

## PACLINE INSTALLATION CHECKLIST

The Pacline Overhead Conveyor Systems can be properly installed by carefully following the Pacline Instruction Manual shipped with each system. Upon completion of the installation ensure that the following steps have been taken:

1)	Check that <b>all</b> installation attachments have been tightened and secured with bolts or welds.	
2)	Ensure that track hanger clamps have been tack welded where appropriate. (Never inside ovens).	
3)	Test run the conveyor system for a minimum of one hour.	
	A. Ensure that drive dogs engage horizontal bearing.	
	B. Ensure that the chain lubricator is properly set up and filled with lubricant.	
	C. Adjust chain tension at take-up assembly, make sure there is no slack chain at any point in the system.	
	D) Check that chain pendant does not catch on any track joints.	
4)	Note any changes to layout drawing and inform Pacline engineering.	
5)	Instruct the end user on safe operation of the system.	
6)	Instruct the end user in the proper loading of the system.	
	A) The system should first be run in for minimum one revolution of entire chain before the product carriers are installed.	
	B) The system should be run for one revolution of entire chain after the product carriers are installed.	
	C) When loading the system for the first time only every other carrier should be loaded for the first revolution of entire chain.	
	D) Ensure chain pendants do not rub on track slot due to carriers having unbalanced loading. Advise the end user if off centre loading may be a concern.	

**Note:** The longer the system and the heavier the load, the more critical it is that the run in sequence be followed and the duration of each run-in cycle should be extended accordingly.

To:

Date:

From:

Attached for your reference is Pacline's Preventative Maintenance Schedule, which should be followed in conjunction with the Pacline engineering information supplied with the system.

The maintenance requirements of the Pacline Overhead Conveyor System will vary depending on the operating environment and load being conveyed. The length and complexity also are a factor in maintenance scheduling.

This Preventative Maintenance Checklist is a list of standard maintenance procedures, which should be carried out regularly.

We recommend that all points be checked at time of installation, after 500 hours of operation and then every 2,000 hours of operation.

If you have any specific questions do not hesitate to contact our engineering department at the following:

***Pacline Corporation***

10 Falconer Drive  
Mississauga, Ontario  
L5N 3L8

Telephone (905) 858-2330  
Fax (905) 858-2333  
Toll Free U.S. (800) 955-8860  
Toll Free Canada (800) 461-7803

***Pacline Conveyors Inc.***

155 Great Arrow Avenue  
Buffalo, New York  
14207

Telephone (716) 876-9250  
Fax (716) 876-9287  
Toll Free (800) 556-2559

**E-Mail [sales@pacline.com](mailto:sales@pacline.com)**  
**Web Site [www.pacline.com](http://www.pacline.com)**

## PACLINE PREVENTIVE MAINTENANCE CHECKLIST

Customer: \_\_\_\_\_ Date: \_\_\_\_\_

Plant Location: \_\_\_\_\_ CONVEYOR #: \_\_\_\_\_

Service Performed By: \_\_\_\_\_ JOB NO: \_\_\_\_\_

	<b>Conveyor Drive: Check ALL hardware is tight.</b>	<b>COMMENTS</b>	<b>CKD</b>
a)	Check that drive dogs are engaged on horizontal bearing wheel.		
b)	Check drive dog springs: Lift one half of drive dog off of the pressure plate and release. If the drive dog snaps back the springs are operating properly, if not, they must be replaced.		
c)	Check that the drive dog rollers spin freely. If not, replace.		
d)	Check drive dogs along edges (beside rollers) where dog contacts pressure plate, align if necessary.		
e)	Check drive dogs for wear at the point where the dog contacts the horizontal bearing wheel. If wear is excessive replace drive dogs.		
f)	If uneven wear is present on the drive dog faces, the drive dog chain and the conveyor chain are out of alignment. Re-align if necessary.		
g)	Pressure Plate: Part No. DP-903	Wear Alignment	
h)	Check pillow block bearings for wear, cracks in seals or housing, bolts and set screws being tight. Apply grease if needed.		
i)	Check tension of drive dog chain assembly. Total chain deflection should be approximately 1".		
j)	Check tension of drive chain between reducer and drive shaft. Chain deflection should be 1/8" per foot.		
k)	Check motor for excessive noise. Clean fan & vents.		
l)	Sprockets:	Alignment Wear Lubrication Set Screws - Tight	
m)	Wear Strips:	Wear Fasteners Lubrication	
n)	Drive Plate:	Tighten all bolts Condition of chain slot for wear. All stickers in place	
o)	Reducer: Check gear box for proper oil level. Change oil after 2000 hours of operation. Check reducer for excessive noise.	Check Seals  Motor secured properly Motor shaft has key in it.	
p)	Misc. Drive	Drive dog pins straight Drive dog roller spring pin's slot must face up.	

## PACLINE PREVENTIVE MAINTENANCE CHECKLIST

	<b>Track &amp; Chain:</b>	<b>COMMENTS</b>	<b>CKD</b>
a)	Check for broken or damaged pendants	Rectify cause.	
b)	If track slot exceeds 3/8" to 1/2" that portion of track should be replaced. Check slot alignment throughout system.		
c)	Check chain tension, 1/8" to 1/4" movement in direction of travel.		
d)	Chain inspection. Remove cover from inspection port. While the conveyor is operating observe the chain for any visible defects or irregularities. Make sure bearings turn freely and easily. Check for wear indicated by excessive play in bearing raceway.		
e)	Check for loose hardware, including support structure.		
f)	Is any contaminant reaching the chain surface.		
g)	Measure & record centers of 10 ft. section of chain.		
h)	Curves: Horizontal	Flattening or wear on inside radius or excessive slot width.	
i)	Curves: Vertical	Any opening of vertical slot.	
j)	Track:	Any bent or damaged sections	
k)	Track & Beam Clamps:	All hardware tight, bolted & welded securely	
l)	Flanges:	Welded & tightened correctly	
<b>Lubricator:</b>			
a)	Make sure chain is being properly lubricated. Top-up lubricant.		
b)	Operational	Set up properly & operational.	
c)	Record:	Type of Lubricator:	
		Type of Lubricant:	
<b>Take-up Unit:</b>			
a)	Check for adequate remaining adjustment		
b)	Alignment:		
c)	Springs:		
d)	Grease sleeves:		
<b>Carriers:</b>			
a)	Check for damage and note:		
<b>Safety Guarding:</b>			
a)	Check for proper installation		
b)	Check for product clearance		
c)	Safety signs in place		
d)	Padding at lower level		