

Service Report for Rotary Orienter BD 1800-6-8-??

Date: Jan 22, 2009

Prepared by: OnTrack Service Technician

Mechanical Audit:

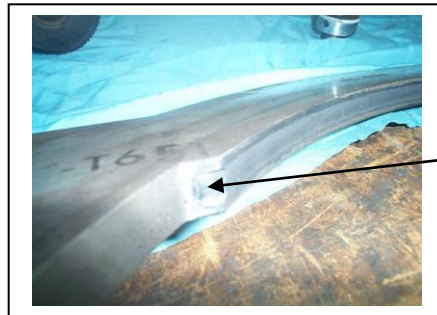
1. Lower Main Drive Unit

Current Condition;

- a) Lower Main Turret assembly found to be in good working order with one (1) exception, Bottle Clamping CAM is worn at entrance of trigger valve actuation. Wear was found from entrance to release point.

Recommended and/or Required Action;

- a) Recommended replacement of Bottle Clamping CAM, if not replaced machine will still run but at risk of destroying trigger valves and machine failure.



Entrance wear area,
continues to end of CAM

2. Lower In-Feed Star-wheel Drive Unit

Current Condition;

All items found to be in good working order.

Recommended and/or Required Action;

No actions required at this time.

3. Lower Discharge Star-wheel Drive Unit

Current Condition;

All items found to be in good working order.

Recommended and/or Required Action;

No actions required at this time.

Sample Report

4. Lower Feedscrew Drive Unit

Current Condition;

All items found to be in good working order.

Recommended and/or Required Action;

No actions required at this time.

5. Upper Feedscrew Drive

Current Condition;

- a. Feedscrew drive apex joints-worn, missing oil, Apex boot(s) are destroyed.
- b. In-feed Feedscrew adjustment assembly is ceased and cannot adjust.
- c. Discharge Feedscrew adjustment assembly is worn and unstable.

Recommended and/or Required Action;

- a. Feedscrew drive apex joints require replacement.
- b. Infeed Feedscrew drive assembly requires dismantling, replace bushing, replace ball drive, clean and lube
- c. Discharge Feedscrew drive assembly requires dismantling, replace bushing, replace ball drive, clean and lube



Sample Report

Assembly

Worn Apex Joints

6. Upper Hub In-feed Star-wheel Drive Unit

Current Condition;

All items found to be in good working order.

Recommended and/or Required Action;

No actions required at this time.

7. Upper Hub Discharge Star-wheel Drive Unit

Current Condition;

All items found to be in good working order.

Recommended and/or Required Action;

No actions required at this time.

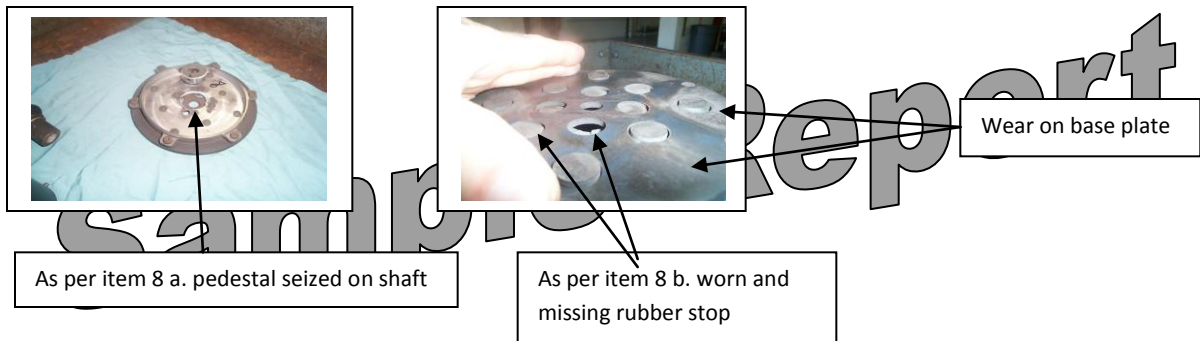
8. 8 - Head Pedestal Base Turret

Current Condition;

- Bottle Pedestals 1, 5, 7 & 8 – centre hubs seized on actuator shaft.
- Bottle Pedestals 2, 3, 4 & 6 – missing rubber stops, base plate worn,
- Rotary Actuators in good condition.

Recommended and/or Required Action;

- Replace 1, 5, 7 & 8 Bottle Pedestals, new model will incorporate new design change as per Orienter 1, provides longer life and durability.
- Replace 2, 3, 4 & 6 Bottle Pedestals, new model will incorporate new design change as per Orienter 1, provides longer life and durability.
- No action required.



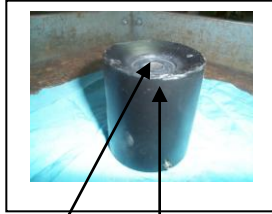
9. 8 - Head Upper Bottle Clamping Turret

Current Condition;

- Bottle Centering Bells badly worn on outer edge and centre position. Also does not comply with required package sizes as per Orienter 1
- Bearing Assembly number 1, 2,3,4,6 & 7 are worn and are at end of service life, machine can run but will cause bottling handling to be sloppy or misaligned.
- Bearing Assembly number 5 & 8 are showing minor wear and are fine, however if action is taken on 9.b. above then these should also be replaced.

Recommended and/or Required Action;

- a. Replace all 8 Bottle Centering Bells.
- b. Replace ASAP (no later than 1 year) Bearing Assembly number 1, 2,3,4,6 & 7
- c. Replace Bearing Assembly 5 & 8 when Bearing Assembly number 1, 2,3,4,6 & 7 are replaced.



As per item 9 a. wear on outer edge and center hub.



As per item 9 b and c bearing assembly

Sample Report

10. Pneumatic System

Note: Main air control unit is missing; see safety audit report below for further details.



Air Control and Dump Valve is missing, was part of the original unit as I-O switch is present in panel. Required for safety and control.

I. Pneumatic Lower Turret

Current Condition;

All items found to be in good working order.

Recommended and/or Required Action;

No actions required at this time.