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PELLERIN MILNOR CORPORATION POST OFFICE BOX 400, KENNER, LOUISIANA 70063-0400, U.S.A.



# **MKDSUH01U1/25215A**

## **1. English**

Maintenance Guide - Pass-through Shaker

MKDSUH01EN/2021495



English

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Manual Number: MKDSUH01EN  
Edition (ECN): 2021495

# Maintenance Guide

## Pass-through Shaker



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# 1 Machine Description and Identification

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## 1.1 About This Manual and Your Milnor® Machine

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This manual applies to two or more models that share the mechanical characteristics stated below. If you received this manual with your machine, your machine is one of the applicable models. However, before using this manual, verify that your machine does have these characteristics.

### 1.1.1 Description

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This product is a laundering system machine. Most such machines are fully automated. This machine is the specific type described below.

**Pass-through Shaker** A machine of this type does not use heat, but only tumbles the goods to prepare them for another (usually ironing) process. Pass-through shakers are front-loaded and rear unloaded.

## 1.1.2 Machine Identification

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**Machine Data Plate** — Find the model number and other data for your machine on the machine data plate affixed to the machine and described below.

**Figure 1. Machine Data Plate**

View of Data Plate (English text shown)				Legend
				<p>1. Model number.</p> <p>2. Data that uniquely identifies your machine</p> <p>3. Cylinder maximum rotation speed in revolutions per minute</p> <p>4. Cylinder volume in the units of measure shown</p> <p>5. Piped utility requirements</p> <p>6. Electrical requirements</p> <p>7. Part number for multi-unit machine, if applicable.</p>

**About Machines With Multiple Data Plates** — Machines shipped as multiple units for assembly on site (example: CBW® tunnel washer) will have multiple data plates—one for each unit and a master plate for the complete machine, located on the primary unit. Although each unit can have a different model number, they will all share the same basic serial number. The basic serial number is usually 8 digits. Some of the units will have a two-digit suffix at the end of the serial number.

## 2 Safety

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### 2.1 Safety — Pass Through Dryer

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#### 2.1.1 Safety Alert Messages—Internal Electrical and Mechanical Hazards

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The following are instructions about hazards inside the machine and in electrical enclosures.



**WARNING: Electrocutation and Electrical Burn Hazards** — Contact with electric power can kill or seriously injure you. Electric power is present inside the cabinetry unless the main machine power disconnect is off.



- ▶ Do not unlock or open electric box doors.
- ▶ Do not remove guards, covers, or panels.
- ▶ Do not reach into the machine housing or frame.
- ▶ Keep yourself and others off of machine.
- ▶ Know the location of the main machine disconnect and use it in an emergency to remove all electric power from the machine.



**WARNING: Entangle and Crush Hazards** — Contact with moving components normally isolated by guards, covers, and panels, can entangle and crush your limbs. These components move automatically.



- ▶ Do not remove guards, covers, or panels.
- ▶ Do not reach into the machine housing or frame.
- ▶ Keep yourself and others off of machine.
- ▶ Know the location of all emergency stop switches, pull cords, and/or kick plates and use them in an emergency to stop machine motion.



**CAUTION: Burn Hazards** — Contact with hot goods or machine components can burn you.



- ▶ Do not remove guards, covers, or panels.
- ▶ Do not reach into the machine housing or frame.

## 2.1.2 Cylinder and Processing Hazards

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## 2.1.3 Safety Alert Messages—Unsafe Conditions

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### 2.1.3.1 Hazards Resulting from Inoperative Safety Devices

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**WARNING: Multiple Hazards** — Operating the machine with an inoperative safety device can kill or injure personnel, damage or destroy the machine, damage property, and/or void the warranty.

- ▶ Do not tamper with or disable any safety device or operate the machine with a malfunctioning safety device. Request authorized service.



**WARNING: Electrocutation and Electrical Burn Hazards** — Electric box doors—Operating the machine with any electric box door unlocked can expose high voltage conductors inside the box.



- ▶ Do not unlock or open electric box doors.



**WARNING: Entangle and Crush Hazards** — Guards, covers, and panels—Operating the machine with any guard, cover, or panel removed exposes moving components.



- ▶ Do not remove guards, covers, or panels.



**WARNING: Fire Hazards** — Sprinkler and overheat control—Failure to supply water to the sprinkler or to open the manual valve, or failure of the overheat control, eliminates the machine's internal fire protection. Normally the machine stops and water is sprayed into the cylinder if outlet temperature reaches 240 degrees Fahrenheit (116 degrees Celsius).



- ▶ Verify the overheat control system and plant fire extinguishers are functioning before operating the machine. Be sure to turn water supply on after testing.

- ▶ Keep the manual shut-off test valve open except when testing.
- ▶ Test or inspect the system after every automatic actuation, or monthly.



**WARNING: Explosion and Fire Hazards** — Gas train—Operating the machine with damaged or malfunctioning gas valves, safeties, controls, or piping can permit gas to escape into the fire box, cylinder, or laundry room. The enclosure will explode if gas comes in contact with any spark or flame.



- ▶ Do not operate the machine with any evidence of damage or malfunction.
- ▶ Stop the machine immediately and alert authorities if you smell gas.

### 2.1.3.2 Hazards Resulting from Damaged Mechanical Devices

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**WARNING: Multiple Hazards** — Operating a damaged machine can kill or injure personnel, further damage or destroy the machine, damage property, and/or void the warranty.

- ▶ Do not operate a damaged or malfunctioning machine. Request authorized service.

### 2.1.4 Careless Use Hazards

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#### 2.1.4.1 Careless Operation Hazards—Vital Information for Operator Personnel (see also operator hazards throughout manual)

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**WARNING: Multiple Hazards** — Careless operator actions can kill or injure personnel, damage or destroy the machine, damage property, and/or void the warranty.

- ▶ Do not tamper with or disable any safety device or operate the machine with a malfunctioning safety device. Request authorized service.
- ▶ Do not operate a damaged or malfunctioning machine. Request authorized service.
- ▶ Do not attempt unauthorized servicing, repairs, or modification.
- ▶ Do not use the machine in any manner contrary to the factory instructions.
- ▶ Use the machine only for its customary and intended purpose.
- ▶ Understand the consequences of operating manually.



**CAUTION: Goods Damage and Wasted Resources** — Entering incorrect cake data causes improper processing, routing, and accounting of batches.

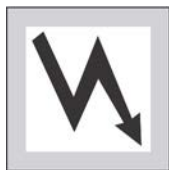
- ▶ Understand the consequences of entering cake data.

#### 2.1.4.2 Careless Servicing Hazards—Vital Information for Service Personnel (see also service hazards throughout manuals)

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**WARNING: Electrocution and Electrical Burn Hazards** — Contact with electric power can kill or seriously injure you. Electric power is present inside the cabinetry unless the main machine power disconnect is off.



- ▶ Do not service the machine unless qualified and authorized. You must clearly understand the hazards and how to avoid them.
- ▶ Abide by the current OSHA lockout/tagout standard when lockout/tagout is called for in the service instructions. Outside the USA, abide by the OSHA standard in the absence of any other overriding standard.



**WARNING: Entangle and Crush Hazards** — Contact with moving components normally isolated by guards, covers, and panels, can entangle and crush your limbs. These components move automatically.



- ▶ Do not service the machine unless qualified and authorized. You must clearly understand the hazards and how to avoid them.
- ▶ Abide by the current OSHA lockout/tagout standard when lockout/tagout is called for in the service instructions. Outside the USA, abide by the OSHA standard in the absence of any other overriding standard.



**WARNING: Confined Space Hazards** — Confinement in the cylinder can kill or injure you. Hazards include but are not limited to panic, burns, poisoning, suffocation, heat prostration, biological contamination, electrocution, and crushing.



- ▶ Do not enter the cylinder until it has been thoroughly purged, flushed, drained, cooled, and immobilized.

# 3 Routine Maintenance

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## 3.1 Routine Maintenance

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Do the maintenance in [Section 3.1.1 : Maintenance Summary, page 9](#) to make sure that the machine is safe, keeps the warranty, and operates correctly. This will also decrease repair work and unwanted shutdowns. Speak to your dealer or the Milnor® Service department if repairs are necessary.



**WARNING:** Mechanisms — can pull in and mutilate body parts.



- ▶ Do not service the machine unless qualified and authorized. You must clearly understand the hazards and how to avoid them.
- ▶ Do not service the machine with power on except when explicitly called for in the service instructions. Use extreme care when working near moving components.

- ▶ Replace guards and covers that you remove for maintenance.

If you use software to keep the maintenance schedule for your plant, add the items in the following maintenance summary to that schedule. If not, you can put marks on a calendar that work with the tables in the maintenance summary. See [Section 3.1.7 : How To Show the Maintenance On a Calendar, page 17](#)

### 3.1.1 Maintenance Summary

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Each of the following sections is for a type of maintenance. For example, the section “Guards and Related Components” says “Examine these items. If an item is damaged, missing, or has the wrong setting, correct this discrepancy immediately to prevent injury.” A table in each section identifies the applicable items and the frequency. The “More Data” column gives special instructions if necessary.

\* If the machine operates more than 12 hours each day, do the “day” items two times each day. Do the other items at the given hours or on the days that you show on a calendar (see Section 1). **Do all items in all sections for the maintenance intervals that apply (for example, day, 40 to 60 hours, and 200 hours).**



**TIP:** The maintenance summary has many links to the sections that follow the summary. These sections give more information about the maintenance items. After you learn this information, it is only necessary to look at the summary to do the maintenance.



### 3.1.1.1 Guards and Related Components

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Examine these items. If an item is damaged, missing, or has the wrong setting, correct this discrepancy immediately to prevent injury.

**Table 1. Guards and Related Components**

Mark						Do this each	Component	More Data
1	2	3	4	5	6			
x						day*	guards, covers	Speak to your dealer or Milnor for replacement components.
x						day*	safety placards	
		x				200 hours	fasteners	Fasteners must be tight.
		x				200 hours	anchor bolts and grout	Grout must be good. Bolts must be tight.
x						day*	emergency stop mechanism	See <a href="#">Section 3.2.5</a> , page 24. Do a test of the control.

### 3.1.1.2 Filters, Screens, and Sensitive Components

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Remove contamination from these items to prevent damage and unsatisfactory performance.

**Table 2. Filters, Screens, and Sensitive Components**

Mark						Do this each	Component	More Data. See also <a href="#">Section 3.1.2</a> , page 12
1	2	3	4	5	6			
	x					40 to 60 hours	inverter fans, vents, filters	See <a href="#">Figure 5</a> , page 21. Keep good air flow.
			x			600 hours	motors	Keep good air flow.
				x		2400 hours	entire machine	Remove excessive dust and dirt.
x						day*	self-purging filter (and regulator) for compressed air	See <a href="#">Figure 7</a> , page 22. Make sure the bowl drains automatically.
		x				200 hours	filter element for the filter (and regulator)	Replace the filter if you cannot remove contamination.
				x		1200 hours	mufflers, quick exhaust valves	See <a href="#">Figure 8</a> , page 23
		x				200 hours	strainer(s) for air inlet	See <a href="#">Figure 6</a> , page 21
x						day*	photoeyes	See <a href="#">Figure 9</a> , page 24
				x		2400 hours	proximity switches	See <a href="#">Figure 10</a> , page 24
				x		2400 hours	access panel under shell	See <a href="#">Figure 11</a> , page 26
		x				200 hours	air intake areas	Inspect for, and remove any materials that may block air flow.
			x			600 hours	exhaust duct	Open inspection covers. Remove any lint buildup.

### 3.1.1.3 Fluid Containers

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Examine these items. Add fluid if necessary and keep components clean to prevent damage.

**Table 3. Fluid Containers**

Mark						Do this each	Component	More Data. See also <a href="#">Section 3.1.3 : Lubricant Identification, page 13</a>
1	2	3	4	5	6			
For the next three items, see <a href="#">Figure 13, page 27</a>								
						first 100 hours	speed reducer (gear reducer)	Remove used oil. Add oil 220 ( <a href="#">Table 9, page 14</a> ).
				x		1200 hours		Add oil 220 ( <a href="#">Table 9, page 14</a> ) if necessary.
					x	2400 hours		Remove used oil. Add oil 220 ( <a href="#">Table 9, page 14</a> ).

### 3.1.1.4 Components that Become Worn

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Examine these items. Tighten or replace the item if necessary, to prevent shutdowns and unsatisfactory performance. Speak to your dealer for replacement parts.

**Table 4. Components that Become Worn**

Mark						Do this each	Component	More Data
1	2	3	4	5	6			
		x				200 hours	drive belts and pulleys	See <a href="#">Section 3.2.1 , page 19</a>
		x				200 hours	air seals. These include: <ul style="list-style-type: none"> <li>• T-seal around basket</li> <li>• Nomex, felt at front of basket</li> <li>• felt, rubber at top of load door</li> <li>• felt at bottom of load door</li> <li>• felt at unload door</li> <li>• rubber at access doors</li> </ul>	Examine. See <a href="#">Section 3.3.1 , page 27</a>
		x				200 hours	support wheels (4) under basket	Examine. If wheels are worn, repairs can be necessary. Speak to your dealer or Milnor. This is not routine maintenance.

### 3.1.1.5 Bearings and Bushings

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Unless the item is sealed, apply grease to prevent damage. See the next section for motors.

**Table 5. Bearings and Bushings**

Mark						Do this each	Component	More Data . See also <a href="#">Section 3.1.3 , page 13</a>
1	2	3	4	5	6			
			x			600 hours	motor and pump bearings	See <a href="#">Section 3.1.5 : Procedures for Motors, page 14</a>
		x				200 hours	support wheel bearings (4)	See <a href="#">Figure 12, page 26</a> . Add 0.12 oz. (3.5 mL) of grease EPLF2 ( <a href="#">Table 9, page 14</a> ).
		x				200 hours	drive chain	See <a href="#">Figure 13, page 27</a> . Remove dirty grease with a cloth. Apply grease CG ( <a href="#">Table 9, page 14</a> ).
						none	blower shaft bearings	These are sealed bearings. No grease maintenance is necessary.

### 3.1.1.6 Motor Grease Schedule

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Use the data in [Table 10: Motor Grease Intervals and Quantities](#), [page 17](#) to complete this table.

**Table 6. Motor Grease Schedule**

Motor Identification (example: main drive)	Interval		Quantity		Dates When Grease is Added							
	Years	Hours	fl oz	mL								

### 3.1.1.7 Mechanisms and Settings

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**Make sure mechanisms are serviceable and settings are correct to prevent unsatisfactory performance.**

**Table 7. Mechanisms and Settings**

Mark						Do this each	Component	More Data
1	2	3	4	5	6			
					x	2400 hours	controller circuitry	Examine wiring and connections in electrical boxes. Look for corrosion, loose connections. See <a href="#">Section 3.1.2</a> , <a href="#">page 12</a>
		x				200 hours	compressed air mechanisms	See <a href="#">Section 3.2.3</a> , <a href="#">page 21</a>

## 3.1.2 How To Remove Contamination

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**Table 8. Contamination Types, Cleaning Agents, and Procedures**

Material or Component	Usual Contamination	Example	Cleaning Agent	More Data
machine housing	dust, dirt	—	compressed air or shop vacuum	Air—no more than 30 psi (207 kpa). Do not push dust in mechanisms.
fans and vents on electrical components	dust	motors, inverters, braking resistors	shop vacuum, soft bristle brush, canned air for electrical components	Do not push dust in mechanisms.
electric box interior	dust	all electric boxes		
electrical connections	corrosion, varnish	spade connector, molex connector, plug-in relay	spray solvent for electrical components	Disconnect then connect it again. Use solvent if the bad connection continues.
electronic sensors	dust	photoeye lens, reflector, laser, proximity switch, temperature probe	none	Use a clean, soft, dry cloth.
	dirt		warm water with soap, then water flush	Use clean, soft cloths.
stainless steel	chemical spill	shell, supply injector	water	Use a hose to flush the chemical supply from the surface fully. Do

**Table 8 Contamination Types, Cleaning Agents, and Procedures (cont'd.)**

Material or Component	Usual Contamination	Example	Cleaning Agent	More Data
				not get water on electrical components or mechanisms.
300 series stainless steel	chemical corrosive attack	shell interior, cylinder	pickling and passivation	Speak to your dealer or Milnor. This is not routine maintenance.
painted metal, unpainted aluminum	dust, dirt, grease	frame members	warm water with soap, then water to flush	Use clean cloths. Do not get water in electrical components.
rubber	dirt, oil, grease	drive belts, hoses	warm water with soap, then water to flush	Use clean cloths. Flush fully. Oil or soap must not stay on drive belts. Make sure that drive belts are serviceable.
clear plastic, acrylic	discoloration (yellowing)	compressed air filter bowl, visual flow meter	warm water with soap, then water to flush, then acrylic cleaner. Do not use ammonia.	Use only the necessary cleaning agents. Wash and rinse with clean, soft cloths. Follow instructions on acrylic cleaner.
glass	discoloration (yellowing)	door glass, site glass	ammonia and water solution and water rinse then acetone	Use clean, soft cloths. Use only the necessary cleaning agents. If necessary, soak in cleaner.
soft air filter, lint filter,	dust, lint	on inverter electric box door, in air line filter bowl, in dryers	shop vacuum	Replace the used with a new filter when the vacuum cannot remove contamination.
rigid strainers, screens for water, steam	mineral particles	in water line, y-strainer	water	Use a rigid bristle brush. Flush with a flow of water.
rigid strainers, screens for oil	metal shavings	in hydraulic line	carburetor cleaner or equivalent solvent	Soak. Use a rigid bristle brush.
steel drive components	dirt, hardened lubricant	bearings, roller chains, sprockets, gears	carburetor cleaner or equivalent solvent	Soak. Use a cloth or soft bristle brush.

### 3.1.3 Lubricant Identification

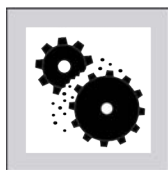
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The table below identifies the lubricant for each lubricant code given in the maintenance summary. Get these or equivalent lubricants from your local lubricant supplier.

When you add grease, always use the procedures given in [Section 3.1.4 : Grease Gun Procedures, page 14](#). When you add grease to motors, also use the procedures given in [Section 3.1.5 : Procedures for Motors, page 14](#).



**CAUTION:** **Bad lubricant** — will decrease the life of components.



- ▶ Make sure that all equipment and fittings used to apply lubricants are clean.
- ▶ Use only the given lubricants or equivalent lubricants that have the same specifications.

**Table 9. Lubricant Identification**

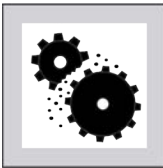
Code	Type	Trademark Name	Application Example
CG	grease	Shell Alvania CG or equivalent AG-MA CG-1 or CG-2	drive couplings
EM	grease	Mobil Polyrex EM or as given on the motor nameplate	motor bearings
EPLF2	grease	Shell Alvania EP (LF) Type 2	drive shaft bearings and bushings, ball joints, chain drives
23	oil	Shell Tellus 23	air line lubricator
220	oil	Shell Morlina 220	small bearing housings, gear reducers, Hydro-cushion™ cylinders

### 3.1.4 Grease Gun Procedures

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**CAUTION:** Hydraulic pressure — can push out seals and push grease into unwanted areas (example: motor windings).



- ▶ Use a hand grease gun. A power grease gun gives too much pressure.
- ▶ Know the quantity of grease your grease gun gives each cycle (each stroke).
- ▶ Operate the grease gun slowly (10 to 12 seconds for one cycle).
- ▶ Add only the specified quantity. Stop if new grease come out of a drain port or other opening.
- ▶ Remove spilled grease from belts and pulleys.

The tables give grease quantities in fluid ounces (fl oz) and milliliters (mL). You can also use grease gun cycles (strokes). A cycle is each time that you pull the trigger. One cycle is usually approximately 0.06 fl oz (1.8 mL). Your grease gun can give more or less than this. Measure the output of your grease gun as follows:

- Make sure that the grease gun operates correctly.
- Operate the grease gun to put grease into a small container with fluid ounce or milliliter increments. Pull the trigger fully and slowly.
- Add a sufficient quantity of grease to measure accurately. Count the number of cycles of the grease gun (the number of times that you pull the trigger).
- Calculate the quantity for each cycle of the grease gun, as in the following examples.

*Example: 2 fl oz / 64 cycles = 0.031 fl oz for each cycle*

*Example: 59 mL / 64 cycles = 0.92 mL for each cycle*

### 3.1.5 Procedures for Motors

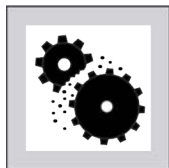
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If a motor on your machine does not have grease fittings, no grease maintenance is necessary. If a motor on your machine has grease fittings, it is necessary to add grease. But the interval is usually

longer than for other maintenance. [Table 10: Motor Grease Intervals and Quantities, page 17](#) gives motor grease intervals and quantities for motors with specified frame sizes and speeds. You get this data from the motor nameplate. Use [Table 6: Motor Grease Schedule, page 12](#) to record the data for the motors on your machine.

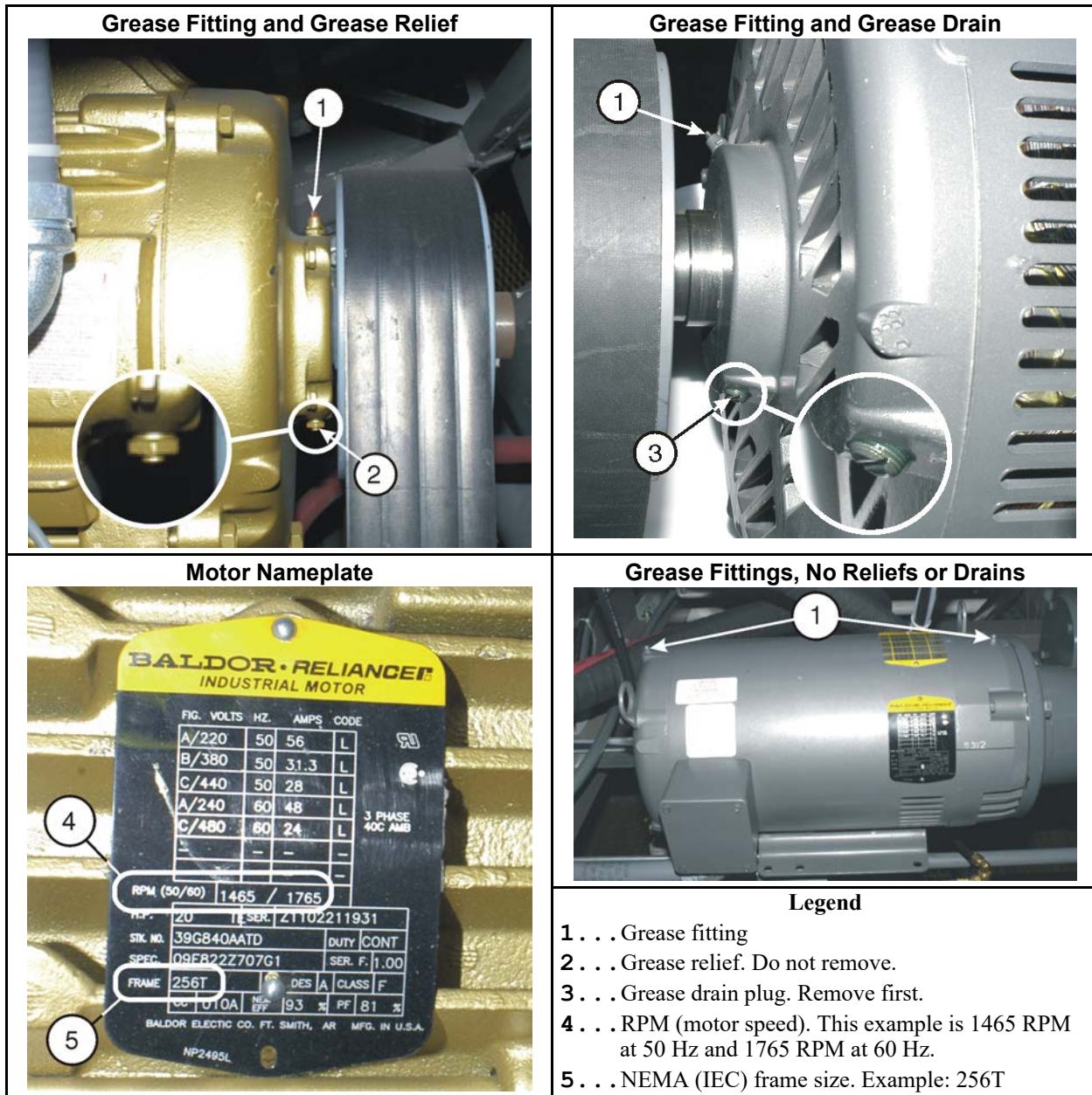


**CAUTION:** **Failure to remove grease drain plugs** — can cause grease to enter the windings and burn out the motor.



- If the motor has grease drain plugs, remove them before you add grease. If the motor has grease relief fittings, it is not necessary to remove them.

**Figure 2. Motor Grease Maintenance Conditions**



Apply grease as follows:

1. Operate the machine or use manual functions to operate the motor until it is warm.
2. Remove power from the machine.
3. If the motor has grease drain plugs, remove them. See the caution statement above..
4. Add grease EM ([Table 9: Lubricant Identification, page 14](#)) with the motor stopped. If the motor with the nameplate in the above figure operates at 60 Hz, the specified grease quantity for each grease fitting is 0.65 fl oz (18.4 mL).



5. If the motor has a grease drain plugs, operate the machine or use manual functions to operate the motor for two hours. Replace the drain plug.

**Table 10. Motor Grease Intervals and Quantities**

On Motor Nameplate (see <a href="#">Figure 2: Motor Grease Maintenance Conditions, page 16</a> )		Interval		Quantity	
NEMA (IEC) Frame Size	RPM Less Than or Equal To	Years	Hours	Fluid Ounces	mL
Up to 210 (132)	900	5.5	11000	0.34	9.5
	1200	4.5	9000		
	1800	3	6000		
	3600	1.5	3000		
>210 to 280 (132 to 180)	900	4.5	9000	0.65	18.4
	1200	3.5	7000		
	1800	2.5	5000		
	3600	1	2000		
>280 to 360 (180 to 200)	900	3.5	7000	0.87	24.6
	1200	3	6000		
	1800	2	4000		
	3600	0.5	1000		
>360 to 5000 (200 to 300)	900	2.5	5000	2.23	63.2
	1200	2	4000		
	1800	1	2000		
	3600	0.5	1000		

### 3.1.6 First Time Oil Procedure for Speed Reducers (Gear Reducers)

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The oil in a speed reducer can deteriorate faster when this mechanism is new. Replace the oil in the speed reducer after the first 100 hours of operation. Do this maintenance one time, in addition to the periodic oil maintenance given in the table for fluid containers in the maintenance summary.

### 3.1.7 How To Show the Maintenance On a Calendar

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You can put marks on a calendar that work with the tables in [Section 3.1.1, page 9](#). The marks are the numbers 2, 3, 4, 5, and 6. It is not necessary to show the number 1 (items you do each day) on the calendar. The number 2 = items you do each 40 to 60 hours, 3 = each 200 hours, 4 = each 600 hours, 5 = each 1200 hours, and 6 = each 2400 hours. These are the "Mark" numbers at the top of the narrow columns on the left of each table in [Section 3.1.1, page 9](#).

The table below shows where to put the marks on a calendar. For example, if your machine operates between 41 and 60 hours each week, the first three marks are 2, 2, and 3. Put these marks on the first, second, and third weeks after the machine starts operation. If you do routine



maintenance on a given day of the week, put the mark on that day of each week. Continue to put marks on the subsequent weeks. **It can be necessary to do the 40 to 60 hour (2) maintenance more than one time each week.** If the machine operates between 61 and 100 hours, put a 2 on two days of the week. If the machine operates 101 or more hours, put a 2 on three days of the week.

On each date with a 3, do the items with an x in the 3 or the 2 column of each table in [Section 3.1.1 , page 9](#). On each date with a 4, do the items with an x in the 4, 3, or 2 column. Continue this pattern.

**Table 11. Where to Put Marks On a Calendar**

Hours / Week	Week Number																													
	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30
Up to 40	2	2	2	2	3	2	2	2	2	3	2	2	2	2	4	2	2	2	2	3	2	2	2	2	3	2	2	2	2	5
41 - 60	2	2	3	2	2	2	3	2	2	4	2	2	3	2	2	2	3	2	2	5	2	2	3	2	2	2	3	2	2	4
61 - 80	2	2	3	2	3	2	4	2	2	3	2	2	3	2	5	2	3	2	2	3	2	4	2	2	3	2	2	3	2	6
81 - 100	2	3	2	3	2	4	2	3	2	3	2	5	2	3	2	3	2	4	2	3	2	3	2	6	repeat					
101 - 120	2	3	2	3	4	2	3	2	3	5	2	3	2	3	4	2	3	2	3	6	repeat									
121 - 140	2	3	2	3	4	3	2	3	5	2	3	2	3	4	3	2	3	6	repeat											
Hours / Week	Week Number, continued																													
	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60
Up to 40	2	2	2	2	3	2	2	2	2	3	2	2	2	2	4	2	2	2	2	3	2	2	2	2	3	2	2	2	2	6
41 - 60	2	2	3	2	2	2	3	2	2	6	repeat																			

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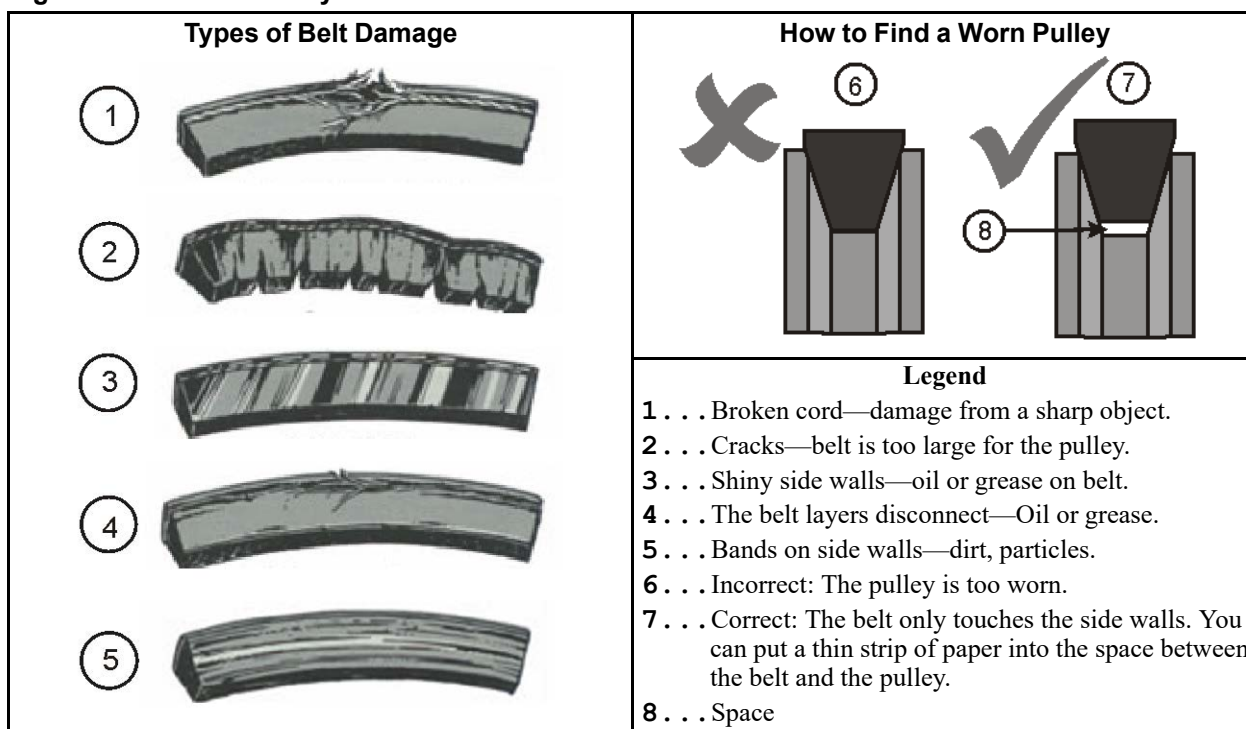
## 3.2 Maintenance Components—Machines and Controls Group

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### 3.2.1 How to Examine V-belts and Pulleys

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**Figure 3. Belt and Pulley Conditions To Look For**



**With power removed:**

- Look for dirt, dust, oil, and grease. Remove contamination.
- Look for belt damage as shown in the figure above.
- Look for worn pulleys as shown in the figure above.

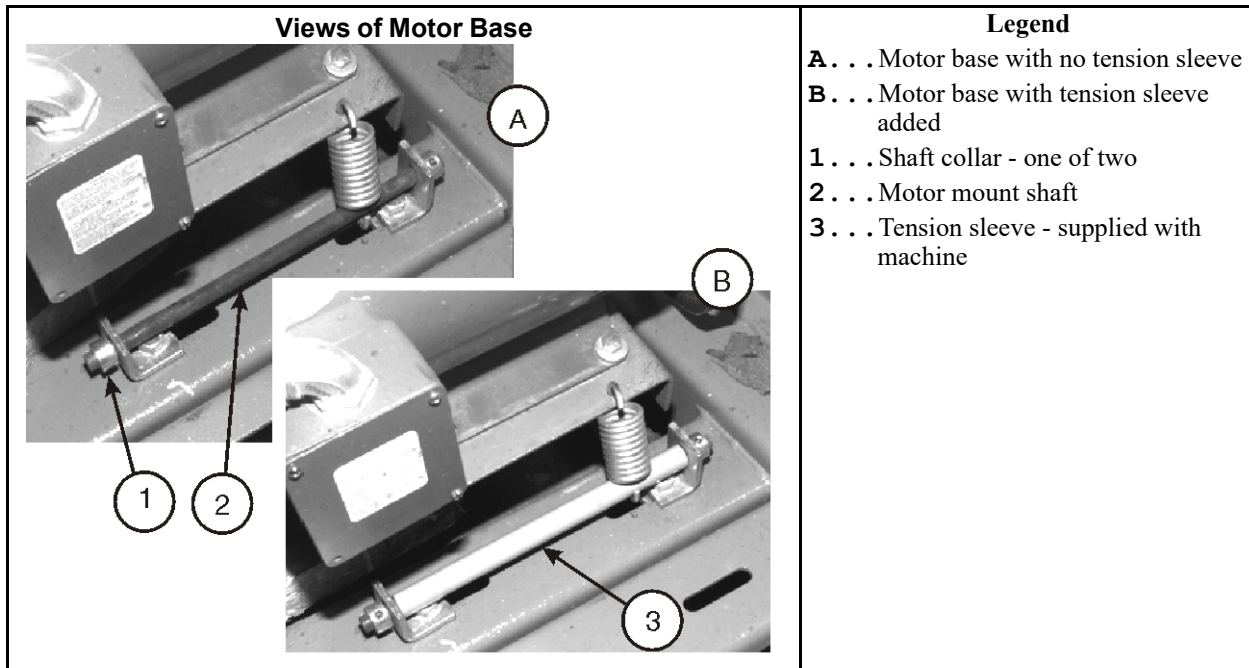
**With the machine in operation—Do not touch the machine.** Look and listen:

- A belt can have some vibration and not cause damage. It is necessary to correct this condition only if the vibration is large.
- A belt must have sufficient tension that there is no slippage on the pulley during operation. If slippage occurs, you can usually tell from the noise.

**About Component Replacement and Tension Adjustment**—Correct adjustment is very important to the service life of components and operation of the machine. Your Milnor® dealer can do this work. If you know how to do this work (for example, correctly align belts and pulleys), and you want to do it, speak to your dealer or Milnor® for part numbers. Replace worn components before you make tension adjustments.

- Machines that use rods with full threads and nuts to hold the position of the motor base—Turn the nuts on the rods as necessary to adjust tension. Tighten the nuts.
- Machines that use a spring to hold tension on the motor base—Use the belt tension sleeve supplied with the machine. Put the sleeve on the rod that the spring is attached to or remove the sleeve to increase or decrease tension (see the figure below). Replace the spring if necessary.

**Figure 4. How to Adjust Belt Tension On a Machine That Uses Spring Tension**



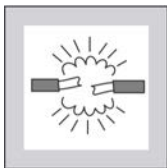
### 3.2.2 Inverters

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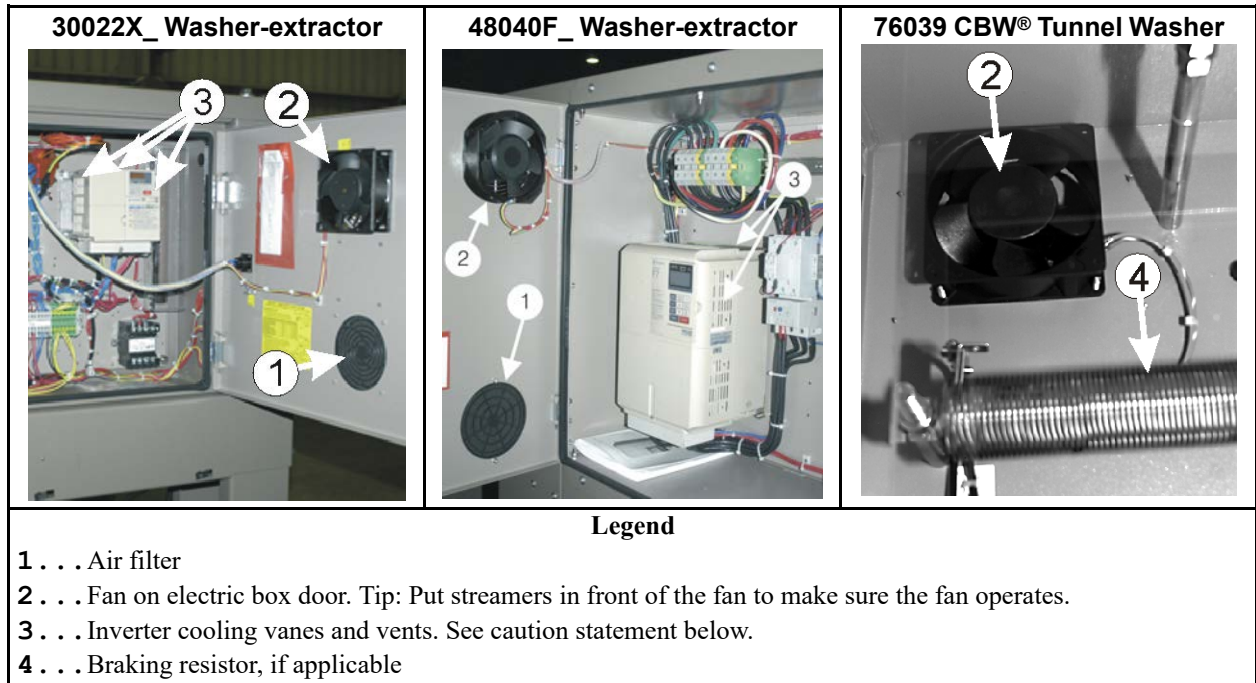


**CAUTION:** **Insufficient airflow** — will cause the inverter to burn out.

- Keep fans, filter, vents, and braking resistors clean.



**Figure 5. Electric Box and Inverter. These are examples. Your machine can look different.**



### 3.2.3 How to Examine Compressed Air Mechanisms

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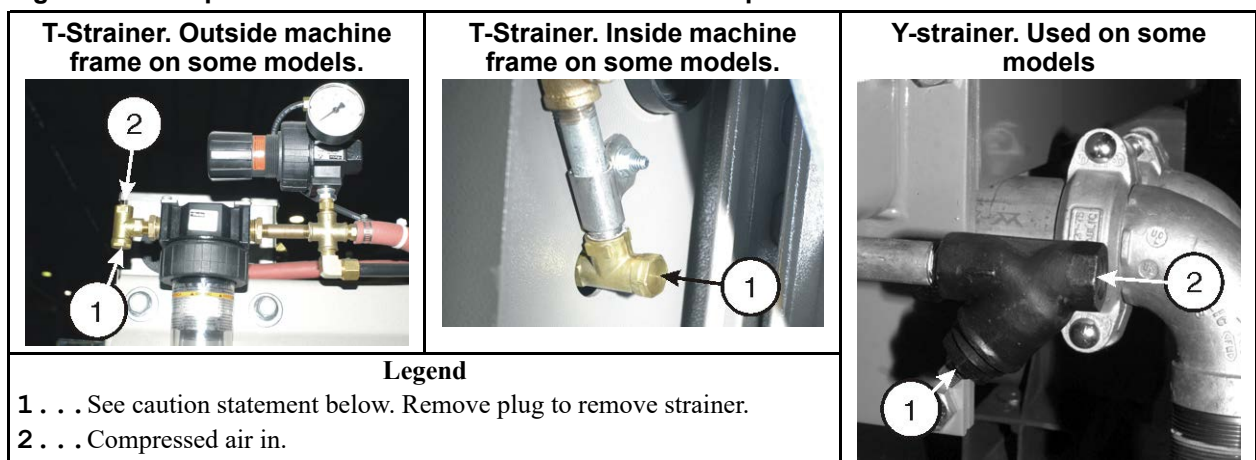


**CAUTION:** Compressed air pressure — can cause components to fly apart forcefully.

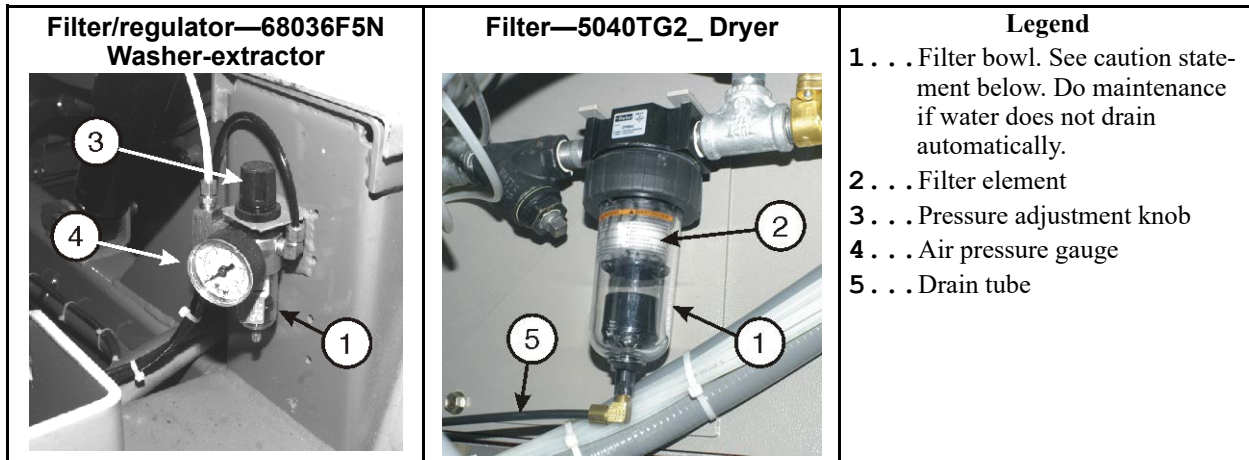


► Close the external shutoff valve and release remaining pressure before you do maintenance.

**Figure 6. Compressed Air Inlet Strainers. These are examples. Your machine can look different.**



**Figure 7. Self-purging Air Line Filter to Remove Moisture and Other Contamination. These are examples. Your machine can look different.**



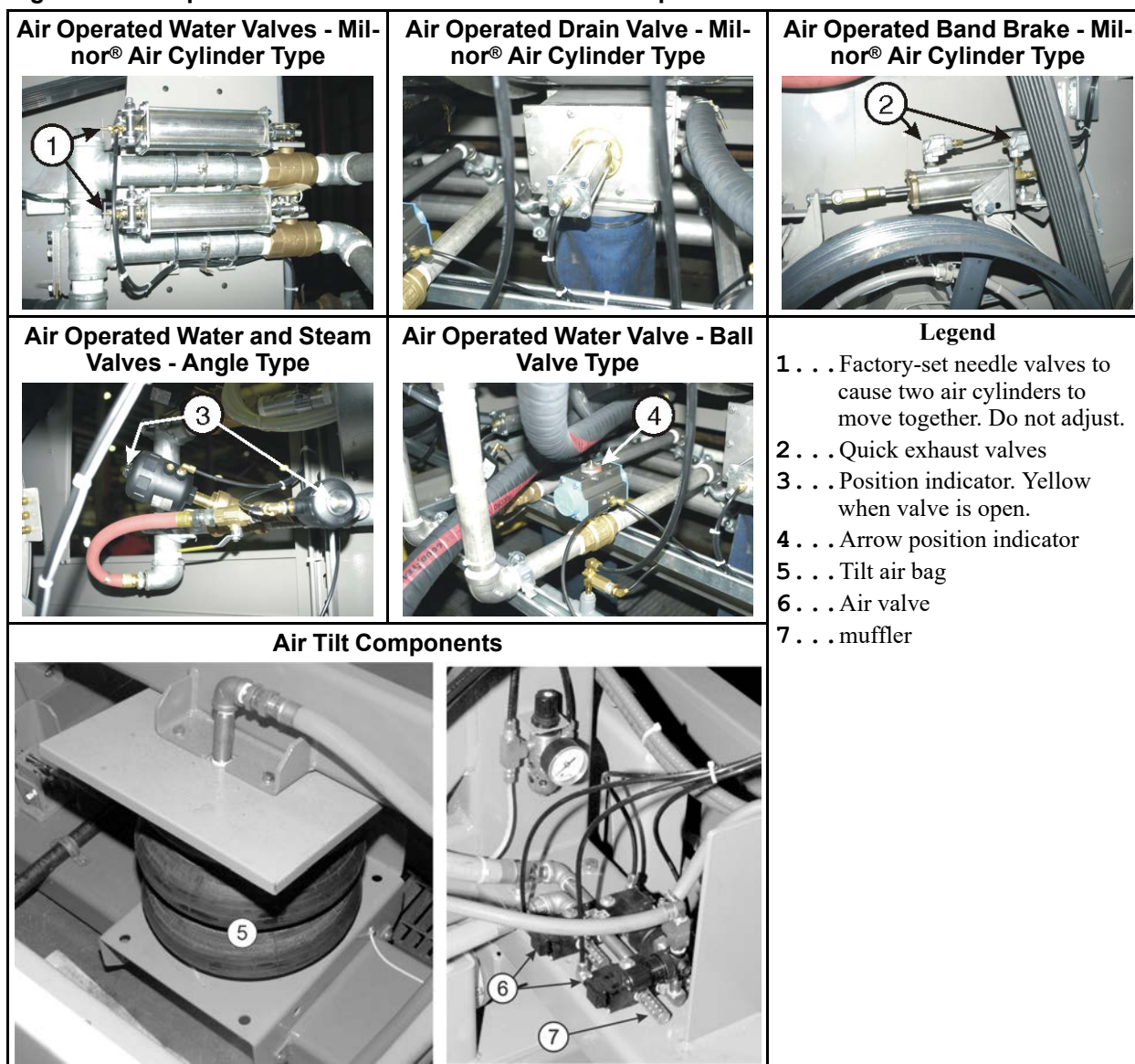
Your machine has one or more mechanisms that use compressed air for movement. [Figure 8, page 23](#) shows some examples. See the related figure in document BNVUUH01. To examine a compressed air mechanism, look at the mechanism and listen to it in operation. **Do not touch the mechanism or put your hand in the machine.** Usually you can see movement directly or on a position indicator. Frequently, you can hear a valve open and close. When a signal from the controller to operate the mechanism occurs, the air pressure must increase sufficiently before movement occurs. When the signal stops, the system must release the compressed air. You can usually hear the sound of the exhaust air for a short time.

When a compressed air mechanism operates correctly, its time of movement is usually less than two seconds. The movement is smooth. It does not shake, change speed, or stop in the middle of travel. A mechanism that does not operate correctly will cause unsatisfactory performance. If the mechanism does not operate correctly and you cannot repair the problem, speak to your dealer or Milnor®. Possible causes are as follows:

- a blockage or a leak in the air tube,
- a worn pilot air valve,
- worn components in the mechanism,
- air pressure supplied to the machine is not sufficient,
- a component used to remove contamination from the air line is clogged,
- a quick exhaust valve or muffler is clogged,
- on machines with an air line lubricator, a malfunction or incorrect adjustment prevents sufficient lubrication.



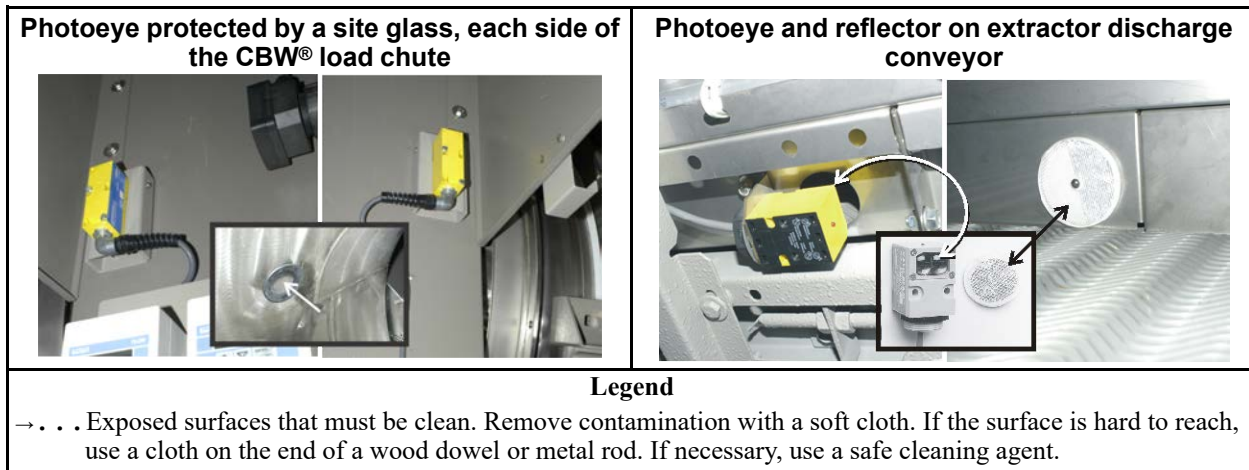
**Figure 8. Compressed Air Mechanisms** These are examples. Your machine can look different.



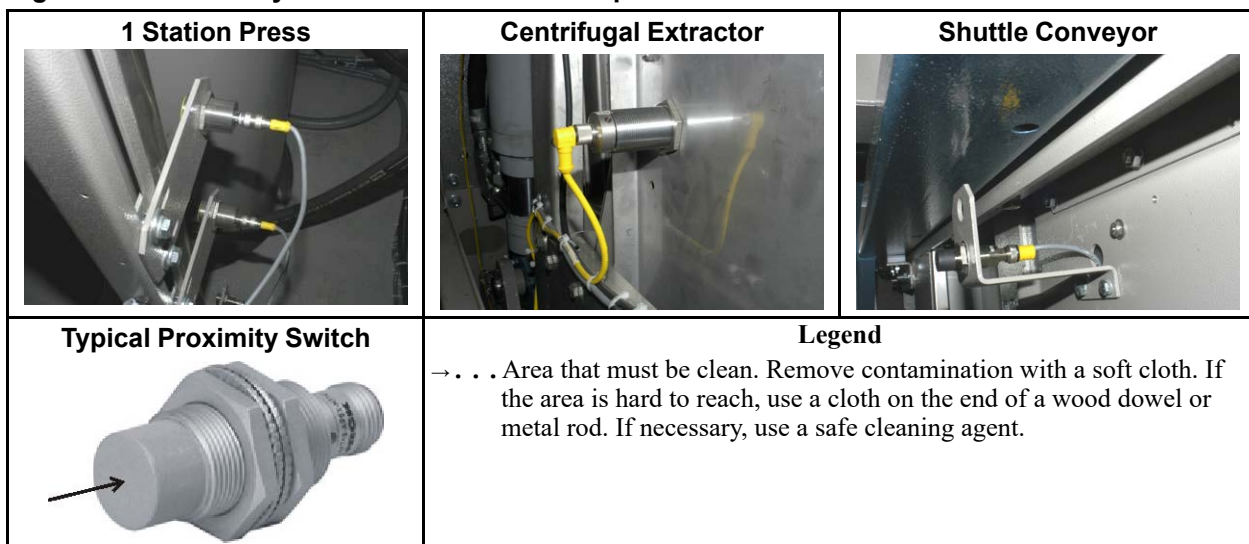
## 3.2.4 Photoeyes and Proximity Switches

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**Figure 9. Photoeyes.** These are examples. Your machine can look different.



**Figure 10. Proximity Switches** These are examples. Your machine can look different.



## 3.2.5 How to Do a Test of Emergency Stop Mechanisms

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This test applies to machines that have one or more stop mechanisms in addition to the Stop button (⓪). Do this test at the intervals given in the maintenance summary.

Definitions:

**3-wire circuit** a series electrical circuit on a Milnor® machine that must close before the machine can operate. If a switch in the circuit opens, machine movement stops and the operator alarm (a buzzer and a display message) comes on. When you push the start button (①), this closes the 3-wire circuit, which stops the operator alarm and lets the machine operate.

**emergency stop mechanism** a manual control that opens the 3-wire circuit when a person or object operates the control. Examples - emergency stop button, kick plate, pull cord.

**emergency stop button** a red push button on a yellow field that locks when a person pushes it (the electrical contacts stay open). It is necessary to turn the button clockwise to unlock it. A machine can have zero or more emergency stop buttons.

**kick plate** a metal plate on a shuttle conveyor that operates a switch when an object applies sufficient force to the plate. The kick plate is usually the first component of the shuttle to hit an object in the shuttle path. All Milnor® shuttles that go left/right on a path have kick plates on the two sides of the machine.



**WARNING:** — You can be killed or severely injured if a shuttle strikes you even if you come in contact with the kick plate first.



- ▶ Never do a test of the kick plate when the shuttle operates.

**pull cord** a wire on a conveyor that operates a switch when a person pulls the wire. All Milnor® free-stand conveyors (a conveyor that is not a component of a larger machine) have pull cords on the two sides of the conveyor.

Do a test of all emergency stop mechanisms on the machine as follows:

1. Apply power to the machine (⏻).
2. Push the start button (①). **Do not cause the machine to operate.** For example, do not start a formula or operate the machine manually. It is not necessary to do the test when the machine operates.
3. Operate an emergency stop mechanism (examples - button, kick plate, pull cord). If the mechanism operates correctly, the operator alarm comes on. Did this occur?
  - Yes—Release the emergency stop mechanism if necessary. For example, if this is an emergency stop button, turn the button clockwise to unlock it. Push the start button (①). Do the test on a different emergency stop mechanism. Continue until you do the test on all emergency stop mechanisms on the machine.
  - No—An electrical component is defective. Shut down the machine. Do not let the machine operate until you correct the problem.



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## 3.3 Maintenance Components—Dryer and Dryvac Group

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Figure 11. Remove Material Brought In With the Goods

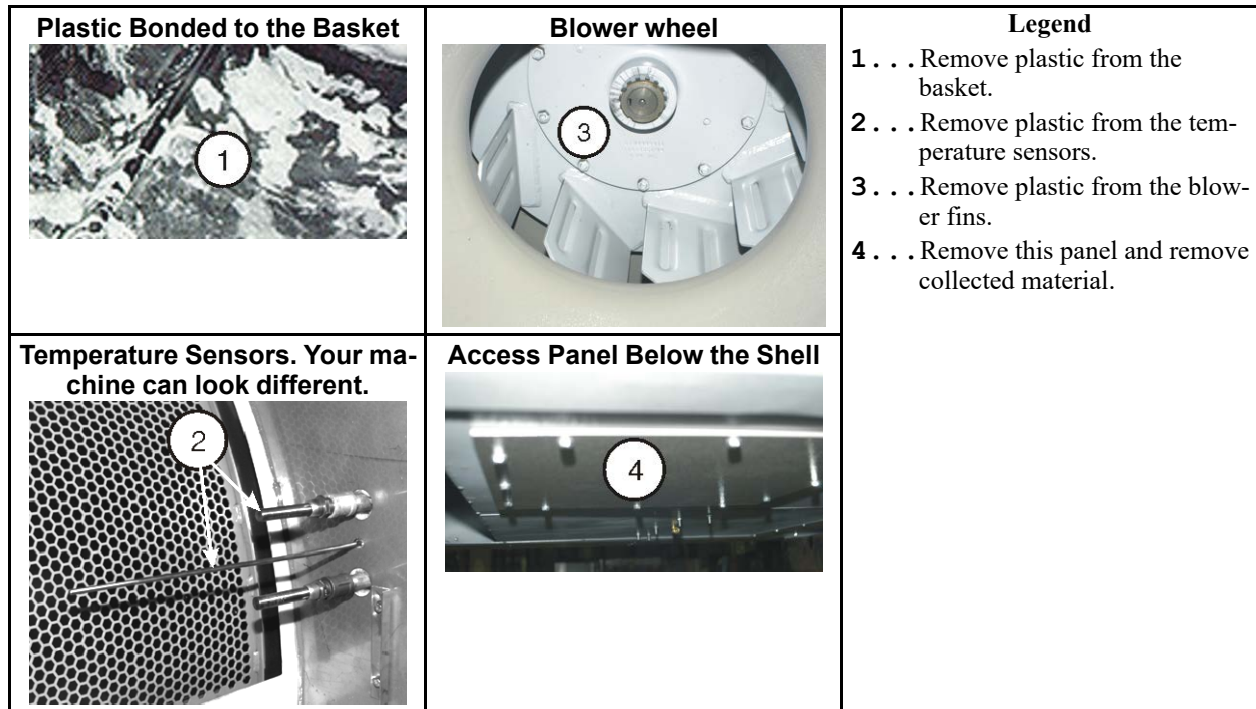
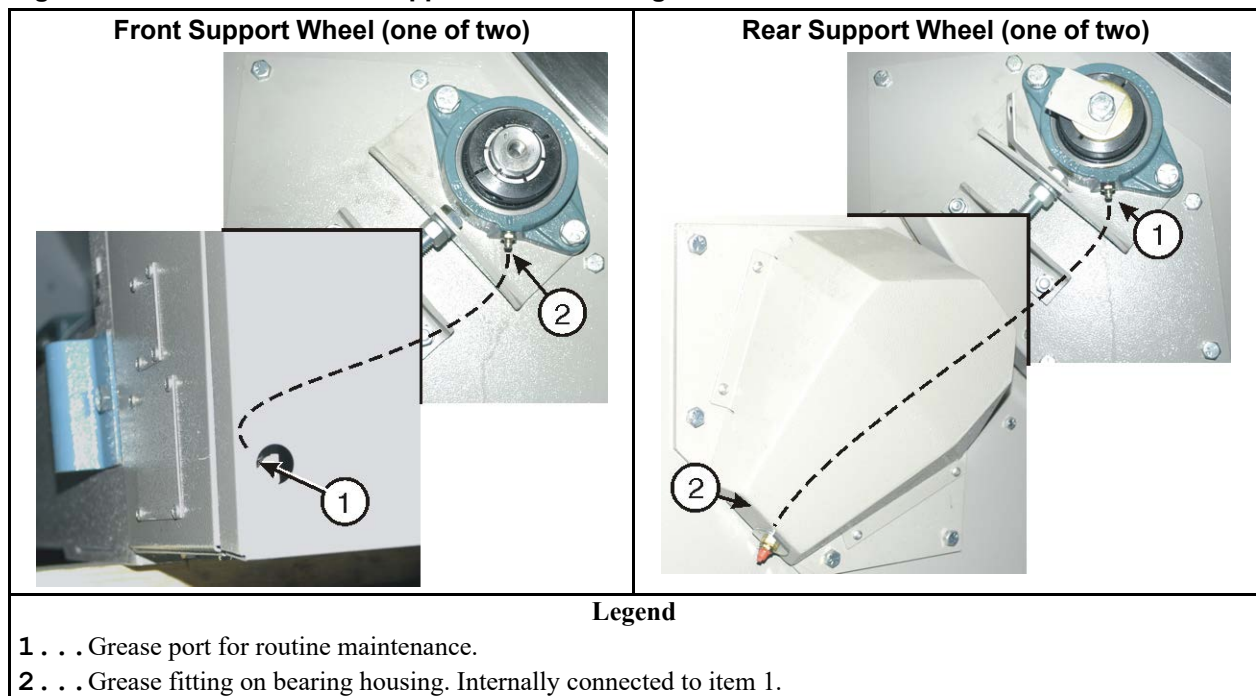
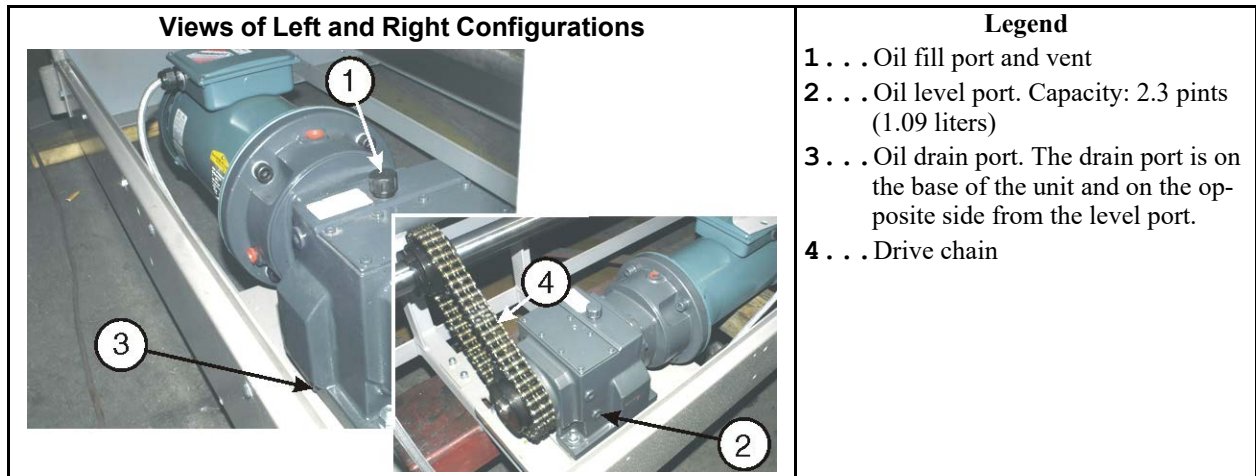


Figure 12. Grease Ports for Support Wheel Bearings



**Figure 13. Lubrication of Basket Drive Components**

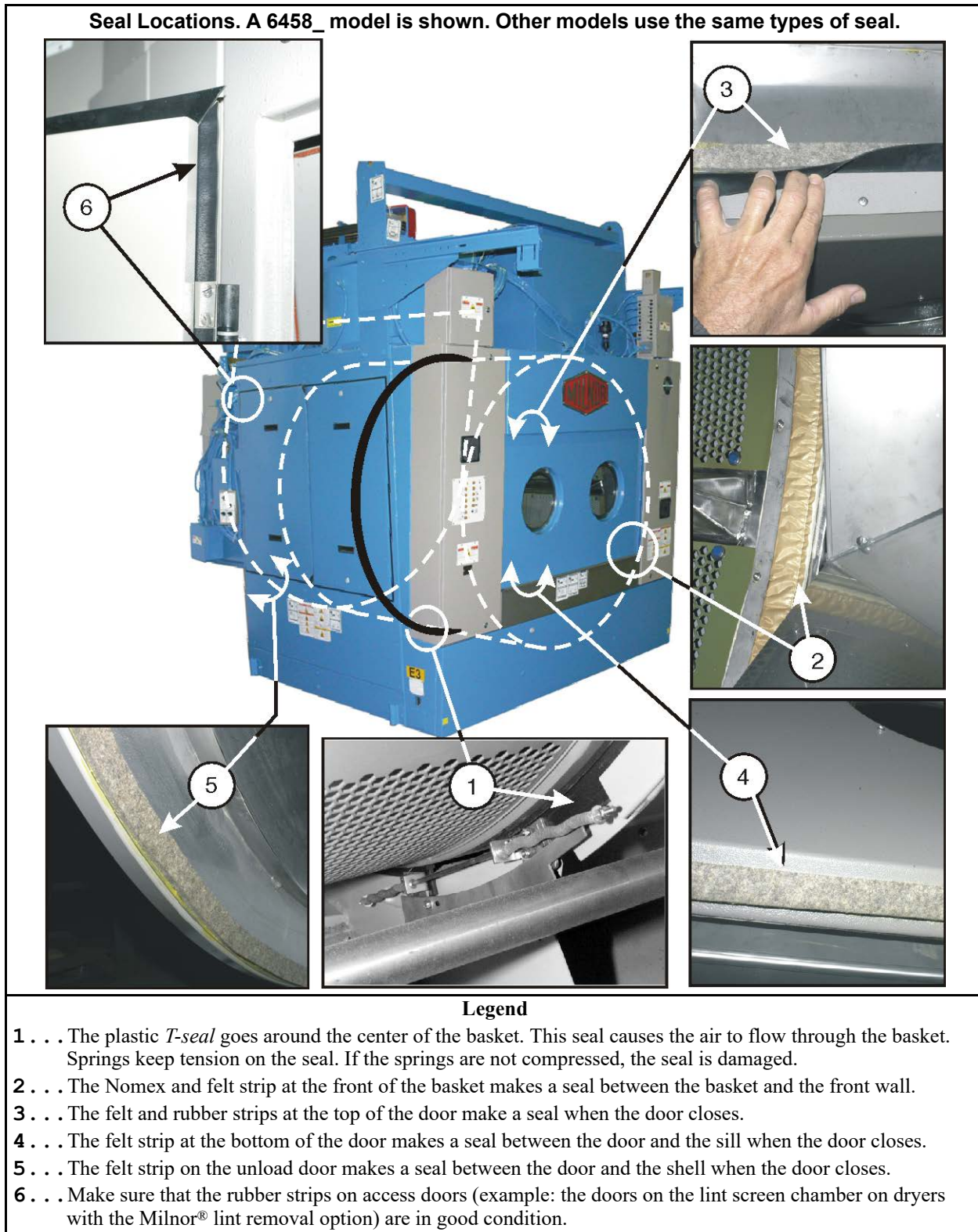
### 3.3.1 The Dryer Air Seals

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The air seals shown in [Figure 14: Dryer Air Seals, page 28](#) are necessary for correct dryer function. Examine the seals at the intervals given in the maintenance summary. After some time, a seal can become worn or damaged. When this occurs, it is necessary to repair the seal to keep good dryer function. Speak to your dealer or Milnor®. This is not routine maintenance.

You can operate the doors in the **Manual** mode for access to the felt seals. But do not get in the machine with power connected. If necessary, use a board to hold a door open then remove power from the machine before you examine the seal.

**Figure 14. Dryer Air Seals**



### 3.3.2 How Particle Contamination Occurs in the Dryer

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The maintenance summary gives the intervals that are usually necessary to remove particle contamination from the dryer. If low air errors occur or quality decreases, shorter maintenance intervals can be necessary. Three types of particle contamination occur:

**Material brought in with the air** Lint and other material will collect on the screen in front of the gas burner or steam coils in the air flow. After some time, some material will get through the screen and collect in the burner or steam coils.

**Lint that comes out of the goods** The lint collects on the lint screens. If the dryer has the optional Milnor® lint removal system, these screens are in the dryer. If not, the screens are external. With the two types, an automatic system removes the lint from the screens. If this system does not operate correctly, the air flow through the basket will quickly decrease. If this occurs, it is necessary to repair the lint removal system.

**Material mixed with the goods** When the goods are sorted, this material should be removed. Plastic material that is not removed can melt in the dryer. The melted plastic can bond to the basket and decrease the flow of air. The basket surface can be stainless steel or optional Teflon. Teflon decreases this problem, but does not fully prevent it. The plastic can bond to the fins on the main blower. This can make the blower not balanced which will decrease the life of the bearings. The plastic can also bond to temperature sensors and cause the controller to read incorrect temperature values. If plastic contamination occurs quickly, examine how you sort the goods.