

YAI-F26-6-PLC PREVENTIVE MAINTENANCE INSPECTION CHECKLIST

Customer: _____ Date _____

Customer Contact: _____

Serial # _____ Power On Hours _____ Mold Plate Hours _____

Service Technician: _____ S.O. #: _____

Draw Bar Assembly & Top Plate

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|-------|---|------|----------------------|----------|
| 1.00 | 000283-A-YA Draw bar Bearings | | | |
| 2.00 | 9000142 Draw Bar Mounting Bolts (8) | | | |
| 3.00 | Adapter Bar Spacing | | | |
| 4.00 | Adapter Bar Height Adjustment | | | |
| 5.00 | Draw Bar Pins | | | |
| 6.00 | Draw Bar Level to Top Plate | | | |
| 7.00 | Operator Side Arm Level to Top Plate | | | |
| 8.00 | Non-Operator Side Arm Level to Top Plate | | | |
| 9.00 | Operator Side 283 Slot Wear | | | |
| 10.00 | Non-Operator 283 Slot Wear | | | |
| 11.00 | Condition of Top Plate | | | |
| 12.00 | Condition of Fill Slot Bolt Threaded Holes | | | |
| 13.00 | Condition of Mold Plate Studs 000054-B-YA (4) | | | |
| 14.00 | Condition of Mold Plate Nuts 901576-YA (4) | | | |

Draw Bar Drive Linkage Operator-Side

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|-------|---|------|----------------------|----------|
| 15.00 | Upper Wiper Seal 000209-A-YA | | | |
| 16.00 | Lower Wiper Seal 004081-B-YA 011835 LF/PF | | | |
| | Lower Wiper Seal 000207-Std 011820 LF | | | |
| 17.00 | Drive Arm Bearing, Outside 000180-B-YA | | | |
| 18.00 | Drive Arm Bearing, Inside 004077-B-YA Paper | | | |
| | Drive Arm Bearing, Inside 000248-B-YA | | | |
| 19.00 | Pistol Grip Spherical Bearing 901513-YA | | | |
| 20.00 | Drive Arm Clevis Bolt 000656-A-YA | | | |
| 21.00 | Drive Arm Tie Rod Bolt 000664-YA | | | |
| 22.00 | Long Mold Plate Drive Arm 012013 Non-Paper | | | |
| | Long Mold Plate Drive Arm 004210 Paper | | | |

YAI-F26-6-PLC PREVENTIVE MAINTENANCE INSPECTION CHECKLIST

Draw Bar Drive Linkage Non-Operator-Side

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|-------|--|------|----------------------|----------|
| 23.00 | Upper Wiper Seal 000209-A-YA | | | |
| 24.00 | Lower Wiper Seal 004080-B-YA PF 011835 LF PF | | | |
| | Lower Wiper Seal 000208 STD 011821 LF | | | |
| 25.00 | Drive Arm Bearing, Outside 000180-B-YA | | | |
| 26.00 | Drive Arm Bearing, Inside 004079-B-YA Paper | | | |
| | Drive Arm Bearing, Inside 000248-B-YA | | | |
| 27.00 | Pistol Grip Spherical Bearing 901513-YA | | | |
| 28.00 | Drive Arm Clevis Bolt 000656-A-YA | | | |
| 29.00 | Drive Arm Tie Rod Bolt 000664-YA | | | |
| 30.00 | Long Mold Plate Drive Arm 012013 Non-Paper | | | |
| | Long Mold Plate Drive Arm 004210 Paper | | | |

Reducer Main Drive Gear C-177

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|-------|---|------|----------------------|----------|
| 31.00 | Check the four bolts that bolt it to main frame | | | |
| 32.00 | Check the bolts for the reducer to center mount | | | |
| 33.00 | Operator Side Output shaft keyway condition. | | | |
| 34.00 | Input shaft keyway condition. | | | |
| 35.00 | Input shaft oil seal for leaks. | | | |
| 36.00 | Input shaft End-Play (Note the Amount Of Play) | | | |
| 37.00 | Operator side output shaft seal for leaks. | | | |
| 38.00 | Non-Oper.output shaft seal for leaks | | | |
| 39.00 | Non-Oper.output shaft key (A247) for wear. | | | |
| 40.00 | Knockout Drive sprocket on Reducer (901573) | | | |
| 41.00 | Main Drive box reducer oil level. | | | |

Connecting Rod Assembly

| Serial Number _____ (Remove Connecting Rod) | | GOOD | NEEDS REPLACEMENT | REPLACED |
|---|--|------|----------------------|----------|
| 42.00 | Connecting rod washer (A-2304-YA) | | | |
| 43.00 | Connecting Rod Bushing (A-2303-YA) | | | |
| 44.00 | Connecting Rod Bolt (A-0240056-YA) Replace | | | |
| 45.00 | Connection Rod Williams Washer (900036) | | | |
| 46.00 | Con-Rod Adjusting Bracket (B-24058-YA) | | | |
| 47.00 | Con-Rod Stroke Adjustment Nut (A-24058) | | | |
| 48.00 | Rod Eye to Shaft (Tight to Shaft) | | | |
| 49.00 | Con-Rod Bearing (Rod Eye) | | | |
| 50.00 | Con-Rod Lower Bearing (9000827) | | | |
| 51.00 | Con-Rod Hose Condition | | | |
| 52.00 | Con-Rod Aliment (Monthly) | | | |

YAI-F26-6-PLC PREVENTIVE MAINTENANCE INSPECTION CHECKLIST

Crank Arm Assembly

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|-------|--|------|----------------------|----------|
| 53.00 | Crank Arm Key-way and Key Condition | | | |
| 54.00 | Crank Arm Bushing | | | |
| 55.00 | Crank Arm Snap Ring (903424) | | | |
| 56.00 | Bolt and nut that fasten arm to output shaft | | | |
| 57.00 | Drive Pulley on Winsmith Tight | | | |
| 58.00 | Drive Pulley on mold plate drive motor tight | | | |
| 59.00 | Drive belt tracking correctly | | | |
| 60.00 | Drive belt tension correctly | | | |
| 61.00 | Keyway play in drive motor to pulley | | | |
| 62.00 | Keyway play in drive pulley to Winsmith shaft | | | |
| 63.00 | Mold plate drive motor output shaft end play | | | |
| 64.00 | Mold plate drive motor (Bearing noise running) | | | |
| 65.00 | Mold plate drive motor wiring condition | | | |
| 62.00 | Keyway play in drive pulley to Winsmith shaft | | | |
| 63.00 | Mold plate drive motor output shaft end play | | | |

Knock Out Drive System

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|-------|--|------|----------------------|----------|
| 64.00 | Lower Right Angle lower output shaft (Note End Play) | | | |
| 65.00 | Lower Right angle upper output shaft (Note End Play) | | | |
| 66.00 | Lower Right angle drive input shaft (Note End Play) | | | |
| 67.00 | Lower right angle drive input seal (Check for Leaks) | | | |
| 68.00 | Lower right angle drive output seal lower (Note Leaks) | | | |
| 69.00 | Lower right angle drive upper output shaft seal | | | |
| 70.00 | Lower right angle drive backlash (Note Amount) | | | |
| 71.00 | #40 Chain sprocket on Winsmith (note Condition) | | | |
| 72.00 | #40 sprocket on Winsmith check keyway condition | | | |
| 73.00 | #40 sprocket on Winsmith two set screw for tightness | | | |
| 74.00 | #40 sprocket on lower right angle drive (Note Condition) | | | |
| 75.00 | #40 sprocket on lower right angle drive check key way | | | |
| 76.00 | #40 sprocket on lower right angle drive two set screws | | | |
| 77.00 | Knock Out drive coupling (004149) | | | |
| 78.00 | Knock Out drive coupling key-way and key condition | | | |
| 79.00 | Knock Out drive set screw secure to shaft | | | |
| 80.00 | Knock Out drive set screw socket condition | | | |
| 81.00 | Knock Out Lower Yoke condition | | | |
| 82.00 | Lower Pin and block assembly (Note Backlash) | | | |
| 83.00 | Torque Tube (000072-A-YA) (Note Pin hole Condition) | | | |
| 84.00 | Torque tube/Spline Shaft(69-A) mate (Note Backlash) | | | |
| 85.00 | Spline Shaft (000069-A-YA) (Note Upper Hole Condition) | | | |
| 86.00 | Upper pin & Block Assembly (Note Backlash) | | | |
| 87.00 | Upper Knock Out Drive Yolk (009110-A) | | | |
| 88.00 | 099110-A Keyway and Key Condition | | | |
| 89.00 | 099110-A Set screw condition | | | |

YAI-F26-6-PLC PREVENTIVE MAINTENANCE INSPECTION CHECKLIST

Knock Out Drive System (Continued)

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|-------|--|------|----------------------|----------|
| 90.00 | Upper right angle drive input seal | | | |
| 91.00 | Upper right angle drive shaft (End Play) | | | |
| 92.00 | Upper right angle drive output shaft seal | | | |
| 93.00 | Upper right angle drive output shaft (End Play) | | | |
| 94.00 | Upper right angle drive oil level. | | | |
| 95.00 | Upper right angle drive output shaft Coupling | | | |
| 96.00 | 901732 Coupling Output Right Angle drive Key& Keyway | | | |
| 97.00 | 900565 Bronze Spider between Coupling Backlash | | | |

Mold Cover Assembly

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|--------|---|------|----------------------|----------|
| 98.00 | Knock out cam drive shaft coupling (901732) | | | |
| 99.00 | Shaft coupling key and Keyway condition (End Play) | | | |
| 100.00 | Roll pin condition on shaft coupling | | | |
| 101.00 | Knock out cam shaft 011783 condition | | | |
| 102.00 | Knock out cam,non-oper alignment to arm | | | |
| 103.00 | Knock out cam, non-oper bolts secure | | | |
| 104.00 | Knock out cam, non-oper Cam oil level in pan | | | |
| 105.00 | Knock out cam, non-oper cam oil wick | | | |
| 106.00 | 035627-A-YA non-oper side KO arm | | | |
| 107.00 | Non-oper KO arm 00114 bearing condition | | | |
| 108.00 | Non-oper KO arm cam area for wear (Note Wear) | | | |
| 109.00 | Non-oper KO Arm oil wick for arm (000878-A-YA) | | | |
| 110.00 | Non-oper KO Arm rubber bounce pads (Note Condition) | | | |
| 111.00 | Non-oper KO Arm Upper bounce Pad (001424-B) | | | |
| 112.00 | Non-oper KO Arm Upper bounce pad Clearance (note) | | | |
| 113.00 | Non-oper KO 901706 spring tension | | | |
| 114.00 | 002883-A-YA Non-oper side Clevis bearing wear | | | |
| 115.00 | 002883-A-YA Shaft and set screws tighten | | | |
| 116.00 | Non-Oper side Remove front KO Tower Cover Inspect | | | |
| 117.00 | Non-Oper side 000288-A bounce pad condition | | | |
| 118.00 | Non-Oper Side 000092-A KO slide condition | | | |
| 119.00 | Non-Oper side 002884-A Clevis and bearing condition | | | |
| 120.00 | Clean off all parts before reassembly of tower Non-Oper | | | |
| 121.00 | Knock out cam,oper-side alignment to arm | | | |
| 122.00 | Knock out cam, oper-side bolts secure | | | |
| 123.00 | Knock out cam, oper-side Cam oil level in pan | | | |
| 124.00 | Knock out cam, oper-side cam oil wick | | | |
| 125.00 | 035627-A-YA oper-side side KO arm | | | |
| 126.00 | Oper-side KO arm 00114 bearing condition | | | |
| 127.00 | Oper-Side KO arm cam area for wear (Note Wear) | | | |
| 128.00 | Oper-Side KO Arm oil wick for arm (000878-A-YA) | | | |
| 129.00 | Oper-Side KO Arm rubber bounce pads (Note Condition) | | | |
| 130.00 | Oper-Side KO Arm Upper bounce Pad (001424-B) | | | |
| 131.00 | Oper-Side KO Arm Upper bounce pad Clearance (note) | | | |
| 132.00 | Oper-Side KO 901706 spring tension | | | |
| 133.00 | 002883-A-YA Oper-side Clevis bearing wear | | | |
| 134.00 | 002883-A-YA Shaft and set screws tighten | | | |

YAI-F26-6-PLC PREVENTIVE MAINTENANCE INSPECTION CHECKLIST

Mold Cover Assembly Continued

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|--------|--|------|----------------------|----------|
| 135.00 | Oper-side Remove front KO Tower Cover Inspect | | | |
| 136.00 | Oper-side 000288-A bounce pad condition | | | |
| 137.00 | Oper -Side 000092-A KO slide condition | | | |
| 138.00 | Oper-side 002884-A Clevis and bearing condition | | | |
| 139.00 | Clean off all parts before reassembly of tower Oper-Side | | | |
| 140.00 | Drain excess water from mold cover box | | | |
| 141.00 | Check knock out heater nuts inside mold cover | | | |
| 142.00 | Inspect the knock out heater for any damage | | | |
| 143.00 | Inspect knock out heater to insure clearance from KO | | | |
| 144.00 | Inspect the seal condition around top cover | | | |
| 145.00 | 002300-A-YA Mold Cover Seal rear condition | | | |
| 146.00 | Non-oper Side 012366 Check valve base part | | | |
| 147.00 | Oper-side 012366 Check Valve base part | | | |
| 148.00 | Non-Oper Side 012367 check valve stainless steel | | | |
| 149.00 | Oper-side 012367 check valve stainless steel | | | |
| 150.00 | Non-Oper side 012368 check valve retainer | | | |
| 151.00 | Oper-side 012368 stainless steel check valve retainer | | | |
| 152.00 | Mold cover square with top plate | | | |

Conveyor Assembly

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|--------|---|------|----------------------|----------|
| 153.00 | Conveyor Drive output shaft (Check for End Play) | | | |
| 154.00 | Conveyor drive output shaft seal | | | |
| 155.00 | Conveyor drive sprocket | | | |
| 156.00 | Conveyor drive chain condition | | | |
| 157.00 | Conveyor drive chain tensioner set correctly | | | |
| 158.00 | Lubricate conveyor drive chain | | | |
| 159.00 | Conveyor driven sprocket key and key way | | | |
| 160.00 | Spline driven shaft to Pulley stub (Check for End Play) | | | |
| 161.00 | Spline shaft inner bearing support | | | |
| 162.00 | Spline shaft outer bearing support | | | |
| 163.00 | Conveyor drive roller spline | | | |
| 164.00 | Conveyor drive roller bearing support | | | |
| 165.00 | Conveyor drive roller bushing (Front) | | | |
| 166.00 | Conveyor drive rubber coating condition | | | |
| 167.00 | Conveyor drive idler roller oper-side bushing | | | |
| 168.00 | Conveyor drive idler roller operator side bushing | | | |
| 169.00 | Conveyor drive idler roller stub shaft operator side | | | |
| 170.00 | Conveyor drive idler roller stub shaft non-oper side | | | |
| 171.00 | Conveyor belt condition | | | |
| 172.00 | Conveyor belt tension | | | |
| 173.00 | Operator side Hopper pan Front shoulder bolt 502-A-YA | | | |
| 174.00 | Operator side hopper pan rear shoulder bolt 901645 | | | |
| 175.00 | Non-Oper side hopper pan front should bolt 502-A-YA | | | |
| 176.00 | Non-Oper side hopper pan rear shoulder bolt 901645 | | | |

YAI-F26-6-PLC PREVENTIVE MAINTENANCE INSPECTION CHECKLIST

Feed Screw Assembly

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|--------|---|------|----------------------|----------|
| 177.00 | Feed Screw #1 (Note End Play) Non-Operator Side | | | |
| 178.00 | Feed screw #1 Lower bearing | | | |
| 179.00 | Feed Screw #1 Upper bearing | | | |
| 180.00 | Feed Screw #1 Spider (Note End play) | | | |
| 181.00 | Feed Screw #1 O-ring seal condition | | | |
| 182.00 | Feed Screw #1 gear box output shaft (Note End Play) | | | |
| 183.00 | Feed Screw #2 (Note End Play) Middle | | | |
| 184.00 | Feed screw #2 Lower bearing | | | |
| 185.00 | Feed Screw #2 Upper bearing | | | |
| 186.00 | Feed Screw #2 Spider (Note End play) | | | |
| 187.00 | Feed Screw #2 O-ring seal condition | | | |
| 188.00 | Feed Screw #2 gear box output shaft (Note End Play) | | | |
| 189.00 | Feed Screw #3 (Note End Play) Operator side | | | |
| 190.00 | Feed screw #3 Lower bearing | | | |
| 191.00 | Feed Screw #3 Upper bearing | | | |
| 192.00 | Feed Screw #3 Spider (Note End play) | | | |
| 193.00 | Feed Screw #3 O-ring seal condition | | | |
| 194.00 | Feed Screw #3 gear box output shaft (Note End Play) | | | |
| 195.00 | Vacuum excess water from feed screw housing | | | |
| 196.00 | Condition of O-ring seals housing to overarm mounts | | | |
| 197.00 | 008312 Trip arm swings freely | | | |
| 198.00 | Trip arm prox sensor working correctly | | | |
| 199.00 | Trip arm spring return tension set correctly | | | |

Mold Cover Lift Assembly (Hydraulic)

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|--------|---|------|----------------------|----------|
| 200.00 | Non-oper side Screw Jack Condition (903717) | | | |
| 201.00 | Non-Oper side screw jack 903720 coupling | | | |
| 202.00 | Non-Oper side T-bar connector (024130-B) | | | |
| 203.00 | Non-Oper side Shoulder bolt (903723 Qty-2) | | | |
| 204.00 | Non-Oper side T-Bar (024137-C) Condition | | | |
| 205.00 | Non-Oper Side Super-Seal (023079-YA) | | | |
| 206.00 | Non-oper side screw jack input shaft (Note end play) | | | |
| 207.00 | Non-oper side screw jack output screw (Note end play) | | | |
| 208.00 | Non-oper side (024139-C) guide block | | | |
| 209.00 | Non-oper side (024132-B) guide block backer plate | | | |
| 210.00 | Non-oper side coupling screw jack set screw | | | |
| 211.00 | Non-oper side rubber spider for (903720) coupling | | | |
| 212.00 | Non-oper side cross shaft (903720) Coupling set screw | | | |
| 213.00 | Non-oper side Cross shaft (024129-A) Keys & key ways | | | |
| 214.00 | 024129-A Cross shaft coupling 9003719 to gear box | | | |
| 215.00 | 9003718 Hub City gear box input shaft (Note end Play) | | | |
| 216.00 | 9003718 Hub City gear box output shafts (Note end Play) | | | |
| 217.00 | 9003718 Hub city gear box input coupling 903721 | | | |
| 218.00 | 702118 Charlyn Hyd. Motor output shaft (Note end play) | | | |
| 219.00 | 702118 Charlyn Hyd. Motor output shaft coupling | | | |
| 220.00 | 702119 Charlyn Hyd. Motor output shaft seal | | | |
| 221.00 | Oper side Screw Jack Condition (903717) | | | |
| 222.00 | Oper side screw jack 903719 coupling | | | |
| 223.00 | Oper side T-bar connector (024130-B) | | | |
| 224.00 | Oper side Shoulder bolt (903723 Qty-2) | | | |
| 225.00 | Oper side T-Bar (024137-C) Condition | | | |

YAI-F26-6-PLC PREVENTIVE MAINTENANCE INSPECTION CHECKLIST

Mold Cover Lift Assembly (Hydraulic) Continued

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|--------|---|------|-------------------|----------|
| 226.00 | Oper Side Super-Seal (023079-YA) | | | |
| 227.00 | Oper side screw jack input shaft (Note end play) | | | |
| 228.00 | Oper side screw jack output screw (Note end play) | | | |
| 229.00 | Oper side (024138-C) guide block | | | |
| 230.00 | Oper side (024131-B) guide block backer plate | | | |
| 231.00 | Oper side coupling screw jack set screw | | | |
| 232.00 | Oper side rubber spider for (903719) coupling | | | |

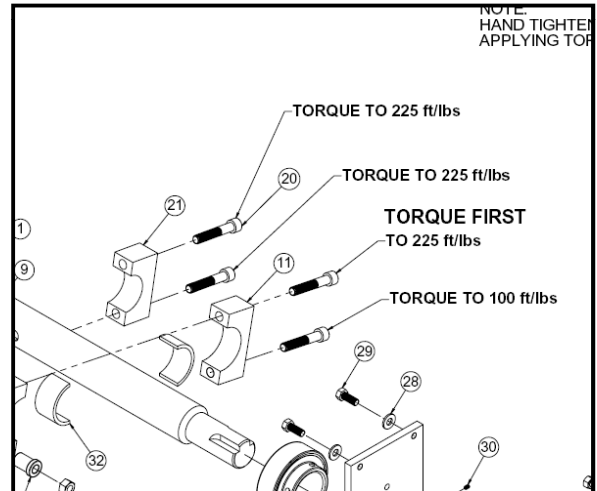
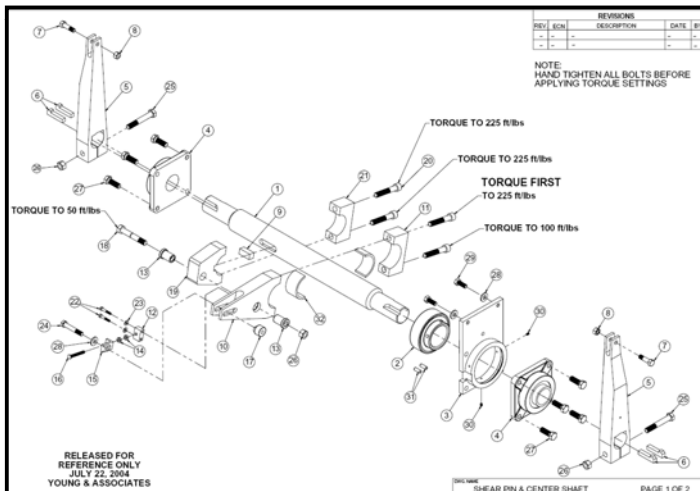
Hydraulic System

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|--------|--|------|-------------------|----------|
| 233.00 | Motor to Low pressure pump coupling | | | |
| 234.00 | Hydraulic reservoir oil level | | | |
| 235.00 | Product pressure adjustor working correctly | | | |
| 236.00 | Inspect for oil leaks. (Record leaks) | | | |
| 237.00 | Accumulator Pressure (175/PSI) = _____ | | | |
| 238.00 | Pump running Digital reading (18) = _____ | | | |
| 239.00 | Digital pressure setting HP (50) = _____ | | | |
| 240.00 | Relief setting (750/PSI) = _____ | | | |
| 241.00 | Accumulator Dump valve functions correctly | | | |
| 242.00 | Product pressure gauge reading correctly 5/1 reading | | | |

Shear Pin & Center Shaft Assembly


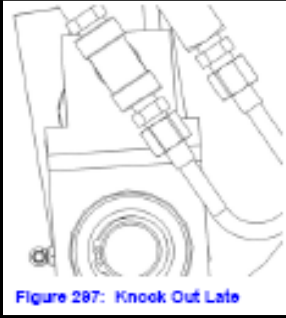
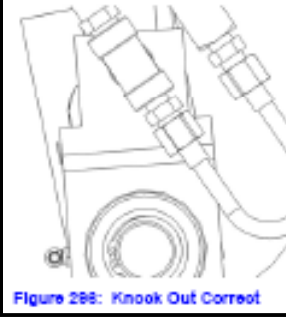
| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|--------|--|------|-------------------|----------|
| 243.00 | Shear Pin Keyed block. (Key and Keyway) | | | |
| 244.00 | Shear pin bushing in keyed arm (23699 Check Cracks) | | | |
| 245.00 | Center support bearing and holder (Check for Cracks) | | | |
| 246.00 | Short rocker arm two piece Assembly | | | |
| 247.00 | Shear Pin check Torque (50/ft/lbs) | | | |
| 248.00 | Keyed short rocker are Torque (250/ft/lbs) | | | |
| 249.00 | Short Rocker arm bushing (at Least 125/ft/lbs****) | | | |

**** When checking the 125/ft/lbs on the short rocker arm this is only insure that nothing is backing off or any of the shoulder bolts are broken. When installing this arm on the center shaft make sure that you follow the torque setting called out in this procedure. Drawing #024348-M-YA



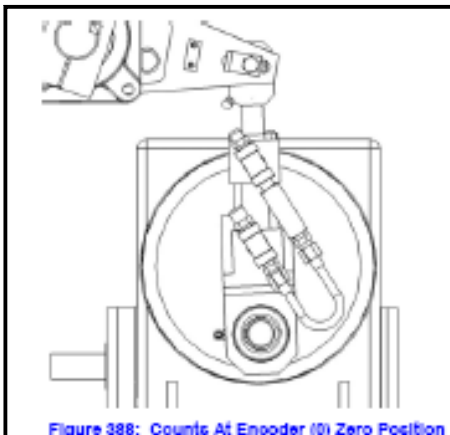
YAI-F26-6-PLC PREVENTIVE MAINTENANCE INSPECTION CHECKLIST

Stroke Length & Mold Plate Position

| | |
|--------|---|
| 250.00 | Stroke length Factory spec = 9-5/32" +0 -1/32" |
| 251.00 | Mold Plate position = 1" +1/32-1/32 tolerance |
| 252.00 | Stroke length prior to adjustment = _____ After Adjustment = _____ |
| 253.00 | Stroke length position prior to adjustment = _____ After Adjustment = _____ |
| | Knock out Timing (ID Before adjustment ID after adjustment) |
| |  |
| |  |
| |  |

Mold Plate Encoder

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|--------|--|------|-------------------|----------|
| 254.00 | Check encoder coupling alignment & Condition | | | |
| 255.00 | Check encoder cable connection and cable | | | |
| 256.00 | Check Index and counts 0-600 counts | | | |
| 257.00 | Record encoder counts = _____ After Adjustment = _____ | | | |



Counts range at this position should read 590-599



Plunger #1 and #2 Inspections

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|--------|---|------|-------------------|----------|
| 258.00 | Plunger #1 Non-Oper Side prox gap set correctly 3/16" | | | |
| 259.00 | Plunger #1 prox clearance check Plunger Forward | | | |
| 260.00 | Plunger #1 prox clearance checked plunger retracted | | | |
| 261.00 | Plunger #1 Trip arm surface cleaned off | | | |
| 262.00 | Plunger #1 Trip arm follower block checked for wear | | | |
| 263.00 | Plunger #1 Guide blocks Inspected on Plunger window | | | |
| 264.00 | Plunger #1 Plunger inspected for crack or damages | | | |
| 265.00 | Plunger #1 Plunger plate to cylinder inspected for wear | | | |
| 266.00 | Plunger #2 Oper Side prox gap set correctly 3/16" | | | |
| 267.00 | Plunger #2 prox clearance check Plunger Forward | | | |
| 268.00 | Plunger #2 prox clearance checked plunger retracted | | | |
| 269.00 | Plunger #2 Trip arm surface cleaned off | | | |
| 270.00 | Plunger #2 Trip arm follower block checked for wear | | | |

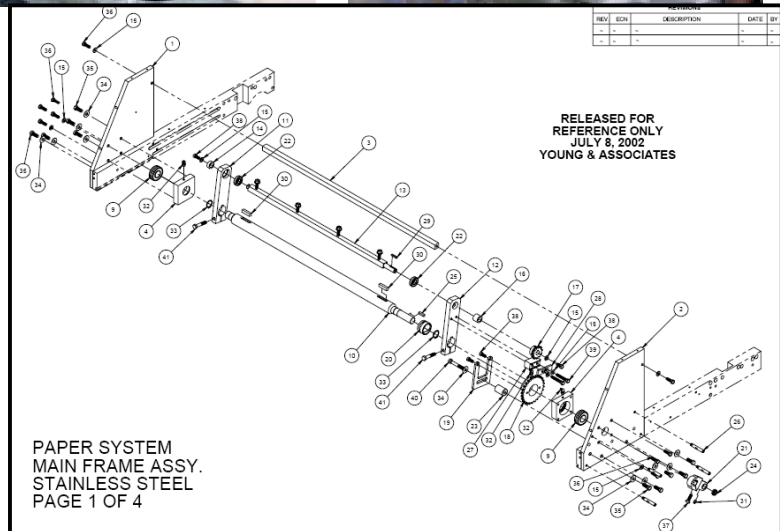
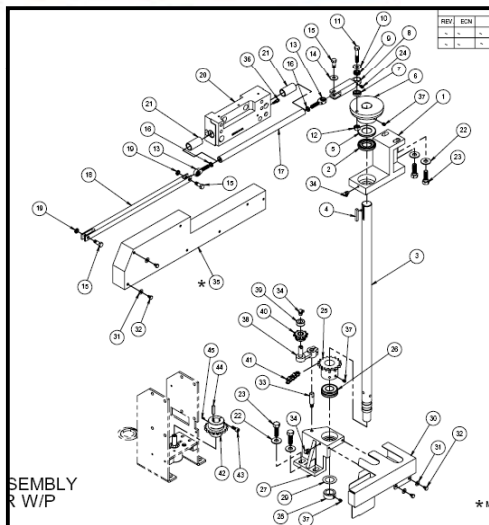
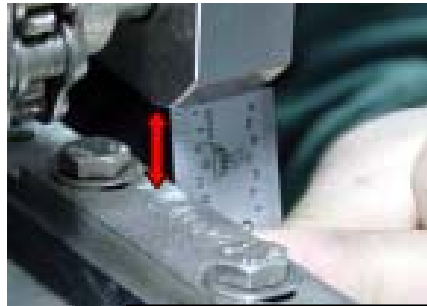
YAI-F26-6-PLC PREVENTIVE MAINTENANCE INSPECTION CHECKLIST

Plunger #1 and #2 Inspections Continued

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|--------|---|------|-------------------|----------|
| 271.00 | Plunger #2 Guide blocks Inspected on Plunger window | | | |
| 272.00 | Plunger #2 Plunger inspected for crack or damages | | | |
| 273.00 | Plunger #2 Plunger plate to cylinder inspected for wear | | | |
| 274.00 | Plunger #1 Non-Oper side shaft seal (Inspect for Leaks) | | | |
| 275.00 | Plunger #2 Oper-Side Shaft seal (Inspect for Leaks) | | | |
| 276.00 | Plunger #1 Mounting bolts secure to base of machine | | | |
| 277.00 | Plunger #2 Mounting bolts secure to base of machine | | | |

Paper Feed System Attachments

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|--------|--|------|-------------------|----------|
| 271.00 | Shuttle arm wiper operator side | | | |
| 272.00 | Shuttle arm wiper Non-operator side | | | |
| 273.00 | Non-operator side reversing gear rack (Check for wear) | | | |
| 274.00 | Operator side reversing gear rack (Check for wear) | | | |
| 275.00 | Check paper arm 5/8" dimension | | | |
| 276.00 | Check Paper arm 3/4" dimension | | | |
| 277.00 | Set 1" paper bar locator dimension | | | |
| 278.00 | Check paper feed bearing for wear | | | |
| 279.00 | Grease zerks under paper feed arm guard cover | | | |
| 280.00 | 4033-A Bronze chain wear strips adjust or Replace | | | |
| 281.00 | Set Vacuum cup bar angle | | | |
| 282.00 | Set Vacuum cups to paper bar height | | | |



YAI-F26-6-PLC PREVENTIVE MAINTENANCE INSPECTION CHECKLIST

Paper Feed Attachment Vacuum Box

| | | GOOD | NEEDS REPLACEMENT | REPLACED |
|--------|--|------|----------------------|----------|
| 283.00 | Inspect vacuum lines for cracks or worn spots | | | |
| 284.00 | Record vacuum level paper bar (Prior Cleaning) -22 -27 | | | |
| 285.00 | Record vacuum level stem bar (Prior Cleaning) -20 -22 | | | |
| 286.00 | Record vacuum level stem bar (W/O/relief) -22 -27 | | | |
| 287.00 | Flush vacuum paper bar valves and lines | | | |
| 288.00 | Flush vacuum paper stem valves and lines | | | |
| 289.00 | Remove and clean vacuum canisters filters and jars | | | |
| 290.00 | Check for damaged aluminum canisters jars | | | |
| 291.00 | Note air pressure for air blow back (10/psi/max) | | | |
| 292.00 | Record vacuum level paper bar (Prior Cleaning) -22 -27 | | | |
| 293.00 | Record vacuum level stem bar (W/relief) -17 -22 | | | |
| 294.00 | Record vacuum level stem bar (W/O/relief) -22 -27 | | | |
| 295.00 | Check belt tension on pumps, wear, and alignment | | | |
| 296.00 | Check cabinet blower is working correctly | | | |

Safety Interlocks-Guards-Labels

| | | GOOD | Operative | Non-operative |
|--------|---|------|-----------|---------------|
| | Door Interlocks (Must shut down machine immediately) | | | |
| 297.00 | Door #1 Operator side | | | |
| 298.00 | Door #2 Non-operator side front door. | | | |
| 299.00 | Door #3 Non-operator side middle door | | | |
| 300.00 | Door #4 Non-operator side rear door | | | |
| 301.00 | Door #5 Single rear door (Super-Seal Only) | | | |
| 302.00 | Door #5 Rear door Left hand side | | | |
| 303.00 | Door #6 Rear door right hand side | | | |
| 304.00 | Hopper Side Pan Proxs | | | |
| | Hopper pans (Must shut down machine immediately) | | | |
| 305.00 | Operator side hopper side cover | | | |
| 306.00 | Non-operator side hopper side cover | | | |
| | Plunger guards (Must shut down machine immediately) | | | |
| 307.00 | Operator side plunger guard | | | |
| 308.00 | Non-operator side plunger guard | | | |
| | KO Guards (Must shut down mold plate immediately) | | | |
| 309.00 | Operator side mold cover | | | |
| 310.00 | Non-operator side mold cover guard | | | |
| 311.00 | Tube valve/ operator side shuttle arm guard | | | |
| 312.00 | Non-Operator side shuttle arm guard | | | |
| 313.00 | Paper feed hopper guard | | | |
| | Feed Screw Cover (Must shut down mold plate immediately) | | | |
| 315.00 | Operator side overarm prox | | | |
| 316.00 | Paper Feed (Must shut down machine immediately) | | | |
| 317.00 | Paper hopper prox | | | |
| 318.00 | Operator-side vacuum pump box side door | | | |
| 319.00 | Non-operator side vacuum pump box side door | | | |
| 320.00 | Top access cover vacuum pump box | | | |
| | E-Stops (Must shut down machine immediately) | | | |
| 321.00 | E-stop Swing arm control panel | | | |
| 322.00 | E-Stop operator side overarm | | | |
| 323.00 | E-Stop non-operator side overarm | | | |
| 324.00 | E-Stop Front of machine paper hopper area (P/F only) | | | |

