

PM Master Work Order Form

Job No. ROD-001/RM-LUB AND INSPECT

Procedure Description LUB & INSPECT

Priority
Cost Center 4509
Shift 1,2,3

Maintenance Code MAINT
Work Type

Equipment No.	Equipment Name	Location
ROD-001/RODMILL	ROD DRAW MACHINE	RODMILL

Cycle Type	Last Scheduled Date	Active Date	Next Scheduled Date
Daily	05/05/2011	06/10/2011	06/17/2011

Runtime Cycle	Runtime Advance	Next PM	Last PM
0.00	0.00	0.00	0.00

Cycle Type	Task No.	Description	Labor Code	Est. Hours
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Cycle Type	Part No.	Part Name	Qty Allocated	Stockroom
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Cycle Type	Employee No.	Employee Name	Labor Code	Est. Hours	Task No.
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Cycle Type Tool Description

WO Desc.

DRAW MACHINE-M85

- A) REPLACE FILTERS (DRIVE BLOWERS) (CONTROL CABINETS)
- B) OIL HINGES AND BALL VALVE OILER (VACTRA OIL #2)
- C) GREASE GUIDE PULLEY FINAL CAPSTAN (EP-2) GREASE ROTARY UNION (EP-2)
- D) CHECK RUBBER BUFFER MAIN DRIVE COUPLING, FINAL CAPSTAN DRIVE BELTS AND BELT ON FINISH DIE INSIDE FINAL CAPSTAN.
- E) CHECK OIL LEVEL

ANNEALER- R501

- A) REPLACE FILTER (COOLING FAN ON TOP)
- B) OIL HINGES (DTE 24)
- C) CHECK BELTS (CONTACT PULLEYS, 2 FLAT BELTS)
- D) CHECK BRUSHES AND CONTACT RINGS- CLEAN OUT CARBON DUST.
- E) CLEAN FLOATS IN TANK- REMOVE PLATE IN TOP OF TANK; FLOATS WILL BE ATTACHED
- F) GREASE ROTARY UNIONS (EP-2)

COILER- WF800

- A) REPLACE FILTER (DRIVE BLOWER)
- B) CHECK ALL BELTS (MAIN DRIVE,BARREL POSITIONING,ZERO GEAR.
- C) GREASE MAIN SHAFT BEARINGS (2 NIPPLES ON TOP MACHINE) USE (EP-2)
- D) GREASE STRAIGHTENER PULLEYS (3 FITTINGS) USE(MOBIL HP)
- E) GREASE CENTRAL GUIDE PULLEY (2 FITTINGS) AND ZERO GEAR BEARINGS(2 FITTINGS) USE (MOBIL SCH-32 SYNTHETIC GREASE)
- F) INSPECT FINGERS FOR WEAR AND TIGHTNESS

THREADER

- A) GREASE (6 FITTINGS) USE (EP-2)
- B) CHECK OIL LEVEL (MOBILGEAR 630)

WELDER

- A) INSPECT FOR WEAR, CLEAN CONTACT PADS AND CHECK OPERATION.

*****PM PERFORMED @ HRS.*****
DATE=

ADDITIONAL P/M PERFORMED
USERPMM.RPT

PM Master Work Order Form

8/4/2011

Job No. ROD-001/RM-LUB

Procedure Description LUB

Priority

Maintenance Code MAINT

Cost Center

Work Type

Shift 1,2,3

Equipment No.
ROD-001/RODMILL

Equipment Name
ROD DRAW MACHINE

Location
RODMILL

Cycle Type
Daily

Last Scheduled Date
05/01/2011

Active Date
07/10/2011

Next Scheduled Date
07/17/2011

Runtime Cycle
0.00

Runtime Advance
0.00

Next PM
0.00

Last PM
0.00

Cycle Type	Task No.	Description	Labor Code	Est. Hours
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Cycle Type	Part No.	Part Name	Qty Allocated	Stockroom
All	0-0982645-1	GREASE (EP2 {ALVANIA R2})	1	MAIN

Cycle Type	Employee No.	Employee Name	Labor Code	Est. Hours	Task No.
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Cycle Type Tool Description

WO Desc.

ANNEALER

A) GREASE BEARING ASSEMBLIES ON CONTACT PULLEYS AND FINAL CAPSTAN- USE (EP2)

***** PM PERFORMED @ HRS. *****
Cyc: DATE=

Cyc:

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C.

Cyc

Cyc

PM Master Work Order Form

Job No. ROD-001/RM BRUSHES

Procedure Description CHECK BRUSHES

Priority
 Cost Center 4509
 Shift 1,2,3

Maintenance Code MAINT
 Work Type

Equipment No. ROD-001/RODMILL
 Equipment Name ROD DRAW MACHINE
 Location RODMILL

Cycle Type Daily
 Last Scheduled Date 02/28/2011
 Active Date 08/15/2011
 Next Scheduled Date 08/29/2011

Runtime Cycle 0.00
 Runtime Advance 0.00
 Next PM 0.00
 Last PM 0.00

Cycle Type	Task No.	Description	Labor Code	Est. Hours
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Cycle Type	Part No.	Part Name	Qty Allocated	Stockroom
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Cycle Type	Employee No.	Employee Name	Labor Code	Est. Hours	Task No.
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Cycle Type Tool Description

WO Desc.

DRAW MACHINE-M85

TO BE PERFORMED ON MAIN DRIVE AND FINAL CAPSTAN DRIVE:

- A) INSPECT DRIVE BRUSHES-BLOW OUT CARBON DUST,CLEAN COMMUTATOR, BRUSH HOLDERS AND BRUSH GEARS. (MIN. BRUSH LENGTH= 16 MM.)
- B) CHECK AND CLEAN TACHOMETER.
- C) CHECK ALL PIPES AND HOSES FOR LEAKS.

ANNEALER- R501

- A) CHECK HOSES,PIPES AND SEALS IN ANNEALING AND COOLING SECTIONS FOR LEAKS.
- B) CHECK GROUNDED INLET AND OUTLET PULLEYS RESISTANCE= LESS THAN 0.1 OHM.

COILER- WF800

- A) INSPECT DRIVE BRUSHES-BLOW OUT CARBON DUST,CLEAN COMMUTATOR, BRUSH HOLDERS AND BRUSH GEARS. (MIN. BRUSH LENGTH= 12 MM.)
- B) CHECK PISTON GUIDE BARS FOR WEAR.
- C) CHECK OIL LEVEL IN 3 GEARBOXES=USE (MOBILGEAR 630)
- D) LUB 2 CHAINS ON HEAD= USE(AW 2)
- E) INSPECT ALIGNMENT AND TIGHTNESS OF FINGERS

***** PM PERFORMED @ HRS. *****
 DATE:

PM Master Work Order Form

Job No. ROD-001/RM CHANGE

Procedure Description CHANGE OIL

Priority
Cost Center 4509
Shift 3

Maintenance Code MAINT
Work Type

Equipment No. ROD-001/RODMILL Equipment Name ROD DRAW MACHINE Location RODMILL

Cycle Type Daily Last Scheduled Date 03/24/2010 Active Date 02/16/2012 Next Scheduled Date 03/01/2012

Runtime Cycle 0.00 Runtime Advance 0.00 Next PM 0.00 Last PM 0.00

Cycle Type Task No. Description Labor Code Est. Hours

Cycle Type	Part No.	Part Name	Qty Allocated	Stockroom
All	A203604	TYVEK COVERALL (WHITE)	2	MAIN
All	MOBILGEAR 630	OIL (MOBILGEAR 630)(OMALA 220)	110	MAIN

Cycle Type Employee No. Employee Name Labor Code Est. Hours Task No.

Cycle Type Tool Description

WO Desc.

TO BE PERFORMED EVERY 2500 HRS or 2 YEARS..(WHICH EVER COMES FIRST)

DRAW MACHINE- M85

A) REPLACE OIL (USE MOBILGEAR 630) APPROX. 110 GALS.

COILER- WF800

A) REPLACE OIL IN GEARBOXES (USE MOBILGEAR 630)

THREADER

A) REPLACE OIL (USE MOBILGEAR 630)

***** PM PERFORMED @ HRS. *****
DATE=

PM Master Work Order Form

8/4/2011

Job No. ROD-001/RM-BASIN

Procedure Description REMOVE COPPER FROM BASINS

Priority
Cost Center

Maintenance Code OPER
Work Type

Shift 1,2,3

Equipment No.
ROD-001/RODMILL

Equipment Name
ROD DRAW MACHINE

Location
RODMILL

Cycle Type
Daily

Last Scheduled Date
05/12/2011

Active Date
08/28/2011

Next Scheduled Date
09/04/2011

Runtime Cycle
0.00

Runtime Advance
0.00

Next PM
0.00

Last PM
0.00

Cycle Type	Task No.	Description	Labor Code	Est. Hours
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Cycle Type	Part No.	Part Name	Qty Allocated	Stockroom
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Cycle Type	Employee No.	Employee Name	Labor Code	Est. Hours	Task No.
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Cycle Type Tool Description

WO Desc.

- 1) REMOVE COPPER BUILD UP FROM LARGE DRAW BASIN IN BACK, ALSO REMOVE BUILD UP FROM AROUND FLOATS.
- 2) REMOVE COPPER BUILD UP FROM INSIDE ANNEALER BASIN AND DRAWBOX..
- 3) CHECK SOLUTION FLOW TO EACH DIE FOR LEAKAGE & CLEAN OUT ALL SPRAY NOZZLES.
- 4) CHECK VIBRATION DAMPER FOR WEAR. REPLACE IF NECESSARY.

P/M PERFORMED BY _____
DATE PERFORMED _____
TIME TAKEN FOR PM _____
MACHINE HOURS _____

ADDITIONAL P/M REQUESTED _____

PM Master Work Order Form

8/4/2011

Job No. ROD-001/RM-CLEAN

Procedure Description CHECK ANNEALER BANDS/COILER

Priority
Cost Center 4509
Shift 1,2,3

Maintenance Code OPER
Work Type

Equipment No. ROD-001/RODMILL
Equipment Name ROD DRAW MACHINE
Location RODMILL

Cycle Type Daily
Last Scheduled Date 04/08/2011
Active Date 06/29/2011
Next Scheduled Date 07/06/2011

Runtime Cycle 0.00
Runtime Advance 0.00
Next PM 0.00
Last PM 0.00

Cycle Type	Task No.	Description	Labor Code	Est. Hours
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Cycle Type	Part No.	Part Name	Qty Allocated	Stockroom
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Cycle Type	Employee No.	Employee Name	Labor Code	Est. Hours	Task No.
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Cycle Type	Tool Description
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WO Desc.

- 1) CLEAN UP MACHINE EXTERIOR SURFACES
- 2) INSPECT ANNEALER BANDS (REPLACE IF NEEDED)
- 3) INSPECT FOR WEAR AREAS (CERAMIC GUIDES AND PULLEYS)
- 4) WIPE CLEAN CERAMIC GUIDES AND PULLEYS
- 5) CLEAN AND CLEAR ALL DRAINS IN ANNEALER CHAMBER
- 6) CHECK AND CLEAN AIR WIPES
- 7) CHECK COILER CAPSTAN FOR SURFACE WEAR AND DAMAGE
- 8) INSPECT CERAMIC FINGERS FOR WEAR AND DAMAGE
- 9) CHECK ALL CERAMIC GUIDES AND PULLEYS
- 10) CHECK LAYERING RODS FOR SURFACE DAMAGE
- 11) CLEAN FLOATS IN RESY FILTER AND CHECK OPERATION

P/M PERFORMED BY _____
DATE PERFORMED _____
TIME TAKEN FOR PM _____
MACHINE HOURS _____

ADDITIONAL P/M REQUESTED _____

PM Master Work Order Form

Job No. ROD-001/RM-BELTS

Procedure Description CHECK ANNEALER BELTS

Priority

Maintenance Code MAINT

Cost Center 4509

Work Type

Shift 1,2,3

Equipment No.
ROD-001/RODMILL

Equipment Name
ROD DRAW MACHINE

Location
RODMILL

Cycle Type
Daily

Last Scheduled Date
04/04/2011

Active Date
06/27/2011

Next Scheduled Date
07/04/2011

Runtime Cycle
0.00

Runtime Advance
0.00

Next PM
0.00

Last PM
0.00

Cycle Type	Task No.	Description	Labor Code	Est. Hours
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Cycle Type	Part No.	Part Name	Qty Allocated	Stockroom
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Cycle Type	Employee No.	Employee Name	Labor Code	Est. Hours	Task No.
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Cycle Type	Tool Description
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WO Desc.

ANNEALER (replace when determined by pinnix and masters)

- 1) INSPECT LARGE AND SMALL BELTS FOR WEAR AND TENSION TO DETERMINE IF ADJUSTMENT OR REPLACEMENT IS NECESSARY. (PINNIX AND MASTERS)
- 2) RECORD RUN HOURS

BELT # 1 (LARGE) Pretension @ 2.4%
BELT # 2 (SMALL) No pretension required)

ADDITIONAL P/M REQUESTED

- 2/9/05: replaced main drive belt @ 6971 hrs. (reed)
- 10/20/06: changed pm from every 500 hrs to every 1000 hrs per pinnix.
- 11/13/07: replaced both belts (scott thomas and allen ivey) @ 8283 hrs.

10/20/06

BELT

PM Master Work Order Form

8/4/2011

Job No. ROD-001/RM-ANNEALER

Procedure Description REPLACE ANNEALING QUENCH

Priority
Cost Center
Shift

Maintenance Code OPER
Work Type

Equipment No.	Equipment Name	Location
ROD-001/RODMILL	ROD DRAW MACHINE	RODMILL

Cycle Type	Last Scheduled Date	Active Date	Next Scheduled Date
Daily	05/12/2011	08/28/2011	09/04/2011

Runtime Cycle	Runtime Advance	Next PM	Last PM
0.00	0.00	0.00	0.00

Cycle Type	Task No.	Description	Labor Code	Est. Hours
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Cycle Type	Part No.	Part Name	Qty Allocated	Stockroom
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Cycle Type	Employee No.	Employee Name	Labor Code	Est. Hours	Task No.
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Cycle Type	Tool Description
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WO Desc.

TO BE PERFORMED ON ANNEALER TANK

- 1) REMOVE OLD ANNEALING QUENCH
- 2) CLEAN TANK
- 3) ADD NEW ANNEALING QUENCH

P/M PERFORMED BY _____
DATE PERFORMED _____
TIME TAKEN FOR PM _____
MACHINE HOURS _____

ADDITIONAL P/M PERFORMED/REQUESTED