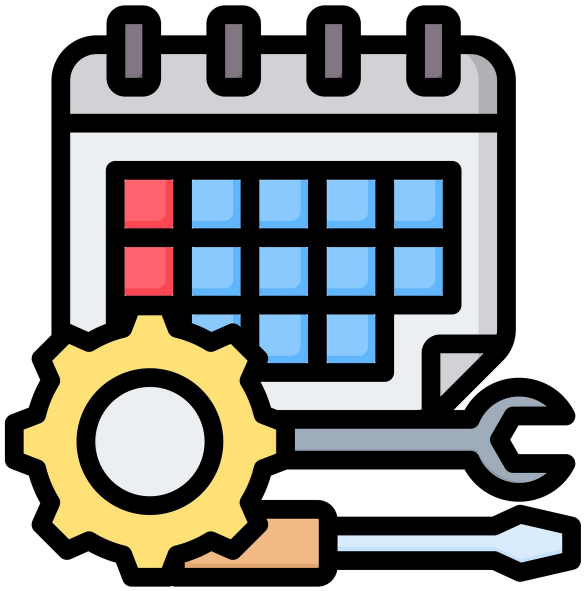
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Maintenance Schedule WF10

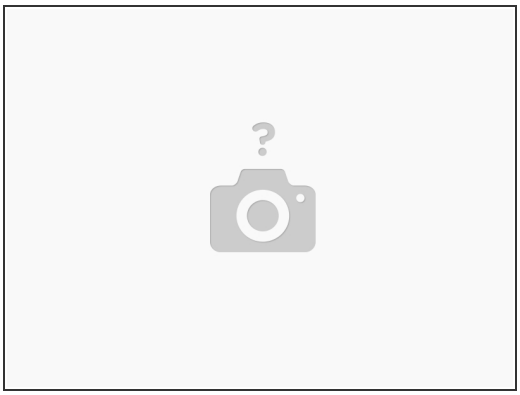
Maintenance Recommendations for the WF10

Written By: Ian Ho



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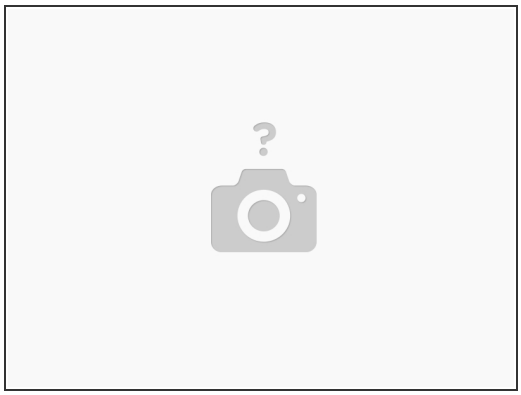
Step 1 — Daily



- Keep framework and conveyor belts clean of dirt build-up, grease and oil residues.
- Check drivebelts for wear.
- Verify that the air pressure is regulated to the proper setting (90 PSI), and that any water is drained from the filter.
- Check for worn or broken electrical and air connections.
- Visually inspect the WF10T for loose fasteners, and leaks in the pneumatic system, and drain bottle overflow.
- Ensure that the LinMot® linear motors are adequately lubricated. Ensure that the guide rods are adequately lubricated.
- Clean the tape knife on the Tape Head with WD-40 or a similar low-toxicity cleaner and lubricate the blade guard pad with silicone.

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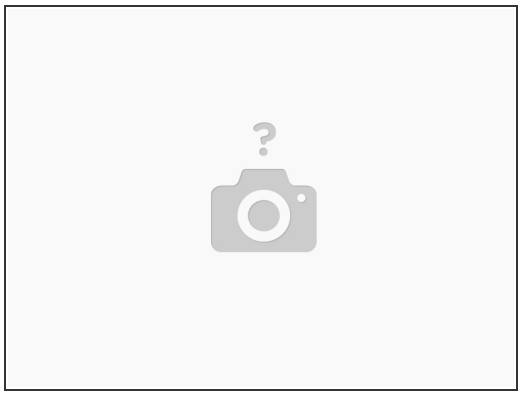
Step 2 — Weekly



- Check reducer lubricant level and replenish as required.
- Check conveyor belt condition, tracking, and tension.

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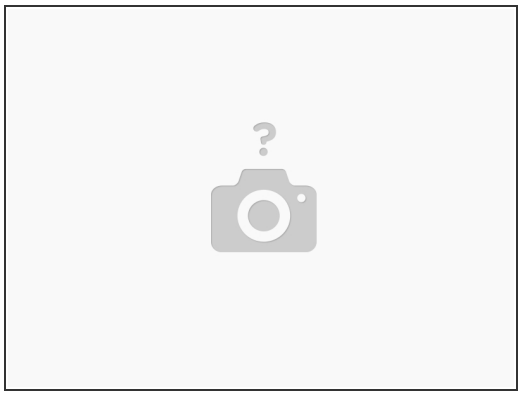
Step 3 — Monthly



- Timeframes are based on a WF10T running 10 cycles per minute, 8 hours per day, and 22 days/month, or 1,200,000 cycles per year. Adjust your schedule according to your machine use.
- Thoroughly clean all sprockets, chains, LinMot® linear motors, and sliding components, and then lightly grease with Fuchs FM Grease AX/EP 2 Food Grade Oil.
- Lubricate the discharge conveyor drive chain and width adjustment roller chain with a chain spray lube.
- Inspect the electric motor for evidence of oil leakage, noise, or vibration.
- Keep unit free of dirt. Excess accumulation of dirt or grease will affect the proper cooling of the units.
- Correct tension and tracking will prolong the belt and drive bearing life. Check belt condition, tracking, and tension

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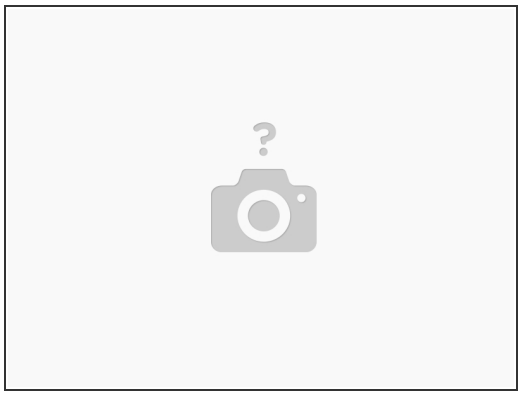
Step 4 — Every 3 Months



- Timeframes are based on a WF10T running 10 cycles per minute, 8 hours per day, and 22 days/month, or 1,200,000 cycles per year. Adjust your schedule according to your machine use.
- Lubricate width and height adjustment leadscrews with Fuchs FM Grease AX/EP 2 Food Grade Oil.
- Remove drivebelts. Drive pulleys and idler pulleys should be inspected for bearing wear and pulley damage. Remove any dirt build-up before drivebelts are re-installed.
- Remove flap folders for servicing. Remove covers and check for worn parts.
- Check the tension of the discharge conveyor drivebelt chain drive.
- Proper tension for the discharge conveyor drivebelt chain drive is achieved when the horizontal sag in the chain measures between 1/8” and ¼” with the drivebelts in a fully opened position.

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Step 5 — Every 3 Months part 2



- Inspect all pneumatic and electrical limit switches and verify that they are properly adjusted and in good working order.
- Check for any loose or missing fasteners.
- For more information on the recommended schedule for replacing parts for wear, see the Recommended Spare Parts List, which is located in the Supplementary Manual.

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