

SPIRAL SUPPORT

# Spiral Conveyor Recommended Maintenance Program



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The following recommendations are provided for Spiral Conveyors delivered by Apollo VTS. These maintenance guidelines are based on an average of 10 hour of operation per day for 5 days per week.

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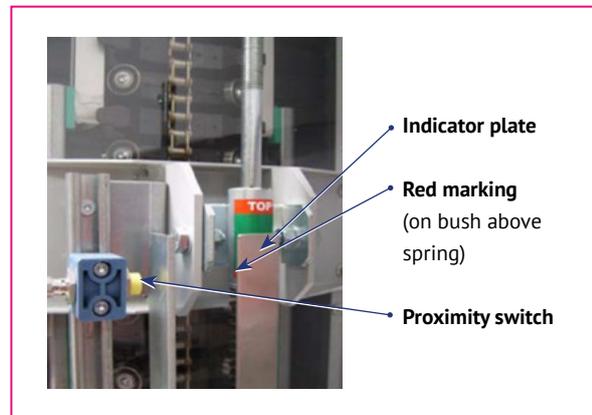
## Daily:

- I. Check the Spiral Conveyor for missing or damaged parts.
- II. Check the Spiral Conveyor for strange noises.

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## Weekly:

- I. Check and tighten all fasteners (bolts and nuts) if required.
- II. Check the chain tension and adjust if necessary.
  - **Spirals with spring tensioner** – Check the spring compression. The spring tension is correct when the red marking is not visible above the indicator plate.
  - **Spirals with pneumatic tensioner** – Check the air pressure on the pneumatic cylinder. The air pressure should maximum be 1.5bar for an ascending spiral and maximum 2.5bar for a descending spiral. The pressure can be adjusted with the regulation valve. Ensure that the proximity switch does not give a warning to be sure the tensioning works adequately.



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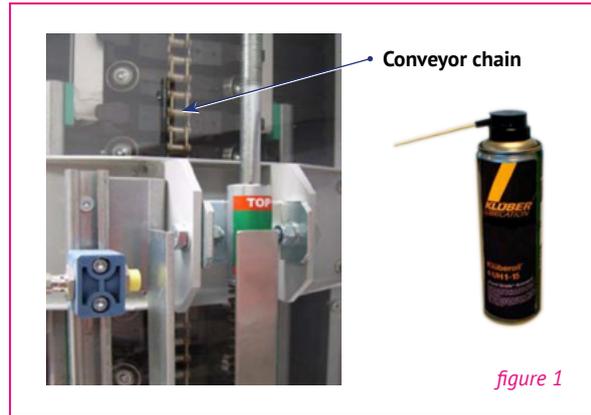
## Monthly:

- I. Clean Spiral Conveyor for dust and debris
  - Take into account the cleaning instructions. Powder coated dry use and stainless steel dry use machines may only be wiped with a cloth to ensure no damaged parts. For stainless steel wash down machines cleaning should only be done at low pressures to avoid damage to the parts or coating. Cleaning may only be done with mild cleaners and the cleaning liquid may only be rinsed at low temperatures. After cleaning the chain must be re-lubricated. After cleaning the chain must be lubricated
- II. Inspect slats and carriers and replace any damaged parts.
- III. Check if the warning stickers are still visible, clean or replace if necessary.

[Read more about maintenance on the next page →](#)

## Every 6 months:

- I. Lubricate conveyor chain
  - The access hole (figure 1) for the lubrication of the conveyor chain is applied in the return-box. The lubrication hole marked with a red circular sticker. The lubricant spray must be fitted with a spray nozzle. It is recommended to lubricate the chain with ISO-VG 15 (for food industry Bel-Ray No-Tox HD Grease is recommended).
- II. Check for wear of chain and sprockets
  - Wear can be visually checked
- III. Check complete Spiral Conveyor on defects and change defect parts if required



## Yearly:

- I. Check overload and automatic chain tension devices for functionality

## Every 5 years:

- I. Replace oil of the gear units

## Before carrying out any maintenance activities, ensure the following:



**Make sure the machine is switched off COMPLETELY before carrying out any maintenance activities**



**In case the conveyor has a pneumatic chain tensioner: make sure the air supply is switched off.**



**Only qualified personnel is authorized to carry out maintenance procedures at the machine.**



**There is a danger that moving parts can hurt persons that maintain the machine.**



**When working on the machine, the LOTOTO procedure must always be followed**

Reference is made to the operation and maintenance manual for more details. The Apollo Service Department is always available to assist with your installation, service or maintenance questions. Feel free to call +31 (0)524 515 051 or e-mail [service@apollobv.nl](mailto:service@apollobv.nl) with questions.



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