and administrate a basic Maintenance schedule and will signal through the start interrupt screen (A flashing Maintenance Required Warning), which is detailed on the dedicated Maintenance Screen. Each function will be flagged as the period (in Machine Running hours), is counted from commissioning, or the last reset of the function. A warning on the start interrupt screen will not impede Machine start.

MAINTENANCE PERIODS HAVE BEEN ESTABLISHED FROM EXPERIENCE. DO NOT ACKNOWLEDGE A FUNCTION IF IT HAS NOT BEEN CARRIED OUT.

Maintenance Functions.

CHECK ELECTRICAL CONNECTOR TIGHTNESS Period 1000 hrs.

Required because of high frequency vibration from mains voltage transformers transmitted through the machine frame.
Ensure the Machine has been disconnected at the main isolator.
Each screw terminal in the control cabinet should be individually checked for engagement and tightness (tug wire, check clamp screw with driver).
Accumulated dust and debris should be **VACUUMED** from the main electronics cabinet (**DO NOT USE AIRLINE TO BLOW**)

CHECK MECHANICAL TIGHTNESS Period 500 hrs

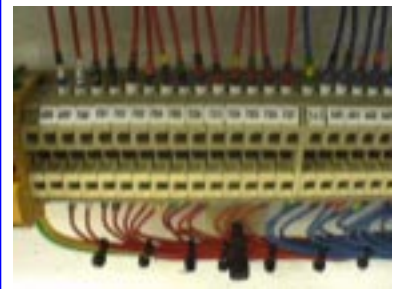
Required because of Electrical and mechanical vibration.

All Mainframe and mounting screws on the machine should be checked for tightness with a torque wrench, to the values shown in the table.

LUBRICATE UNWIND & GUIDER LEADSCREWS Period 1000 hrs

Remove dust grime and old grease with a clean wipe, and deposit a film of new Teflon depositing grease. Repeatedly working the shaft until an even distribution is achieved.

E.P.MULTIP GREASE
As used in original manufacture
is available from
ASHE CONVERTING EQUIPMENT



Torque Values Screw Sizes in mm		
Dia	Kgfm	ibf.in
3	.185	16
4	.553	48
5	.840	73
6	1.510	131
8	3.480	302
10	6.830	592
12	13.40	1116
16	31.50	2736
20	56.70	4920
24	95.5	71.65

