

PARTS REPLACEMENT SCHEDULE

ITEM	DESCRIPTION	NORMAL REPLACEMENT PERIOD (assumes 8 hours per day operation)	DATE LAST REPLACED	NEXT REPLACEMENT DATE
Rotary machine	Bag opening vacuum pads	2 - 3 months		
	Magazine vacuum pads	6 months		
	Bag clip pad	6 months		
	Sealing jaw heater	8 - 12 months		
	CAM	4 - 6 years		
	CAM bearing	1 year		
	Air cylinder	4 - 6 years		
	Solenoid valve	3 - 5 years		
	Gripper spring (S)	2 - 3 years		
	Gripper spring (M)	3 - 4 years		
	Base lever spring	2 - 3 years		
	Center gripper spring	2 - 3 years		
	DU bearing	3 - 4 years		
	Touch screen	6 - 8 years		
Motor	1P, 220V	5 - 6 years		
	3P, 220V / 380V	5 - 6 years		
	Bag loading (3W)	2 - 3 years		
Lamp (LED)	220V	5 - 7 years		
Button switch	1P / 2P	5 - 7 years		
Sensor	2-way type	6 - 8 years		
	Proximity sensor	6 - 8 years		
Electrical parts	SSR	6 - 8 years		
	TM4	6 - 8 years		
	PLC	8 - 10 years		
	Servo drives	8 - 10 years		
	Inverter	8 - 10 years		
	Encoder	8 - 10 years		
Electrical parts, relay	220V	5 - 7 years		
Electrical parts, magnetic	220V	5 - 7 years		

CONTACT

Viking SoIPac technical support:

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Preventive Maintenance & Service Plans:

**CAUTION**

Before cleaning, turn off and disconnect the power.

Only a trained maintenance technician should repair and maintain the machine.

Prior to starting any maintenance activity, the energy sources to the machine must be isolated and locked-out.

When repairing or maintaining the machine, take care not to drop small parts or tools into the machine. This can cause serious mechanical issues.

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