Preventative Maintenance Schedule for DD104 Dough Divider REV 2

Remove all power sources as required for safe testing

Most items are completed during normal cleaning and reassembly of the machine

Routine daily cleaning after operation is critical to system performance, oil residue can build up and become sticky limiting machine function!

Area	Action or Inspect for	Frequency
Guarding		
	clean sensor head of guarding position switches	daily
	ensure guarding position sensors operate correctly, only on when guard is in place	daily
	ensure all guarding is in place and secured	daily
	ensure that the guarding is intact with no unwanted access to inside of guarding	daily
	inspect pins and lanyards for wear, replace if damaged	monthly
Pan Handler		
	clean sensor head of guarding position and pan detection switches	daily
	verify the retractable pin works freely	daily
	ensure rollers move freely and are clean and undamaged	daily
	ensure door remains closed unless Pan is used to release it	daily
	ensure proximity sensor sees Pan when it is inserted	daily
	ensure proximity sensor sees Pan Handler when it is in position	daily
	ensure all mounting hardware is in place and secure	monthly
	ensure hinges are in good working order	monthly
Blade		
	check for chips, cracks, replace as required	daily
	ensure blade moves freely in the assembly and is clean and undamaged	daily
	ensure u- shaped drive pin is undamaged and is fully inserted	daily
	ensure blade is positioned properly, hole is centered under hopper when extended	daily

Block, Dough Pocket & Exit

check base plate, top plate, and blowout assembly for cleanliness and damage	daily
ensure pocket is free of damage with no sharp edge that could cause feeding issues	daily
ensure u- shaped drive pin is undamaged and is fully inserted	daily
ensure block moves freely in the assembly and is clean and undamaged	daily
ensure O-rings are free of cuts and other wear, replace if damaged	daily
ensure dough block is positioned properly, hole is centered under hopper when retracted	daily
inspect tightening knobs and lanyards for wear, replace if damaged	monthly

Hopper

verify lid latch function, check for damage to clasps or pins- replace if found	daily
check for leaks observe that it holds pressure	daily
check for damage to tank, cracks and dents- replace if found	daily
check for wear of engagement of turn-lock to the top plate	daily
check tri clamp function - tight	daily
check lid-arm, pin, and hinge are secure and not worn	daily
inspect hopper gasket for cracks, tears, bubbles, replace if damaged or not sealing	daily
verify pressure relief valves ASME and weighted relief work.	monthly

Air Compressor

drain filter bowls	weekly
drain tank condensation	weekly
check operation of dump and relief valve	monthly
check for proper pressure setting as indicated by label on or near device	monthly
check for cracks or leaks in the housing	monthly
ensure fittings and hose connections are secure and tight	monthly
check condition of filter media	monthly
check operation of the pressure switch	monthly
check tightness of mounting hardware that secures the unit to the frame	6 months

Tubing

check for leaks at fittings- tighten or replace as required	6 months
check for cracks or wear on the tubing walls- replace as required	6 months

Cylinders	
check cylinder mounting nuts for tightness	monthly
ensure the cylinders are not leaking- replace as required	6 months
verify all pneumatic connections are tight and tubing is secured back to valves	6 months
check operation of proximity switch, ensure switch is mounted securely	6 months
ensure cables are not damaged and is secured in a safe manner to prevent damage.	6 months

Electrical cabinet	
check operation of the main switch on / off	daily
ensure proper operation of Estop button and indicator	daily
ensure HMI screen is operational and not damaged	daily
ensure cabinet is closed	daily
check cord and cable entries for damage	monthly
check cabinet for damage or fluid & dust entry points	monthly
ensure ground is connected	monthly
ensure cable connectors are secure	monthly
check incoming voltages	6 months
check internal components are mounted to the back plate	6 months
check wiring terminals are tight	6 months
check condition of signal cable and the connectors are seated in the HMI tightly	6 months
ensure cabinet support is firmly attached to machine	6 months
ensure grommets are in place for cable passages between machine sections	6 months

Oiler (option only)	
check draw tube for cleanliness, cracks or damage	daily
check oil lines for cleanliness, air bubbles, leaks and damage	daily
inspect oil nozzle for bends, cracks, breaks and alignment	daily

Base	
Check tightness of mounting hardware	6 months
ensure floor casters are secured to the frame and roll freely	6 months

For additional preventative procedures
Refer to the OEM manufactures maintenance manual for service instructions