

## Check List

**Customer:**

Customer No: Customer Name:

Line No: Plant Name:

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**Machine:**Machine Type No: Machine Type Text:  
648651 Tetra Brik Aseptic TBA/8 LSCMachine Identity:  
20215/82147List Variant: List Text:  
/15LITR TBA/8 LSCVolume: Dev. Step:  
1500 010V

El. Control System:

**Installed Variants:****Installed Options:****Installed Rebuildings:****Checklist Overview Used:**

Overview Referring to Document:

Issued By:

Issue Date:

06.01.2000

Approved By:

Technical support

Machine Identity:

20215/82147

Responsible:

Tetra Pak

Interval:

7000

Page No:

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Section/Description	Action	S	Document Reference	Time	Interval	Pos No	Result Code	C	Notes
<b>00. Pre-Maintenance Checks</b>									
WARNING! Before starting any service work, read the safety precaution in the corresponding Maintenance Manual. Doc No:	Check	7	MM: 82180-0102		1000	40			
Calender roller. Function.	Check	7	1.2.1-2		1000	60			
Compressor. Kontrola těsnosti.	Check	7	1.7-1		1000	80			
Peroxide tank- Pump	Check	7	2.2.1-1		1000	100			
Pressure roller; Short stop nozzle-Function	Check	7	6.3-7		1000	120			
Hot air element; LS SS- Function	Check	7	1.4-2		1000	140			
Temperaturregulatorer	Record	7	8.1-1		1000	160			
Design delay; the number of packages ejected from "Filling on" until machine goes into design	Count & Record	7	4.9-2		1000	180			
Package - check package according to OM.	Check	7	OM		1000	200			
Aseptic chamber- Under-pressure / Over-pressure	Check & Record	7	1-2		1000	220			
Cooling water system- Flow	Check	7	OM		1000	240			
Cleaning pump	Check	7	5.15-1		1000	260			
Bending roller. Otáčky.	Check & Record	7	1.2.2-5		1000	280			
250 h check lists. Go through the lists carried out since the last 1000 h service. If all checks are not completed carry them out together with this service.	Check	7			1000	320	A		
250 h check lists - Go through the lists carried out since the last 1000 h service. If all checks are not completed carry them out together with this service.	Check	7			1000	340	A		
Daily / Weekly checks. Are they being carried out? If not, then carry them out together with the operator before starting this service.	Check	7			1000	360	A		

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Section/Description	Action	S	Document Reference	Time	Interval	Pos No	Result Code	C	Notes
<b>01. Superstructure</b>									
Seal	Check	7	1.3.1-1		1000	10080	A		
Air knife	Check	7	1.2.3-1		2000	10100	A		
Scrubber- Filter	Clean	7	1.7.3-1		1000	10260	A		
Change-over valve; Upper Suction-Seals	Change	7	1.10.3-1		7000	10280	D	X	
Tube support / Forming rings	Check	7	1.1.1-1		1000	10520	A		
<b>02. Machine body</b>									
Central lubrication- Pressure	Check	7	2.1-2		1000	20080	A		
Peroxide pipe- Safety lids	Check	7	2.2-1		1000	20100	A		
Valve panel; Pressure	Check	7	2.2.2-1		250	20120	A		
Vodní lázeň - Pressure switch. Function.	Check	7	1.8-7		1000	20140	A		
Peroxide pipe. Kontrola těsnosti.	Check	7	2.2-2		1000	20180	A		
Hydraulic system- Pressure	Check	7	2.3-6		1000	20280	A		
Hydraulic system. Kontrola těsnosti.	Check	7	2.3-7		1000	20300	A		
Pipe work; Water. Kontrola těsnosti.	Check	7	2.6-1		1000	20320	A		
<b>03. Drive unit</b>									
Impulse transmitter. Nastavit vůli ventilů.	Check	7	3.6-3		1000	30115	B		
Hold-down device; Safety switch-Function	Check	7	3.5-8		1000	30140	B		
Link system- Rods	Check	7	3.7-1		1000	30220	A		
Vačky. Kontrola povrchu.	Check	7	3.3-1		1000	30260	A		
Link system- Ball bearing	Change	7	3.7-5		7000	30360	B	X	
Link system- Bearings	Check	7	3.7-4		1000	30380	A		

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Section/Description	Action	S	Document Reference	Time	Interval	Pos No	Result Code	C	Notes
<b>04. Jaw system</b>									
Korekce dekoru. Fotobuňky - kontrola těsnosti. Kontrola čoček.	Check	7	4.9-1		1000	40040	A		
Volume curve piece- Support roller	Check	7	4.6-3		1000	40160	A		
Volume flap	Check	7	4.4-1		1000	40180	A		
Yoke- Felt seal / Scraper device	Change	7	4.2-1		4000	40220	C		
Yoke- Bushings	Check	7	4.2-2		2000	40240	A		
Link- Bushings	Check	7	3.4-3		2000	40280	A		
Toothed segment	Check	7	4.11-1		2000	40300	A		
Folding device	Check	7	4.10-1		1000	40400	A		
Folding flap mechanism	Adjust	7	4.1-15		1000	40420	B		
Mezera mezi čelistmi.	Adjust	7	4.1-11		1000	40460	B		
Nerovnoběžnost čelistí.	Check	7	4.1-10		1000	40490	A		
Pressure jaw; Catch- Springs	Check	7	4.7-1		1000	40520	A		

**05. Final folder**

Station chain. Kontrola. Oprava na vyžádání.	Overhaul	7	5.2-3		1000	50060	D	X	
Drive wheel	Check	7	5.7-1		1000	50240	A		

**06. Strip applicator**

Prítlačný váleček. Tryska krátkého stopu.	Check	7	6.3-4		1000	60050	A		
Tryska SA. Kontrola nastavení a tlaku.	Check	7	6.4-1, 6.4-3		1000	60070	A		
Splice detector. Function.	Check	7	6.6-1		1000	60130	A		

**07. Automatic splicing unit**

Automatic splicing unit- Function	Check	7	7-2		1000	70020	A		
Paper holder- Position	Check	7	7.3.1-2		2000	70120	A		

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Section/Description	Action	S	Document Reference	Time	Interval	Pos No	Result Code	C	Notes
<b>08. Electric equipment</b>									
Cooling fan	Check	7	8.4-2		1000	80100	A		
<b>60. Start-up checks</b>									
Hydraulic system. Accumulator.	Check	7	2.3-5		1000	600040	A		
Bezpečnostní funkce.	Check	7	8.5-1		1000	600060	A		
<b>95. After-Maintenance Checks</b>									
Package - check package according to OM.	Check	7	OM		1000	950020	A		
Design delay; the number of packages ejected from "Filling on" until machine goes into design	Check	7	4.9-2		1000	950040	A		10
Aseptic chamber. Under-pressure, Over-pressure.	Check	7	1-2		1000	950060	A		
Calender rollers. Kontrola zda neprochází peroxid za válce.	Check	7	1.2.1-2		1000	950080	A		+25/-10
Krátký stop. Kontrola sváru.	Check	7			1000	950083	A		
Váha krabice. Kontrola a zápis.	Check & Record	7			1000	950086	A		
LS tryska. Kontrola funkce.	Check	7	1.6-1		1000	950089	A		
LS tryska krátkého stopu. Kontrola funkce.	Check	7	1.4-1		1000	950092	A		
SA tryska. Kontrola funkce.	Check	7	6.4-3		1000	950095	A		
SA tryska krátkého stopu. Kontrola funkce.	Check	7	6.3-4		1000	950098	A		
TPIH nastavení výkonu.	Check & Record	7			1000	950100	A		
Pokud nebyla provedena prohlídka před údržbou, proved'te ji nyní.	Check	7			1000	950120	A		
Dohled na výrobu.	Check	7			1000	950140	A		
Nechte udělat kopie kontrolních listů pro zákazníka, originály odeslat do TP.	Check	7			1000	950160			

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Section/Description	Action	S	Document Reference	Time	Interval	Pos No	Result Code	C	Notes
<b>95. After-Maintenance Checks</b>									
Příprav na zpětné odeslání servisní kufry, rotační jednotky a přípravky.	Check	7			1000	950180			
Total Expected Worktime	18 Hrs	0 Min							
Total expected downtime	11 Hrs	25 Min							

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Pos No	Comments
10280	Úkon odložen na další servis
30360	Pro příští servis objednat : SPC - 434062 1x shaft
50060	úkon odložen na další servis
*****	
Fojtík, Turoň	

Start Date: 14.07.2008	Completion Date: 15.07.2008	Total Used Worktime: 18:00	Hour meter: 6940	Workorder No:
Start Time: 08:00	Completion Time: 26:00	Total Used Downtime: 11:25	Adjusted Hourmeter:	
Engineer Signature:		Customer Signature:		

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