Cleaning

Regular cleaning of the machine is crucial for maintaining hygiene, ensuring product quality, and extending the life of the equipment. This section provides guidelines for daily and weekly cleaning routines, emphasizing the importance of using appropriate cleaning materials and methods to avoid damage to the machine's components.

⚠ DANGER Electrical hazards can cause serious injury or death. Use proper lockout/tagout procedures before cleaning or servicing the machine. Only trained personnel should perform maintenance. Ensure the machine is safe before starting, and wear appropriate PPE.

Take appropriate steps to cover external electrical components and unsealed panels to avoid damage caused by water infiltration. Damage by water infiltration is not covered under warranty.

The addition of optional components on your machine may require modification to the following procedures. If you are unsure how to clean any items on your machine, please contact your Viking Masek representative before conducting any cleaning activities.

General Cleaning

Use clean, dry rags or cellulose paper towels lightly moistened with a suitable cleaning solution to wipe down machine surfaces, particularly those that contact the product. Ensure no moisture or cleaning agents are left behind.

Jaws Cleaning

- Remove any film or product residues from the sealing jaws.
- Avoid using sharp objects or knives that could damage the jaws' surfaces.
- Clean the jaws gently with a soft cloth to protect the mechanical components.

Fin Sealing Group and End Sealing Group

- Regularly inspect and clean these areas to remove any film or product residue.
- Use a soft cloth dampened with an appropriate cleaning agent to thoroughly clean these groups.

Touchscreen

- Clean the touchscreen with a soft, dry cloth.
- Avoid using abrasive materials or harsh chemicals that could damage the screen.
- Ensure the screen is powered off before cleaning to prevent accidental inputs.

Pneumatic Components

- Periodically clean the compressed air filter cup to remove accumulated moisture or debris.
- Inspect, and clean the pneumatic components according to the manufacturer's guidelines.

Lubrication

Proper lubrication is essential for ensuring longevity, and smooth operation of the machine. This section outlines the lubrication requirements for various components, including gearboxes, bearings, chains, and other high-temperature applications. It provides specific recommendations for food-grade lubricants, and emphasizes the importance of following correct procedures to prevent contamination and equipment damage.

Important Notes

•Components lubricated by Viking Masek with a specific oil or lubricant should not be lubricated with any other grease or lubricant, even if they have similar characteristics. Mixing different types of oils or lubricants may alter their properties, potentially leading to hardening and damage.
•If changing the grease or lubricant is necessary, completely remove the existing lubricant using an appropriate solvent or degreaser before applying the new grease.
•Always follow the operating, and safety instructions provided by the lubricant manufacturer.

Lubrication Guidelines

1. Gearboxes

•The gearboxes installed in the flow wrapper are permanently lubricated and do not require additional lubrication throughout their lifespan.
•If lubricant refilling or replacement is necessary, use a food-grade lubricant such as ELESA LUBRITEF (aerosol) from the ELESA brand.

2. Bearings

•The bearings in the machine are designed to operate without additional lubrication for their entire lifespan.
•If lubrication is required, use food-grade oil like BESLUX ATOX 100 from the BRUGAROLAS brand.

3. Chains

•Chains, particularly the pusher chain of the product inlet conveyor, do not require lubrication to avoid potential product contamination.
•If lubrication is necessary, follow these steps:
1- Apply FIN DEGREASER EM30+ from INTERFLON to clean the chain.
2- Allow it to sit for 15-20 minutes.
3- Clean the chain with a cotton cloth.
4- Blow the chain with dry compressed air to remove any residue.
5- Apply a food-grade chain-specific lubricant like FIN FOOD LUBE (USDA H1 ref. 122875) from INTERFLON or ELESA LUBRITEF (aerosol) from ELESA.

4. Assembly Grease

•Use food-grade assembly grease appropriate for the application:
1- For high temperatures up to 250ºC, use GREASE HTG-ES (USDA H2 ref. 123419) from INTERFLON or ELESA 70-SBR from ELESA.
2- For very high temperatures up to 2000ºC, use INTERFLON PASTE HT 1200 or ELESA 67 CERAMICA PLUS PTFE.
•For stainless steel components, use INTERFLON PASTE HT 1200 or ELESA 67 CERAMICA PLUS PTFE.

Maintenance

Regular maintenance is crucial for ensuring the optimal performance, safety, and longevity of the machine. This section provides detailed guidelines for conducting routine inspections and preventive maintenance tasks. It includes a schedule for daily, weekly, and periodic checks, along with specific maintenance procedures for various machine components. Adhering to these guidelines helps to prevent unexpected breakdowns, maintain the machine's efficiency, and ensure a safe working environment.

Component-Specific Maintenance

Belt Conveyor System

Tensioning	Adjust only on the tail side.
	Pre-tension: 0.15%–0.3% of belt length.
	Recheck after 48 hours of operation post-installation or replacement.
Alignment	Adjust rollers to ensure central tracking.
	Use threaded pins for fine adjustment.
Replacement	De-tension belt via tail-specific procedure.
	Remove side rails if needed.
	Re-tension and align after installation.

Pneumatic System

Weekly	Check for leaks and pressure drops.
Monthly	Drain and clean filter cup.
Every 5k Hours	Replace pneumatic valves and cylinders or service O-rings.

Electrical System

Daily	Test all safety systems (e-stops, guards, switches).
Monthly	Inspect indicator lights.
Every 3 Months	Clean slip rings and brushes with dry air and cloth.

Lubrication

Monthly	Lubricate linear bushings (e.g., INA KGHK, FAG 20204-TVP).
Annually	Lubricate push conveyor pinions.
Approved Lubricants	FIN FOOD GREASE 2, ELESA ATOX/2, ELESA LUBRITEF, etc.

Caution: *Do not mix lubricants. Fully clean before switching types.*

CONTACT

Viking Masek Technical Support:	(920) 250-8601 or TechSupport@vikingmasek.com

CAUTION

Before cleaning, turn off and disconnect the power.
Sealing jaws and knife are hot. Wear heat-resistant gloves and proper Personal Protective Equipment (PPE). Prior to starting any maintenance activity, the energy sources to the machine must be isolated and locked-out.

Check safety switches/magnets for condition/security and function. Same for E-stop. With the main power on and faults reset, open and close the doors and verify the air is dumped when the guards open.

This information is for planning purposes only. Consult your owner's manual for machine-specific instructions and safety warnings.

Preventative Maintenance Worksheet Flow Wrapping Machine

RESPONSIBLE PERSON:

PREVENTIVE MAINTENANCE SCHEDULE: Flow Wrapper																																
DAY		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	31
WEEK																																
MONTH																																
DAILY	Clean product-contact surfaces using approved cleaning agents.																															
	Remove film/product waste from sealing areas.																															
	Check all safety systems (e-stops, guards, switches).																															
	Disconnect power and air before cleaning or maintenance.																															
WEEKLY	Clean the full machine of dust, film, grease, and debris.																															
	Inspect: Chains, pinions and jaws																															
	Inspect: Belt alignment and condition																															
	Check for pneumatic leaks																															
	Inspect: Photoelectric sensor lenses																															
	Clean PETg/PC guards with water and neutral soap (no solvents).																															
MONTHLY	Check chain tension.																															
	Inspect lights and replace if needed.																															
	Clean slip rings and brushes on sealing units (dry air and cloth only).																															
Every 5k Hours	Ensure all rollers turn smoothly.																															
	Replace or service: Pneumatic valves (O-rings)																															
	Replace or service: Pneumatic cylinders (O-rings)																															
Every 10k Hours	Replace: Toothed belts																															
	Replace: Chains																															
Every 20k-30k Hours	Replace: gearboxes (depending on model and operating temperature).																															