

Rotary Equipment Preventive Maintenance Guide

Weekly maintenance tasks

1. Check graphite block lubrication
 - Are holders clean and free of product or dirt contamination?
 - Is the graphite block free and loose in its holder?
 - Is the graphite providing an adequate supply of lubrication?
2. Check creep or gap of tires on all piers.
 - Has level of creep increased since the last inspection?
3. Lubricate between the filler bars and tire ID.
4. Check the condition of the rollers at each pier.
 - Are the rollers thrusting uphill or downhill?
5. Clean the pier tops of dirt, oil or product spillage.

Monthly maintenance tasks

- Check for pitch line separation of gear and pinion.
- Check for pitch line run-out of gear and pinion.
- Check condition of welds on gear flange and mounting lugs.
- Check for excessive ring and roller wear.
- Lubricate the drive coupling.
- Semi-annual maintenance tasks
- Change gear lube and clean sump and gear area if needed.
- Change grease on pinion shaft and support roller bearings.
- Change grease in thrust roller bearings.
- Inspect shell for cracks under rings.
- Check radial alignment of gear and pinion.
- Inspect drive coupling grid members.

Annual maintenance tasks

1. Check the alignment of the unit.
2. Adjust the rollers to a neutral position to re-train the unit.
3. Weld repair cracks in shell, wedges, filler bars or support bands.
4. Clean and inspect gear.
 - Check gear teeth for abnormal wear.
 - Change gear lubrication.
 - Check drive train couplings for wear and replace if needed.
 - Check and repair welds on gear flange or mounting lugs and gear if needed.
 - Check for loose nuts or bolts on gear mounting flange.
 - Inspect, clean repack and change lubrication on pinion bearings.
 - Check brush rigging and electrical components of drive motor.
 - Take samples of gear box oil and send to a laboratory to detect oil contamination.
5. Clean and inspect support roller bearings.
6. Clean and grease the support roller adjustment screws and wrap them in burlap.



When periodic maintenance tasks are performed, problems can be easily discovered. Most problems can be solved immediately but a few require outside maintenance assistance. If you spot any of the following problems, call your equipment supplier or maintenance vendor immediately.

- Convex-concave wear on tires and carrying rollers that is causing control problems or reduced bearing area
- Spalling, excessive galling, or metal breakage on tires or rollers
- Severe tapers on tires
- Gear bottoming out or excessive vibration

Contact us



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