

G-26: PM Conveyor (Power & Free)

SAFETY FIRST

- Follow all Caterpillar facility safety standards when performing this task.
- An overhead hazard exists due to the rails and track components of the overhead conveyor system.
- Be careful when raising and lowering the manlift; practice all safe practices associated with using a manlift.
- A flashlight is needed due to low lighting.
- A heat hazard exists when working within 10-20 feet of the ceiling during the warm months, and drink plenty of water.
- Watch for pinch points when checking the chain over the sprockets.

EQUIPMENT

- shop towels
- screwdriver
- flashlight
- hammer
- punch
- needle nose pliers
- 3/8-inch drive ratchet
- 9/16-inch socket
- manlift
- lock and tag
- power remote
- radio

RESOURCES

- none



PM Conveyor (Power & Free)

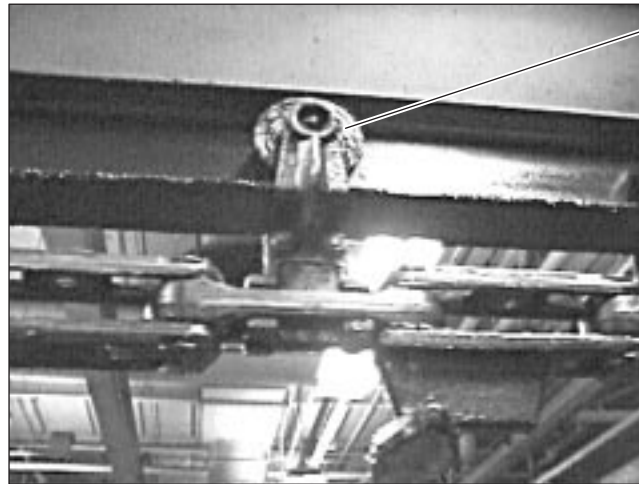
1. **Disconnect the conveyor power at the main panel.**
 - Leave the power to the conveyor requiring a PM.
2. **Ensure that the line is free from obstructions.**
 - Walk the conveyor line to ensure that the area is free of all equipment and obstructions.
 - Announce on the radio to all personal that the line will be operated.
3. **Position the manlift in a lighted area and under the conveyor.**
4. **Connect the remote to the individual chain power supply.**



Power Supply

5. **Check the chain components.**
 - While on the manlift, tie a rag to one of the puller dogs. Tying a rag to a puller dog indicates a starting/stopping point.
 - Activate the conveyor and observe the chain as it passes. Continue to observe the chain until the puller dogs with the rag return.

- ❑ Check all rollers on the trolley for wear. The rollers must not wobble, and there must not be any ball bearing missing in the rollers. Replace any defective rollers.



Roller

- ❑ Check the chain for wear. The chain must run smooth with no binding or slack. Replace any defective chain links.



Chain

- Check the puller and pusher dogs for looseness and wear. The dogs should have minimal side-to-side play. The bottom of the dogs must not show signs of wear.



Puller Dog

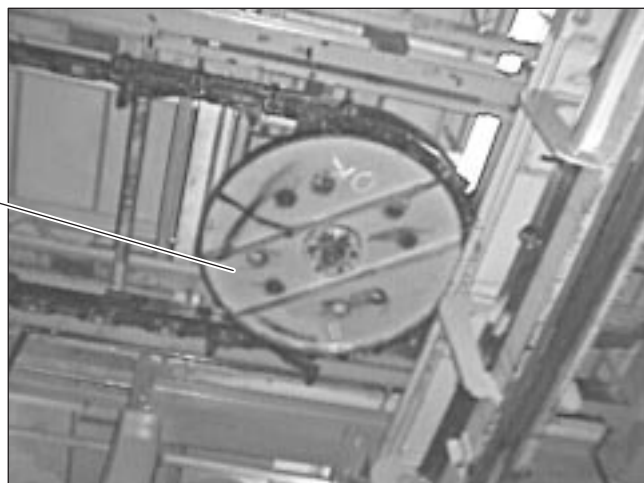


Pusher Dog

- Ensure that the tripper pins on the trolley are not bent. Straighten any bent tripper pins.

6. Check the corner wheels for security.

- Check the bolts that hold the corner wheel for tightness.



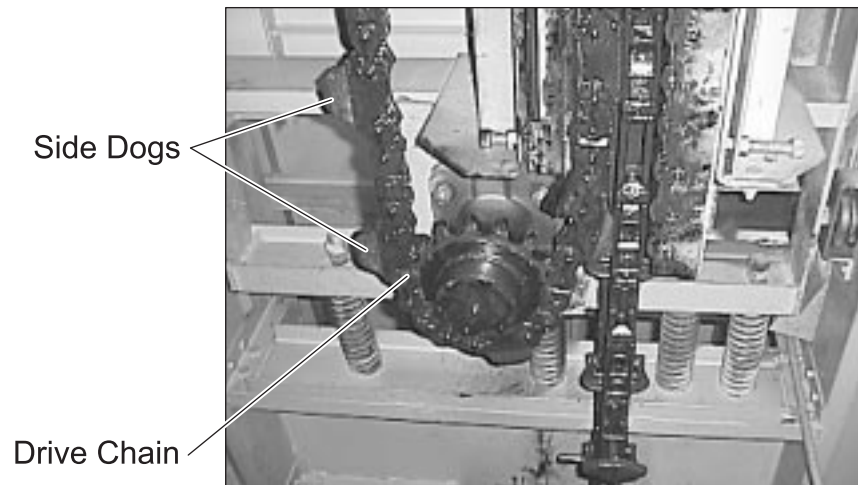
Corner Wheel

7. Check the corner rollers.

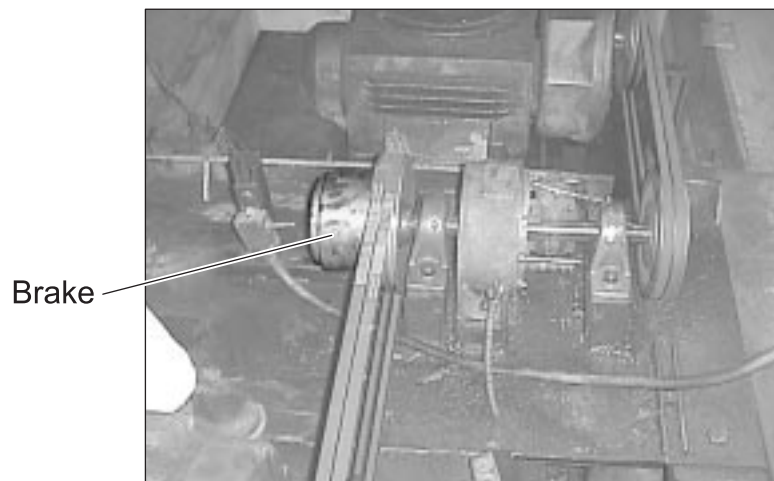
- Check the rollers for wear and that the grease fittings are installed.

8. Check the drive chain assembly.

- Observe the drive chain to ensure that the chain rides in the socket without binding.
- Ensure that there are no missing side dogs on the drive chain.



- Check the side dogs on the drive chain to ensure that they engage in the links of the conveyor chain.
- With the power off, rotate the motor and observe the drive belts to ensure that they travel in the groove of the pulleys. Physically check the tension on the belts.
- Check the brake manually to ensure that it operates according to manufacture specifications.



9. Check the air operated takeup.

- Open the air valves and observe the takeup as it moves forward.
- Close the air valves and observe the takeup as it moves backwards.
- Check the extenders for security.



Extender



- Examine the extender rails where the takeup rails meet, and ensure that there is sufficient extender rail left. If there is not enough extender rail, move the extender towards the takeup.



Extender Rails

- 10. Lower the manlift and move it out of the path of the chain.**
- 11. Document the work history.**