



MAINTAINENCE

OVERHEAD MONORAIL CONVEYOR

WEEKLY

1. Lubricate chain for at least 3-4 circulations on the circuit.

METHOD:

- a) Air pressure on regulator – set at 2-3 bars.
- b) Open oil regulator to 1 drop / second.
- c) Check physically if lubrication reaches the chain and bearings.
- d) Use only OMEGA 613 molybdenum based lubricant.
- e) Over-lubrication can cause dripping on products without serving any real purpose.
- f) Check chain tension on conveyor – If pendants are held between the two fingers and pushed upwards, it should move upwards by approximately 30-40 millimetres. (Do this at the inspection section with the lid removed)
- g) Check free movement of the tension unit.
- h) Check correct operation and cleanliness of the torque limiter.
Loosen three adjusting bolts until the clutch clips under full load. Tighten each adjusting bolt by approximately one-third revolution at a time until the chain moves. Finally tighten one-quarter turn each. Torque limiter will now slip if the chain jams, but will not slip under the load.

MONTHLY:

- a) Check gearbox oil level and check for any leaks
- b) Apply, if necessary, an appropriate grease to the transmission chain, taking care not to allow any grease to drip onto the torque limiter.
- c) Check for any excess wear on bearing.
- d) Check for any wear on track and bends.
- e) If V- belt driven, check for V-belt wear, as well as free operation of springloaded variable speed pulley.