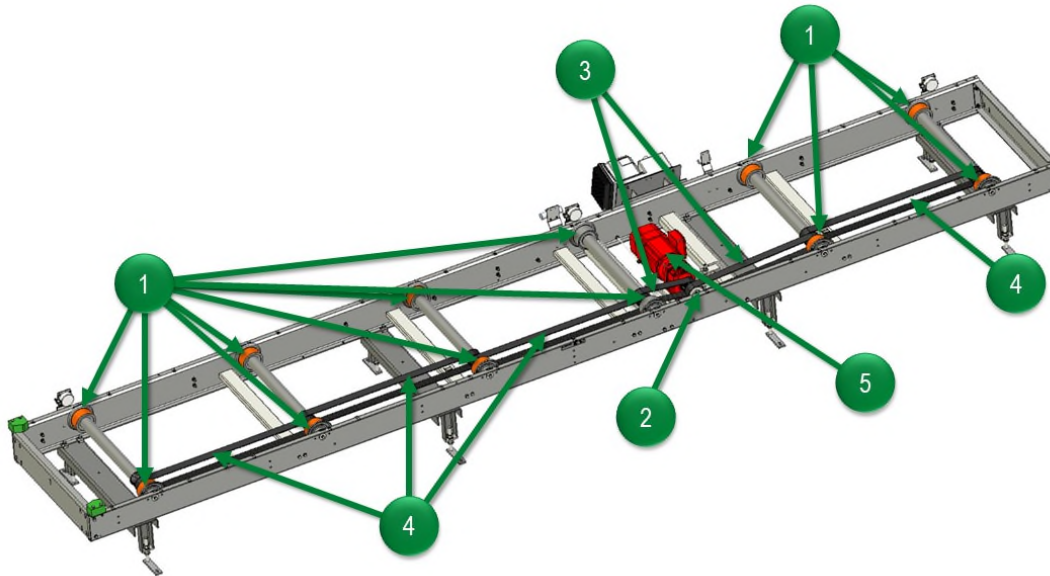


Preventive Maintenance

Typical Power Roll Bed Inspection Items



Interval	Item #	Component	Description
Daily/Visual	--	All	<ul style="list-style-type: none"> Obvious signs of damage to the equipment. Damage or noticeable wear on the rollers. Loose bolts. Signs of oil leaks on the equipment or on the floor below any gearbox.
3 months	1	Roller	<ul style="list-style-type: none"> Check rollers for bearing clearance, damage, and wear. Abrasion should not exceed 5 mm on diameter (minimum diameter is 120 mm), unevenness at the surface maximum 3 mm.
	2	Motor Drive Pulley	<ul style="list-style-type: none"> Check secure mounting on drive shaft.
	3	Drive Belt	<ul style="list-style-type: none"> Check for excessive fraying on belt edges and for broken teeth. Check for sufficient tension, if necessary, replace belt
	4	Driven Belts	<ul style="list-style-type: none"> Index the lift. Check that belts run freely and without excessive noise. Check for excessive fraying on belt edges and for any exposed reinforcing wires.
6 months	5	Gearmotor	<ul style="list-style-type: none"> Check gearmotor for excessive noise. Remove the oil level plug to check the level of oil. See Gearmotor Lubrication Table for recommended lubricants.
36 months			<ul style="list-style-type: none"> Replace gearmotor oil. Depending on operating conditions, oil change interval may be shorter.

Lubrication

Except for the gearmotor, all components on FATA Automation Power Roll Beds or Stands follow “lube-for-life” specifications and do not require lubrication intervals.

The following table lists the viscosity oil grade of the standard SEW gearmotors that are used. When adding oil, do not mix oil grades.

Gearmotor Lubrication Table

Part Description	Type of Gearing	Type of Oil	Manufacturer Type	Viscosity/ Grade
SEW Drive Units	Helical-Bevel	Synthetic	Shell Omala S4-GX220	ISO VG 220

Please refer to the gearmotor data plate and the SEW Eurodrive manufacturer’s instruction manual for additional service requirements and technical data.

⚠ CAUTION ⚠

- Risk of burns due to hot gear unit and hot gear unit lubricant.
- Let the gear unit cool down before you start working on it.
- Carefully remove the oil level plug and the oil drain plug.
- Before attempting any maintenance on this equipment all involved personnel should follow plant internal regulations along with any state, federal, or province regulations. Do not begin any repair procedure until the proper shutdown procedures and the appropriate power lockout procedures have been applied.



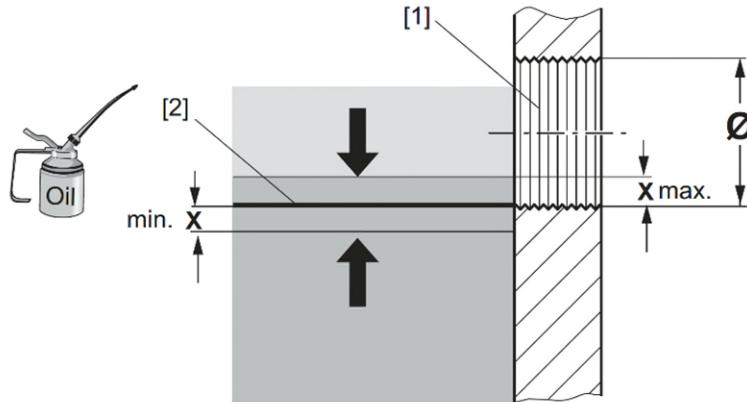
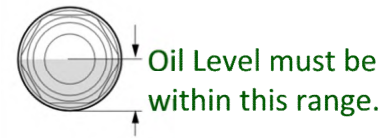
▲ Sample SEW gearmotor data plate.



▲ Oil Sight Level Glass location on gearmotor.

How to Check Oil Level of SEW Gearmotor

1. Locate the positions of the oil level plug and the breather valve.
2. If the gearmotor is equipped with an oil sight glass, you can determine the oil level according to the figure on the right.
3. If the gearmotor does not have a site glass, place a container underneath the oil level plug.
4. Slowly unscrew the oil level plug. Small amounts of oil may leak out as the permitted maximum oil level is higher than the lower edge of the oil level bore.
5. Check the oil level according to the following figure and the corresponding table.



[1] Oil Level Bore [2] Oil Level Setpoint [X] Min./Max. Oil Level

Ø Oil Level Bore	Approved fluctuation "x" of the oil level [mm]
M10 x 1	1.5
M12 x 1.5	2
M22 x 1.5	3
M33 x 2	4
M42 x 2	5

6. If the oil level is too low, proceed as follows:
 - a. Remove the breather valve from the breather bore.
 - b. Fill in fresh oil of the same type via the breather bore, up to the lower edge of the oil level bore.
 - c. Screw in the breather valve again. When doing this, please observe tightening torques.
7. Screw in the oil level plug again. When doing this, please observe tightening torques below for oil level plugs, oil drain plugs, breather valves, and oil sight glasses:

Thread	Tightening Torque (Nm)
M10 x 1	12
M12 x 1.5	15
M22 x 1.5	60
M33 x 2	100
M42 x 2	150

Checking the Oil Consistency of SEW Gearmotor via Oil Drain Plug

1. Locate the positions of the oil level plug and the breather valve.
2. Remove a little oil from the oil drain plug.
3. Check the oil consistency:
 - a. Viscosity (have this carried out by a suitable laboratory if necessary)
 - d. If you can see that the oil is heavily contaminated, it is advisable to change the oil, even if this is outside the specified service intervals.
 - b. Check the oil level according **How to Check Oil Level of SEW Gearmotor** on previous page.

Checking the Oil of SEW Gearmotor via Oil Drain Plug and Breather Valve

1. Locate the positions of the oil level plug and the breather valve.
2. Place a container underneath the oil drain plug.
3. Remove the oil level plug, the breather valve and the oil drain plug.
4. Drain all the oil.
5. Re-insert the oil drain plug. When doing this, please observe tightening torques.
6. Fill in fresh oil of the same type via the breather bore. Do not mix different synthetic lubricants.
 - a. Observe the oil quantities according to the specifications on the nameplate.
 - b. Check the oil level at the oil level plug.
7. Re-insert the oil level plug and the breather valve. When doing this, please observe tightening torques.