

Apilion SMS 220/24 EL — Preventive Maintenance (Fillable)

OEM – Several times a day / each replenishment

Lubricate welding & contact rollers
Check pneumatic spring element pressures

OEM – Once per shift

Check weld quality (tear test)
Verify contact pressure rollers
Safety devices check
Wire reel brake & guide
Wire clamp function/pressure

OEM – Weekly (~40h)

Clean heat exchanger
Coolant level
Pneumatic lines
Diameter-adjustment chains
Spreader spindle nut lubrication
Circumferential chains lubrication
Cage pull-out gears lubrication
Cable drag chains
Welding roller isolation (QE)

OEM – Monthly (~160h)

Support spindle lubrication
Main drive chain lubrication
Pull-out wheel drive chain lubrication
Transformer contact surfaces (QE)

OEM – Annual (~1920h)

Maintain air conditioner
Clean cooling system & replace coolant
Inspect complete electrical equipment (QE)
Check motor couplings & gearboxes
Replace gearbox oil
Check holding/service brakes

Planning – 30 Days

Weekly items completed
Spot-check lubrication points
Verify weld quality & safety logs
Visual check: cable drag chains & pneumatics

Sign-Off: Technician _____ Date _____ Supervisor _____ Date _____

Planning – 90 Days

- All monthly items
- Clean/torque transformer contacts
- Review adjustment chain tension
- Cooling unit inspection

Planning – 120 Days

- All 90-day items
- Test E■Stops & light curtains
- Detailed pull-out assembly inspection
- Check HMI connections/enclosure

Sign-Off: Technician _____ **Date** _____ **Supervisor** _____ **Date** _____