



Maintenance Report

Work Order Number:	S002085513	Customer Plant:	[SEC-UPFIELD HEL] Upfield Helsingborg
Parent WO Number:		Line And Machine:	SEC-UPFIELD HEL-327-8 \ 63202/20152
ECC Service Order Number:	72403789	Asset Description:	[9000216560] TT/3-200V MINI TAISHAN A38 HAAD
Purchase Order:	4800050884	Asset Type Description:	[600351-2000] TETRA TOP TT/3
Type Of Work:	[PREVEN] Preventive	Optimisation Level:	N
Section:	[TP] Tetra Pak	Status:	Closed
Estimated Duration:	59:36	Completed On:	2021-04-23 21:59:00 (UTC)
Start On:	2021-04-19 00:00:00 (UTC)	Main Scheduled Reading:	4000
Work Required:	[UNIBES_327-7_TT3_S002085513] Tasks (94) for: 4000 Hours; 2000 Hours; 1000 Hours; (97 Tasks Proposed; 94 Tasks Created; 3 Tasks Suppressed) [Merged from S002009285]		
		Work Performed:	TPMS Performed

Meter Code	Meter Description	Scheduled Meter Reading	Completion Meter Reading	Completion Meter Reading On
63202/20152_110014060	PROD-TOTAL	4000	4455	2021-04-22

WARNING! Before starting any service work, read the safety precaution in the corresponding Maintenance Manual.

Maintenance Manual	Operator Manual	Spare Parts Catalogue	Technical Manual	Rebuilding Manual
MM-3030000-0121	OM / 3030002-0118 XH, 3030004-0120 XHIC OM / 3030006-0115 AD 3411400-0109 ADY OM / 3358725-0111 ADIC, 3211300-0112 ASCM PC / 3451443-0111 XH&XHIC, 3611282-0103 AD&ADIC	SPC-3030013-0122		

Done By	Hours Worked
Karl-Magnus Holmbäck	40:00
Dennis Dahlkvist	40:00
Andre Jonsson	20:00
William PalmerSunmo	20:00

Option Code	Option Description	Option Value
CA_ACCESSPLATFORM	Access Platform	LADDER
CA_ADD_INT_LEAD_TIME	Addition Internal lead time	2.000
CA_AGITATOR	Agitator	W/O AGITATOR
CA_APPROVAL	Approval (CE/UL/CSA)	CE
CA_CAU	CAU	WITHOUT CAU
CA_CAU_GEARBOX_VERSION	CAU Gearbox Version	2
CA_CONDITION_MONITORING	Condition Monitoring	WITHOUT CM
CA_CONFIG_STATUS	Configuration Status	RESTRICTED SALES
CA_CONFIG_USAGE	Configuration Usage	EQUIPMENTS
CA_CONNECTION_BOX_VERSION	Connection Box Version	1
CA_DEVSTEP	Development step	20
CA_DOOR_VERSION	Door version	GLASS COV
CA_DRIVE_UNIT_S1	Drive Unit Version S1	2
CA_DRIVE_UNIT_S2	Drive Unit Version S2	2
CA_FINAL_DESTINATION	Final Destination	OTHER COUNTRIES NOT USA/CANADA
CA_FREQ	Frequency	50
CA_HEADSPACE_SYSTEM	Headspace System	NOHEADSPACE SYSTEM
CA_HOT_CHANNEL_PISTON_VERSION	Hot Channel Piston Version	2
CA_HYGIENE_LEVEL	Hygiene level	HAAD

CA_HYGIENIC_CLEANING_VALVE_VER	Hyg. Cleaning Valve Version	VERS 1
CA_LANG	Language	EN
CA_LANG_2	Language 2	SV
CA_LIGHT_EC	Light in Electriac Cabinet	FLOUR
CA_LOGOTYPE_S1	Logotype S1	N/A
CA_LOGOTYPE_S2	Logotype S2	N/A
CA_MACHMODEL	Machine model	TT/3
CA_MARKET	Market	SE
CA_MEMBRANE_TYPE_S1	Membrane type S1	N/A
CA_MEMBRANE_TYPE_S2	Membrane type S2	N/A
CA_OIL	Oil	PAO
CA_OPENING_S1	Opening Side 1	TAISHAN S1
CA_OPENING_S2	Opening Side 2	TAISHAN S2
CA_OTHER_REGULATIONS	Other Regulations	N/A
CA_PACKAGE_SHAPE_S1	Package shape Side 1	STD S1
CA_PACKAGE_SHAPE_S2	Package shape Side 2	STD S2
CA_PACKAGE_TYPE_S1	Package type Side 1	MINI S1
CA_PACKAGE_TYPE_S2	Package type Side 2	MINI S2
CA_PACKAGE_VARIANT	Package variant	TT 0250 MINI
CA_PNEU_ASU	Pneumatic in ASU	FESTO
CA_PNEU_CAU	Pneumatic in CAU	FESTO
CA_PNEU_CS	Pneumatic in CS	FESTO
CA_PNEU_FS_S1	Pneumatic in FS S1	FESTO
CA_PNEU_FS_S2	Pneumatic in FS S2	FESTO
CA_PNEU_PS_S1	Pneumatic in PS S1	FESTO
CA_PNEU_PS_S2	Pneumatic in PS S2	FESTO
CA_PNEUMATIC	Pneumatic	FESTO
CA_PRODUCT	Product	ASD
CA_PRODUCT_TANK	Pressure Directive	PED
CA_PURCHASE_COST	Variant condition	ASD
CA_PURCHASE_COST	Variant condition	CA_HC PISTON W COOLING
CA_PURCHASE_COST	Variant condition	CA_HC PISTON W/O COOLING
CA_PURCHASE_COST	Variant condition	CE W/O AGITATOR ASD
CA_PURCHASE_COST	Variant condition	DOOR VERSION GLASS
CA_PURCHASE_COST	Variant condition	HAAD ASD
CA_PURCHASE_COST	Variant condition	HYGIENE LEVEL HAAD
CA_PURCHASE_COST	Variant condition	MINI TAISHAN S1
CA_PURCHASE_COST	Variant condition	MINI TAISHAN S2
CA_PURCHASE_COST	Variant condition	MINI_S1 MINI_S2
CA_PURCHASE_COST	Variant condition	N/A
CA_PURCHASE_COST	Variant condition	W/O AGITATOR
CA_PURCHASE_COST	Variant condition	WITHOUT CAU
CA_REBUILDING_KIT	Rebuilding Kit	3255642-0100 - MKC Strip Applicator HAAD TT3 2000
CA_REBUILDING_KIT	Rebuilding Kit	3561115-0100 - MKC RVG200-Logger Diodes TT3
CA_REBUILDING_KIT	Rebuilding Kit	3571082-0100* - MKC SW Release 2018 Q4 TT/3
CA_REBUILDING_KIT	Rebuilding Kit	3587427-0100 - MKS CS Doors Cleaning Alarms TT3
CA_REBUILDING_KIT	Rebuilding Kit	3597731-0100 - MKS UV Lamp Temperature TT/3
CA_REBUILDING_KIT	Rebuilding Kit	3600615-0100 - MKC US Converter Air Supply TT3
CA_REBUILDING_KIT	Rebuilding Kit	3606777-0100 - MKS TTCU/CIP Alarm Behaviour
CA_REBUILDING_KIT	Rebuilding Kit	3610216-0100 - MKC Hydrogen Peroxide Degradation
CA_REBUILDING_KIT	Rebuilding Kit	3612425-0100 - MKS Temp. Supervision TT/3
CA_REBUILDING_KIT	Rebuilding Kit	3625804-0100* - MKC Hot Channel Upgrade AD and ADIC
CA_REBUILDING_KIT	Rebuilding Kit	3632396-0100 - MKC Improved Heating Evaporator TT/3
CA_REBUILDING_KIT	Rebuilding Kit	3632897-0100 - MKC TS Alarm Supervision TT/3
CA_REBUILDING_KIT	Rebuilding Kit	3643983-0100 - MKC H202 Concent. Test in Package TT3
CA_REBUILDING_KIT	Rebuilding Kit	3652415-0100 - MKC ASU FESTO Valve Ramp TT/3
CA_REGULATING_VALVE	Regulating Valve	VERSION 2
CA_REGULATORY_REQ	Regulatory requirement	WITHOUT 3A
CA_RENOVATION_STATUS	Renovation Status	N/A
CA_SAFETY_SIGNS	Safety signs	ISO
CA_SCREWCAP_TYPE_S1	Screwcap type S1	A38 S1
CA_SCREWCAP_TYPE_S2	Screwcap type S2	A38 S2

CA_SD_VARCOND	Variant condition	ASD
CA_SD_VARCOND	Variant condition	CA_HC PISTON W COOLING
CA_SD_VARCOND	Variant condition	CA_HC PISTON W/O COOLING
CA_SD_VARCOND	Variant condition	CE W/O AGITATOR ASD
CA_SD_VARCOND	Variant condition	DOOR VERSION GLASS
CA_SD_VARCOND	Variant condition	HAAD ASD
CA_SD_VARCOND	Variant condition	HYGIENE LEVEL HAAD
CA_SD_VARCOND	Variant condition	MINI TAISHAN S1
CA_SD_VARCOND	Variant condition	MINI TAISHAN S2
CA_SD_VARCOND	Variant condition	MINI_S1 MINI_S2
CA_SD_VARCOND	Variant condition	N/A
CA_SD_VARCOND	Variant condition	W/O AGITATOR
CA_SD_VARCOND	Variant condition	WITHOUT CAU
CA_SER_NUMBER	Serial Number	63202/20152
CA_SPRUE_REMOVER_S1	Sprue Remover S1	VERSION 2 S1
CA_SPRUE_REMOVER_S2	Sprue Remover S2	VERSION 2 S2
CA_STRIP_APPL_VER	Strip Applicator version	2
CA_TELSONIC_GEN_VERS	Telsonic generator version	2
*Multiple configurable materials available for this rebuilding kit number		

Task Feedback Classifications

<u>Not Done Reason</u>		<u>Changed Part Condition</u>		<u>Part Source</u>	
Code	Description	Code	Description	Code	Description
1	Part not available	1	Part failed	TP	Tetra Pak
2	Part condition good	2	Potential failure	CS	Customer stock - Tetra Pak supplied
3	Customer decision	3	Part condition good	CN	Customer stock - non Tetra Pak supplied
4	Insufficient labour available			CR	Customer stock - refurbished part
5	Insufficient information			SB	Service box
6	Task incorrectly added				
7	Task recently done				
9	Template not available				

Maintenance Report		SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD			S002085513		
Task Code	Task Action	Task Description		Task Code in bold font indicates that the task has changed since the work order was created.			
Trade	Section	Motion Type	Duration	Interval			
Doc Ref		Last Done					
1 Pre-Maintenance Checks: (9000216560) TT/3-200V MINI TAISHAN A38 HAAD \ [600351-2000] TETRA TOP TT/3							
*3021514	Check	Check Run machine. Check function. If machine does not function correctly, inform supervisor before continuing.		Done	Yes	Changed Part Condition	
ENGR	TP	Only when In Motion	0:10	1000 Hours	Not Done Reason	Part Source	
OM 4				Failed		Update Request Ref.	
1 Pre-Maintenance Checks: (600351-2000:600301-2000 (857618)) Automatic Splicing Unit \ [1025388-0600] Strip Appl. Unit S1 \ [1116936-0600] Strip Applicator Cast S1 \ [2611432-0400] Strip applicator house S1							
*3020757	Check	Check Side Strip applicator unit Strip applicator Cast Check splice and sealing of strip.		Done	Yes	Changed Part Condition	
ENGR	TP	Only when In Motion	0:02	1000 Hours	Not Done Reason	Part Source	
1.3.2.2-2				Failed		Update Request Ref.	
1 Pre-Maintenance Checks: (600351-2000:600301-2000 (857618)) Automatic Splicing Unit \ [1025388-0600] Strip Appl. Unit S1 \ [1116936-0700] Strip Applicator Cast S1 \ [2611432-0500] Strip applicator house S1							
*20661668	Check	Check Side Strip applicator unit Strip applicator Cast Check splice and sealing of strip.		Done	Yes	Changed Part Condition	
ENGR	TP	Only when In Motion	0:02	1000 Hours	Not Done Reason	Part Source	
1.3.2.2-7				Failed		Update Request Ref.	
1 Pre-Maintenance Checks: (600351-2000:600301-2000 (857618)) Automatic Splicing Unit \ [1367716-0400] Strip Appl. Unit S2 \ [1367922-0500] Strip Applicator Cast S2 \ [1367930-0600] Strip applicator house S2							
*20661680	Check	Check Side Strip applicator unit Strip applicator Cast Check splice and sealing of strip.		Done	Yes	Changed Part Condition	
ENGR	TP	Only when In Motion	0:02	1000 Hours	Not Done Reason	Part Source	
1.3.2.2-7				Failed		Update Request Ref.	
1 Pre-Maintenance Checks: (600351-2000:600301-2000 (857618)) Automatic Splicing Unit \ [1367716-0400] Strip Appl. Unit S2 \ [1367922-0400] Strip Applicator Cast S2 \ [1367930-0500] Strip applicator house S2							
*3017587	Check	Check Side Strip applicator unit Strip applicator Cast Check splice and sealing of strip.		Done	Yes	Changed Part Condition	
ENGR	TP	Only when In Motion	0:02	1000 Hours	Not Done Reason	Part Source	
1.3.2.2-2				Failed		Update Request Ref.	
1 Pre-Maintenance Checks: (600351-2000:600302-2000 (857619)) Carton section \ [3312083-0100] Cutting function S1 \ [3434618-0200] {Sprue Remover Unit} \ [3426816-0100] Connection box \ [90064-0082] Push button, white							
*17152618	Check	Check (Reset / Step Up / Push down) Signal lamp		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:01	1000 Hours	Not Done Reason	Part Source	
2.14.3.1				Failed		Update Request Ref.	
1 Pre-Maintenance Checks: (600351-2000:600302-2000 (857619)) Carton section \ [3312084-0100] Cutting function S2 \ [3434618-0200] {Sprue Remover Unit} \ [3426816-0100] Connection box \ [90064-0082] Push button, white							
*17152618	Check	Check (Reset / Step Up / Push down) Signal lamp		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:01	1000 Hours	Not Done Reason	Part Source	
2.14.3.1				Failed		Update Request Ref.	
1 Pre-Maintenance Checks: (600351-2000:600311-0400 (857625)) LFU \ [1551358-0400] LFU S1							
*3018037	Check	Check 250 h check lists. Go through the lists carried out since the last 1000 h service. If all checks are not completed carry them out together with this service.		Done	Yes	Changed Part Condition	
ENGR	TP	Only when In Motion	0:05	1000 Hours	Not Done Reason	Part Source	
3.15.3-1				Failed		Update Request Ref.	
*3018025	Record	Record Status check of LFU.		Done	Yes	Changed Part Condition	
ENGR	TP	Only when In Motion	0:10	1000 Hours	Not Done Reason	Part Source	
3.15.3-2				Failed		Update Request Ref.	

Maintenance Report			SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD			S002085513		
Task Code	Task Action	Task Description	Task Code in bold font indicates that the task has changed since the work order was created.					
Trade	Section	Motion Type	Duration	Interval				
Doc Ref	Last Done							
1 Pre-Maintenance Checks: (600351-2000:600311-0400 (857625)) LFU \ [1551359-0400] LFU S2								
*3134709	Check	Check 250 h check lists. Go through the lists carried out since the last 1000 h service. If all checks are not completed carry them out together with this service.	Done	Yes	Changed Part Condition			
ENGR	TP	Only when In Motion	0:05	1000 Hours	Not Done Reason		Part Source	
3.15.3-1					Failed		Update Request Ref.	
*3018055	Record	Record Status check of LFU.	Done	Yes	Changed Part Condition			
ENGR	TP	Only when In Motion	0:10	1000 Hours	Not Done Reason		Part Source	
3.15.3-2					Failed		Update Request Ref.	
1 Pre-Maintenance Checks: (600351-2000:600303-2000 (857620)) Package section \ [600303-2000] Package section								
*3021465	Check	Check Side 1 Package check - Check package according to recommendation in Operation Manual.	Done	Yes	Changed Part Condition			
ENGR	TP	Only when In Motion	0:10	1000 Hours	Not Done Reason		Part Source	
OM PC					Failed		Update Request Ref.	
*3021471	Check	Check Side 2 Package check - Check package according to recommendation in Operation Manual.	Done	Yes	Changed Part Condition			
ENGR	TP	Only when In Motion	0:10	1000 Hours	Not Done Reason		Part Source	
OM PC					Failed		Update Request Ref.	
1 Pre-Maintenance Checks: (600351-2000:600304-2000 (857621)) Filling section \ [1298977-0500] Filling section \ [986308-0900] Machine body \ [1105831-0300] Cleaning Cantilever \ [1469485-0200] Cleaning box S1								
*129946	Check	Check Side 1 Fill system; Ensure that the fill nozzles close properly during filling without dripping and that product does not splash on the nozzles. The volume must be correct and not fluctuating.	Done	Yes	Changed Part Condition			
ENGR	TP	Only when In Motion	0:02	1000 Hours	Not Done Reason		Part Source	
OM 8					Failed		Update Request Ref.	
1 Pre-Maintenance Checks: (600351-2000:600304-2000 (857621)) Filling section \ [1298977-0500] Filling section \ [986308-0900] Machine body \ [1105831-0300] Cleaning Cantilever \ [1469486-0200] Cleaning box S2								
*129948	Check	Check Side 2 Fill system; Ensure that the fill nozzles close properly during filling without dripping and that product does not splash on the nozzles. The volume must be correct and not fluctuating.	Done	Yes	Changed Part Condition			
ENGR	TP	Only when In Motion	0:02	1000 Hours	Not Done Reason		Part Source	
OM 8					Failed		Update Request Ref.	
(600351-2000:600301-2000 (857618)) Automatic Splicing Unit \ [977852-0500] Splicing Device S1 \ [996461-0500] Splicing Dev Bracket S1 \ [996465-0400] Pressure roller S1								
*90110	Check	Check Pressure roller	Done	Yes	Changed Part Condition			
ENGR	TP	Only when Stationary	0:05	4000 Hours	Not Done Reason		Part Source	
1.2.2.2-1					Failed		Update Request Ref.	
(600351-2000:600301-2000 (857618)) Automatic Splicing Unit \ [977852-0500] Splicing Device S1 \ [996461-0500] Splicing Dev Bracket S1 \ [1185250-0400] Creasing unit S1								
*204141	Check	Check Centering	Done	Yes	Changed Part Condition			
ENGR	TP	Only when Stationary	0:05	3000 Hours	Not Done Reason		Part Source	
1.2.2.3-3					Failed		Update Request Ref.	
1355671-0000	TEMPLATE		TL		1			
(600351-2000:600301-2000 (857618)) Automatic Splicing Unit \ [1367711-0300] Splicing device S2 \ [1367713-0300] Splicing Dev Bracket S2 \ [1367719-0200] Pressure roller S2								
*90117	Check	Check Pressure roller	Done	Yes	Changed Part Condition			
ENGR	TP	Only when Stationary	0:05	4000 Hours	Not Done Reason		Part Source	
1.2.2.2-1					Failed		Update Request Ref.	

Maintenance Report				SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD		S002085513	
Task Code	Task Action	Task Description		Task Code in bold font indicates that the task has changed since the work order was created.			
Trade	Section	Motion Type	Duration	Interval			
Doc Ref				Last Done			
(600351-2000:600301-2000 (857618)) Automatic Splicing Unit \ [1367711-0300] Splicing device S2 \ [1367713-0300] Splicing Dev Bracket S2 \ [1369270-0300] Creasing unit S2							
*204149	Check	Check Centering		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	3000 Hours	Not Done Reason	Part Source	
1.2.2.3-3				Failed		Update Request Ref.	
1355671-0000	TEMPLATE		TL	1			
(600351-2000:600301-2000 (857618)) Automatic Splicing Unit \ [1025388-0600] Strip Appl. Unit S1 \ [1116936-0700] Strip Applicator Cast S1 \ [3430568-0100] Strip Applicator S1							
*20661692	Check	Check Pressure and counter roller		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:03	1000 Hours	Not Done Reason	Part Source	
1.3.2.3-1				Failed		Update Request Ref.	
(600351-2000:600301-2000 (857618)) Automatic Splicing Unit \ [1025388-0600] Strip Appl. Unit S1 \ [1116936-0600] Strip Applicator Cast S1 \ [1035366-0100] Pressure roller							
*19032006	Check	Check Pressure and counter roller		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:03	1000 Hours	Not Done Reason	Part Source	
OM 8 Weekly				Failed		Update Request Ref.	
(600351-2000:600301-2000 (857618)) Automatic Splicing Unit \ [1025388-0600] Strip Appl. Unit S1 \ [1025399-0400] Strip magazine S1							
*3017395	Check	Check Strip magazine		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	2000 Hours	Not Done Reason	Part Source	
1.3.3.1-1				Failed		Update Request Ref.	
(600351-2000:600301-2000 (857618)) Automatic Splicing Unit \ [1367716-0400] Strip Appl. Unit S2 \ [1367922-0500] Strip Applicator Cast S2 \ [3432863-0100] Strip Applicator S2							
*20661699	Check	Check Pressure and counter roller		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:03	1000 Hours	Not Done Reason	Part Source	
1.3.2.3-1				Failed		Update Request Ref.	
(600351-2000:600301-2000 (857618)) Automatic Splicing Unit \ [1367716-0400] Strip Appl. Unit S2 \ [1367922-0400] Strip Applicator Cast S2 \ [1035366-0100] Pressure roller							
*19032006	Check	Check Pressure and counter roller		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:03	1000 Hours	Not Done Reason	Part Source	
OM 8 Weekly				Failed		Update Request Ref.	
(600351-2000:600301-2000 (857618)) Automatic Splicing Unit \ [1367716-0400] Strip Appl. Unit S2 \ [1367722-0300] Strip magazine S2							
*3017467	Check	Check Strip magazine		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	2000 Hours	Not Done Reason	Part Source	
1.3.3.1-1				Failed		Update Request Ref.	
(600351-2000:600302-2000 (857619)) Carton section \ [600302-2000] Carton section							
*3023461	Clean	Clean Filter GSU		Done	Yes	Changed Part Condition	
ENGR	TP	Only when In Motion	0:05	3000 Hours	Not Done Reason	Part Source	
9.1-1				Failed		Update Request Ref.	
(600351-2000:600302-2000 (857619)) Carton section \ [915299-0900] Conveying equipment S1 \ [915308-0900] Drive Unit S1							
*3021559	Check	Check Rubber Squeezer wheel		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	1000 Hours	Not Done Reason	Part Source	
2.4.4-4				Failed		Update Request Ref.	

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Task Code	Task Action	Task Description		Task Code in bold font indicates that the task has changed since the work order was created.			
Trade	Section	Motion Type	Duration	Interval			
Doc Ref		Last Done					
*3021577	Change	Change Rubber Squeezer wheel		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:30	2000 Hours	Not Done Reason	Part Source	CS
2.4.4-9				Failed		Update Request Ref.	
Part No		Part Description		MU/TL	Qty Required		Qty Used
344224-0200		Ball bearing, 10.00x26.00x8.00mm			4		4
977510-0000		Squeezer			1		1
*3021565	Change	Change Drive belt		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:45	3000 Hours	Not Done Reason	Part Source	CS
2.4.4-8				Failed		Update Request Ref.	
Part No		Part Description		MU/TL	Qty Required		Qty Used
90417-0385		Timing belt, T5-DL 460.0/16.0mm			1		1
*3021547	Check	Check Carrier belt		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	1000 Hours	Not Done Reason	Part Source	
2.4.4-1				Failed		Update Request Ref.	
(600351-2000:600302-2000 (857619)) Carton section \ [1367882-0400] Conveying equipment S2 \ [1367885-0400] Drive Unit S2							
*3017515	Check	Check Rubber Squeezer wheel		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	1000 Hours	Not Done Reason	Part Source	
2.4.4-4				Failed		Update Request Ref.	
*3017497	Change	Change Rubber Squeezer wheel		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:30	2000 Hours	Not Done Reason	Part Source	CS
2.4.4-9				Failed		Update Request Ref.	
Part No		Part Description		MU/TL	Qty Required		Qty Used
344224-0200		Ball bearing, 10.00x26.00x8.00mm			4		4
977510-0000		Squeezer			1		1
*3017521	Change	Change Drive belt		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:45	3000 Hours	Not Done Reason	Part Source	
2.4.4-8				Failed		Update Request Ref.	
Part No		Part Description		MU/TL	Qty Required		Qty Used
90417-0385		Timing belt, T5-DL 460.0/16.0mm			1		1
*3017503	Check	Check Carrier belt		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	1000 Hours	Not Done Reason	Part Source	
2.4.4-1				Failed		Update Request Ref.	
(600351-2000:600302-2000 (857619)) Carton section \ [986239-0600] Side feeder S1							
*209924	Check	Check Bushings		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	2000 Hours	Not Done Reason	Part Source	
2.5-1				Failed		Update Request Ref.	
(600351-2000:600302-2000 (857619)) Carton section \ [1367886-0200] Side feeder S2							
*209955	Check	Check Bushings		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	2000 Hours	Not Done Reason	Part Source	
2.5-1				Failed		Update Request Ref.	

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Trade	Section	Motion Type	Duration	Interval				
Doc Ref						Last Done		
(600351-2000:600302-2000 (857619)) Carton section \ [986242-0800] Erector S1 \ [1025038-0500] Distributor drive S1								
*92743	Turn	Turn Sliding strip			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	3000 Hours	Not Done Reason		Part Source	
2.6.4-4					Failed		Update Request Ref.	
(600351-2000:600302-2000 (857619)) Carton section \ [986242-0800] Erector S1 \ [986385-0600] Erector fingers S1								
*90396	Check	Check Ball bushing / Strut bearing			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	1000 Hours	Not Done Reason		Part Source	
2.6.6-2, 2.6.6-3					Failed		Update Request Ref.	
(600351-2000:600302-2000 (857619)) Carton section \ [1367887-0300] Erector S2 \ [1367889-0100] Distributor drive S2								
*92862	Turn	Turn Sliding strip			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	3000 Hours	Not Done Reason		Part Source	
2.6.4-4					Failed		Update Request Ref.	
(600351-2000:600302-2000 (857619)) Carton section \ [1367887-0300] Erector S2 \ [1367890-0200] Erector fingers S2								
*90426	Check	Check Ball bushing / Strut bearing			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	1000 Hours	Not Done Reason		Part Source	
2.6.6-2, 2.6.6-3					Failed		Update Request Ref.	
(600351-2000:600302-2000 (857619)) Carton section \ [986221-1400] Supply unit \ [2786400-0300] Cooling water system								
*3020859	Check	Check TPOP alarm / Deionizer cartridge			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	1000 Hours	Not Done Reason		Part Source	
2.7.2-1					Failed		Update Request Ref.	
(600351-2000:600302-2000 (857619)) Carton section \ [986221-1400] Supply unit \ [1551463-0300] Hydraulic system								
*3018416	Check	Check Oil			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	3000 Hours	Not Done Reason		Part Source	
2.7.3.1-3					Failed		Update Request Ref.	
1590255-0000		Sampling valve		TL	1			
*3018422	Change	Change oil filter			Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:15	2000 Hours	Not Done Reason		Part Source	CS
2.7.3.1-9					Failed		Update Request Ref.	
Part No		Part Description		MU/TL	Qty Required		Qty Used	
90459-3391		Filter Cartridge, 0165 R 010 BN3HC			1		1	
90459-6090		Filter Cartridge, 0060 D 020 BN4HC			1		1	
*3018428	Check	Check Pre-charge pressure WARNING! Do not charge accumulator if pressure is below 90 bar! In this case the part must be changed to avoid internal explosion, that will damage the machine.			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	1000 Hours	Not Done Reason		Part Source	
2.7.3.1-4					Failed		Update Request Ref.	
996373-0101		PRE-LOADING EQUIPMENT		TL	1			
(600351-2000:600302-2000 (857619)) Carton section \ [1469970-0300] Drive Unit Carton \ [986245-0600] Cam Modul cut & fold								
*3021751	Check	Check Side 1 Air cylinder / Link head			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	1000 Hours	Not Done Reason		Part Source	
2.2-1					Failed		Update Request Ref.	
3488500-0101		Service Tool		TL	1			

Maintenance Report				SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD		S002085513		
Task Code	Task Action	Task Description		Task Code in bold font indicates that the task has changed since the work order was created.				
Trade	Section	Motion Type	Duration	Interval				
Doc Ref				Last Done				
*3021769	Check	Check Side 2 Air cylinder / Link head		Done	Yes	Changed Part Condition		
ENGR	TP	Only when Stationary	0:10	1000 Hours	Not Done Reason		Part Source	
2.2-1				Failed		Update Request Ref.		
3488500-0101		Service Tool		TL	1			
(600351-2000:600302-2000 (857619)) Carton section \ [1025162-0700] Curve unit \ [977894-0800] Link arm \ [977892-0800] Link arm S1								
*18086061	Check	Check bearing		Done	Yes	Changed Part Condition		
ENGR	TP	Only when Stationary	0:05	1000 Hours	Not Done Reason		Part Source	
2.10.3-1				Failed		Update Request Ref.		
(600351-2000:600302-2000 (857619)) Carton section \ [1025162-0700] Curve unit \ [977894-0800] Link arm \ [1367891-0200] Link arm S2								
*18086065	Check	Check bearing		Done	Yes	Changed Part Condition		
ENGR	TP	Only when Stationary	0:05	1000 Hours	Not Done Reason		Part Source	
2.10.3-1				Failed		Update Request Ref.		
(600351-2000:600302-2000 (857619)) Carton section \ [2925230-0200] HEPA Unit \ [2888313-0200] Filter Housing S1								
*3021201	Change	Change HEPA filter		Done	No	Changed Part Condition		
ENGR	TP	Only when Stationary	0:30	3000 Hours	Not Done Reason	3	Part Source	
2.11-1; 6.2.6-1; 6.2.6-2				Failed		Update Request Ref.		
Part No	Part Description		MU/TL	Qty Required		Qty Used		
90600-3038	Filter, MX-457x457			1		0		
(600351-2000:600302-2000 (857619)) Carton section \ [2925230-0200] HEPA Unit \ [2895748-0200] Filter Housing S2								
*3021207	Change	Change HEPA filter		Done	No	Changed Part Condition		
ENGR	TP	Only when Stationary	0:30	3000 Hours	Not Done Reason	3	Part Source	
2.11-1; 6.2.6-1; 6.2.6-2				Failed		Update Request Ref.		
Part No	Part Description		MU/TL	Qty Required		Qty Used		
90600-3038	Filter, MX-457x457			1		0		
(600351-2000:600302-2000 (857619)) Carton section \ [3312083-0100] Cutting function S1 \ [3434618-0200] {Sprue Remover Unit} \ [3411304-0200] Brake unit \ [3411306-0200] Belt Drive S2 \ [3411311-0200] Upper section \ [3249496-0100] Adjusting roller								
*12725344	Check	Check bearing		Done	Yes	Changed Part Condition		
ENGR	TP	Only when Stationary	0:05	3000 Hours	Not Done Reason		Part Source	
2.14.3.2.1-6				Failed		Update Request Ref.		
(600351-2000:600302-2000 (857619)) Carton section \ [3312083-0100] Cutting function S1 \ [3434618-0200] {Sprue Remover Unit} \ [3411304-0200] Brake unit \ [3411307-0100] Belt Drive S1 \ [3411312-0100] Upper section \ [3249496-0100] Adjusting roller								
*12725344	Check	Check bearing		Done	Yes	Changed Part Condition		
ENGR	TP	Only when Stationary	0:05	3000 Hours	Not Done Reason		Part Source	
2.14.3.2.1-6				Failed		Update Request Ref.		
(600351-2000:600302-2000 (857619)) Carton section \ [3312083-0100] Cutting function S1 \ [3434618-0200] {Sprue Remover Unit} \ [3411304-0200] Brake unit \ [3411307-0100] Belt Drive S1 \ [3249609-0100] Lower section								
*13068280	Check	Check ball bearing		Done	Yes	Changed Part Condition		
ENGR	TP	Only when Stationary	0:05	3000 Hours	Not Done Reason		Part Source	
2.14.3.2.1-6				Failed		Update Request Ref.		

Maintenance Report				SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD		S002085513		
Task Code	Task Action	Task Description				Task Code in bold font indicates that the task has changed since the work order was created.		
Trade	Section	Motion Type	Duration	Interval				
Doc Ref							Last Done	
(600351-2000:600302-2000 (857619)) Carton section \ [3312083-0100] Cutting function S1 \ [3434618-0200] {Sprue Remover Unit} \ [3548655-0100] Pneumatic system								
*20353535	Change	Change Filter			Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:10	1000 Hours	Not Done Reason		Part Source	CS
2.14.3.5-2					Failed		Update Request Ref.	
Part No		Part Description		MU/TL	Qty Required		Qty Used	
90459-3814		C6-499, Filter Cartridge, MS4-LFP-E			1		1	
(600351-2000:600302-2000 (857619)) Carton section \ [3312083-0100] Cutting function S1 \ [3434618-0100] {Sprue Remover Unit} \ [3411304-0100] Brake unit \ [3411307-0100] Belt Drive S1 \ [3249609-0100] Lower section								
*13068280	Check	Check ball bearing			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	3000 Hours	Not Done Reason		Part Source	
2.14.3.2.1-6					Failed		Update Request Ref.	
(600351-2000:600302-2000 (857619)) Carton section \ [3312084-0100] Cutting function S2 \ [3434618-0200] {Sprue Remover Unit} \ [3411304-0200] Brake unit \ [3411306-0200] Belt Drive S2 \ [3411311-0200] Upper section \ [3249496-0100] Adjusting roller								
*12725344	Check	Check bearing			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	3000 Hours	Not Done Reason		Part Source	
2.14.3.2.1-6					Failed		Update Request Ref.	
(600351-2000:600302-2000 (857619)) Carton section \ [3312084-0100] Cutting function S2 \ [3434618-0200] {Sprue Remover Unit} \ [3411304-0200] Brake unit \ [3411307-0100] Belt Drive S1 \ [3411312-0100] Upper section \ [3249496-0100] Adjusting roller								
*12725344	Check	Check bearing			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	3000 Hours	Not Done Reason		Part Source	
2.14.3.2.1-6					Failed		Update Request Ref.	
(600351-2000:600302-2000 (857619)) Carton section \ [3312084-0100] Cutting function S2 \ [3434618-0200] {Sprue Remover Unit} \ [3411304-0200] Brake unit \ [3411307-0100] Belt Drive S1 \ [3249609-0100] Lower section								
*13068280	Check	Check ball bearing			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	3000 Hours	Not Done Reason		Part Source	
2.14.3.2.1-6					Failed		Update Request Ref.	
(600351-2000:600302-2000 (857619)) Carton section \ [3312084-0100] Cutting function S2 \ [3434618-0200] {Sprue Remover Unit} \ [3548655-0100] Pneumatic system								
*20353535	Change	Change Filter			Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:10	1000 Hours	Not Done Reason		Part Source	CS
					Failed		Update Request Ref.	
Part No		Part Description		MU/TL	Qty Required		Qty Used	
90459-3814		C6-499, Filter Cartridge, MS4-LFP-E			1		1	
(600351-2000:600302-2000 (857619)) Carton section \ [3312084-0100] Cutting function S2 \ [3434618-0100] {Sprue Remover Unit} \ [3411304-0100] Brake unit \ [3411306-0100] Belt Drive S2 \ [3411311-0100] Upper section \ [3249496-0100] Adjusting roller								
*12725344	Check	Check bearing			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	3000 Hours	Not Done Reason		Part Source	
2.14.3.2.1-6					Failed		Update Request Ref.	
(600351-2000:600302-2000 (857619)) Carton section \ [3312084-0100] Cutting function S2 \ [3434618-0100] {Sprue Remover Unit} \ [3411304-0100] Brake unit \ [3411307-0100] Belt Drive S1 \ [3411312-0100] Upper section \ [3249496-0100] Adjusting roller								
*12725344	Check	Check bearing			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	3000 Hours	Not Done Reason		Part Source	
2.14.3.2.1-6					Failed		Update Request Ref.	

Maintenance Report				SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD		S002085513	
Task Code	Task Action	Task Description		Task Code in bold font indicates that the task has changed since the work order was created.			
Trade	Section	Motion Type	Duration	Interval			
Doc Ref				Last Done			
(600351-2000:600302-2000 (857619)) Carton section \ [3312084-0100] Cutting function S2 \ [3434618-0100] {Sprue Remover Unit} \ [3411304-0100] Brake unit \ [3411307-0100] Belt Drive S1 \ [3249609-0100] Lower section							
*13068280	Check	Check ball bearing		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	3000 Hours	Not Done Reason	Part Source	
2.14.3.2.1-6				Failed		Update Request Ref.	
(600351-2000:600311-0400 (857625)) LFU \ [600311-0400] LFU							
*3023563	Check	Check Status check of LFU. S1		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:30	1000 Hours	Not Done Reason	Part Source	
3.15.3-2 / 3.2-2				Failed		Update Request Ref.	
*3023575	Check	Check Status check of LFU. S2		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:30	1000 Hours	Not Done Reason	Part Source	
3.15.3-2 / 3.2-2				Failed		Update Request Ref.	
*3023599	Remove	Remove Side 1 Take out the unit to its service position and put it back to its production position after that the service have been performed.		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	2:30	3000 Hours	Not Done Reason	Part Source	
3.2-5				Failed		Update Request Ref.	
915399-0201		Rail	TL	1			
*3023605	Remove	Remove Side 2 Take out the unit to its service position and put it back to its production position after that the service have been performed.		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	2:30	3000 Hours	Not Done Reason	Part Source	
3.2-5				Failed		Update Request Ref.	
915399-0201		Rail	TL	1			
*8918490	Set	Set LFU Side 1		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	3:00	3000 Hours	Not Done Reason	Part Source	
3.2-2				Failed		Update Request Ref.	
*8918492	Set	Set LFU Side 2		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	3:00	3000 Hours	Not Done Reason	Part Source	
3.2-2				Failed		Update Request Ref.	
(600351-2000:600311-0400 (857625)) LFU \ [1551358-0400] LFU S1 \ [1551360-0400] Supply Unit S1 \ [1551381-0300] Valve Ramp Unit - Hydraulic S1 \ [1551379-0300] Accumulator unit S1							
*3018073	Change	Change Accumulator		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:30	3000 Hours	Not Done Reason	Part Source	
3.14.3-15				Failed		Update Request Ref.	
Part No		Part Description	MU/TL	Qty Required		Qty Used	
2826272-0000		Accumulation Unit		1		1	
90459-2873		Nipple, ext thread,hexagon, G3/4 - G3/4		1		1	
*8852692	Change	Change Check-valve		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:20	4000 Hours	Not Done Reason	Part Source	
3.14.3-8				Failed		Update Request Ref.	
Part No		Part Description	MU/TL	Qty Required		Qty Used	
90459-2874		Check Valve, RKVE-04		1		1	
2838500-0000		KEY	TL	1			

Maintenance Report					SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD		S002085513	
Task Code	Task Action	Task Description		Task Code in bold font indicates that the task has changed since the work order was created.				
Trade	Section	Motion Type	Duration	Interval				
Doc Ref				Last Done				
(600351-2000:600311-0400 (857625)) LFU \ [1551358-0400] LFU S1 \ [1551360-0400] Supply Unit S1 \ [1551367-0300] Pipe work - Hydraulic S1								
*12564936	Check	Check Pipe Work Hydraulic Small movement S1			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:20	1000 Hours	Not Done Reason		Part Source	
3.14.3-2					Failed		Update Request Ref.	
*12564930	Check	Check Pipe Work Hydraulic Large movement S1			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:20	1000 Hours	Not Done Reason		Part Source	
3.14.3-2					Failed		Update Request Ref.	
(600351-2000:600311-0400 (857625)) LFU \ [1551358-0400] LFU S1 \ [1551360-0400] Supply Unit S1 \ [1551385-0200] Lubricating system S1								
*9495501	Check	Check Leakage / Damage			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	1000 Hours	Not Done Reason		Part Source	
3.14.2-1					Failed		Update Request Ref.	
(600351-2000:600311-0400 (857625)) LFU \ [1551358-0400] LFU S1 \ [1551389-0400] Mandrel group S1 \ [1551396-0400] Bearing housing S1								
*3018109	Check	Check Oil leakage			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:03	1000 Hours	Not Done Reason		Part Source	
3.3.1-2					Failed		Update Request Ref.	
(600351-2000:600311-0400 (857625)) LFU \ [1551358-0400] LFU S1 \ [1551401-0300] Hanger S1 tool \ [1551387-0300] Hanger S1 tool								
*3018085	Change	Change Distance cylinder			Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:15	3000 Hours	Not Done Reason		Part Source	
3.4.1-2					Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required		Qty Used		
2811633-0000	Cylinder			2		2		
312105-0463	Bolt, M8x60 A4 80 ISO4014			4		4		
351523-0216	O-ring, 22.20x3.00mm FKM-80A			2		2		
1573180-0000	Puller		TL	1				
1573181-0000	Puller		TL	1				
351532-0050	Threadlocker Loctite 2400 50 ml		TL	1				
(600351-2000:600311-0400 (857625)) LFU \ [1551358-0400] LFU S1 \ [1551406-0300] Drive S1 tool								
*16347618	Change	Change timing belt 600351-2000 Valid for serial numbers from 63202/20089			Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:30	3000 Hours	Not Done Reason		Part Source	
3.10-2					Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required		Qty Used		
90459-1110	Timing belt, AT10 1320.0/32.0mm			2		2		
(600351-2000:600311-0400 (857625)) LFU \ [1551358-0400] LFU S1 \ [1551408-0400] Motor unit S1								
*14560808	Change	Change Drive belt 600351-2000 Valid for serial numbers from 63202/20089			Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	1:30	3000 Hours	Not Done Reason		Part Source	
3.11-4 / -3					Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required		Qty Used		
90606-2436	Timing belt, AT10 780.0/50.0mm			1		1		

Maintenance Report				SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD		S002085513	
Task Code	Task Action	Task Description		Task Code in bold font indicates that the task has changed since the work order was created.			
Trade	Section	Motion Type	Duration	Interval			
Doc Ref				Last Done			
(600351-2000:600311-0400 (857625)) LFU \ [1551358-0400] LFU S1 \ [1551410-0200] Guide steering S1 Verti							
*204190	Check	Check Sliding strip		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:30	3000 Hours	Not Done Reason	Part Source	
3.3.1-3				Failed		Update Request Ref.	
(600351-2000:600311-0400 (857625)) LFU \ [1551358-0400] LFU S1 \ [1551412-0300] Hot Channel S1							
*4185493	Check	Check heating element		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	1000 Hours	Not Done Reason	Part Source	
3.8.1-1				Failed		Update Request Ref.	
(600351-2000:600311-0400 (857625)) LFU \ [1551358-0400] LFU S1 \ [1551412-0300] Hot Channel S1 \ [1551414-0300] Guide S1 hot channel							
*3018187	Change	Change Distance cylinder		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:30	3000 Hours	Not Done Reason	Part Source	
3.8.2-2				Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required		Qty Used	
3119886-0000	Cylinder			2		2	
312105-0467	Bolt, M8x80 A4 80 ISO4014			4		4	
315211-0108	250R-170-72, Bonded Seal SS/NBR90 G1/4			4		4	
(600351-2000:600311-0400 (857625)) LFU \ [1551358-0400] LFU S1 \ [1551420-0300] Pressing unit S1 horis							
*3018277	Change	Change Locking cylinder		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:15	1000 Hours	Not Done Reason	Part Source	
3.6-3				Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required		Qty Used	
342722-0197	Straight Coupling			2		2	
90604-3129	Round cylinder, DSNU 16x25mm			1		1	
*18655234	Check	Check beam		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	3000 Hours	Not Done Reason	Part Source	
3.6-6				Failed		Update Request Ref.	
*8842797	Change	Change Scissors Bushings		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:15	3000 Hours	Not Done Reason	Part Source	
3.6-5				Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required		Qty Used	
1565340-0000	Spacer			1		1	
344270-0302	Flange bushing, 20.00x26.00x15.00mm			2		2	
(600351-2000:600311-0400 (857625)) LFU \ [1551358-0400] LFU S1 \ [1551422-0300] Reference stop S1							
*11466655	Change	Change Washers		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	1000 Hours	Not Done Reason	Part Source	
3.2-2				Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required		Qty Used	
2986074-0000	Washer			4		4	

Maintenance Report		SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD				S002085513	
Task Code	Task Action	Task Description Task Code in bold font indicates that the task has changed since the work order was created.					
Trade	Section	Motion Type	Duration	Interval			
Doc Ref				Last Done			
*3018331	Change	Change cylinder / Stop		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	1:30	3000 Hours	Not Done Reason	Part Source	
3.7-2				Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required	Qty Used		
2655523-0000	Shock Absorber			4	4		
2956633-0000	Cylinder			2	2		
2986074-0000	Washer			4	4		
2986075-0000	Washer			4	4		
312105-0505	Bolt, M10x70 A4 80 ISO4014			4	4		
351523-0216	O-ring, 22.20x3.00mm FKM-80A			2	2		
(600351-2000:600311-0400 (857625)) LFU \ [1551358-0400] LFU S1 \ [1551424-0300] Transfer unit S1 \ [1551451-0200] Transfer unit S1							
*3018397	Check	Check TransferUnit		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	3000 Hours	Not Done Reason	Part Source	
3.9.2-1				Failed		Update Request Ref.	
(600351-2000:600311-0400 (857625)) LFU \ [1551358-0400] LFU S1 \ [1551431-0300] Stripper S1							
*8946187	Check	Check Stripper		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	2000 Hours	Not Done Reason	Part Source	
3.12.2-1				Failed		Update Request Ref.	
(600351-2000:600311-0400 (857625)) LFU \ [1551359-0400] LFU S2 \ [1551361-0400] Supply System S2 \ [1551382-0300] Valve Ramp Unit - Hydraulic S2 \ [1551380-0300] Accumulator unit S2							
*3018079	Change	Change Accumulator		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:30	3000 Hours	Not Done Reason	Part Source	CS
3.14.3-15				Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required	Qty Used		
2826272-0000	Accumulation Unit			1	1		
90459-2873	Nipple, ext thread,hexagon, G3/4 - G3/4			1	1		
*8852694	Change	Change Check-valve		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:20	4000 Hours	Not Done Reason	Part Source	CS
3.14.3-8				Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required	Qty Used		
90459-2874	Check Valve, RKVE-04			1	1		
2838500-0000	KEY		TL	1			
(600351-2000:600311-0400 (857625)) LFU \ [1551359-0400] LFU S2 \ [1551361-0400] Supply System S2 \ [1551368-0300] Pipe work - Hydraulic S2							
*12564991	Check	Check Pipe Work Hydraulic Small movement S2		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:20	1000 Hours	Not Done Reason	Part Source	
3.14.3-2				Failed		Update Request Ref.	
*12564985	Check	Check Pipe Work Hydraulic Large movement S2		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:20	1000 Hours	Not Done Reason	Part Source	
3.14.3-2				Failed		Update Request Ref.	

Maintenance Report				SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD		S002085513	
Task Code	Task Action	Task Description Task Code in bold font indicates that the task has changed since the work order was created.					
Trade	Section	Motion Type	Duration	Interval			
Doc Ref	Last Done						
(600351-2000:600311-0400 (857625)) LFU \ [1551359-0400] LFU S2 \ [1551361-0400] Supply System S2 \ [1551386-0200] Lubricating system S2							
*9495504	Check	Check Leakage / Damage		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	1000 Hours	Not Done Reason	Part Source	
3.14.2-1				Failed		Update Request Ref.	
(600351-2000:600311-0400 (857625)) LFU \ [1551359-0400] LFU S2 \ [1551390-0400] Mandrel group S2 \ [1551397-0400] Bearing housing S2							
*3018121	Check	Check Oil leakage		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:03	1000 Hours	Not Done Reason	Part Source	
3.3.1-2				Failed		Update Request Ref.	
(600351-2000:600311-0400 (857625)) LFU \ [1551359-0400] LFU S2 \ [1551402-0300] Hanger S2 tool \ [1551388-0300] Hanger S2 tool							
*3018097	Change	Change Distance cylinder		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:15	3000 Hours	Not Done Reason	Part Source	CS
3.4.1-2				Failed		Update Request Ref.	
Part No	Part Description			MU/TL	Qty Required	Qty Used	
2811633-0000	Cylinder				2	2	
312105-0463	Bolt, M8x60 A4 80 ISO4014				4	4	
351523-0216	O-ring, 22.20x3.00mm FKM-80A				2	2	
1573180-0000	Puller			TL	1		
1573181-0000	Puller			TL	1		
351532-0050	Threadlocker Loctite 2400 50 ml			TL	1		
(600351-2000:600311-0400 (857625)) LFU \ [1551359-0400] LFU S2 \ [1551407-0300] Drive S2 tool							
*16347625	Change	Change timing belt 600351-2000 Valid for serial numbers from 63202/20089		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:30	3000 Hours	Not Done Reason	Part Source	CS
3.10-2				Failed		Update Request Ref.	
Part No	Part Description			MU/TL	Qty Required	Qty Used	
90459-1110	Timing belt, AT10 1320.0/32.0mm				2	2	
(600351-2000:600311-0400 (857625)) LFU \ [1551359-0400] LFU S2 \ [1551409-0400] Motor unit S2							
*14560812	Change	Change Drive belt 600351-2000 Valid for serial numbers from 63202/20089		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	1:30	3000 Hours	Not Done Reason	Part Source	CS
3.11-4 / -3				Failed		Update Request Ref.	
Part No	Part Description			MU/TL	Qty Required	Qty Used	
90606-2436	Timing belt, AT10 780.0/50.0mm				1	1	
(600351-2000:600311-0400 (857625)) LFU \ [1551359-0400] LFU S2 \ [1551411-0200] Guide steering S2 Verti							
*204224	Check	Check Sliding strip		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:30	3000 Hours	Not Done Reason	Part Source	
3.3.1-3				Failed		Update Request Ref.	
(600351-2000:600311-0400 (857625)) LFU \ [1551359-0400] LFU S2 \ [1551413-0300] Hot Channel S2							
*4185493AA	Check	Check heating element		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	1000 Hours	Not Done Reason	Part Source	
3.8.1-1				Failed		Update Request Ref.	

Maintenance Report				SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD		S002085513	
Task Code	Task Action	Task Description Task Code in bold font indicates that the task has changed since the work order was created.					
Trade	Section	Motion Type	Duration	Interval			
Doc Ref				Last Done			
(600351-2000:600311-0400 (857625)) LFU \ [1551359-0400] LFU S2 \ [1551413-0300] Hot Channel S2 \ [1551415-0300] Guide S2 hot channel							
*3018205	Change	Change Distance cylinder		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:30	3000 Hours	Not Done Reason	Part Source	CS
3.8.2-2				Failed		Update Request Ref.	
Part No		Part Description		MU/TL	Qty Required		Qty Used
3119886-0000		Cylinder			2		2
312105-0467		Bolt, M8x80 A4 80 ISO4014			4		4
315211-0108		250R-170-72, Bonded Seal SS/NBR90 G1/4			4		4
(600351-2000:600311-0400 (857625)) LFU \ [1551359-0400] LFU S2 \ [1551421-0300] Pressing unit S2 horis							
*3018307	Change	Change Locking cylinder		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:15	1000 Hours	Not Done Reason	Part Source	CS
3.6-3				Failed		Update Request Ref.	
Part No		Part Description		MU/TL	Qty Required		Qty Used
342722-0197		Straight Coupling			2		2
90604-3129		Round cylinder, DSNU 16x25mm			1		1
*18711944	Check	Check beam		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	3000 Hours	Not Done Reason	Part Source	
3.6-6				Failed		Update Request Ref.	
*8842799	Change	Change Scissors Bushings		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:15	3000 Hours	Not Done Reason	Part Source	CS
3.6-5				Failed		Update Request Ref.	
Part No		Part Description		MU/TL	Qty Required		Qty Used
1565340-0000		Spacer			1		1
344270-0302		Flange bushing, 20.00x26.00x15.00mm			2		2
(600351-2000:600311-0400 (857625)) LFU \ [1551359-0400] LFU S2 \ [1551423-0300] Reference stop S2							
*11466657	Change	Change Washers		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:10	1000 Hours	Not Done Reason	Part Source	CS
3.2-2				Failed		Update Request Ref.	
Part No		Part Description		MU/TL	Qty Required		Qty Used
2986074-0000		Washer			4		4
*3018343	Change	Change cylinder / Stop		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	1:30	3000 Hours	Not Done Reason	Part Source	CS
3.7-2				Failed		Update Request Ref.	
Part No		Part Description		MU/TL	Qty Required		Qty Used
2655523-0000		Shock Absorber			4		4
2956633-0000		Cylinder			2		2
2986074-0000		Washer			4		4
2986075-0000		Washer			4		4
312105-0505		Bolt, M10x70 A4 80 ISO4014			4		4
351523-0216		O-ring, 22.20x3.00mm FKM-80A			2		2

Maintenance Report				SEC-UPFIELD HEL-327-8 \ 63202\20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD		S002085513	
Task Code	Task Action	Task Description		Task Code in bold font indicates that the task has changed since the work order was created.			
Trade	Section	Motion Type	Duration	Interval			
Doc Ref				Last Done			
(600351-2000:600311-0400 (857625)) LFU \ [1551359-0400] LFU S2 \ [1551425-0300] Transfer unit S2 \ [1551452-0200] Transfer unit S2							
*3018404	Check	Check TransferUnit		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	3000 Hours	Not Done Reason	Part Source	
3.9.2-1				Failed		Update Request Ref.	
(600351-2000:600311-0400 (857625)) LFU \ [1551359-0400] LFU S2 \ [2758442-0200] Stripper S2							
*8946670	Check	Check Stripper		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	2000 Hours	Not Done Reason	Part Source	
3.12.2-1				Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [915313-0900] Conveying equipment S1 \ [982042-1000] Cassette S1							
*3021619	Check	Check Cassette Link / shaft		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:40	3000 Hours	Not Done Reason	Part Source	
5.2.3-3				Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [915313-0900] Conveying equipment S1 \ [571337-0700] Package guide S1							
*3021345	Change	Change Package guide cylinder		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:45	3000 Hours	Not Done Reason	Part Source	
5.2.4.2-3 / -4 / -5				Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required		Qty Used	
90600-4859	Seal Kit, DKL11150-K-001			4		4	
(600351-2000:600303-2000 (857620)) Package section \ [915316-0900] Conveying equipment S2 \ [1469923-0700] Cassette S2							
*3017971	Check	Check Cassette Link / shaft		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:40	3000 Hours	Not Done Reason	Part Source	
5.2.3-3				Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [915316-0900] Conveying equipment S2 \ [1469716-0400] Package guide S2							
*3017905	Change	Change Package guide cylinder		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:45	3000 Hours	Not Done Reason	Part Source	
5.2.4.2-3 / -4 / -5				Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required		Qty Used	
90600-4859	Seal Kit, DKL11150-K-001			4		4	
(600351-2000:600303-2000 (857620)) Package section \ [2532721-0300] Bottom Seal S1							
*3018728	Check	Check Lubrication hose / Air hose / Loosen screws / Wear		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:30	1000 Hours	Not Done Reason	Part Source	
No Reference 5.3.				Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [2532721-0300] Bottom Seal S1 \ [2633200-0200] Frame S1							
*3020799	Change	Change seal & Turn 2 Shafts 10 Degrees		Done	No	Changed Part Condition	
ENGR	TP	Only when Stationary	1:30	4000 Hours	Not Done Reason	9 Part Source	
5.3.6-4				Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required		Qty Used	
315206-0606	O-ring, 56.74x3.53mm EPDM-70A			3		0	
315206-0805	O-ring, 53.70x1.78mm EPDM-70A			2		0	
90459-3210	Seal, D30.0xW8.0mm NBR			5		0	

Maintenance Report				SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD		S002085513	
Task Code	Task Action	Task Description		Task Code in bold font indicates that the task has changed since the work order was created.			
Trade	Section	Motion Type	Duration	Interval			
Doc Ref				Last Done			
(600351-2000:600303-2000 (857620)) Package section \ [2532721-0300] Bottom Seal S1 \ [2633192-0300] Sonotrode unit S1:1							
*3020769	Turn	Turn Sonotrode unit		Done	No	Changed Part Condition	
ENGR	TP	Only when Stationary	1:00	4000 Hours	Not Done Reason	9	Part Source
5.3.6-6 / -7				Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required		Qty Used	
90609-7372	O-ring, 63.00x2.00mm NBR-70A			2		0	
3549863-0000	Tool		TL	1			
(600351-2000:600303-2000 (857620)) Package section \ [2532721-0300] Bottom Seal S1 \ [2581977-0300] Sonotrode Unit S1:2							
*3018843	Turn	Turn Sonotrode unit		Done	No	Changed Part Condition	
ENGR	TP	Only when Stationary	1:00	4000 Hours	Not Done Reason	9	Part Source
5.3.6-6 / -7				Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required		Qty Used	
90609-7372	O-ring, 63.00x2.00mm NBR-70A			2		0	
(600351-2000:600303-2000 (857620)) Package section \ [2565786-0300] Bottom Seal S2							
*3018782	Check	Check Lubrication hose / Air hose / Loosen screws / Wear		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:30	1000 Hours	Not Done Reason		Part Source
No Reference 5.3.				Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [2565786-0300] Bottom Seal S2 \ [2633201-0200] Frame S2							
*3020805	Change	Change seal & Turn 2 Shafts 10 Degrees		Done	No	Changed Part Condition	
ENGR	TP	Only when Stationary	1:30	4000 Hours	Not Done Reason	9	Part Source
5.3.6-4				Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required		Qty Used	
315206-0606	O-ring, 56.74x3.53mm EPDM-70A			3		0	
315206-0805	O-ring, 53.70x1.78mm EPDM-70A			2		0	
90459-3210	Seal, D30.0xW8.0mm NBR			5		0	
(600351-2000:600303-2000 (857620)) Package section \ [2565786-0300] Bottom Seal S2 \ [2633193-0300] Sonotrode unit S2:1							
*3020781	Turn	Turn Sonotrode unit		Done	No	Changed Part Condition	
ENGR	TP	Only when Stationary	1:00	4000 Hours	Not Done Reason	9	Part Source
5.3.6-6 / -7				Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required		Qty Used	
90609-7372	O-ring, 63.00x2.00mm NBR-70A			2		0	
3549863-0000	Tool		TL	1			
(600351-2000:600303-2000 (857620)) Package section \ [2565786-0300] Bottom Seal S2 \ [2633194-0300] Sonotrode Unit S2:2							
*3020793	Turn	Turn Sonotrode unit		Done	No	Changed Part Condition	
ENGR	TP	Only when Stationary	1:00	4000 Hours	Not Done Reason	9	Part Source
5.3.6-6 / -7				Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required		Qty Used	
90609-7372	O-ring, 63.00x2.00mm NBR-70A			2		0	
3549863-0000	Tool		TL	1			

Maintenance Report			SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD			S002085513			
Task Code	Task Action	Task Description					Task Code in bold font indicates that the task has changed since the work order was created.		
Trade	Section	Motion Type	Duration	Interval					
Doc Ref						Last Done			
(600351-2000:600303-2000 (857620)) Package section \ [571376-0800] Outfeed Unit S1 \ [982047-0500] Discharger S1									
*9568371	Check	Check Link heads				Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	1000 Hours		Not Done Reason		Part Source	
5.5.2-13						Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [571376-0800] Outfeed Unit S1 \ [982048-0800] Pusher S1									
*3021703	Check	Check Pusher				Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	2000 Hours		Not Done Reason		Part Source	
5.5.4-1						Failed		Update Request Ref.	
3488500-0101		Service Tool		TL		1			
(600351-2000:600303-2000 (857620)) Package section \ [571376-0800] Outfeed Unit S1 \ [571364-0700] Ejecting device S1									
*3021399	Check	Check Ejecting device				Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	2000 Hours		Not Done Reason		Part Source	
5.5.3-1						Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [571376-0800] Outfeed Unit S1 \ [571377-0400] Guiding plate S1									
*8236654	Change	Change Outfeed unit Guiding Plate Bushing S1				Done	No	Changed Part Condition	
ENGR	TP	Only when Stationary	1:15	3000 Hours		Not Done Reason	9	Part Source	
5.5.2-10 / -4						Failed		Update Request Ref.	
Part No		Part Description		MU/TL		Qty Required		Qty Used	
315202-0803		O-ring, 44.17x1.78mm NBR-70A				4		0	
90240-0293		Flange bushing, 25.00x28.00x21.00mm				4		0	
90603-1093		Rotating seal, 25.0/32.5mm TURCON T40				4		0	
(600351-2000:600303-2000 (857620)) Package section \ [1469995-0500] Outfeed Unit S2 \ [1371037-0300] Discharger S2									
*9568379	Check	Check Link heads				Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	1000 Hours		Not Done Reason		Part Source	
5.5.2-13						Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [1469995-0500] Outfeed Unit S2 \ [1371038-0400] Pusher S2									
*3017647	Check	Check Pusher				Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	2000 Hours		Not Done Reason		Part Source	
5.5.4-1						Failed		Update Request Ref.	
3488500-0101		Service Tool		TL		1			
(600351-2000:600303-2000 (857620)) Package section \ [1469995-0500] Outfeed Unit S2 \ [1469998-0400] Ejecting device S2									
*3018013	Check	Check Ejecting device				Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	2000 Hours		Not Done Reason		Part Source	
5.5.3-1						Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [1469995-0500] Outfeed Unit S2 \ [1371036-0200] Guiding plate S2									
*8236656	Change	Change Outfeed unit Guiding Plate Bushing S2				Done	No	Changed Part Condition	
ENGR	TP	Only when Stationary	1:15	3000 Hours		Not Done Reason	9	Part Source	
5.5.2-10 / -4						Failed		Update Request Ref.	
Part No		Part Description		MU/TL		Qty Required		Qty Used	
315202-0803		O-ring, 44.17x1.78mm NBR-70A				4		0	
90240-0293		Flange bushing, 25.00x28.00x21.00mm				4		0	
90603-1093		Rotating seal, 25.0/32.5mm TURCON T40				4		0	

Maintenance Report				SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD		S002085513	
Task Code	Task Action	Task Description	Task Code in bold font indicates that the task has changed since the work order was created.				
Trade	Section	Motion Type	Duration	Interval			
Doc Ref	Last Done						
(600351-2000:600303-2000 (857620)) Package section \ [982041-1300] Hygiene chamber \ [571362-0900] Hygiene Chamber Lower S1 \ [915312-0700] Photocell unit S1							
*3021583	Check	Check Photocell unit		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	1000 Hours	Not Done Reason	Part Source	
5.6.5-1				Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [982041-1300] Hygiene chamber \ [1368144-0500] Hygiene Chamber Lower S2 \ [1368152-0300] Photocell unit S2							
*3017605	Check	Check Photocell unit		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	1000 Hours	Not Done Reason	Part Source	
5.6.5-1				Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [982041-1300] Hygiene chamber \ [571352-1000] Hygiene Chamber Upper S1 \ [1469424-0500] UV Lamp S1							
*3017749	Check	Check Intensity		Done	No	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	1000 Hours	Not Done Reason	Part Source	
5.6.2-1 / -2				Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [982041-1300] Hygiene chamber \ [571352-1000] Hygiene Chamber Upper S1 \ [1185148-0500] Cassette centering S1							
*4819069	Change	Change cylinder		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	1:00	3000 Hours	Not Done Reason	Part Source	
5.6.4.1-4				Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required	Qty Used		
312155-0331	Screw, Hex socket Flat M5x20 A4			2	2		
90287-0190	Socket screw, M5x65 DIN912			4	4		
90602-9870	Double acting, Compact, cyl 25-40			2	2		
(600351-2000:600303-2000 (857620)) Package section \ [982041-1300] Hygiene chamber \ [1368145-0600] Hygiene Chamber Upper S2 \ [1469935-0500] UV Lamp S2							
*3018001	Check	Check Intensity		Done	No	Changed Part Condition	
ENGR	TP	Only when Stationary	0:10	1000 Hours	Not Done Reason	Part Source	
5.6.2-1 / -2				Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [982041-1300] Hygiene chamber \ [1368145-0600] Hygiene Chamber Upper S2 \ [1368150-0300] Cassette centering S2							
*4819071	Change	Change cylinder		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	1:00	3000 Hours	Not Done Reason	Part Source	CS
5.6.4.1-4				Failed		Update Request Ref.	
Part No	Part Description		MU/TL	Qty Required	Qty Used		
312155-0331	Screw, Hex socket Flat M5x20 A4			2	2		
90287-0190	Socket screw, M5x65 DIN912			4	4		
90602-9870	Double acting, Compact, cyl 25-40			2	2		
(600351-2000:600303-2000 (857620)) Package section \ [982041-1300] Hygiene chamber \ [2887539-0200] Pump unit							
*4167800	Clean	Clean gasket		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:20	3000 Hours	Not Done Reason	Part Source	
5.6.7-2				Failed		Update Request Ref.	

Maintenance Report				SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD		S002085513	
Task Code	Task Action	Task Description		Task Code in bold font indicates that the task has changed since the work order was created.			
Trade	Section	Motion Type	Duration	Interval			
Doc Ref				Last Done			
(600351-2000:600303-2000 (857620)) Package section \ [982044-0700] Cassette lifter							
*3021625	Check	Check Side 1 Cassette lifter filling Fork / Sealing		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:06	1000 Hours	Not Done Reason	Part Source	
5.8.1-1				Failed		Update Request Ref.	
*3021649	Check	Check Side 2 Cassette lifter filling Fork / Sealing		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:06	1000 Hours	Not Done Reason	Part Source	
5.8.1-1				Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [2581969-0200] Cassette lifter							
*3018813	Check	Check Side 1 Sealing		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:06	1000 Hours	Not Done Reason	Part Source	
5.3.8-1				Failed		Update Request Ref.	
*3018825	Check	Check Side 2 Sealing		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:06	1000 Hours	Not Done Reason	Part Source	
5.3.8-1				Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [2581970-0200] Cassette lifter S1 \ [2564618-0200] Volume displacement S1							
*3018776	Change	Change Volume displacer seal		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	1:00	3000 Hours	Not Done Reason	Part Source	
5.3.9-5 / -3				Failed		Update Request Ref.	
Part No		Part Description		MU/TL	Qty Required		Qty Used
90600-4859		Seal Kit, DKL11150-K-001			4		4
(600351-2000:600303-2000 (857620)) Package section \ [2565787-0200] Cassette lifter S2 \ [2658236-0200] Volume displacement S2							
*3020847	Change	Change Volume displacer seal		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	1:00	3000 Hours	Not Done Reason	Part Source	
5.3.9-5 / -3				Failed		Update Request Ref.	
Part No		Part Description		MU/TL	Qty Required		Qty Used
90600-4859		Seal Kit, DKL11150-K-001			4		4
(600351-2000:600303-2000 (857620)) Package section \ [1567299-0200] Servo lifter filling S1							
*3018434	Check	Check Belt / ball bearing Filling		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	1000 Hours	Not Done Reason	Part Source	
5.9.3-1				Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [1567459-0200] Servo lifter filling S2							
*3018488	Check	Check Belt / ball bearing Filling		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	1000 Hours	Not Done Reason	Part Source	
5.9.3-1				Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [1567413-0200] Servo lifter sealing S1							
*3018458	Check	Check Belt / ball bearing Sealing		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	1000 Hours	Not Done Reason	Part Source	
5.9.1-1				Failed		Update Request Ref.	

Maintenance Report		SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD				S002085513	
Task Code	Task Action	Task Description		Task Code in bold font indicates that the task has changed since the work order was created.			
Trade	Section	Motion Type	Duration	Interval			
Doc Ref				Last Done			
(600351-2000:600303-2000 (857620)) Package section \ [1567414-0200] Servo lifter sealing S2							
*3018470	Check	Check Belt / ball bearing Sealing		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	1000 Hours	Not Done Reason	Part Source	
5.9.1-1				Failed		Update Request Ref.	
(600351-2000:600303-2000 (857620)) Package section \ [1567409-0200] Servo lifter discharger							
*18748654	Change	Change Belt		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	1:40	3000 Hours	Not Done Reason	Part Source	
5.9.2-2				Failed		Update Request Ref.	
Part No		Part Description		MU/TL	Qty Required		Qty Used
344226-0104		Ball bearing, 20.00x47.00x14.00mm			8		8
90459-1734		Timing belt, AT5 975.0/50.0mm			2		2
(600351-2000:600303-2000 (857620)) Package section \ [982045-0600] Volume change S1							
*3021667	Check	Check cylinder		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	3000 Hours	Not Done Reason	Part Source	
5.11.1-2				Failed		Update Request Ref.	
3488500-0101		Service Tool		TL	1		
(600351-2000:600303-2000 (857620)) Package section \ [1469860-0400] Volume change S2							
*3017959	Check	Check cylinder		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:05	3000 Hours	Not Done Reason	Part Source	
5.11.1-2				Failed		Update Request Ref.	
3488500-0101		Service Tool		TL	1		
(600351-2000:600304-2000 (857621)) Filling section \ [1298977-0500] Filling section \ [986308-0900] Machine body \ [1105831-0300] Cleaning Cantilever \ [1469485-0200] Cleaning box S1							
*19929947	Check	Check gasket - (Pos 140)		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:20	2000 Hours	Not Done Reason	Part Source	
No Reference 6.3.2-3				Failed		Update Request Ref.	
(600351-2000:600304-2000 (857621)) Filling section \ [1298977-0500] Filling section \ [986308-0900] Machine body \ [1105831-0300] Cleaning Cantilever \ [1469486-0200] Cleaning box S2							
*19987987	Check	Check gasket - (Pos 140)		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:20	2000 Hours	Not Done Reason	Part Source	
No Reference 6.3.2-3				Failed		Update Request Ref.	
(600351-2000:600304-2000 (857621)) Filling section \ [1298977-0500] Filling section \ [986269-0900] Supply system \ [986282-0900] Pneumatic supply \ [3395507-0100] Pneumatic supply							
*20198846	Change	Change Filter		Done	Yes	Changed Part Condition	2
ENGR	TP	Only when Stationary	0:05	4000 Hours	Not Done Reason	Part Source	CS
6.6.1-2				Failed		Update Request Ref.	
Part No		Part Description		MU/TL	Qty Required		Qty Used
90603-2381		Filter, MS9-LF-G-EUV			1		1
(600351-2000:600304-2000 (857621)) Filling section \ [1298977-0500] Filling section \ [1025115-0800] Granulate inlet \ [1025040-0700] Granulate hopper							
*11202345	Clean	Clean Granulate hopper Filter		Done	Yes	Changed Part Condition	
ENGR	TP	Only when Stationary	0:20	2000 Hours	Not Done Reason	Part Source	
No Reference 6.7- / 9.1-1				Failed		Update Request Ref.	

Maintenance Report				SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD		S002085513	
Task Code	Task Action	Task Description		Task Code in bold font indicates that the task has changed since the work order was created.			
Trade	Section	Motion Type	Duration	Interval			
Doc Ref				Last Done			
4 After-Maintenance Checks: (9000216560) TT/3-200V MINI TAISHAN A38 HAAD \ [600351-2000] TETRA TOP TT/3							
*3021513	Check	Check Door guard/emergency stop		Done	Yes	Changed Part Condition	
ENGR	TP	Only when In Motion	0:10	1000 Hours	Not Done Reason	Part Source	
10.5.4-1 / -5 / 11.7-1				Failed		Update Request Ref.	
*3021512	Check	Check Run machine. Check function. If machine does not function correctly, inform supervisor before continuing.		Done	Yes	Changed Part Condition	
ENGR	TP	Only when In Motion	1:00	1000 Hours	Not Done Reason	Part Source	
OM 4				Failed		Update Request Ref.	
*3021511	Check	Check Side 1 Package check - Check package according to recommendation in Operation Manual.		Done	Yes	Changed Part Condition	
ENGR	TP	Only when In Motion	0:05	1000 Hours	Not Done Reason	Part Source	
OM PC				Failed		Update Request Ref.	
*3021510	Check	Check Side 2 Package check - Check package according to recommendation in Operation Manual.		Done	Yes	Changed Part Condition	
ENGR	TP	Only when In Motion	0:05	1000 Hours	Not Done Reason	Part Source	
OM PC				Failed		Update Request Ref.	
4 After-Maintenance Checks: (600351-2000:600304-2000 (857621)) Filling section \ [1298977-0500] Filling section \ [986308-0900] Machine body \ [1105831-0300] Cleaning Cantilever \ [1469485-0200] Cleaning box S1							
*129941	Check	Check Side 1 Fill system; Ensure that the fill nozzles close properly during filling without dripping and that product does not splash on the nozzles. The volume must be correct and not fluctuating.		Done	Yes	Changed Part Condition	
ENGR	TP	Only when In Motion	0:05	1000 Hours	Not Done Reason	Part Source	
OM 8				Failed		Update Request Ref.	
4 After-Maintenance Checks: (600351-2000:600304-2000 (857621)) Filling section \ [1298977-0500] Filling section \ [986308-0900] Machine body \ [1105831-0300] Cleaning Cantilever \ [1469486-0200] Cleaning box S2							
*129943	Check	Check Side 2 Fill system; Ensure that the fill nozzles close properly during filling without dripping and that product does not splash on the nozzles. The volume must be correct and not fluctuating.		Done	Yes	Changed Part Condition	
ENGR	TP	Only when In Motion	0:05	1000 Hours	Not Done Reason	Part Source	
OM 8				Failed		Update Request Ref.	
Additional Work							
DEFAULT		Default Task		Done	Yes	Changed Part Condition	
0:00				Not Done Reason		Part Source	
				Failed		Update Request Ref.	

Maintenance Report		SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD				S002085513	
Part No	Part Description	MU/TL	Task Code	Component Tree Path	Qty Required	Qty Used	Unit Of Measure
Spares							
1565340-0000	Spacer		*8842797	[1551358-0400] LFU S1 \ [1551420-0300] Pressing unit S1 horis	1	1	PC
1565340-0000	Spacer		*8842799	[1551359-0400] LFU S2 \ [1551421-0300] Pressing unit S2 horis	1	1	PC
2655523-0000	Shock Absorber		*3018331	[1551358-0400] LFU S1 \ [1551422-0300] Reference stop S1	4	4	PC
2655523-0000	Shock Absorber		*3018343	[1551359-0400] LFU S2 \ [1551423-0300] Reference stop S2	4	4	PC
2811633-0000	Cylinder		*3018097	[1551359-0400] LFU S2 \ [1551402-0300] Hanger S2 tool \ [1551388-0300] Hanger S2 tool	2	2	PC
2811633-0000	Cylinder		*3018085	[1551358-0400] LFU S1 \ [1551401-0300] Hanger S1 tool \ [1551387-0300] Hanger S1 tool	2	2	PC
2826272-0000	Accumulation Unit		*3018073	[1551358-0400] LFU S1 \ [1551360-0400] Supply Unit S1 \ [1551381-0300] Valve Ramp Unit - Hydraulic S1 \ [1551379-0300] Accumulator unit S1	1	1	PC
2826272-0000	Accumulation Unit		*3018079	[1551359-0400] LFU S2 \ [1551361-0400] Supply System S2 \ [1551382-0300] Valve Ramp Unit - Hydraulic S2 \ [1551380-0300] Accumulator unit S2	1	1	PC
2956633-0000	Cylinder		*3018331	[1551358-0400] LFU S1 \ [1551422-0300] Reference stop S1	2	2	PC
2956633-0000	Cylinder		*3018343	[1551359-0400] LFU S2 \ [1551423-0300] Reference stop S2	2	2	PC
2986074-0000	Washer		*11466657	[1551359-0400] LFU S2 \ [1551423-0300] Reference stop S2	4	4	PC
2986074-0000	Washer		*11466655	[1551358-0400] LFU S1 \ [1551422-0300] Reference stop S1	4	4	PC
2986074-0000	Washer		*3018331	[1551358-0400] LFU S1 \ [1551422-0300] Reference stop S1	4	4	PC
2986074-0000	Washer		*3018343	[1551359-0400] LFU S2 \ [1551423-0300] Reference stop S2	4	4	PC
2986075-0000	Washer		*3018331	[1551358-0400] LFU S1 \ [1551422-0300] Reference stop S1	4	4	PC
2986075-0000	Washer		*3018343	[1551359-0400] LFU S2 \ [1551423-0300] Reference stop S2	4	4	PC
3119886-0000	Cylinder		*3018187	[1551358-0400] LFU S1 \ [1551412-0300] Hot Channel S1 \ [1551414-0300] Guide S1 hot channel	2	2	PC
3119886-0000	Cylinder		*3018205	[1551359-0400] LFU S2 \ [1551413-0300] Hot Channel S2 \ [1551415-0300] Guide S2 hot channel	2	2	PC
312105-0463	Bolt, M8x60 A4 80 ISO4014		*3018097	[1551359-0400] LFU S2 \ [1551402-0300] Hanger S2 tool \ [1551388-0300] Hanger S2 tool	4	4	PC
312105-0463	Bolt, M8x60 A4 80 ISO4014		*3018085	[1551358-0400] LFU S1 \ [1551401-0300] Hanger S1 tool \ [1551387-0300] Hanger S1 tool	4	4	PC

Maintenance Report		SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD			S002085513		
Part No	Part Description	MU/TL	Task Code	Component Tree Path	Qty Required	Qty Used	Unit Of Measure
Spares							
312105-0467	Bolt, M8x80 A4 80 ISO4014		*3018187	[1551358-0400] LFU S1 \ [1551412-0300] Hot Channel S1 \ [1551414-0300] Guide S1 hot channel	4	4	PC
312105-0467	Bolt, M8x80 A4 80 ISO4014		*3018205	[1551359-0400] LFU S2 \ [1551413-0300] Hot Channel S2 \ [1551415-0300] Guide S2 hot channel	4	4	PC
312105-0505	Bolt, M10x70 A4 80 ISO4014		*3018331	[1551358-0400] LFU S1 \ [1551422-0300] Reference stop S1	4	4	PC
312105-0505	Bolt, M10x70 A4 80 ISO4014		*3018343	[1551359-0400] LFU S2 \ [1551423-0300] Reference stop S2	4	4	PC
312155-0331	Screw, Hex socket Flat M5x20 A4		*4819069	[982041-1300] Hygiene chamber \ [571352-1000] Hygiene Chamber Upper S1 \ [1185148-0500] Cassette centering S1	2	2	PC
312155-0331	Screw, Hex socket Flat M5x20 A4		*4819071	[982041-1300] Hygiene chamber \ [1368145-0600] Hygiene Chamber Upper S2 \ [1368150-0300] Cassette centering S2	2	2	PC
315202-0803	O-ring, 44.17x1.78mm NBR-70A		*8236654	[571376-0800] Outfeed Unit S1 \ [571377-0400] Guiding plate S1	4	0	PC
315202-0803	O-ring, 44.17x1.78mm NBR-70A		*8236656	[1469995-0500] Outfeed Unit S2 \ [1371036-0200] Guiding plate S2	4	0	PC
315206-0606	O-ring, 56.74x3.53mm EPDM-70A		*3020805	[2565786-0300] Bottom Seal S2 \ [2633201-0200] Frame S2	3	0	PC
315206-0606	O-ring, 56.74x3.53mm EPDM-70A		*3020799	[2532721-0300] Bottom Seal S1 \ [2633200-0200] Frame S1	3	0	PC
315206-0805	O-ring, 53.70x1.78mm EPDM-70A		*3020805	[2565786-0300] Bottom Seal S2 \ [2633201-0200] Frame S2	2	0	PC
315206-0805	O-ring, 53.70x1.78mm EPDM-70A		*3020799	[2532721-0300] Bottom Seal S1 \ [2633200-0200] Frame S1	2	0	PC
315211-0108	250R-170-72, Bonded Seal SS/NBR90 G1/4		*3018187	[1551358-0400] LFU S1 \ [1551412-0300] Hot Channel S1 \ [1551414-0300] Guide S1 hot channel	4	4	PC
315211-0108	250R-170-72, Bonded Seal SS/NBR90 G1/4		*3018205	[1551359-0400] LFU S2 \ [1551413-0300] Hot Channel S2 \ [1551415-0300] Guide S2 hot channel	4	4	PC
342722-0197	Straight Coupling		*3018277	[1551358-0400] LFU S1 \ [1551420-0300] Pressing unit S1 horis	2	2	PC
342722-0197	Straight Coupling		*3018307	[1551359-0400] LFU S2 \ [1551421-0300] Pressing unit S2 horis	2	2	PC
344224-0200	Ball bearing, 10.00x26.00x8.00mm		*3021577	[915299-0900] Conveying equipment S1 \ [915308-0900] Drive Unit S1	4	4	PC
344224-0200	Ball bearing, 10.00x26.00x8.00mm		*3017497	[1367882-0400] Conveying equipment S2 \ [1367885-0400] Drive Unit S2	4	4	PC
344226-0104	Ball bearing, 20.00x47.00x14.00mm		*18748654	[1567409-0200] Servo lifter discharger	8	8	PC
344270-0302	Flange bushing, 20.00x26.00x15.00mm		*8842797	[1551358-0400] LFU S1 \ [1551420-0300] Pressing unit S1 horis	2	2	PC
344270-0302	Flange bushing, 20.00x26.00x15.00mm		*8842799	[1551359-0400] LFU S2 \ [1551421-0300] Pressing unit S2 horis	2	2	PC
351523-0216	O-ring, 22.20x3.00mm FKM-80A		*3018331	[1551358-0400] LFU S1 \ [1551422-0300] Reference stop S1	2	2	PC

Maintenance Report		SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD			S002085513		
Part No	Part Description	MU/TL	Task Code	Component Tree Path	Qty Required	Qty Used	Unit Of Measure
Spares							
351523-0216	O-ring, 22.20x3.00mm FKM-80A		*3018343	[1551359-0400] LFU S2 \ [1551423-0300] Reference stop S2	2	2	PC
351523-0216	O-ring, 22.20x3.00mm FKM-80A		*3018097	[1551359-0400] LFU S2 \ [1551402-0300] Hanger S2 tool \ [1551388-0300] Hanger S2 tool	2	2	PC
351523-0216	O-ring, 22.20x3.00mm FKM-80A		*3018085	[1551358-0400] LFU S1 \ [1551401-0300] Hanger S1 tool \ [1551387-0300] Hanger S1 tool	2	2	PC
90240-0293	Flange bushing, 25.00x28.00x21.00mm		*8236654	[571376-0800] Outfeed Unit S1 \ [571377-0400] Guiding plate S1	4	0	PC
90240-0293	Flange bushing, 25.00x28.00x21.00mm		*8236656	[1469995-0500] Outfeed Unit S2 \ [1371036-0200] Guiding plate S2	4	0	PC
90287-0190	Socket screw, M5x65 DIN912		*4819069	[982041-1300] Hygiene chamber \ [571352-1000] Hygiene Chamber Upper S1 \ [1185148-0500] Cassette centering S1	4	4	PC
90287-0190	Socket screw, M5x65 DIN912		*4819071	[982041-1300] Hygiene chamber \ [1368145-0600] Hygiene Chamber Upper S2 \ [1368150- 0300] Cassette centering S2	4	4	PC
90417-0385	Timing belt, T5-DL 460.0/16.0mm		*3017521	[1367882-0400] Conveying equipment S2 \ [1367885-0400] Drive Unit S2	1	1	PC
90417-0385	Timing belt, T5-DL 460.0/16.0mm		*3021565	[915299-0900] Conveying equipment S1 \ [915308-0900] Drive Unit S1	1	1	PC
90459-1110	Timing belt, AT10 1320.0/32.0mm		*16347618	[1551358-0400] LFU S1 \ [1551406-0300] Drive S1 tool	2	2	PC
90459-1110	Timing belt, AT10 1320.0/32.0mm		*16347625	[1551359-0400] LFU S2 \ [1551407-0300] Drive S2 tool	2	2	PC
90459-1734	Timing belt, AT5 975.0/50.0mm		*18748654	[1567409-0200] Servo lifter discharger	2	2	PC
90459-2873	Nipple, ext thread,hexagon, G3/4 - G3/4		*3018073	[1551358-0400] LFU S1 \ [1551360-0400] Supply Unit S1 \ [1551381-0300] Valve Ramp Unit - Hydraulic S1 \ [1551379-0300] Accumulator unit S1	1	1	PC
90459-2873	Nipple, ext thread,hexagon, G3/4 - G3/4		*3018079	[1551359-0400] LFU S2 \ [1551361-0400] Supply System S2 \ [1551382-0300] Valve Ramp Unit - Hydraulic S2 \ [1551380- 0300] Accumulator unit S2	1	1	PC
90459-2874	Check Valve, RKVE-04		*8852694	[1551359-0400] LFU S2 \ [1551361-0400] Supply System S2 \ [1551382-0300] Valve Ramp Unit - Hydraulic S2 \ [1551380- 0300] Accumulator unit S2	1	1	PC
90459-2874	Check Valve, RKVE-04		*8852692	[1551358-0400] LFU S1 \ [1551360-0400] Supply Unit S1 \ [1551381-0300] Valve Ramp Unit - Hydraulic S1 \ [1551379-0300] Accumulator unit S1	1	1	PC
90459-3210	Seal, D30.0xW8.0mm NBR		*3020805	[2565786-0300] Bottom Seal S2 \ [2633201-0200] Frame S2	5	0	PC
90459-3210	Seal, D30.0xW8.0mm NBR		*3020799	[2532721-0300] Bottom Seal S1 \ [2633200-0200] Frame S1	5	0	PC
90459-3391	Filter Cartridge, 0165 R 010 BN3HC		*3018422	[986221-1400] Supply unit \ [1551463-0300] Hydraulic system	1	1	PC
90459-3814	C6-499, Filter Cartridge, MS4-LFP-E		*20353535	[3312084-0100] Cutting function S2 \ [3434618-0200] {Sprue Remover Unit} \ [3548655-0100] Pneumatic system	1	1	PC
90459-3814	C6-499, Filter Cartridge, MS4-LFP-E		*20353535	[3312083-0100] Cutting function S1 \ [3434618-0200] {Sprue Remover Unit} \ [3548655-0100] Pneumatic system	1	1	PC

Maintenance Report		SEC-UPFIELD HEL-327-8 \ 63202/20152 [9000216560] TT/3-200V MINI TAISHAN A38 HAAD			S002085513		
Part No	Part Description	MU/TL	Task Code	Component Tree Path	Qty Required	Qty Used	Unit Of Measure
Spares							
90459-6090	Filter Cartridge, 0060 D 020 BN4HC		*3018422	[986221-1400] Supply unit \ [1551463-0300] Hydraulic system	1	1	PC
90600-3038	Filter, MX-457x457		*3021207	[2925230-0200] HEPA Unit \ [2895748-0200] Filter Housing S2	1	0	PC
90600-3038	Filter, MX-457x457		*3021201	[2925230-0200] HEPA Unit \ [2888313-0200] Filter Housing S1	1	0	PC
90600-4859	Seal Kit, DKL11150-K-001		*3021345	[915313-0900] Conveying equipment S1 \ [571337-0700] Package guide S1	4	4	PC
90600-4859	Seal Kit, DKL11150-K-001		*3018776	[2581970-0200] Cassette lifter S1 \ [2564618-0200] Volume displacement S1	4	4	PC
90600-4859	Seal Kit, DKL11150-K-001		*3017905	[915316-0900] Conveying equipment S2 \ [1469716-0400] Package guide S2	4	4	PC
90600-4859	Seal Kit, DKL11150-K-001		*3020847	[2565787-0200] Cassette lifter S2 \ [2658236-0200] Volume displacement S2	4	4	PC
90602-9870	Double acting, Compact, cyl 25-40		*4819069	[982041-1300] Hygiene chamber \ [571352-1000] Hygiene Chamber Upper S1 \ [1185148-0500] Cassette centering S1	2	2	PC
90602-9870	Double acting, Compact, cyl 25-40		*4819071	[982041-1300] Hygiene chamber \ [1368145-0600] Hygiene Chamber Upper S2 \ [1368150-0300] Cassette centering S2	2	2	PC
90603-1093	Rotating seal, 25.0/32.5mm TURCON T40		*8236654	[571376-0800] Outfeed Unit S1 \ [571377-0400] Guiding plate S1	4	0	PC
90603-1093	Rotating seal, 25.0/32.5mm TURCON T40		*8236656	[1469995-0500] Outfeed Unit S2 \ [1371036-0200] Guiding plate S2	4	0	PC
90603-2381	Filter, MS9-LF-G-EUV		*20198846	[1298977-0500] Filling section \ [986269-0900] Supply system \ [986282-0900] Pneumatic supply \ [3395507-0100] Pneumatic supply	1	1	PC
90604-3129	Round cylinder, DSNU 16x25mm		*3018277	[1551358-0400] LFU S1 \ [1551420-0300] Pressing unit S1 horis	1	1	PC
90604-3129	Round cylinder, DSNU 16x25mm		*3018307	[1551359-0400] LFU S2 \ [1551421-0300] Pressing unit S2 horis	1	1	PC
90606-2436	Timing belt, AT10 780.0/50.0mm		*14560812	[1551359-0400] LFU S2 \ [1551409-0400] Motor unit S2	1	1	PC
90606-2436	Timing belt, AT10 780.0/50.0mm		*14560808	[1551358-0400] LFU S1 \ [1551408-0400] Motor unit S1	1	1	PC
90609-7372	O-ring, 63.00x2.00mm NBR-70A		*3020781	[2565786-0300] Bottom Seal S2 \ [2633193-0300] Sonotrode unit S2:1	2	0	PC
90609-7372	O-ring, 63.00x2.00mm NBR-70A		*3020793	[2565786-0300] Bottom Seal S2 \ [2633194-0300] Sonotrode Unit S2:2	2	0	PC
90609-7372	O-ring, 63.00x2.00mm NBR-70A		*3020769	[2532721-0300] Bottom Seal S1 \ [2633192-0300] Sonotrode unit S1:1	2	0	PC
90609-7372	O-ring, 63.00x2.00mm NBR-70A		*3018843	[2532721-0300] Bottom Seal S1 \ [2581977-0300] Sonotrode Unit S1:2	2	0	PC
977510-0000	Squeezer		*3021577	[915299-0900] Conveying equipment S1 \ [915308-0900] Drive Unit S1	1	1	PC
977510-0000	Squeezer		*3017497	[1367882-0400] Conveying equipment S2 \ [1367885-0400] Drive Unit S2	1	1	PC

Special Resources					
1355671-0000	TEMPLATE	TL	*204141	[977852-0500] Splicing Device S1 \ [996461-0500] Splicing Dev Bracket S1 \ [1185250-0400] Creasing unit S1	1
1355671-0000	TEMPLATE	TL	*204149	[1367711-0300] Splicing device S2 \ [1367713-0300] Splicing Dev Bracket S2 \ [1369270-0300] Creasing unit S2	1
1573180-0000	Puller	TL	*3018097	[1551359-0400] LFU S2 \ [1551402-0300] Hanger S2 tool \ [1551388-0300] Hanger S2 tool	1
1573180-0000	Puller	TL	*3018085	[1551358-0400] LFU S1 \ [1551401-0300] Hanger S1 tool \ [1551387-0300] Hanger S1 tool	1
1573181-0000	Puller	TL	*3018097	[1551359-0400] LFU S2 \ [1551402-0300] Hanger S2 tool \ [1551388-0300] Hanger S2 tool	1
1573181-0000	Puller	TL	*3018085	[1551358-0400] LFU S1 \ [1551401-0300] Hanger S1 tool \ [1551387-0300] Hanger S1 tool	1
1590255-0000	Sampling valve	TL	*3018416	[986221-1400] Supply unit \ [1551463-0300] Hydraulic system	1
2838500-0000	KEY	TL	*8852694	[1551359-0400] LFU S2 \ [1551361-0400] Supply System S2 \ [1551382-0300] Valve Ramp Unit - Hydraulic S2 \ [1551380-0300] Accumulator unit S2	1
2838500-0000	KEY	TL	*8852692	[1551358-0400] LFU S1 \ [1551360-0400] Supply Unit S1 \ [1551381-0300] Valve Ramp Unit - Hydraulic S1 \ [1551379-0300] Accumulator unit S1	1
3488500-0101	Service Tool	TL	*3021769	[1469970-0300] Drive Unit Carton \ [986245-0600] Cam Modul cut & fold	1
3488500-0101	Service Tool	TL	*3021751	[1469970-0300] Drive Unit Carton \ [986245-0600] Cam Modul cut & fold	1
3488500-0101	Service Tool	TL	*3021703	[571376-0800] Outfeed Unit S1 \ [982048-0800] Pusher S1	1
3488500-0101	Service Tool	TL	*3017647	[1469995-0500] Outfeed Unit S2 \ [1371038-0400] Pusher S2	1
3488500-0101	Service Tool	TL	*3021667	[982045-0600] Volume change S1	1
3488500-0101	Service Tool	TL	*3017959	[1469860-0400] Volume change S2	1
351532-0050	Threadlocker Loctite 2400 50 ml	TL	*3018097	[1551359-0400] LFU S2 \ [1551402-0300] Hanger S2 tool \ [1551388-0300] Hanger S2 tool	1
351532-0050	Threadlocker Loctite 2400 50 ml	TL	*3018085	[1551358-0400] LFU S1 \ [1551401-0300] Hanger S1 tool \ [1551387-0300] Hanger S1 tool	1
3549863-0000	Tool	TL	*3020781	[2565786-0300] Bottom Seal S2 \ [2633193-0300] Sonotrode unit S2:1	1
3549863-0000	Tool	TL	*3020793	[2565786-0300] Bottom Seal S2 \ [2633194-0300] Sonotrode Unit S2:2	1
3549863-0000	Tool	TL	*3020769	[2532721-0300] Bottom Seal S1 \ [2633192-0300] Sonotrode unit S1:1	1
915399-0201	Rail	TL	*3023599	[600311-0400] LFU	1
915399-0201	Rail	TL	*3023605	[600311-0400] LFU	1
996373-0101	PRE-LOADING EQUIPMENT	TL	*3018428	[986221-1400] Supply unit \ [1551463-0300] Hydraulic system	1

Customer Signature	Service Engineer Signature	Date