DEPARTMENT OF THE ARMY TECHNICAL MANUAL

ORGANIZATIONAL MAINTENANCE MANUAL

BAKERY PLANT, MOBILE M-1945

FSN 7360-221-2418

This copy is a reprint which includes current pages from Changes 2 through 7.

HEADQUARTERS, DEPARTMENT OF THE ARMY

MARCH 1961

AGO 5023A

Changes in force: C2 through C7

TM 10-7360-201-20
C7

CHANGE NO. 7

HEADQUARTERS
DEPARTMENT OF THE ARMY
WASHINGTON, D.C., 25 March 1983

Organizational Maintenance Manual

BAKERY PLANT, TRAILER MOUNTED, FIELD; 16,000-LB CAPACITY OUTPUT PER 24-HR: MODELS M-1945, M-1945-50, M-1945-53, M-534-68, NSN 7360-00-221-2418

CONSISTING OF:

SIFTER MACHINE, FLOUR; ELECTRIC; AGITATOR-TYPE, 110V, AC, 60 HZ; 55-LB PER MINUTE
(ALLIS-CHALMERS MODEL, ARMY MODEL SPE-20) NSN 7320-00-221-2386
(ARMSTRONG PRODUCTS MODEL 42386) NSN 7320-00-043-5340

DOUGH MIXING AND MAKEUP OUTFIT; TRAILER MOUNTED
(CENTURY MACHINE MODEL, ARMY MODEL SPV-18) NSN 7320-00-255-7769
(CENTURY MACHINE MODEL TR306, ARMY MODEL SPV-30) NSN 7320-00-215-5256
(BAKER-PERKINS MODEL TM-BP-68) NSN 7320-00-880-8745
(CAM INDUSTRIES MODEL M-534-1) NSN 7320-00-334-5336

CABINET, DOUGH PROOFING; 36-PAN CAPACITY; ELECTRICALLY HEATED; 220V, AC, 60 HZ
(DRYING SYSTEMS MODEL 1950, ARMY MODEL SPE-23) NSN 7320-00-298-1380
(GREEN AND SONS MODEL 1954, ARMY MODEL SPE-30) NSN 7320-00-215-5189
(WASHINGTON INDUSTRIAL PRODUCTS, INC. MODEL 8848) NSN 7320-00-815-2682
(CAM INDUSTRIES MODEL C-PB30623) NSN 7320-00-935-6632
(CAM INDUSTRIES MODEL C-PB30623) NSN 7320-00-328-4760

BAKERY OVEN, TRAILER MOUNTED; 208V to 220V, AC; 60 HZ, 3-PHASE
(AMERICAN MACHINERY MODEL, ARMY MODEL SPV-26) NSN 7310-00-255-8068
(CENTURY MACHINE MODEL MO-311, ARMY MODEL SPV-31) NSN 7310-00-215-5260
(CAM INDUSTRIES MODEL 533-235) NSN 7310-00-903-5402

TM 10-7360-201-20, 17 March 1961, is changed as follows:

Page 1, Table of Contents. The Reporting of Errors paragraph is superseded as follows:

REPORTING OF ERRORS AND RECOMMENDING IMPROVEMENTS

You can help improve this manual. If you find any mistakes or if you know of a way to improve the procedures, please let us know. Mail you letter, DA Form 2028 (Recommended Changes to Publications and Blank Forms) direct to: Commander, US Army Troop Support & Aviation Materiel Readiness Command, ATTN: DRSTS-MPSD, 4300 Goodfellow Blvd., St. Louis, MO 63120. A reply will be furnished to you.

Page 2, paragraph 1 ***c*** is superseded as follows:

c. Reporting Equipment Improvement Recommendation (EIR's). EIR's can and must be submitted by anyone who is aware of an unsatisfactory condition with the equipment design or use. It is not necessary to show a new design or list a better way to perform a procedure, just simply tell why the design is unfavorable or why a procedure is difficult. EIR's may be submitted on Standard Form (SF) 368. Mail directly to Commander, US Army Troop Support & Aviation Materiel Readiness Command, ATTN: DRSTS-MPSD, 4300 Goodfellow Blvd., St. Louis, MO 63120. A reply will be furnished to you.

Page 3, paragraph 6. Change the word “cycle” to read “Hertz” wherever it appears.

Page 38, figure 12, is superseded as follows:

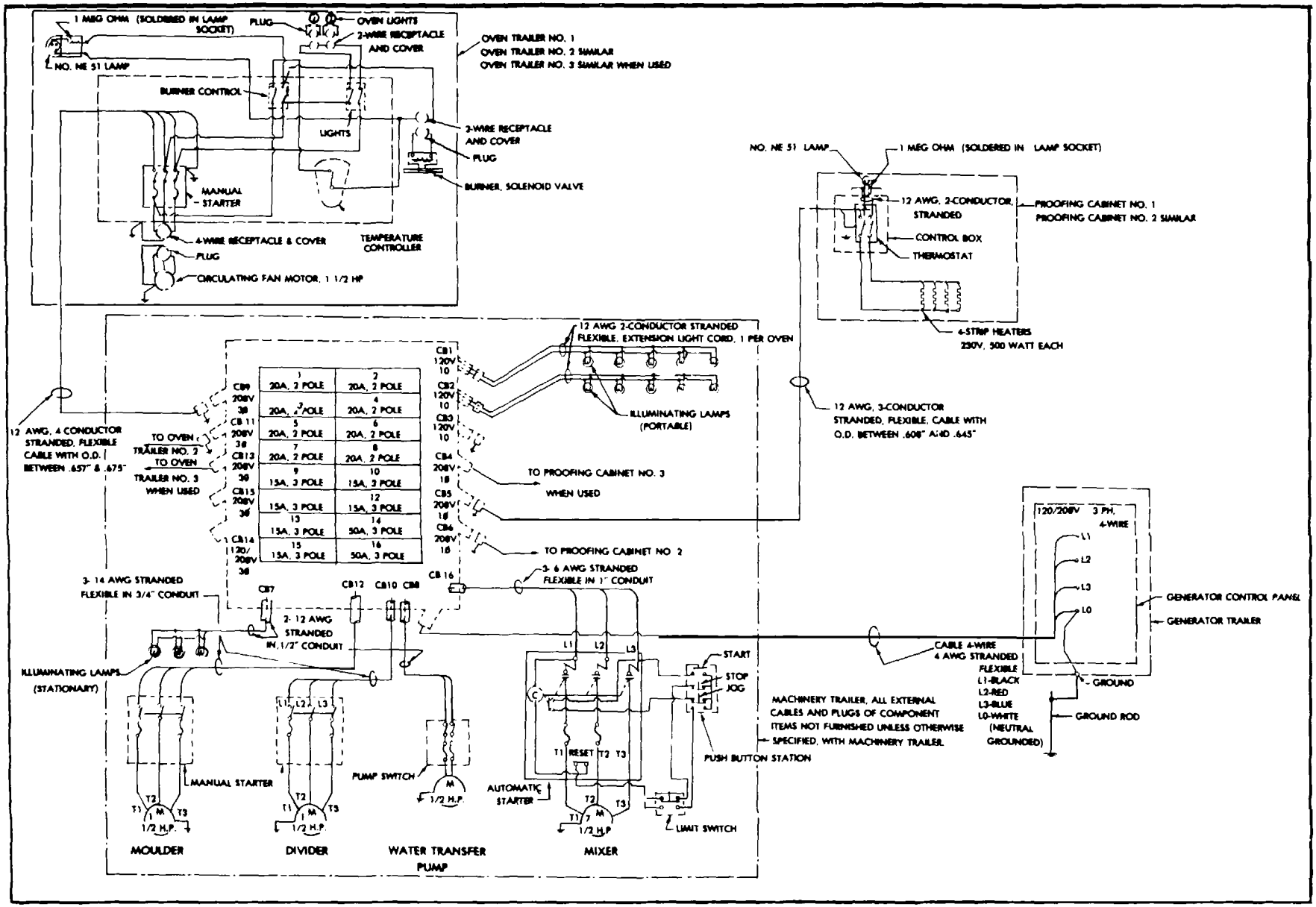


Figure 12. Wiring diagram, bakery plant trailer mounted.

Page 103, Appendix I is superseded as follows:

APPENDIX I

REFERENCES

1.	Fire Protection and Safety	Hand Portable Fire Extinguishers Approved for Army Users.
	TB 5-4200-200-10	
	TB MED 251	Noise and Conservation of Hearing.
2.	Lubrication	
	C9100-1L	Fuels, Lubricants, Oils, and Waxes
	LO 10-7360-201-20-1	Bakery Plant, Trailer Mounted, M-1945 Dough Mixing and Make-up Outfit, Army Models SPV-18 and SPV-30 (Mixer) .
	LO 10-7360-201-20-2	Bakery Plant, Trailer Mounted, M-1945 Dough Mixing and Make-up Outfit, Army Models SPV-18 and SPV-30 (Divider).
	LO 10-7360-201-20-3	Bakery Plant, Trailer Mounted, M-1945 Dough Mixing and Make-up Outfit, Army Models SPV-18 and SPV-30 (Molder).
	LO 10-7360-201-20-4	Bakery Plant, Trailer Mounted, M-1945 Dough Mixing and Make-up Outfit, Army Models SPV-18 and SPV-30 (Monorail and trailer chassis).
	LO 10-7360-201-20-5	Bakery Plant, Trailer Mounted, M-1945; Bakery Oven Army Models SPV-26, SPV-31, and M-533.
	LO 10-7360-201-20-6	Bakery Plant, Trailer Mounted, M-1945; (Chassis, Trailer, 2 ½-ton, 2-wheel, M-537, Used with Bakery Oven M-533).
3.	Painting	
	TM 43-0147	Color, Marking and Camouflage Patterns Used on Military Equipment Managed by TSARCOM.
	TM 43-0139	Painting Instructions for Field Use.
4.	Cleaning	
	C 6800 IL	Chemicals and Chemical Products.
	SB725-7930-1	Hard and Soft Water Cleaning Compounds.
5.	Maintenance	
	TM 5-4310-333-14	Compressor, Air (Champion Pneumatic Model BMa-3M-1), NSN 4310-063-7375.
	TM 9-2330-274-14	Chassis, Trailer, 2 ½-ton, 2-wheel, M-537, NSN 2330-00-777-2958. Chassis, Trailer, 4-ton, 4-wheel, M-795, NSN 2330-00-089-4321.
	TM 10-281	Field Bakery Operations.
	TM 10-7360-201-10	Bakery Plant, Trailer, Mounted, Field: 16,000-lb Capacity per 24 Hr. Models M-1945, M-1945-50, M-1945-53, M-534-68, NSN 7360-00-221-2418.
	TM 38-750	Army Maintenance Management System (TAMMS)

APPENDIX I

REFERENCES

(CONT)

6.	Shipment and Storage	
	TM 746-10	Marking, Packaging and Shipment of Supplies and Equipment: General Packaging Instructions For Field Use.
	TM 38-230-1	Preservation and Packing of Military Equipment.
	TM 740-90-1	Administrative Storage of Equipment.
7.	Demolition	
	TM 750-244-3	Destruction of Materiel to Prevent Enemy Use.

By Order of the Secretary of the Army:

E. C. MEYER
General, United States Army
Chief of Staff

Official:

ROBERT M. JOYCE
Major General, United States Army
The Adjutant General

DISTRIBUTION:

To be distributed in accordance with DA Form 12-25A, Organizational Maintenance Requirements for Equipment: Baking.

Changes in force: C 2 through C 6

TM 10-7360-201-20
C6

CHANGE No. 6

HEADQUARTERS
DEPARTMENT OF THE ARMY
WASHINGTON, DC, *21 May 1976*

Organizational Maintenance Manual

BAKERY PLANT, TRAILER MOUNTED, FIELD; 16,000-LB CAPACITY OUTPUT PER 24-HR: MODELS M-1945, M1945-50, M-1945-53, M-53468, NSN 7360-00-221-2418

CONSISTING OF:

SIFTER MACHINE, FLOUR; ELECTRIC; AGITATOR-TYPE, 110 V, AC, 60 HZ; 55-LB PER MINUTE
(ALLIS-CHALMERS MODEL, ARMY MODEL SPE-20) NSN 7320-00-221-2386
(ARMSTRONG PRODUCTS MODEL 42386) NSN 7320-00-043-5340

DOUGH MIXING AND MAKEUP OUTFIT; TRAILER MOUNTED
(CENTURY MACHINE MODEL, ARMY MODEL SPV-18) NSN 7320-00-255-7769
(CENTURY MACHINE MODEL TR306, ARMY MODEL SPV-30) NSN 7320-00-215-5256
(BAKER-PERKINS MODEL TM-BP-68) NSN 7320-00-880-8745
(CAM INDUSTRIES MODEL M534-1) NSN 7320-00-334-5336

CABINET, DOUGH PROOFING; 36-PAN CAPACITY; ELECTRICALLY HEATED; 220 V, AC, 60 HZ
(DRYING SYSTEMS MODEL 1950, ARMY MODEL SPE-23) NSN 7320-00-298-1380
(GREEN AND SONS MODEL 1954, ARMY MODEL SPE-30) NSN 7320-00-2155189
(WASHINGTON INDUSTRIAL PRODUCTS, INC. MODEL 8848) NSN 7320-00-8152682
(CAM INDUSTRIES MODEL C-PB30623) NSN 7320-00-935-6632
(CAM INDUSTRIES MODEL C-PB30623) NSN 73204)0-328-4760

BAKERY OVEN, TRAILER MOUNTED; 208 V TO 220 V, AC; 60 HZ, 3-PHASE
(AMERICAN MACHINERY MODEL, ARMY MODEL SPV-26) NSN 7310-00-255-8068
(CENTURY MACHINE MODEL MO-311, ARMY MODEL SPV-31) NSN 7310-00-2155260
(CAM INDUSTRIES MODEL 533-235) NSN 7310-00-903-5402

TM 10-7360-201-20, 17 March 17 1961, is changed as follows:

The title is changed to read as shown above.

NOTE

Throughout the manual all "Federal Stock Numbers" should be corrected to the new "National Stock Number" before using. This can be done by inserting-00 after the Federal stock class. *For example*, Federal Stock Number 6350-288-2735 will be corrected to the following National Stock Number: 6350-00-288-2735. Wherever the words "Federal Stock Number" appear correct to read, "National Stock Number."

Page 1, paragraph 1*a*(2), line 3. Add "or NSN 7320-00-334-5336."
Paragraph 1*a*(3), line 3. Add "or NSN 7320-00-328-4760."
Paragraph 1*a*(5), line 3. Add "or NSN 2330-00-089-4321."
Paragraph 1*c* is rescinded.

By Order of the Secretary of the Army:

FRED C. WEYAND
General, United States Army
Chief of Staff'

Official:

PAUL T. SMITH
Major General, United States Army
The Adjutant General

Distribution:

To be distributed in accordance with DA Form 12-25A, (qty rqr block No. 102) Organizational maintenance requirements for Baking Equipment.

Changes in Force: C 2 through C 5

TM 10-7360-201-20
C6

CHANGE No. 5

HEADQUARTERS
DEPARTMENT OF THE ARMY
WASHINGTON, D. C., *10 June 1970*

Organizational Maintenance Manual

BAKERY PLANT, TRAILER MOUNTED, FIELD; 16,000-LB. CAPACITY OUTPUT PER 24-HR.; MODELS M-1945, M-1945-50, M-1945-53, M-534-68, FSN 7360-221-2418

CONSISTING OF:

SIFTER MACHINE, FLOUR; ELECTRIC; AGITATOR-TYPE; 110 V, AC, 60 HZ.; 55-LB. PER MINUTE
(ALLIS-CHALMERS MODEL, ARMY MODEL SPE-20) FSN 7320-221-2386
(ARMSTRONG PRODUCTS MODEL 42386) FSN 7320-043-5340

DOUGH MIXING AND MAKE-UP OUTFIT; TRAILER MOUNTED
(CENTURY MACHINE MODEL, ARMY MODEL SPV-18) FSN 7320-255-7769
(CENTURY MACHINE MODEL TR306, ARMY MODEL SPV-30) FSN 7320-215-5256
(BAKER-PERKINS MODEL TM-BP-68) FSN 7320-880-8745

CABINET, DOUGH PROOFING; 36-PAN CAPACITY; ELECTRICALLY HEATED; 220V, AC, 60 HZ.
(DRYING SYSTEMS MODEL 1950, ARMY MODEL SPE-23) FSN 7320-298-1380
(GREEN AND SONS MODEL 1954, ARMY MODEL SPE-30) FSN 7320-215-5189
(WASHINGTON INDUSTRIAL PRODUCTS, INC. MODEL 8848) FSN 7320-815-2682
(CAM INDUSTRIES MODEL C-PB30623) FSN 7320-935-6632

BAKERY OVEN, TRAILER MOUNTED; 208V TO 220V, AC, 60 HZ., 3-PHASE
(AMERICAN MACHINERY MODEL, ARMY MODEL SPV-26) FSN 7310-255-8068,
(CENTURY MACHINE MODEL 0-311, ARMY MODEL SPV-31) FSN 7310-215-5260,
(CAM INDUSTRIES MODEL 533-235) FSN 7310-903-5402

TM 10-7360-201-20, 17 March 1961, is changed as follows:

The title is changed to read as shown above.

Page 1. CHAPTER 4 is superseded as follows:

Page 2. Paragraph 1, Scope, is superseded as follows:

1. Scope

a. These instructions are published for the use of personnel to whom the trailer-mounted bakery plant is issued. The following pages contain information on organizational maintenance. Listed below are the number, name, and Federal Stock Number of each of the components that comprise the trailer-mounted bakery plant.

(1) Three-Trailer-Mounted Bakery Ovens (FSN 7310-215-5260, FSN 7310-255-8068, and FSN 7310-903-5402). The ovens can be all of one model or any combination of the three models.

(2) One trailer-mounted Dough Mixing and Make-up Outfit (FSN 7320-255-7769, FSN 7320-215-5256, and 7320-880-8745). Either model is used.

(3) Three Dough-Proofing Cabinets (FSN 7320-215-5189, FSN 7320-298-1380, FSN 7320-815-2682, and FSN 7320-935-6632). The dough-proofing cabinets can be all of one model or any combination of all four models.

(4) Two Electric Flour Sifting Machines (FSN 7320-221-2386 and FSN 7320-043-5340). Either model may be used.

(5) Model 534-68 Bakery Plant is mounted on a 4-ton, 4-wheel, M-795 trailer chassis (FSN 2330-089-4321).

(6) Model 534-68 Bakery Plant has a Champion Model BMA-3M-1 air compressor (FSN 4310-063-7375).

(7) Two generator sets, PU-406/M (FSN 6115-738-6342) are required to furnish electrical power for the Bakery Plant and must be requisitioned separately.

b. Instructions for operation and maintenance of the generator sets, PU-406/M, are found in TM 5-6115-365-15 and in TM 5-6115-321-12; refer to TM 5-4310-333-14 for information covering the air compressor; and TM 9-2330-274-14 covers operation and maintenance of the 4-wheel trailer.

c. Reporting of errors, omissions, and recommendations for improving this publication by the individual user is encouraged. Reports should be submitted on DA Form 2028 (Recommended Changes to Publications) and forwarded direct to the Commanding General, U. S. Army Mobility Equipment Command, ATTN: AMSME-MPP, 4300 Goodfellow Boulevard, St. Louis, Mo. 63120.

Page 2. Paragraph 2. REFERENCES is rescinded in its entirety.

Page 2. Paragraph 3 is superseded as follows:

DA Forms and procedures used for equipment maintenance are listed and prescribed in TM 38-750, The Army Maintenance Management System (TAMMS).

Page 3. Paragraph 6*a*. The following is added immediately preceding “Mixer Motor”:

Trailer:

Height..... 9 feet 3 inches
Length (work platform lowered)..... 20 feet 1 inch
Width (monorail extended) .....11 feet 9 inches
Weight (approximate)..... 11,000 pounds
Ground clearance (M795)
(Tandem-wheeled)..... 12 inches
Work platform height (M795)
(Tandem-wheeled)..... 36 inches

Trailer (Continued)
Width (M795) (Tandem-wheeled) ..... 97 inches
Length (M795) (Tandem-wheeled)..... 197-½ inches
Total weight (M795) (Tandem-wheeled)..... 13,120 pounds

Page 3. Paragraphs 6*d* and *e* are added after paragraph 6*c* as follows:

d. Air Compressor. (Refer to TM 5-4310-333-14)

Manufacturer ..... Champion
Model BMA-3M-1
Bore and stroke ..... 1-¾ x 2
Displacement .....2.7 CFM
Delivery.....1.5 CFM
Crankcase oil capacity.....6 oz.
Shipping weight ..... 50 pounds
Overall dimensions.....13 in. x 15 in. x 22 in.
Electric motor data ..... ½ hp, 48 Frame
Power requirements.....115V, 60 Hz, 1 phase

e. Proofing Cabinet

Capacity:
Bread pans 36
Water pans..... 4
Dimensions:
Height..... 70 inches
Width..... 70 inches
Width (model C-PB30623)..... 68 inches
Depth..... 28 inches
Depth (model C-PB30623)..... 31 inches
Weight..... 386 pounds

Page 39. Paragraph 20 is rescinded.

Page 61. Figures 28.1 and 28.2 are added after figure 28.

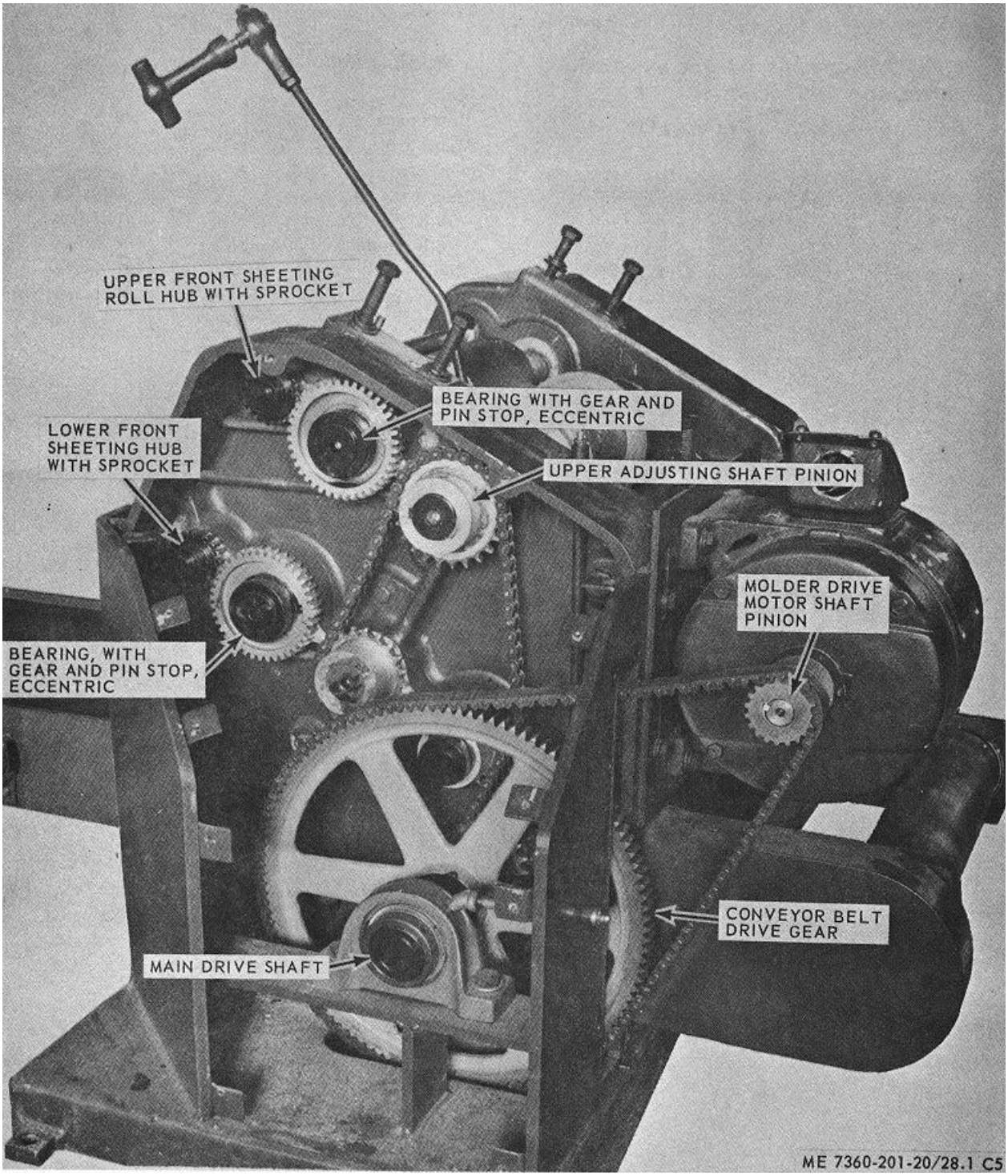


Figure 28.1. Molder headframe, left side Model 534-68.
(ME 7360-201-20/28.1 C5)

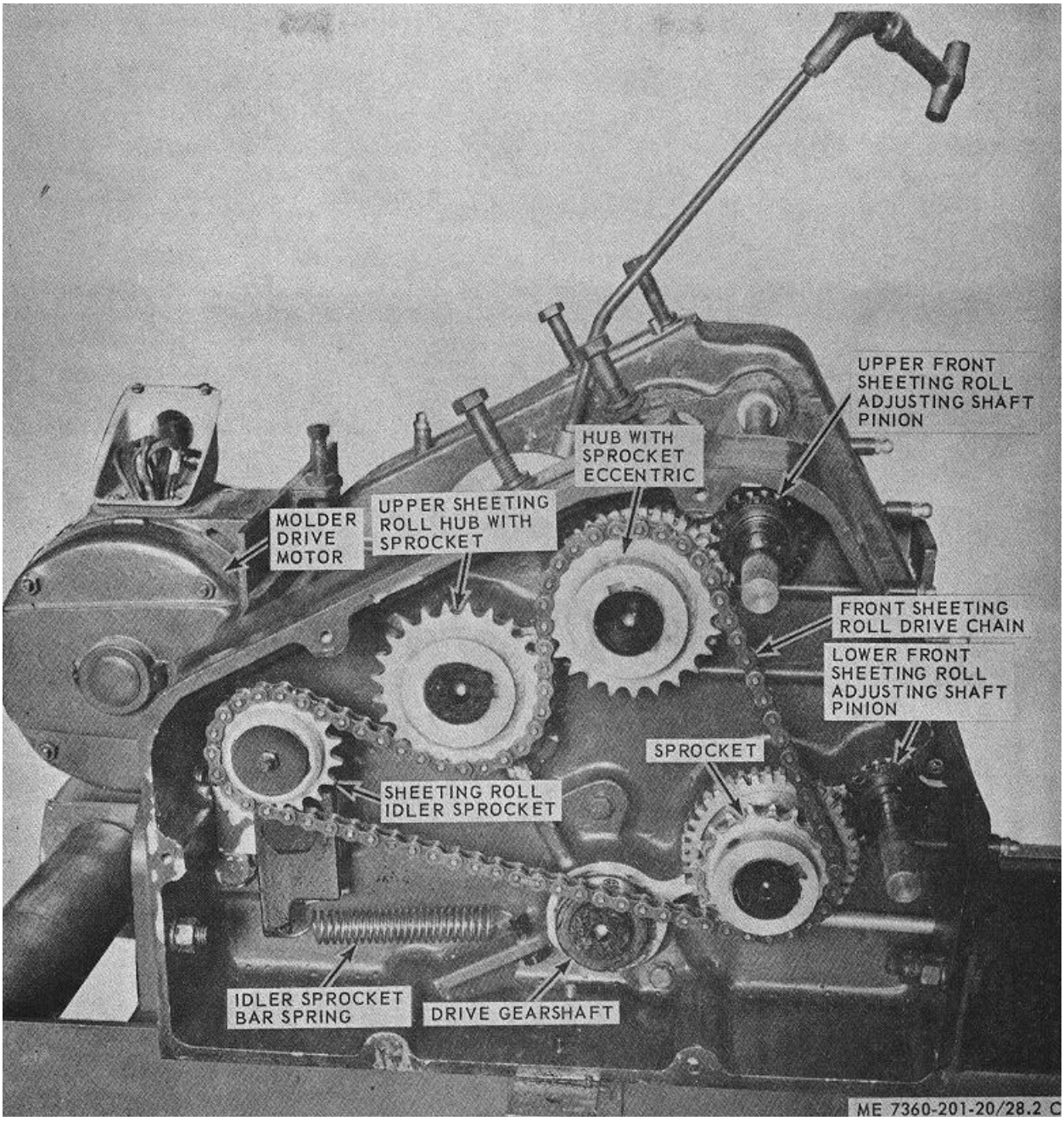


Figure 28.2. Molder headframe, right side Model 534-68.
(ME 7360-201-20/28.2 C5)

Page 63. Paragraph 58. A NOTE is added after subparagraph *a* as follows:

Note

The conveyor belt on Model 534-68 is a one-piece belt unlike the lacing conveyor belt shown in figure 31. The belt on Model 534-68 is removed by loosening the belt adjusting screws completely, and removing the retaining pin and bracket shown in figure 30.1.

Page 64. Figure 30.1 is added after figure 30.

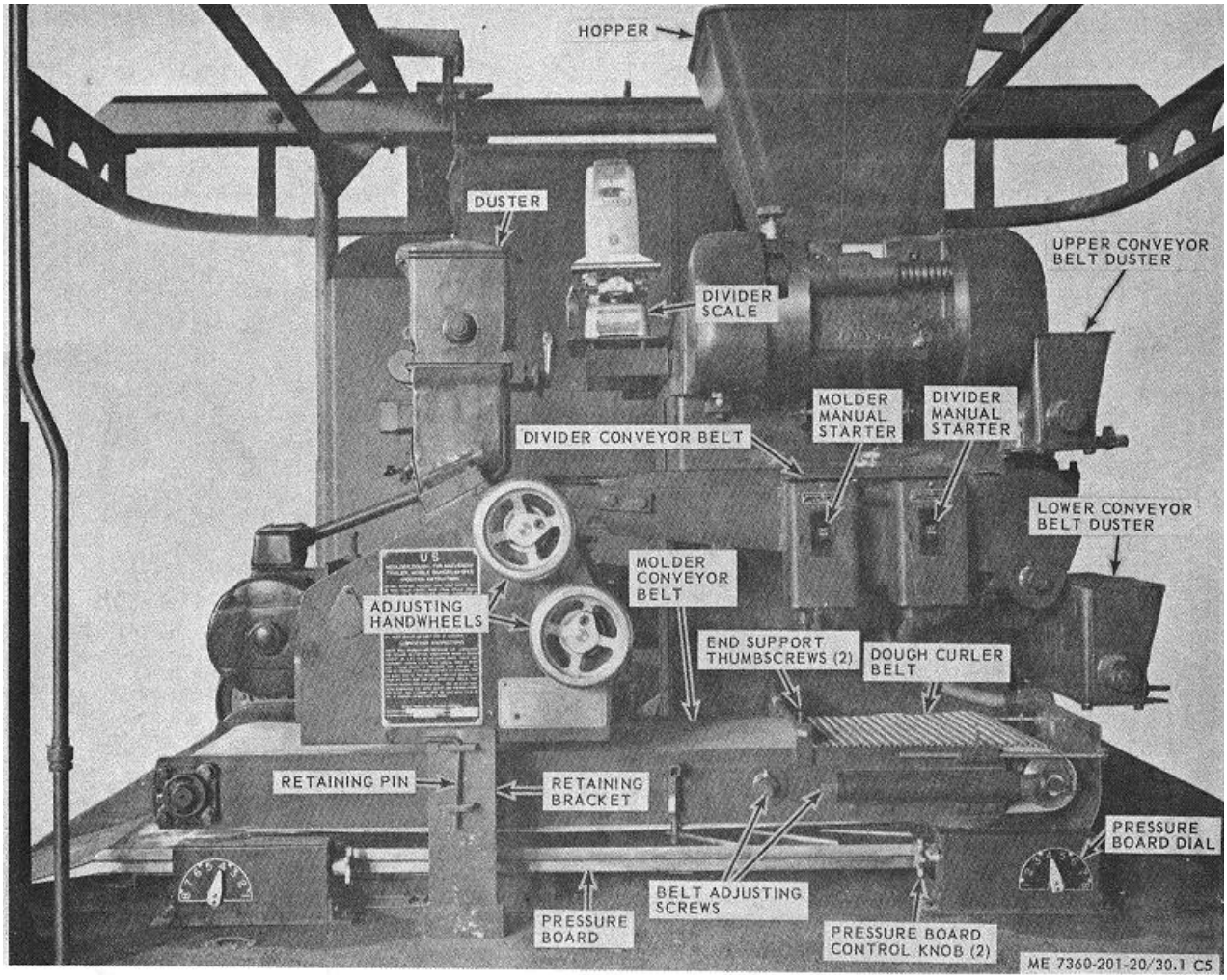


Figure 30.1. Molder and divider assemblies, Model 534-68.
(ME 7360-201-20/30.1 C3)

Page 75. Paragraph 97. In line 3, add the following after the word installed: "See figures 38 and 39".

Page 76. Paragraph 103*d* is superseded as follows:

a. Adjust the idler belt pulley as instructed in TM 10-7360-201-10.

Page 79. Figure 40.1 is added after figure 40.

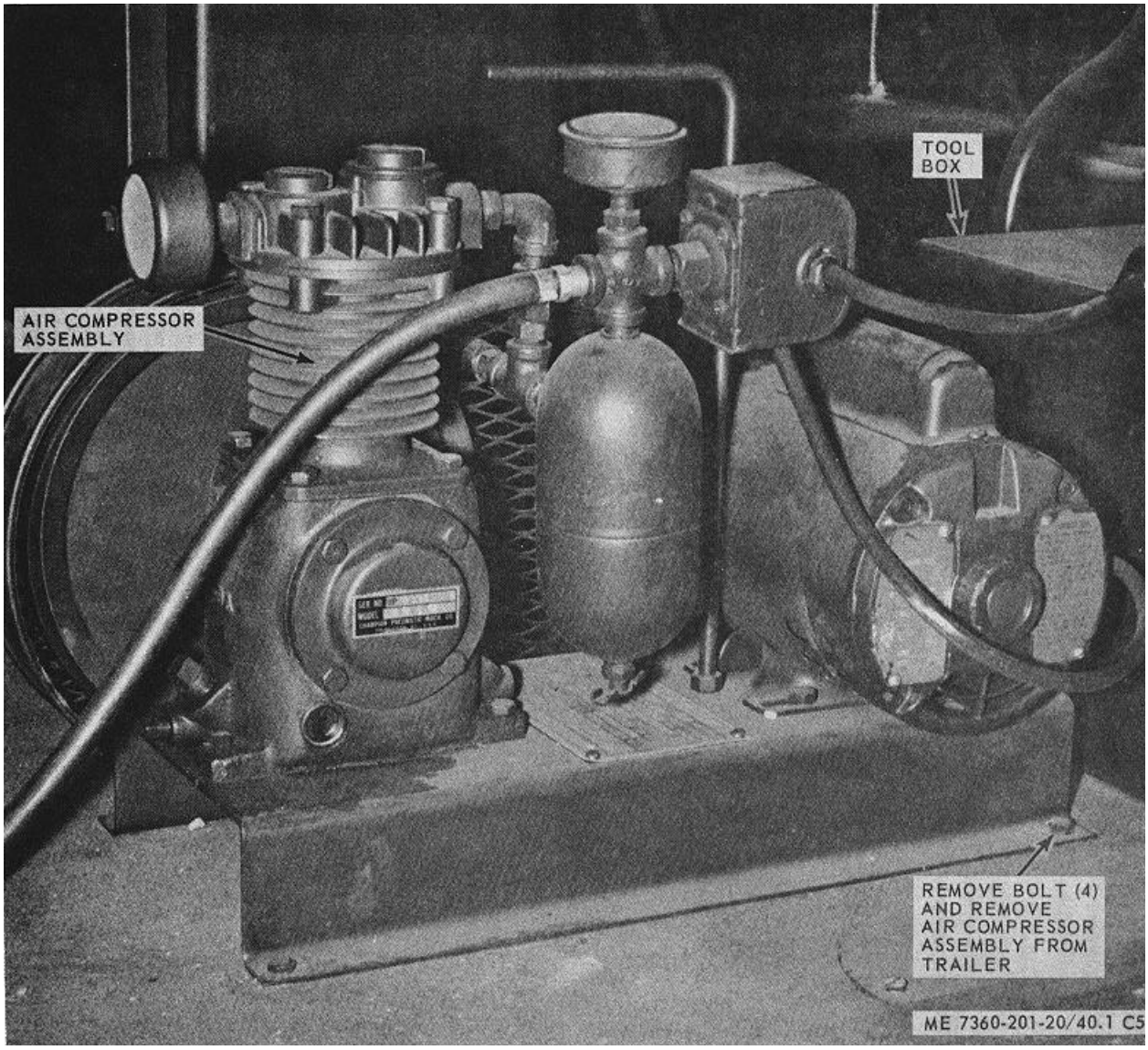


Figure 40.1. Air compressor assembly, Model BMA-3M-1.
(ME 7360-201-20/40.1 C5)

Page 80. Paragraph 121.1 is added after paragraph 121 as follows:

121.1. Air Compressor (Bakery Plant Model 534-68).

The air compressor is mounted on the trailer bed next to the tool box (fig. 40.1) and is used primarily for cleaning the equipment.

For maintenance and operating instructions, refer to TM 5-4310-333-14.

Page 97. Figure 57.1 is added after figure 57.

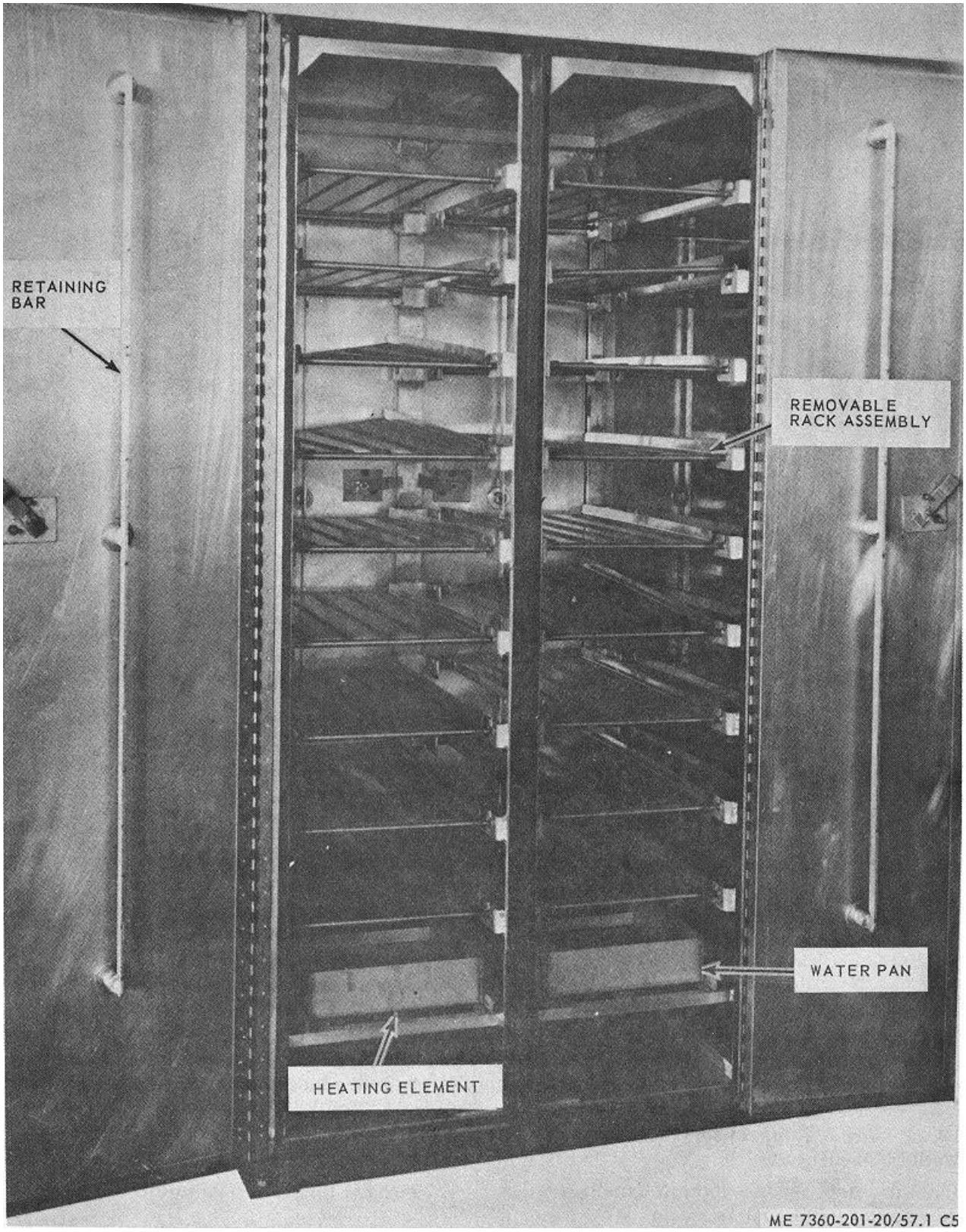


Figure 57.1. Proofing cabinet with front doors open, Model 534-68 (ME 7360-201-20/57.1 C5).

Page 101. Chapter 4 is superseded as follows:

CHAPTER 4

ADMINISTRATIVE STORAGE AND INSTRUCTIONS FOR DESTRUCTION OF MATERIEL TO PREVENT ENEMY USE

Section I. ADMINISTRATIVE STORAGE

Preparation, care, and removal of equipment in administrative storage will be in accordance with the applicable requirements of TM 740-90-1 (Administrative Storage of Equipment).

Section II. INSTRUCTIONS FOR DESTRUCTION OF MATERIAL TO PREVENT ENEMY USE

Instructions for equipment destruction to prevent enemy use are covered in TM 750-244-3.

Page 103. APPENDIX I is superseded as follows:

APPENDIX I

REFERENCES

1. Fire Protection

TB 5-4200-200-18	Hand Portable Fire Extinguishers for Army Users.

2. Lubrication

C 9100-IL	Fuels, Lubricants, Oils, and Waxes.
LO 10-7360-201-20-1	Bakery Plant, Trailer Mounted, M-1945 Dough Mixing and Make-up Outfit, Army Models SPV-18 and SPV-30 (Mixer).
-2	Bakery Plant, Trailer Mounted, M-1945 Dough Mixing and Make-up Outfit, Army Models SPV-18 and SPV-30 (Divider).
-3	Bakery Plant, Trailer Mounted, M-1945 Dough Mixing and Make-up Outfit, Army Models SPV-18 and SPV-30 (Molder).
-4	Bakery Plant, Trailer Mounted, M-1945 Dough Mixing and Make-up Outfit, Army Models SPV-18 and SPV-30 (Monorail and trailer chassis).
-5	Bakery Plant, Trailer Mounted, M-1945; Bakery Oven Army Models SPV-26, SPV-31, and M-533.
-6	Bakery Plant, Trailer Mounted, M-1945 (Chassis, Trailer, 2½-ton, 2-wheel, M-537, Used with Bakery Oven M-533).

3. Painting

TM 9-213	Painting Instructions for Field Use.

4. Cleaning

C 6800 IL	Chemicals and Chemical Products.
SB725-7930-1	Hard and Soft Water Cleaning Compounds.

5. Maintenance

TM 5-4310-333-14	Compressor, Air (Champion Pneumatic Model BMA-3M-1) FSN 4310-063-7375.
TM 9-2330-274-14	Chassis, Trailer, 2 ½-ton, 2-wheel, M-537, FSN 2330-777-2958.
	Chassis, Trailer, 4-ton, 4-wheel, M-795, FSN 2330-089-4321.
TM 10-281	Field Bakery Operations.
TM 10-7360-201-10	Bakery Plant, Trailer Mounted, Field: 16,000-lb Capacity per 24 Hr. Models M-1945, M-1945-50, M-1945-53, M-53468, FSN 7360-221-2418.
TM 38-750	Army Maintenance Management Systems (TAMMS)

6. Shipment and Storage

TB 740-93-2	Preservation of USAMEC Mechanical Equipment for Shipment and Storage.
TM 38-230-1	Preservation and Packing of Military Equipment.
TM 740-90-1	Administrative Storage of Equipment.

7. Demolition

TM 750-244-3	Destruction of Materiel to Prevent Enemy Use.

Page 109. The following entries for MOLDER ASSEMBLY on Bakery Plant Model 534-68 are added after line 5:

	Echelon				
	1	***2***	***3***	***4***	***5***
Molder Assembly (Model 534-68)					
Inspect	X				
Replace, Repair		X			
Rebuild			X		
Belt Assemblies, molder dough curler and conveyor					
Inspect, Replace		X			
Hub With Sprocket, molder conveyor belt drive shaft					
Inspect, Replace		X			
Board Assembly, pressure					
Clean	X				
Inspect, Replace		X			

	Echelon				
	1	2	3	4	5
Pulleys, Molder Conveyor belt drive and idler					
Adjust	X				
Inspect, Replace			X		
Molder Sheeting Rolls, Drive Shaft, Duster Bearings & Bushings					
Inspect, Replace			X		
Eccentric, molder sheeting roll shaft					
Inspect, Replace			X		
Gear, Drive, Molder sheeting rolls and conveyor					
Inspect, Replace			X		
Handle and Engaging Screw, duster adjusting stud					
Inspect, Replace			X		
Hubs with Sprockets, front and rear sheeting roll shaft					
Inspect, Replace			X		
Lever, Regulating, duster, agitator					
Adjust	X				
Inspect, Replace			X		
Pinions, lower and upper front sheeting roll adjusting shaft					
Inspect, Replace			X		
Pinion, molder motor shaft					
Inspect, Replace			X		
Rod, drive, molder sheeting roll duster					
Inspect, Replace			X		
Screen, molder sheeting roll duster					
Inspect, Replace			X		
Shaft Assemblies, sheeting roll					
Inspect, Replace			X		
Shaft, drive, motor sheeting rolls and conveyor					
Inspect, Replace			X		
Springs, front sheeting roll adjusting shaft handwheel					
Inspect, Replace			X		
Springs, tension; chain idler sprocket					
Inspect, Replace			X		
Sprockets, sheeting roll shaft					
Inspect, Replace			X		
Stud, adjusting, duster agitator lever					
Inspect, Replace		X			
Controls, Instruments, and Switches					
Inspect, Replace, Repair		X			
Carrier, dough trough					
Inspect, Replace, Repair		X			
Springs, monorail latch					
Inspect, Replace		X			
Wheel Assemblies, monorail					
Inspect			X		
Replace.					

Page 109. Under GROUP 06 - ELECTRICAL, lines 9, 10, and 11, "Battery, emergency brake -- Inspect, Replace" are rescinded.

Page 114. In second column, lines 19, 20, and 21 are superseded as follows:

	Paragraph	Page
Demolition		101

Page 117. In second column, line 23 is rescinded and last line is changed to read:

	Paragraph	Page
Storage, administrative.		101

By Order of the Secretary of the Army:

W. C. WESTMORELAND,
General, United States Army,
Chief of Staff.

Official:

KENNETH G. WICKHAM,
Major General, United States Army,
The Adjutant General.

Distribution:
To be distributed in accordance with DA Form 12-25, Sec I (qty rqr Block No. 102), Organizational maintenance requirements for Equipment: Baking.

Changes in force: C 2, C 3, and C 4

TM 10-7360-201-20
C4

CHANGE
No. 4

HEADQUARTERS
DEPARTMENT OF THE ARMY
WASHINGTON, D.C., *24 March 1966*

Organizational Maintenance Manual

BAKERY PLANT, TRAILER-MOUNTED, M-1945 (FSN 7360-221-2418)

TM 10-7360-201-20, 17 March 1961, is changed as follows:

"Bakery Plant, Mobile M-1945" on the cover page and wherever it appears throughout, the manual is changed to read "Bakery Plant, Trailer-Mounted, M-1945".

Add "(SPV26 and SPV31)" immediately after the title in paragraphs 152, 153, 157, and 158, and in figures 47, 48, 49, and 51.

1. Scope

a. (Superseded) These instructions are published for the use of personnel responsible for the organizational (second echelon) maintenance of the M-1945 Trailer-Mounted Bakery Plant (FSN 7360-221-2418). Listed below are the number, the name, and the Federal stock number of each of the components that comprise the M-1945 trailer-mounted bakery plant.

(1) Three Trailer-Mounted Bakery Ovens (FSN 7310-215-5260, FSN 7310-255-8068, and FSN 7310-903-5402). The bakery oven can be all of one model or any combination of the three models.
(2) One Trailer-Mounted Dough Mixing and Makeup Outfit (FSN 7320-255-7769 and FSN 7320-215-5256). Either model is used.
(3) Three Dough-Proofing Cabinets (FSN 7320-215-5189, FSN 7320-298-1380, and FSN 7320-815-2682). The dough-proofing cabinets can be all of one model or any combination of the three models.
(4) One Electric Flour Sifting Machine (FSN 7320-221-2386).
(5) Two Generator Sets (FSN 6115-376-7006, FSN 6115-312-7865, FSN 6115-635-8143, and FSN 6115-538-8726) and the accessories. The generator sets can be both of one model or any combination of two out of the four models.

* * * *

c. (Superseded) The direct reporting by the individual user of errors, omissions, and recommendations for improving this manual is authorized and encouraged. DA Form 2028 (Recommended Changes to DA Publications) will be used for reporting these improvement recommendations. This form will be completed using pencil, pen, or typewriter and forwarded direct to Commanding General, U.S. Army Mobility Equipment Center, ATTN: SMOME-MPD, 4300 Goodfellow Blvd., St. Louis, Mo. 63120.

* * * * *

7. General

* * * * *

b. (Superseded) The services described in paragraphs 8 and 9 will apply to both new and used equipment.

* * * * *

11. Lubrication Under Usual Conditions

* * * * *

(1) (Superseded) *LO 10-7360-201-20-1.* LO 10-7360-201-20-1 (fig. 1) prescribes lubrication for the Mixer on the Trailer-Mounted Dough Mixing and Makeup Outfit, Army models SPV18 and SPV30.
Figure 2. Mixer lubrication points. **Rescinded.**
(2) (Superseded) *LO 10-7360-201-20-2.* LO 10-7360-201-20-2 (fig. 3) prescribes lubrication for the Divider on the Trailer-Mounted Dough Mixing and Makeup Outfit, Army models SPV18 and SPV30.
Figure 4. Divider lubrication points. **Rescinded.**
(3) (Superseded) *LO 10-7360-201-20-3.* LO 10-7360-201-20-3 (fig. 5) prescribes lubrication for the Molder on the Trailer-Mounted Dough Mixing and Makeup Outfit, Army models SPV18 and SPV30.

Figure 6. Molder lubrication points. **Rescinded.**

(4) (Superseded) *LO 10-7360-201-20-4.* LO 10-7360-201-204 (fig7) prescribes lubrication for the Monorail and Trailer Chassis on the Trailer-Mounted Dough Mixing and Makeup Outfit, Army models SPTV18 and SPV30.

Figure 8. Monorail and trailer chassis lubrication points. **Rescinded.**

(5) (Superseded) *LO 10-7360-201-20-5.* LO 10-7360-201-20-5 (fig. 9) prescribes lubrication for the Trailer Mounted Bakery Oven, Army models SPV26, SPV31, and M533, with the exception of the trailer chassis for model M533, which is LO 10-7360-201-20-6.

Figure 10. Oven trailer lubrication points. **Rescinded.**

(6) (Added) *LO 10-7360-201-201-20-6.* LO 10-7360-201-20-6 (fig. 10) prescribes lubrication for the M537, 2-Wheel, 2 1/2-Ton Trailer Chassis on the 51533 Trailer-Mounted Bakery Oven.

*** * * * ***

11.1. "Lubrication Intervals"
Rescinded.

Figure 10.1. (MSC 7360-201-20/10.1 (9) C3) --Continued. **Rescinded.**

LUBRICATION ORDER

LO10-7360-201-20-1

4 FEBRUARY 1966 (Supersedes LO10-7360-201-20-1,20 Feb. 61)

BAKERY PLANT, TRAILER-MOUNTED, M-1945: DOUGH MIXING AND MAKEUP OUTFIT, ARMY MODELS SPV18 AND SPV30

(MIXER)

REFERENCE: LO10-7360-201-20-2,-3,-4,-5,-6. C9100-IL

Intervals are based on normal operation. Reduce to compensate for abnormal operation and severe conditions. During inactive periods, sufficient lubrication must be performed for adequate preservation.

Relubricate after washing or fording.

Clean fittings before lubricating.

Clean parts with SD (Solvent, drycleaning).

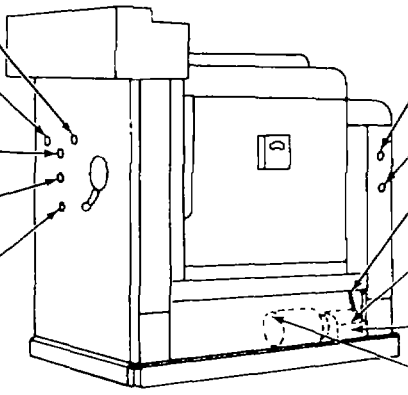
Dry before lubricating.

Broken arrow shafts indicate lubrication points on both sides of the equipment.

FOLD FOLD

LUBRICANT • INTERVAL

- Wormshaft Bearing GAA 50
- Left Shaft Agitator Bearing GAA 50
- Handwheel Shaft Bearing GAA 50
- Left Support Trunnion Fitting GAA 50
- Dump Shaft Sleeve Bushing GAA 50



INTERVAL • LUBRICANT

- 50 GAA Right Shaft Agitator Bearing
- 50 GAA Right Support Trunnion Fitting
- 250 OE *Drive Chain* (See Note 1)
- 50 OE Gear Reduction Unit Oil Level Gage (See Note 3)
- 500 OE Gear Reduction Unit Drain (See Note 3)
- 500 GAA Motor Bearings (See Note 2)

— KEY —

LUBRICANTS	EXPECTED TEMPERATURES — ALL TEMPERATURES	INTERVALS
OE - LUBRICATING OIL, Internal Combustion Engine	OE 30 or 9250	Intervals *given are* in hours of normal operation.
Drive Chain	OE 10 or 9110	
GAA - GREASE, Automotive and Artillery	GAA	

MEC 7360-201-20-1 ①

Figure 1. (Superseded) LO 10-7360-201-20-1.

NOTES:

1. DRIVE CHAINS. Every 250 hours clean, coat sparingly with OE-10, and wipe oil from outer surface.

2. MOTOR BEARINGS. Every 500 hours grease sparingly with GAA, too much grease will cause bearings to overheat.

3. GEAR REDUCTION UNIT. Every 50 hours check oil level and keep level up to center of gage. Every 500 hours drain oil, remove top of reduction unit, and refill with OE-30.

Copy of this Lubrication Order will remain with the equipment at all times. Instructions contained herein are mandatory.

BY ORDER OF THE SECRETARY OF THE ARMY

HAROLD K. JOHNSON
General, United States Army.
Chief of Staff.

OFFICIAL

J. C. LAMBERT,
Major General, United States Army,
The Adjutant General

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MEC 7360-201-20-1 (2)

Figure 1-Continued.

LUBRICATION ORDER

LO10-7360-201-20-2

4 FEBRUARY 1966 (Supersedes LO10-7360-201-20-2, 28 Feb. 61)

BAKERY PLANT, TRAILER-MOUNTED, M-1945: DOUGH MIXING AND MAKEUP OUTFIT, ARMY MODELS SPV18 AND SPV30 (DIVIDER)

Reference: LO10-7360-201-20-1,-3,-4,-5,-6 C9100-IL

Intervals are based on normal operation. Reduce to compensate for abnormal operations and severe conditions. During inactive periods sufficient lubrication must be performed for adequate preservation.

Relubricate after washing or fording.

Clean fittings before lubricating.

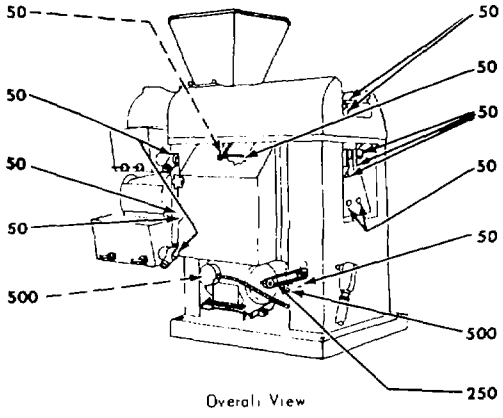
Clean parts with SD (Solvent, drycleaning).

Dry before lubricating.

Broken arrow shafts indicate lubrication points on both sides of the equipment.

FOLD FOLD

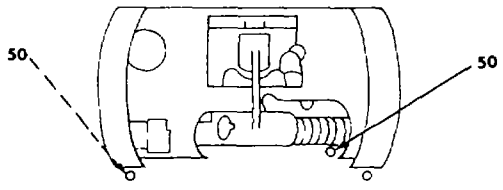
LUBRICANT		INTERVAL
Divider Lever Fitting	GAA	50
Dister Levers (See Note 3)	OE	50
Upper Bar with Eccentric Collar	GAA	50
Lower Bar with Eccentric Collar	GAA	50
Motor Bearings (See Note 2)	GAA	500



Overall View

INTERVAL		LUBRICANT
50	OE	Connecting Links (See Note 3)
50	GAA	Crankshaft Bearing Fitting
50	GAA	Connecting Links
50	GAA	Compression Spring Rod Fittings
50	GO	*Gear Reduction Unit* (Fill and Level) (Check Level)
500	GO	Gear Reduction Unit drain (Drain and Refill)
250	OE	Drive Chain (See Note 1)

Cylinder Bearing Block Stud Fitting	GAA	50



Cylinder

50	GAA	Lever Connecting Stud

MEC 7360-201-20/3 ①

Figure 3. (Superseded) LO 10-7360-201-20-2.

– KEY –

LUBRICANTS	EXPECTED TEMPERATURES ALL TEMPERATURES	INTERVALS
OE–LUBRICATING OIL, Internal Combustion Engine	OE 30 or 9250	Intervals given are in hours of normal operation.
Drive Chain	OE 10 or 9110	
GO–LUBRICATING OIL, Gear	GO 90	
GAA–GREASE, Automotive and Artillery	GAA	

NOTES:

1. DRIVE CHAIN. Every 250 hours clean, coat sparingly with OE-10, and wipe oil from outer surface.

2. MOTOR BEARINGS. Every 500 hours grease sparingly with GAA; too much grease will cause bearings to overheat.

3. OIL CAN POINTS. Every 50 hours clean and lightly lubricate duster levers and connecting links with OE.

Copy of this Lubrication Order will remain with the equipment at all times; instructions contained herein are mandatory

BY ORDER OF THE SECRETARY OF THE ARMY

HAROLD K. JOHNSON
General, United States Army
Chief of Staff.

OFFICIAL.

J. C. LAMBERT,
Major General, United States Army
The Adjutant General

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MEC 7360-201-20/3 (2)

Figure 3–Continued.

LUBRICATION ORDER

LO10-7360-201-20-3

4 FEBRUARY 1966 (Supersedes LO10-7360-201-20-3, 28 Feb 61)

BAKERY PLANT, TRAILER-MOUNTED, M-1945: DOUGH MIXING AND MAKEUP OUTFIT, ARMY MODELS SPV18 AND SPV30 (MOLDER)

REFERENCE: LO10-7360-201-20-1,-2,-4,-5,-6, C9100-IL

Intervals are based on normal operation. Reduce to compensate for abnormal operation and severe conditions. During inactive periods, sufficient lubrication must be performed for adequate preservation.

Relubricate after washing or fording.

Clean fittings before lubricating.

Clean parts with SD (Solvent, drycleaning).

Dry before lubricating.

Broken arrow shafts indicate lubrication points on both sides of the equipment.

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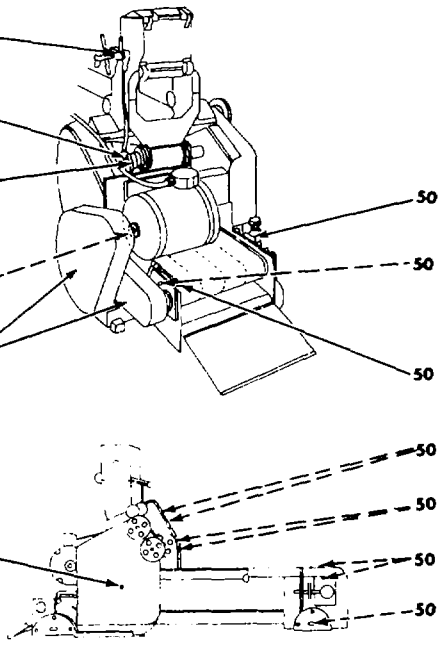

LUBRICANT		INTERVAL	
Duster Regulating Lever (See Note 4)	OE	50	
Upper Rear Sheeting Roll Eccentric	GAA	50	
Eccentric Shaft Idler Sprocket with Bushing	GAA	50	
Motor Bearings (See Note 2)	GAA	500	
Drive Chains (See Note 1)	OE	250	
Front Sheeting Roll Idler Sprocket with Bushing	GAA	50	

INTERVAL		LUBRICANT
50	GAA	Main Drive Shaft Bearing
50	GAA	Conveyor Pulley Shaft Bearings
50	GAA	Main Drive Shaft Bearing
50	GAA	Upper Sheeting Roll Shaft Bearings
50	GAA	Lower Sheeting Roll Shaft Bearings
50	GAA	Conveyor Pulley Shaft Bearings
50	GAA	Worm Gear Bearings (See Note 3)

MEC 7360-201-20/5 ①

Figure 5. (Superseded) LO 10-7360-201-20-3.

– KEY –

LUBRICANTS	EXPECTED TEMPERATURES ALL TEMPERATURES	INTERVALS
OE–LUBRICATING OIL, Internal Combustion Engine	**OE** 30 or **9250**	Intervals given are in hours of normal operation.
Drive Chain	**OE** 10 or **9110**	
GAA-GREASE, Automotive and Artillery	**GAA**	

NOTES:

1. DRIVE CHAINS. Every 250 hours clean, coat sparingly with OE-10, and wipe oil from outer surface.

2. MOTOR BEARINGS. Every 500 hours grease sparingly with GAA; too much grease will cause bearings to overheat.

3. WORM GEAR BEARINGS. Every 500 hours remove housings, clean, and repack with GAA.

4. OIL CAN POINTS. Every 50 hours clean and lightly lubricate duster regulating lever with OE.

Copy of this Lubrication Order will remain with the equipment at all times, instructions contained herein are mandatory.

BY ORDER OF THE SECRETARY OF THE ARMY

HAROLD K. JOHNSON
General, United States Army,
Chief of Staff.

OFFICIAL

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Major General, United States Army,
The Adjutant General

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MEC 7360-201-20 5 (2)

Figure 5-Continued.

LUBRICATION ORDER

LO10-7360-201-20-4

4 FEBRUARY 1966 (Supersedes LO10-7360-201-20-4, 28 Feb 61)

BAKERY PLANT, TRAILER-MOUNTED, M-1945: DOUGH MIXING AND MAKEUP OUTFIT, ARMY MODELS SPV18 AND SPV30 (MONORAIL AND TRAILER CHASSIS)

REFERENCE: LO10-7360-201-20-1,-2,-3,-5,-6. C9100-IL

Intervals are based on normal operation. Reduce to compensate for abnormal operation and severe conditions. During inactive periods, sufficient lubrication must be performed for adequate preservation.

Relubricate after washing or lording.

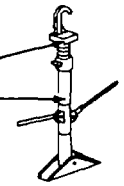
Clean fittings before lubricating.

Clean parts with SD (Solvent, drycleaning).

Dry before lubricating.

Broken arrow shafts indicate lubrication points on both sides of the equipment.

LUBRICANT	• INTERVAL
Front Leveling-Support Jacks	GAA 100



Front (C-Type) Leveling-Support Jacks

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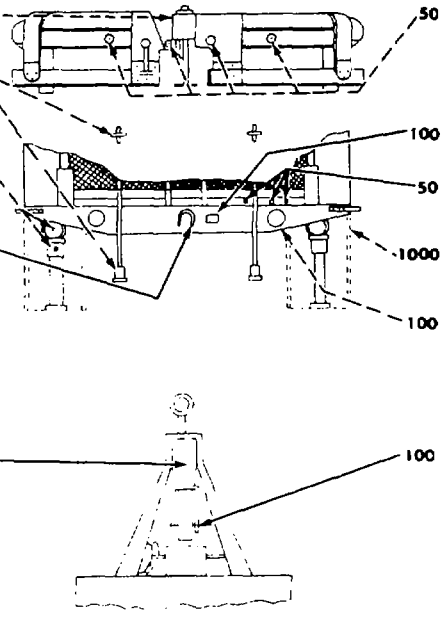
LUBRICANT	• INTERVAL
Monorail Link Bushings	GAA 50
Work Platform Support hinges (See Note 2)	OE 50
Rear Leveling-Support Jacks	GAA 100
Pintle (See Note 2)	OE 100
Caster Wheel Swivel Fitting	GAA 100



INTERVAL	• LUBRICANT
50	GAA Monorail Fittings (See Note 1)
100	HBA Master Cylinder
50	OE Work Platform Hinge (See Note 2)
1000	GAA Wheel Bearings (Remove, Clean, and Pack)
100	GAA Spring Hangers and Brackets
100	GAA Caster Wheel Bearing Fitting

Chassis and Monorail

MEC 7360-201-20 7 (1)

Figure 7. (Superseded) LO 10-7360-201-20-4.

— KEY —

LUBRICANTS	EXPECTED TEMPERATURES ALL TEMPERATURES	INTERVALS
OE – LUBRICATING OIL, Internal Combustion Engine	OE 30 or 9250	Intervals given are in hours of normal operation.
GAA-GREASE, Automotive and Artillery	GAA	
HBA-BRAKE FLUID, Automotive	HBA	

NOTES:

1. MONORAIL FITTINGS. Every 50 hours grease sparingly with GAA; be sure grease does not drip into dough carriers.

2. OIL CAN POINTS. Every 50 hours clean and lightly lubricate work platform support hinges, work platform hinge, and pintle with OE.

Copy of this Lubrication Order will remain with the equipment at all times, instructions contained herein are mandatory

BY ORDER OF THE SECRETARY OF THE ARMY.

HAROLD K. JOHNSON
General, United States Army,
Chief of Staff.

OFFICIAL

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Major General, United States Army,
The Adjutant General

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MEC 7360-201-20/7 ②

Figure 7-Continued.

LUBRICATION ORDER

LO10-7360-201-20-5

4 FEBRUARY 1966 (Supersedes LO10-7360-201-20-5, 28 Feb 61)

BAKERY PLANT, TRAILER-MOUNTED, M-1945: (BAKERY OVEN, ARMY MODELS SPV26, SPV31 AND M533)

Reference: LO10-7360-201-20-1,-2,-3,-4,-6. C9100-IL

Intervals are based on normal operation. Reduce to compensate for abnormal operation and severe conditions. During inactive periods, sufficient lubrication must be performed for adequate preservation.

Relubricate after washing or fording.

Clean fittings before lubricating.

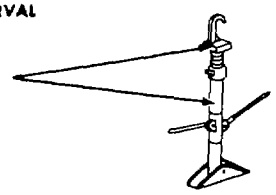
Clean parts with SD (Solvent, drycleaning).

Dry before lubricating.

Broken arrow shafts indicate lubrication points on both sides of the equipment.

LUBRICANT • INTERVAL

Front Leveling-Support Jacks — GAA — 100



Front (C-Type) Leveling-Support Jacks

INTERVAL • LUBRICANT

FOLD

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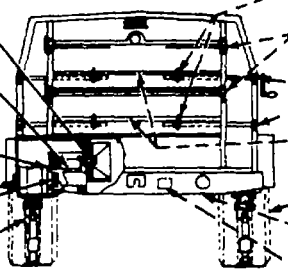
Blower Shaft Bearing (See Note 1) — OE — 100

Blower Shaft Bearing Pillow Block (Drain and Refill) (See Note 2.) — OE — 100

Pillow Block Liquid Sight Indicator (Fill and Level) (Check Level) — OE — 10

Motor Bearings (See Note 3) — GAA — 500

Rear Leveling-Support Jacks — GAA — 100



Oven Trailer

50 • Conveyor Chains (See Note 4) (See Key)

50 OE Oven Door Shaft Bearings (See Note 5)

50 OE Conveyor Drive Shaft Bearings (See Note 5)

50 OE *Door-Locking Mechanisms* (See Note 5)

1000 GAA Wheel Bearings (Remove, Clean, and Pack)

100 GAA Spring Hangers and Brackets

100 HBA Master Cylinder

— KEY —

LUBRICANTS	EXPECTED TEMPERATURES — ALL TEMPERATURES	INTERVALS
OE-LUBRICATING OIL, Internal Combustion Engine	OE 30 *or* 9250	Intervals given are in hours of normal operation.
GAA-GREASE, Automotive and Artillery	GAA	
HBA-BRAKE FLUID, Automotive	HBA	
• -GRAPHITE, Colloidal	MIL-G-26548	

MEC 7360-201-20/9 (1)

Figure 9. (Superseded) LO 10-7360-201-20-5.

NOTES:

1. BLOWER SHAFT BEARING. This bearing is lubricated by oil from pillow block oil well.

2. PILLOW BLOCK. If operated more than 12 hours a day, or if lubricant shows excessive sludge or carbonization, drain and thoroughly flush block every 50 hours or oftener. Drain plug is located on left side of block, near sheave. Refill to full mark on liquid sight indicator.

3. MOTOR BEARINGS. Every 500 hours lubricate bearings sparingly with GAA, too much grease will cause bearings to overheat.

4. CONVEYOR CHAINS. Every 50 hours lubricate chains lightly with colloidal graphite.

5. OIL CAN POINTS. Every 50 hours clean and lightly lubricate oven door shaft bearings, conveyor drive shaft bearings, and door-locking mechanisms with OE.

Copy of this Lubrication Order will remain with the equipment at all times, instructions contained herein are mandatory.

BY ORDER OF THE SECRETARY OF THE ARMY:

HAROLD K. JOHNSON
General, United States Army,
Chief of Staff.

OFFICIAL:

J. C. LAMBERT,
Major General, United States Army,
The Adjutant General

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MEC 7360-201-20/9 (2)

Figure 9-Continued.

LUBRICATION ORDER

LO10-7360-201-20-6

4 FEBRUARY 1966

BAKERY PLANT, TRAILER-MOUNTED,M-1945: (CHASSIS, TRAILER: 2 1/2-TON, 2-WHEEL, M537 USED WITH BAKERY OVEN, M533)

Reference: LO10-7360-201-20-1,-2,-3,-4,-5. C9100-IL

Intervals are based on normal operation. Reduce to compensate for abnormal operation and severe conditions. During inactive periods sufficient lubrication must be performed for adequate preservation.

Relubricate after washing or fording.

Clean parts with SD (Solvent, drycleaning).

Clean fittings before lubricating.

Dry before lubricating.

Broken arrow shafts indicate lubrication points on both sides of the equipment.

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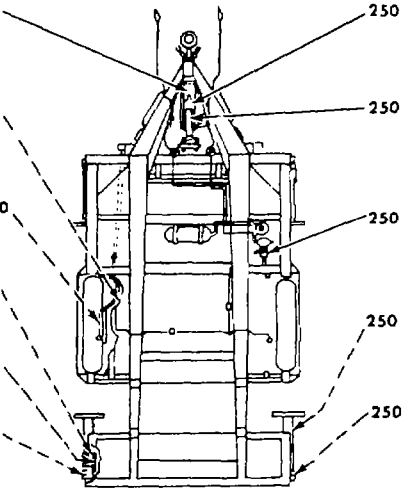
LUBRICANT	•	INTERVAL
Retractable Support Bracket and Spindle Assembly (See Note 1)	GAA	250
Handbrake Flexible Control Link Cable	GAA	250
Wheel Bearings (Remove, Clean and Pack)	GAA	1000
Leveling Jack Swivel Lock Pin (See Note 3)	OE	250
Leveling Jack Swivel (See Note 4)	OE	250
Leveling Jack Screw (See Note 5)	GAA	250



INTERVAL	•	LUBRICANT
250	GAA	Retractable Support Gear and Bearing (See Note 1)
250	GAA	Retractable Support Shaft Screw (See Note 1)
250	HBA	Master Cylinder (Fill to 1/2 Inch From Top) (Capacity: 1 pint)
250	OE	Leveling Jack Inner Tube (See Note 2)
250	GAA	Leveling Jack Gear and Bearing (See Note 5)

MEC 7360-201-20 10

Figure 10. (Added) LO 10-7360-201-20-6.

— KEY —

LUBRICANTS	EXPECTED TEMPERATURES	INTERVALS
	ALL TEMPERATURES	
OE- LUBRICATING OIL, Internal Combustion Engine	OE 30 or 9250	Intervals given are in hours of normal operation.
GAA- GREASE, Automotive and Artillery	GAA	
HBA- BRAKE FLUID, Automotive	HBA	

NOTES:

1. RETRACTABLE SUPPORT. Do not overlubricate.

2. LEVELING JACK INNER TUBE. Every 250 hours extend inner tube fully and lubricate. There are four leveling jacks on the trailer chassis.

3. LEVELING JACK SWIVEL LOCK PIN. Every 250 hours pull lock pin out, lubricate, and work lock pin in and out to coat all surfaces.

4. LEVELING JACK SWIVEL. Every 250 hours lubricate the swivel, and move it back and forth to coat all surfaces.

5. LEVELING JACK SCREW AND GEAR AND BEARING. Do not overlubricate.

6. OIL CAN POINTS. Every 250 hours clean and lightly lubricate handbrake, lever assemblies, linkages, brackets, hinges, and latches with OE.

Copy of this Lubrication Order will remain with the equipment at all times, instructions contained herein are mandatory.

BY ORDER OF THE SECRETARY OF THE ARMY

HAROLD K. JOHNSON
General, United States Army
Chief of Staff.

OFFICIAL

J. C. LAMBERT,
Major General, United States Army
The Adjutant General

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MEC 7360-201-20/10 (2)

Figure 10-Continued.

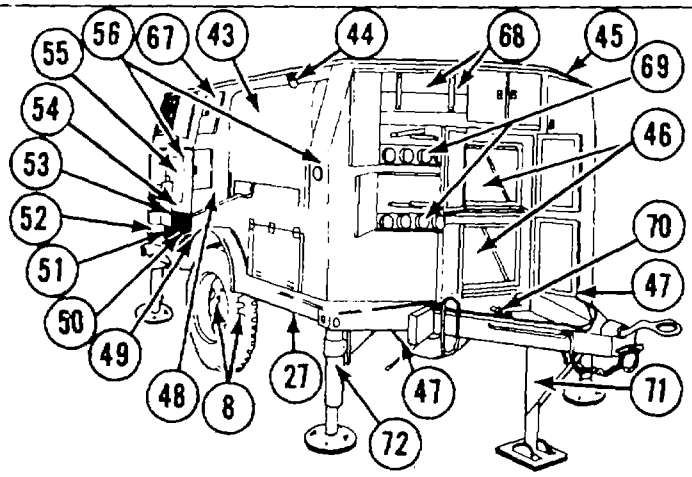
ITEM		PAR REF
65	DRIVE V-BELT. Proper adjustment is a deflection of 1/2 inch midway between sheaves. Replace worn, frayed, or cracked belt.	174
66	CONTROL. (SIFTER MANUAL STARTER). Replace damaged control. Tighten loose mounting. With the unit operating, check for proper operation. Reference TM10-7360-201-10, par. 20.	170
	 M533 BAKERY OVEN	
67	OVEN LIGHT AND OVEN LIGHT FLEXIBLE CONDUIT. Inspect for a serviceable incandescent lamp; for a cracked or broken globe or socket; for a bent or broken compression spring; for loose or missing capscrews; for stripped threads on capscrews, clamp, and pipe hanger; and for broken flexible conduit and wiring.	146
68	INSULATION PILLOWS AND RETAINER STRAPS. Inspect insulation pillows for torn asbestos fabric and loose or missing staples. Inspect for a loose, broken, or missing retainer strap. Check nuts for loose mounting on studs. Inspect nuts and studs for stripped threads.	152.3
69	HEAT EXCHANGER TUBES. Inspect heat exchanger tubes for soot accumulation. Inspect for broken thimble covers and for warped cleanout covers. Inspect cleanout covers for stripped threads.	152.2
70	AIR CLEANER. Inspect air cleaner for a broken housing, element, or spring; for a dirty element; and for dirty or corroded surfaces. Use SD to clean all parts.	26

Figure 10.1. (MSC 7360-201-20/10.1 (9) C 4. Added)-Continued.

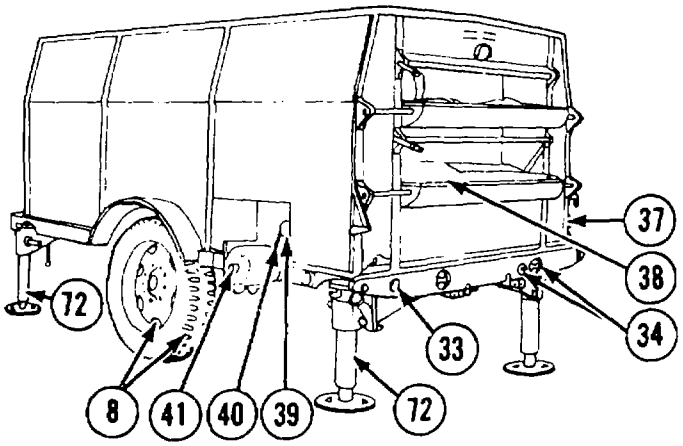
ITEM		PAR REF
71	RETRACTABLE SUPPORT ASSEMBLY. Inspect for a bent, cracked, or worn spindle, for stripped threads, and for worn parts.	34.1
72	LEVELING JACK AND JACK SWIVEL. Inspect leveling jack and jack swivel for bends, breaks, stripped threads, and worn or damaged gears and bearings.	41.1
	 M533 BAKERY OVEN	
	NOTE 1. OPERATIONAL TEST. During operation observe for any unusual noise or vibration.	
	NOTE 2. ADJUSTMENTS. Make all necessary adjustments during operational test.	
	NOTE 3. FIRE EXTINGUISHER. Inspect for broken seal. The dry chemical type must be weighed every 6 months. If the weight has decreased to less than 4 1/2 pounds or the pressure is below 125 psi, the extinguisher must be replaced.	

Figure 10.1. (MSC 7360-201-20 10.1 (10) C 4. Added)-Continued.

Table IV. Troubleshooting Chart

(Trailer Chassis)

Trouble	Cause	Remedy
* *	* *	* * *
Trailer pulls hard	Excessive bend in axle.....	Report a defective axle as stipulated in TM 38-750.
	Brakes out of adjustment (too tight).....	Adjust brakes (para 23).
	Brakeshoe return spring is weak or broken.....	Replace brakeshoe return spring (para 23).
	Brakedrum is out of round	Replace brakedrum (para 31).
* *	* *	* * *
Trailer pulls to one side	Brakes out of adjustment.....	Adjust brakes (para 23).
	Brakeshoe return spring is weak or broken.....	Replace brakeshoe return spring (para 23).
	Wheel bearings are improperly adjusted. .	Adjust wheel bearings (para 30).
	Excessive bend in axle.....	Report a defective axle as stipulated in TM 38-750.
* *	* *	* * *
	Locking device is broken	lave locking device replaced.
Support crank will not turn or will not turn freely (M537 trailer chassis).	Lack of lubrication.....	Lubricate retractable support assembly according to LO 10-7360-201-20-6.
	Worn or damaged gears bearings screw shaft outer tube assembly, or inner tube assembly.	Replace the retractable support assembly (para 34.1).
Support will not swivel or turn freely in lunette mounting bracket (M537 trailer chassis).	Lack of lubrication.....	Lubricate spindle assembly according to LO 10-7360-201-20-6.
	Bracket and spindle assembly bent	Replace retractable support assembly (para 34.1).
Leveling jack crank will not turn or will not turn freely (M537 trailer chassis).	Lack of lubrication.....	Lubricate leveling jack according to LO 10-7360-201-20-6.
	Worn or damaged gears, bearings, screw shaft, outer tube assembly, or inner tube assembly.	Replace the leveling jack (para 41.1).
* *	* *	* * *
	Lamps are burned out	Replace lamps (para 18).
Dim or flickering lights.....	Loose, dirty, or corroded terminals	Clean and tighten terminals.
	Intervehicular cable improperly grounded	Remove screws and washer securing cable ground wire to connector clip assembly. Clean and tighten cable terminal and clean surface of clip assembly. Position cable terminal on clip and secure with screws and washers.
	Taillight assembly improperly grounded ...	Remove screws and washers securing taillight assembly to mounting bracket. Clean screws, and mounting bracket. Position taillight on bracket and install screws and washers. Tighten screws securely.
	Defective lamp.....	Replace lamp (para 46).
	Dirty or corroded lamp sockets or contacts in receptacle or plug.	Remove lamp (para 46) and clean sockets. Clean contacts.
* *	* *	* * *

Table IV. Troubleshooting Chart--Continued

(Trailer Chassis)-Continued

Trouble	Cause	Remedy
	Leaks in hydraulic system	Locate and correct leak.
	Grease on brake lining	Replace brakeshoe (para 23), and check and replace a defective oil seal in line or fitting.
	Worn brake lining	Adjust brakes (para 23).
	Worn out brake lining	Replace brakeshoes (para 23).
* *	* *	* * *
Brakes grab	Moisture in filter	Drain air cleaner (para 26).
	Brakes out of adjustment	Adjust brakes (para 23).
	Grease on brake lining	Replace brakeshoe (para 23) and check and replace a defective oil seal in line or fitting.
	Loose or worn wheel bearings	Adjust bearings (para 30). If they cannot be adjusted properly, replace bearings (para 30).
	Cracked, scarred, or deformed brake drum.	Replace brakedrum (para 31).
	Worn or loose brake lining	Replace brakeshoes (para 23).
	Moisture in air cleaner (filter)	Drain air cleaner (filter).
* *	* *	* * *
Handbrake will not hold vehicle	Service brakes are out of adjustment	Adjust brakes (para 23).
	Brakes out of adjustment	Adjust brakes (para 22.1).
	Handbrake linkage out of adjustment	Adjust linkage (para 22.2).
Handbrakes drag	Handbrake linkage out of adjustment	Adjust linkage (para 22.2).
	Handbrake lever assembly and flexible control link lack lubrication.	Lubricate handbrake lever and flexible control link according to LO 10-7360-201-20-6

Table V. Troubleshooting Chart
(Oven Trailer)

Trouble	Cause	Remedy
* *	* *	* * *
	Air ducts are obstructed or damaged (Heat exchanger tubes and inlet header in M533 bakery oven).	Remove pressure relief sheets (para 133) and remove obstructions. Remove thimble covers from heat exchanger tubes and cleanout covers from inlet header (para 152.2) and then remove soot and any obstruction in air ducts (M533 bakery oven).
* *	* *	* * *

22.1. Handbrake Lever (M533 Bakery Oven)
(Added)

a. Adjustment.

(1) To increase braking action of either handbrake, turn spring-loaded adjusting knob (7, fig. 14.1) on end of handbrake lever (6) clockwise.

(2) To decrease braking action (to prevent dragging of brakeshoes), turn adjusting knob counterclockwise.

(3) If braking action cannot be increased sufficiently by turning adjusting knob clockwise, adjust flexible control link.

b. Removal.

(1) Remove capscrews (8) and lockwashers

that secure mudguard (2) to lever mounting bracket (1) and remove guard.

(2) Remove hexagon nuts and lockwashers from handbrake. lever retaining screws at back side of lever mounting bracket, and remove lever .assembly with handbrake lever retaining screws and attached extension rod (4) from front side of lever mounting bracket.

(3) Remove handbrake lever retaining screws and spacers from lever assembly.

(4) Remove cotter pin and clevis pin that secures clevis (3) on front end of extension rod to lever assembly, and remove extension rod from lever assembly.

a. Inspection. Inspect handbrake lever and strut for a broken spring and worn pawl or sector. Inspect for a bent or broken handbrake lever. Replace a defective handbrake lever as authorized.

d. Installation. Reverse procedures in b above.

22.2. Handbrake Cable Assembly (M533 Bakery Oven)

(Added)

a. Adjustment.

(1) Turn spring-loaded adjusting knob (7, fig. 14.1) on end of the handbrake lever (6) counterclockwise until link pin (5), which rides in slots in handbrake lever, is almost touching ends of slots (toward knob).

(2) Make certain that lever is in fully released position or as far away from vertical position as it will go.

(3) Jack up side of trailer with handbrake linkage that is to be adjusted so that wheel is off the ground.

(4) Loosen retaining nuts at each end of turnbuckle, and twin turnbuckle counterclockwise until brakeshoes drag slightly when wheel and brakedrums are rotated by hand.

(5) Turn turnbuckle counterclockwise (back off) until wheel and drum turn freely without drag.

(6) Test adjustment by moving handbrake lever to vertical position. If lever cannot be moved to fully applied position, turn turnbuckle clockwise until correct lever action is obtained.

(7) Tighten retaining nuts against turnbuckle.

(8) Remove jacks from under trailer.

b. Removal.

(1) Remove wheel and tire (para 29a).

(2) Remove hub and brakedrum (para 33a).

(3) Release handbrake lever on side with wheel. removed, but do not release handbrake for opposite wheel.

(4) Loosen retaining nut at each end of turnbuckle.

(5) Remove capscrews, lockwashers, and bracket that secure upper end of flexible control link to frame, and unscrew turnbuckle from flexible control link and extension rod (4).

(6) Remove flexible control link cable from V-slot. at lower end of handbrake lever.

(7) Remove hexagon nuts and cable guide bracket that secure flexible control link to back side of brake backing plate, and pull flexible control link from hole in backing plate.

c. Inspection. Inspect for a bent, broken, or frayed handbrake cable assembly. Inspect handbrake cable assembly for worn parts. Replace a defective handbrake cable assembly as authorized.

d. Installation. Reverse procedures in *b* above and adjust flexible control link following procedures in *a* above.

24. Wheel Cylinder and Linkage

* * * * * *

f. Bleeding Brakes.

(3) Connect it hose * * * small amount of HBA **(Brake Fluid, automotive).**

(4) Make certain master cylinder is filled with HBA.

* * * * * *

25. Master Cylinder c. Inspection and Repair.

* * * * * *

c. Inspection and Repair.

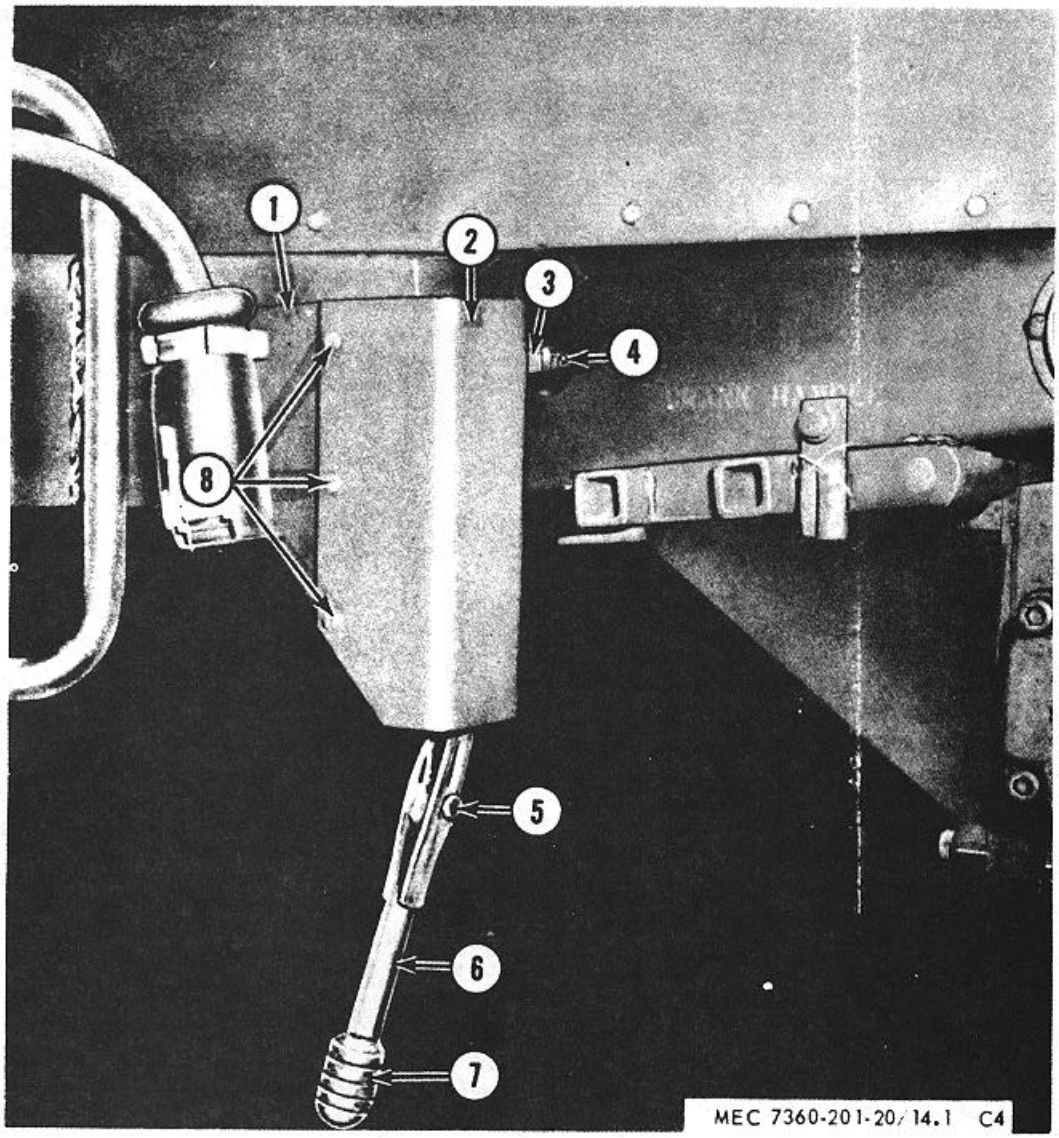
* * * * * *

(3) Coat all parts with clean HBA.

* * * * * *

28. Air System Lines and Fittings

To identify and replace defective lines and fittings, refer to figure 18.



1. Bracket, mounting. lever.
2. Guard, mud.
3. Clevis.
4. Rod, extension.
5. Pin, link.
6. Lever, handbrake.
7. Knob, adjusting, spring-loaded.
8. Capscrews.

Figure 14.1. (Added) Handbrake lever, mounted on trailer (M553 bakery oven).

34.1. Retractable Support Assembly (M533 Bakery Oven)

(Added)

a. Removal.

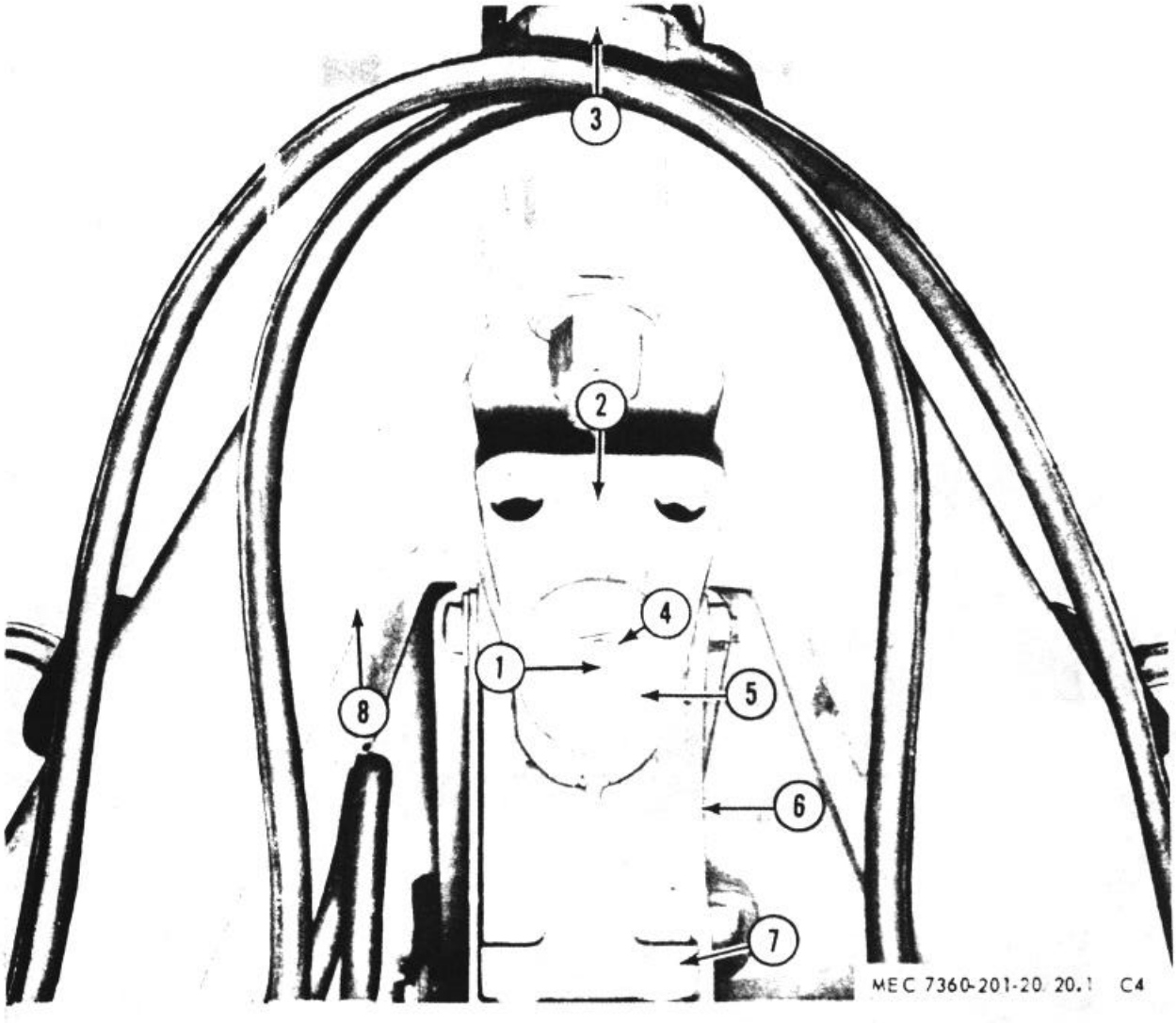
(1) Place appropriate blocking material under lunette (3, fig. 20.1) or use a hoist to support retractable support assembly.

(2) Remove self-locking hexagon nut (4) and upper flat washer (5) from upper end of retractable support spindle (1).

(3) Raise front end of trailer until retractable support spindle is free of retractable support mounting bracket (2) and remove retractable support assembly.

(4) Remove lower flit washer from retractable support spindle.

b. Inspection. Inspect for a bent, cracked, or worn spindle, for stripped threads, and for worn parts. Replace a defective retractable support assembly as authorized.



1 Spindle, retractable support.
2 Bracket, mounting, retractable support,
3 Lunette.
4 Nut, hexagon, self-locking.
5 Washer, flat, upper.
6 Frame.
7 Bracket swivel with spindle.
8 Drawbar.

Figure 20.1. (Added) Retractable support assembly (M533 bakery oven).

c. Repair. Replace defective parts with serviceable items.

d. Installation. Reverse procedures in *a* above.

41.1. Leveling Jack and Jack Swivel (M533 Bakery Oven)

(Added)

a. Leveling Jack Removal.

(1) Turn leveling jack (5, fig. 21.1) to vertical position, and use crank to lower leveling jack pad (6) to ground.

(2) Remove pin assembly (8) and swivel capscrews (4) which secure swivel cap (7) to swivel bite (2).

(3) Remove swivel cap and leveling jack.

b. Jack Swivel Removal.

Note. The leveling jack and jack swivel (1) can be removed separately or as an assembly.

(1) If leveling jack swivel are to be removed together, lower leveling jack pad to the ground.

(2) Remove capscrews (9) which secure swivel base to frame (3), and remove jack swivel.

Note. The capscrews attaching swivel base to rear of frame are threaded into weld nuts on inside of frame.

(3) Follow a (2) and (3) above to remove(leveling jack from jack swivel.

c. Inspection. Inspect leveling jack and jack swivel for bends, breaks, stripped threads, worn or damaged gears and bearings. Replace defective leveling jack or jack swivel is authorized.

d. Jack Swivel Repair. Replace defective parts with serviceable items.

e. Jack Swivel Installation. Reverse procedures in *b* above.

f. Leveling Jack Repair. Replace defective parts with serviceable items.

g. Leveling Jack Installation. Reverse procedures in *d* above.

126. Oven Blower Motor

(Superseded)

The blower motor (fig. 42) is interchangeable with the divider and molder motors.

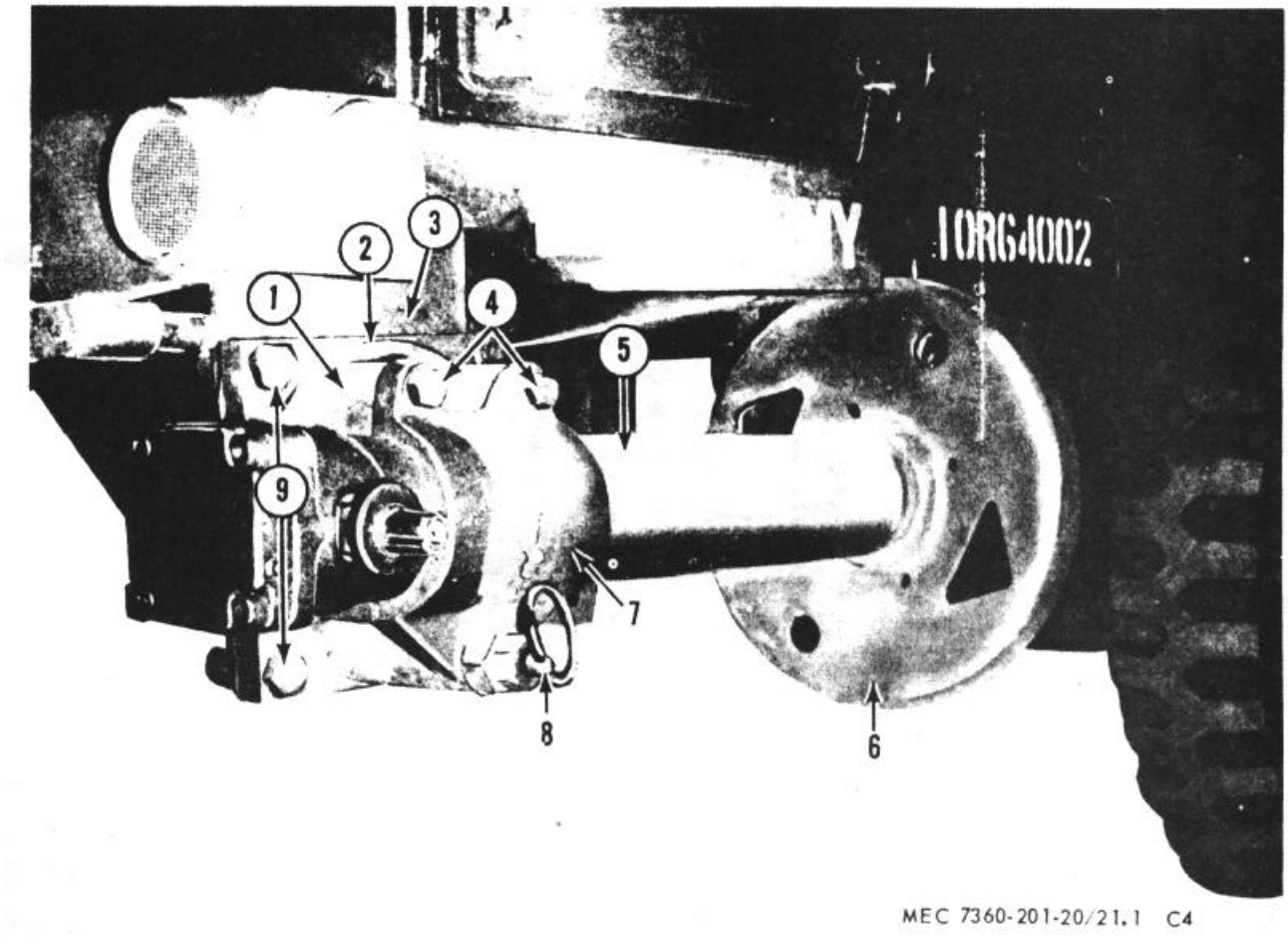
a. Inspections.

(1) Inspection. blower motor for overheating and overload.

(2) Check for improper lubrication and ventilation.

(3) Listen for excessive noises which indicate worn bearings.

(4) Check for objects retarding free operation of motor.



1 Swivel, jack.
2 Base, swivel.
3 Frame.
4 Capscrews, swivel.
5 Jack, leveling.
6 Pad, Jack, leveling,
7 Cap, swivel.
8 Pin assembly.
9 Capscrews.

Figure 21.1. (Added) Leveling jack and jack swivel (M553 bakery oven).

b. Removal.

(1) Remove blower motor cable plug from receptacle in burner compartment.

(2) Loosen wingnut on motor take up arm, and remove arm from mounting bracket on trailer.

(3) Pivot blower motor upward to release tension on V-belt, and remove V-belt.

(4) Slide motor with motor mounting plate from motor support pivot shaft on trailer, and remove motor from trailer.

c. Disassembly.

(1) Remove cal)screws that secure cover to junction box on motor, and remove cover.

(2) Disconnect and tag wires in junction box.

(3) Remove locknuts that secure cable and adapter to junction box, and remove cable and adapter from junction box.

(4) Remove setscrew that secures pulley and key to motor shaft, and remove pulley and key from motor shaft.

(5) Remove nuts, lockwashers, flat washers, and bolts that secure motor mounting plate to motor, and remove motor mounting plate from motor.

d. Assembly. Reverse procedures in c above.

e. Installation. Reverse procedures in b1 above.

134. Burner Head Plate Gasket

* * * * * *

135. Fan Drive Support Assembly Gasket

* * * * * *

143. Oven Pilot Light (Superseded)

a. Inspection. Inspect for a broken or burned out pilot lamp or a broken pilot lamp lens. Replace a defective oven pilot light, pilot lamp, or pilot lamp lens as authorized.

Note. The oven pilot light is located on lower right rear of bakery oven.

b. Repair. Tighten pilot lamp lens, if it is loose. If a new lamp does not make good contact, install a new socket.

c. Removal.

(1) Unscrew and remove pilot lamp lens from socket.

(2) Push pilot lamp inward and twist lamp from socket.

(3) Remove capscrews that secure cover plate to junction box, and remove cover plate from junction box.

(4) Disconnect wires from socket.

(5) Remove nut and flat washer that secures socket to trailer, and remove socket.

d. Installation. Reverse procedures in c above.

146. Oven Light and Oven Light Flexible Conduit (Superseded)

a. Removal and Disassembly.

Note. The following instructions apply to both the upper and lower deck lights.

(1) Disconnect oven power cable.

(2) Twist and withdraw oven light twistlock plug (4, fig. 47 or 17, fig. 48.1) from receptacle box (3, fig. 47 or 16, fig. 48.1).

(3) Loosen oven light pipe hanger (10, fig. 48.1) and withdraw light, from light, housing (4).

(4) Remove packing ring.

(5) Unscrew protecting globe (5, fig. 48 or 5, fig. 48.1), and remove incandescent lamp (6, fig. 48 or 6, fig. 48.1).

(6) Remove globe holder gasket.

(7) Remove capscrews holding body of porcelain socket (7, fig. 48 or 7, fig. 48.1) to cap of porcelain socket, and remove body.

(8) Disconnect wires from cap.

(9) Remove capscrews that secure cap to globe holder (8, fig. 48.1), and remove cap.

(10) Loosen conduit. clamp capscrews (13) that secure flexible conduit (14) to oven light conduit, elbow (11), and remove flexible conduit with wires.

Note. When removing flexible conduit on models SPV26 and SPV31 substitute coupling for clamp.

(11) Remove globe holder from nipple.

(12) Remove compression spring (9) and pipe hanger from nipple.

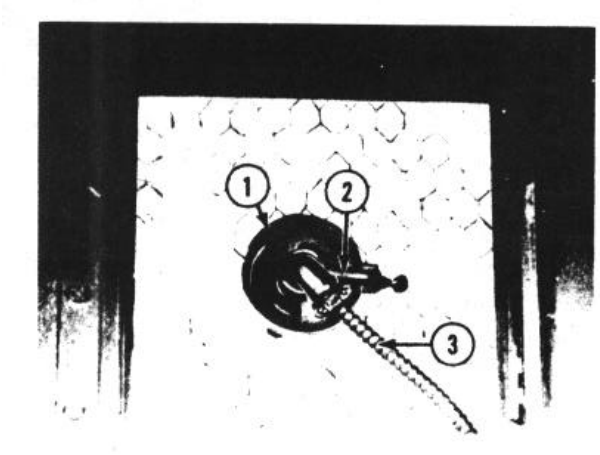
(13) Remove nipple from elbow.

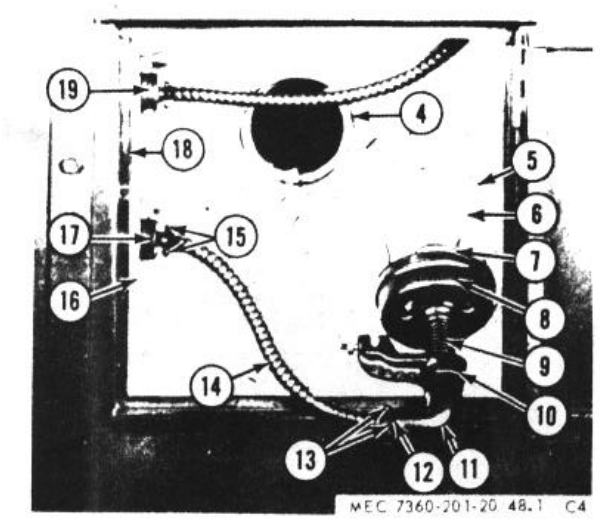
(14) Remove conduit clamp (12) from elbow.

(15) Disconnect wires from oven light twistlock plug.

(16) Loosen clamp capscrews (15) that secure twistlock plug to conduit, and remove plug.

(17) Pull wires from flexible conduit.





1 Housing, light.
2 Hanger. pipe, oven light.
3 Conduit. flexible, oven light.
4 Housing, light.
G Globe, protecting.
6 Lamp. incandescent.
7 Socket, porcelain.
8 Holder. globe.
9 Spring, compression.
10 Hanger, pipe, oven light.
11 Elbow, conduit, oven light.
12 Clamp, conduit.
13 Capscrew. clamp, conduit.
14 Conduit. flexible, oven light.
15 Capscrews., clamp.
16 Box, receptacle.
17 Plug, twistlock.
18 Box, receptacle.
19 Plug, twistlock.

Figure 48.1. (Added) Upper and lower deck lights (M533 bakery oven).

b. Inspection. Inspect for a serviceable incandescent lamp; for a cracked or broken globe or socket; for a bent or broken compression spring; for loose or missing capscrews; for stripped threads on capscrews, clamp and pipe hanger; and for broken flexible conduit and wiring. Replace a defective oven light and flexible conduit as authorized.

c. Assembly and Installation. Reverse procedures in a above.

147. Oven Light Switch

* * * * * *

b. Removal.

* * * * * *

(3) (Superseded) Remove retaining screws and lift light switch from switchbox.

(4) Rescinded.

151. Burner Assembly

a. Removal.

* * * * * *

(2) Disconnect fuel line * * * tank to filter. For model M533, disconnect flexible fuel line (8, fig. 51.1) from fuel supply line (7), and plug end of fuel supply line with union cap.

(3) Unplug magnetic valve cable (2, fig. 51) from receptacle.

* * * * * *

b. Disassembly, .

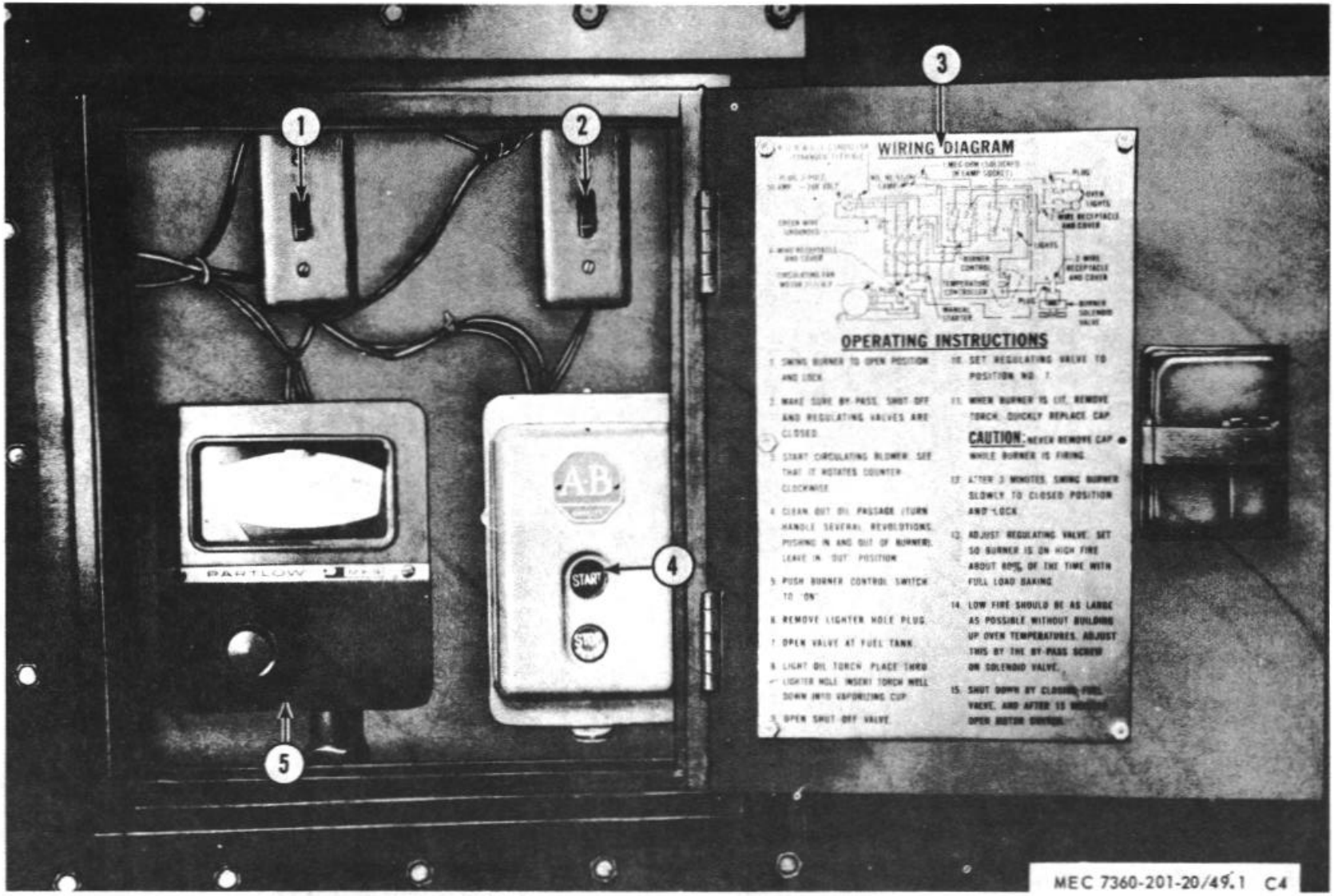
* * * * * *

(2) Unscrew cleanout pipe tee (10) and nipple with nut (9) from burner assembly (8), and separate nipple, nut, and tee.

* * * * * *

(4) Remove four machine * * * plate from burner. For model M533, remove nuts, flatwashers, and springs that secure burner hinge plate to burner assembly, and remove hinge plate from burner assembly.

(5) Unhook chain and * * * (5) from housing. For model M533, remove capscrew that secures lighting port chain (2, fig. 51.1) and lighter torch chain (29) to burner housing, and remove lighting port cover (3) and lighter torch (31) from burner housing.



1 Switch, toggle, oven burner.
2 Switch, toggle, oven lights.
3 Diagram, wiring.
4 Starter, manual, blower motor.
5 Control, temperature indicating.

Figure 49.1. (Added) Control box (M555 bakery oven).

(6) Remove three screws and clips from combustion ring support (1, fig. 53) and lift out combustion and recirculator ring (3).

* * * * * *

c. Cleaning. Using a cloth * * * exterior of burner. Using a hard bristle brush, remove all soot and carbon deposits from vaporizing cup.

* * * * * *

152.1 Combustion Tunnel (M533 Bakery Oven)

(Added)

a. Removal.

(1) Remove burner assembly (para 151a).

(2) Remove nut, lockwasher, and flat washers that secure burner handle (4, fig. 51) 'to burner headplate, and remove burner handle.

(3) Remove nuts, lockwashers, and flat washers that secure headplate to oven trailer, and remove headplate.

b. Inspection. Inspect combustion tunnel wall to make certain it is not burned through. Check for soot accumulation in combustion tunnel. Inspect gasket on combustion tunnel flange for tears and deterioration. Inspect for a bent or broken combustion tunnel flange.

c. Cleaning. Using a brush, remove soot from combustion tunnel.

d. Installation. Reverse procedures in a above.

152.2. Heat Exchanger Tubes (M533 Bakery Oven)

(Added)

To inspect and clean heat exchanger tubes (5, fig. 51.2), open cleanout doors (3); remove retainer straps (2 and 4) from insulation pillows, and remove pillows; loosen covers retaining screws and remove cleanout covers from inlet header; and remove thimble covers (1 and 7) from heat exchanger tubes.

a. Inspection. Inspect heat exchanger tubes for soot accumulation. Inspect for broken thimble covers and for warped cleanout covers. Inspect cleanout covers for stripped threads.

b. Cleaning. Using a heat tube brush (6), remove soot from heat exchanger tubes and inlet header.

152.3. Insulation Pillows and Retainer Straps (M533 Bakery Oven)

(Added)

Inspect insulation pillows (1 and 6, fig. 51.3) for torn asbestos fabric and loose or missing staples. Inspect for loose, broken, bent, or missing retainer straps (2, 4, and 5). Check retainer strap hexagon nuts (3) for loose mounting on studs. Inspect retainer strap hexagon nuts and studs for stripped threads.

153.1. Fuel Filter (M533 Bakery Oven)

(Added)

a. Removal.

(1) Close fuel shutoff valve (3, fig. 54.1) at fuel tank (1).

(2) Disconnect flexible fuel line (8, fig. 51.1) from fuel supply line (7).

(3) Plug end of fuel supply line with union cap.

(4) Remove pipe elbow (12) with flexible fuel line from fuel filter cap (11).

(5) Remove fuel filter (13) from pipe nipple (14) of metering float valve fuel line, and remove fuel filter from burner assembly (4).

b. Disassembly.

(1) Remove vent screw (10) and gasket from filter cap.

(2) Remove capscrew and gasket that secures filter shell and shell gasket to filter cap, and remove filter shell with element and gasket from cap.

(3) Remove element and shell gasket from shell.

c. Inspection. Inspect fuel filter for a cracked or broken shell; torn or deteriorated gaskets; stripped threads in shell or cap, and for deposits of sediment in filter and shell. Replace a defective fuel filter assembly, filter element, and gaskets as authorized.

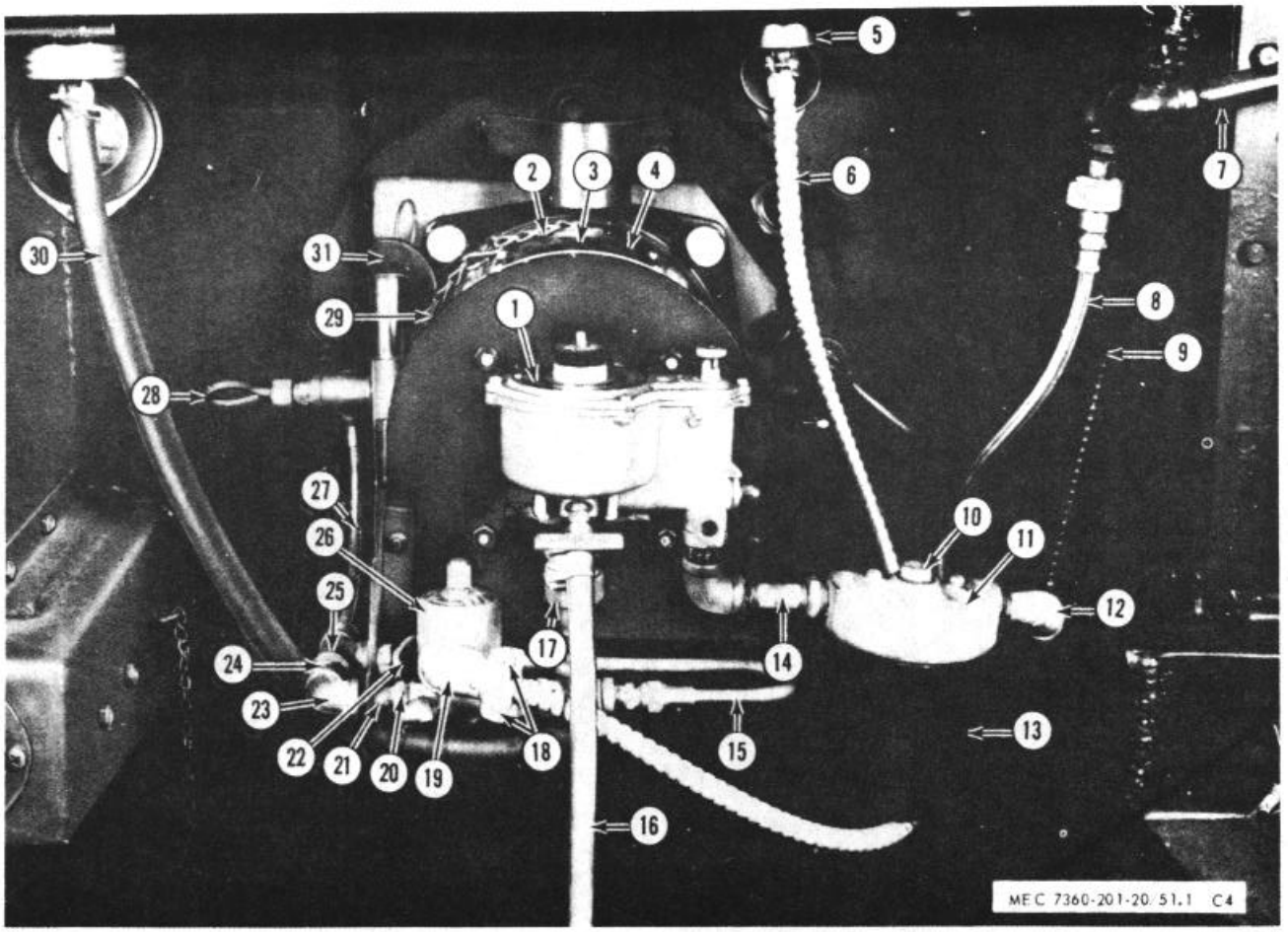
d. Cleaning. Using a clean cloth moistened with SD, clean fuel filter shell.

e. Assembly. Using a new shell gasket, reverse procedures in b above.

f. Installation. Reverse procedures in b above.

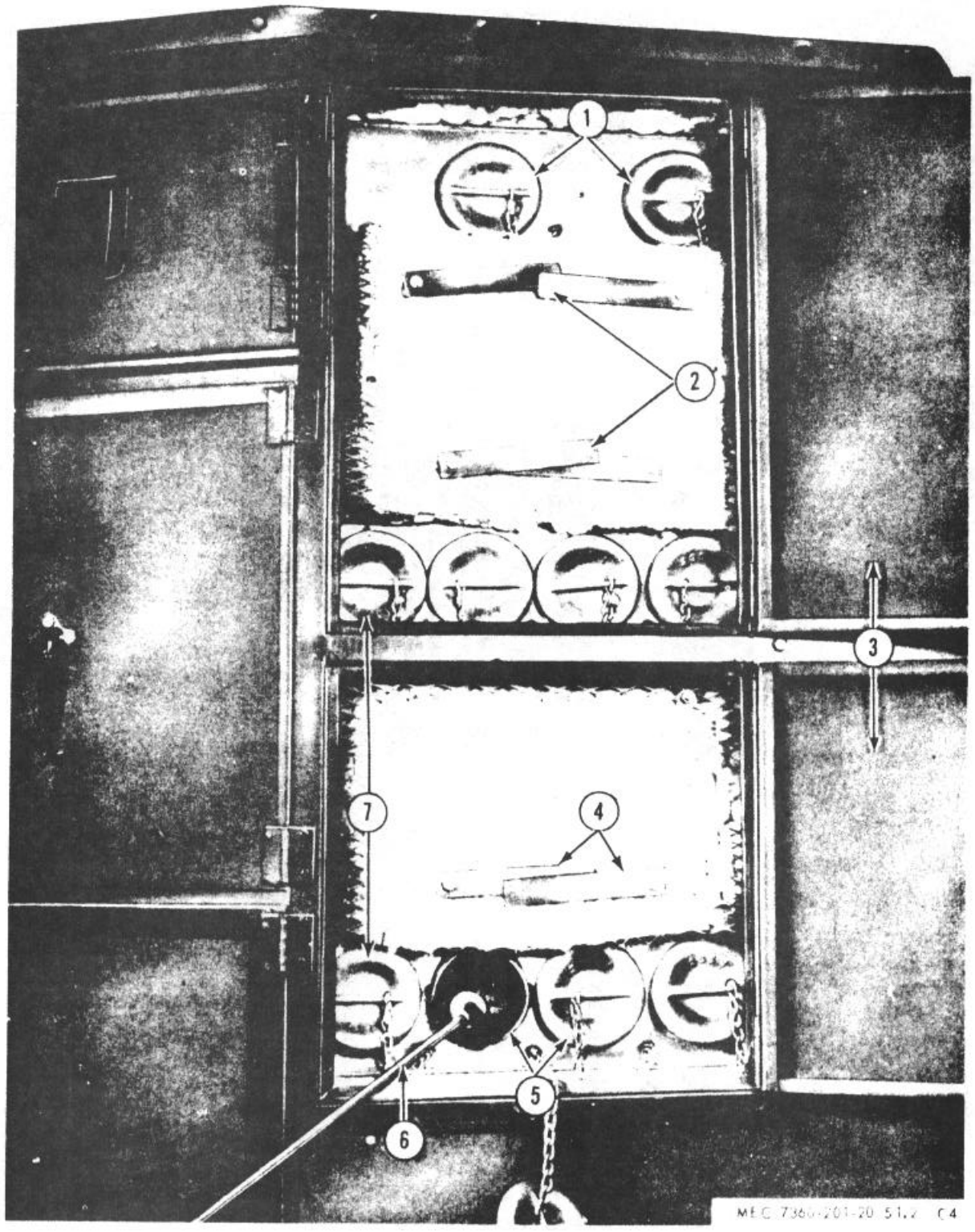
154. Fuel Metering Float Valve

* * * * * *



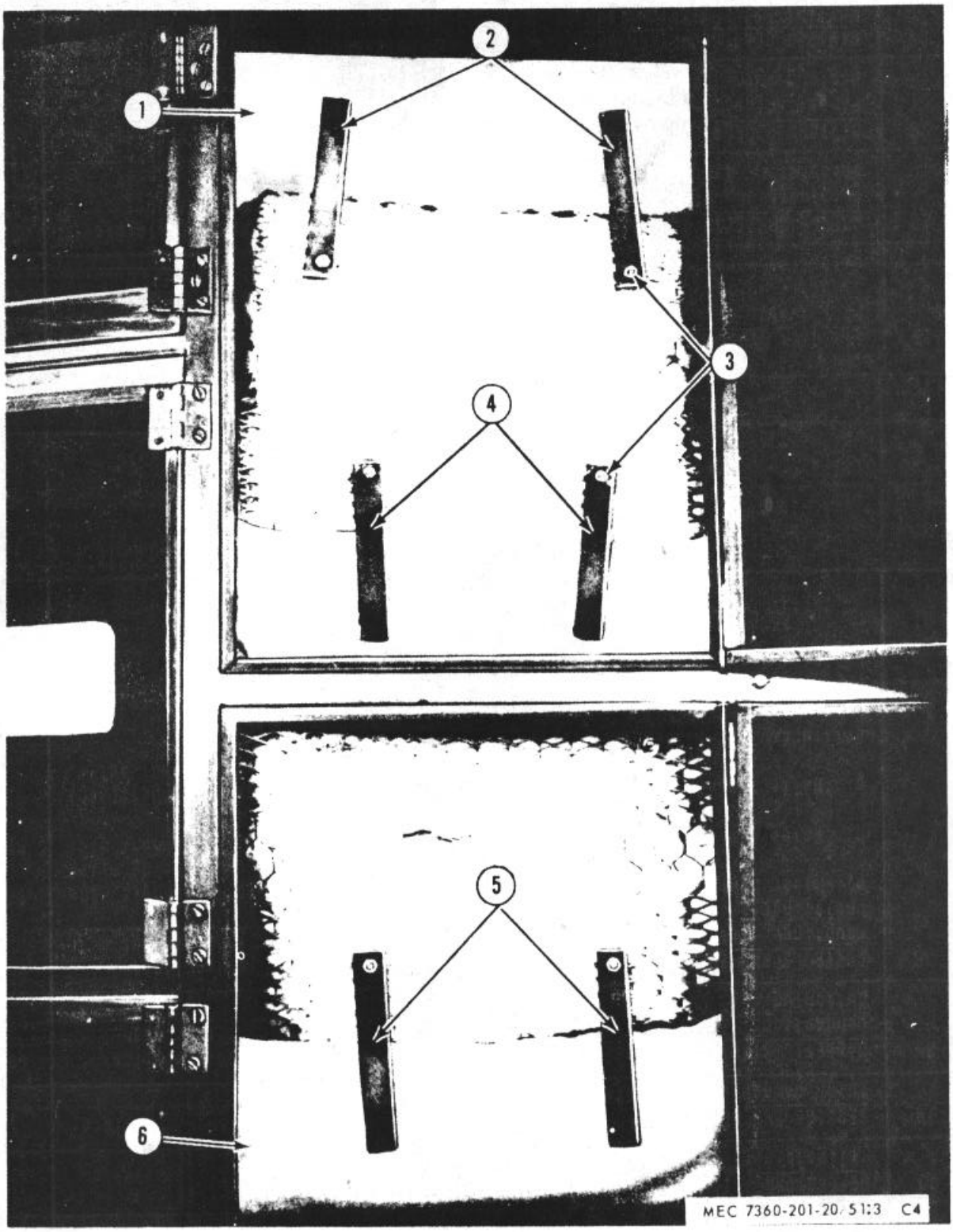
1 Valve. float, fuel metering.
2 Chain, port, lighting.
3 Cover, port, lighting.
4 Burner assembly.
5 Plug, cable, magnetic valve.
6 Cable. valve, magnetic.
7 Line, supply. fuel.
8 Line. fuel, flexible.
9 Chain, cap, union.
10 Screw. vent.
11 Cap, filter. fuel.
12 Elbow, pipe.
13 Filter, fuel.
14 Nipple, pipe.
15 Line, fuel, magnetic valve-to-bypass plug valve.
16 Hose, overflow, fuel metering float valve.
17 Union, pipe.
18 Capscrews.
19 Clamp.
20 Bushing, pipe, reducer.
21 Nipple, pipe.
22 Valve, plug, bypass.
23 Elbow, pipe.
24 Nipple. pipe.
25 Tee, pipe.
26 Valve, magnetic.
27 Line, fuel, magnetic valve-to-vaporizing cup.
28 Rod, cleanout.
29 Chain, torch, lighter.
30 Cable, motor, blower.
31 Torch, lighter.

Figure 51.1. (Added) Burner assembly, installed (M533 bakery oven).



1 Cover, thimble.
2 Straps, retainer.
3 Doors, cleanout.
4 Straps, retainer.
5 Tubes, exchanger, heat.
6 Brush, tube, heat.
7 Cover, thimble.

Figure 51.2. (Added) Heat exchanger tubes, cleanout end (M533 bakery oven).



1 Pillow, insulation.
2 Straps, retainer.
3 Nuts, hexagon, retainer strap.
4 Straps, retainer.
5 Straps, retainer.
6 Pillow, insulation.

Figure 51.3. (Added) Insulation piltow8 and retainer straps (M553 bake oven).

b. Disassembly.

* * * * * *

(5) Remove nut (1), gasket (2), and fuel strainer with plug (3) and strainer gasket from float chamber (7), and remove gasket from fuel strainer.

* * * * * *

156. Bypass Plug Valve

(Superseded)

a. Removal.

(1) Close fuel shutoff valve (3, fig. 54.1) at fuel tank (1).

(2) Remove magnetic valve-to-bypass plug valve fuel line (15, fig. 51.1).

(3) Remove magnetic valve-to-vaporizing cup fuel line (27).

(4) Turn bypass plug valve (22) down ward to clear burner shell, and remove bypass plug valve from pipe tee (25).

b. Inspection. Inspect bypass valve for stripped or burred threads and for improper spring tension. Replace a defective bypass plug valve as authorized.

c. Installation. Reverse procedures in a above.

157.1. Fuel Shutoff Valve (M533 Bakery Oven)

(Added)

a. Removal.

(1) Drain fuel into a suitable container.

(2) Remove lower pipe strap and upper pipe strap (6, fig. 54.1) that secures fuel supply line (5) to bakery oven.

(3) Disconnect flexible fuel line (8, fig. 51.1) to fuel filter (13).

(4) Unscrew and remove fuel supply line from pipe elbow (4, fig. 54.1) at fuel shutoff valve (3).

(5) Unscrew and remove pipe elbow and pipe nipple (7) from street elbow (8) in fuel shutoff valve.

(6) Unscrew and remove fuel shutoff valve with street elbow from pipe nipple (9) in tank.

(7) Remove street elbow from fuel shutoff valve.

b. Inspection. Inspect fuel shutoff valve for stripped threads, broken handwheel, or a bent stem.

c. Installation. Reverse procedures in a above.

158.1. Magnetic Valve (M533 Bakery Oven)

(Added)

a. Removal.

(1) Close fuel shutoff valve (3, fig. 54.1) at fuel tank (1).

(2) Remove magnetic valve cable plug (5, fig. 51.1) from oven receptacle.

(3) Remove bypass plug valve (para 156a).

(4) Remove pipe elbow (23) with pipe nipple (21 and 24) and pipe tee (25) from reducer pipe bushing (20) in magnetic valve (26).

(5) Uncouple pipe union (17) in the fuel line-to-metering float valve, and remove magnetic(valve from burner assembly (4).

(6) Unscrew and remove reducer pipe bushing from magnetic valve.

(7) Unscrew reduce'. pipe bushing with pipe nipples and fittings from opposite side of magnetic valve.

(8) Disconnect leads from plug.

(9) Remove capscrews (18) and clamp (19) that secure flexible conduit to magnetic valve.

(10) Remove flexible conduit, with plug from magnetic valve.

(11) Remove flexible conduit adapter from magnetic valve.

b. Inspection. Inspect, for stripped or burred threads; cracked or broken valve body; worn insulation; and broken leads.

c. Installation. Reverse procedures in a above.

185. Preliminary Services

* * * * * *

b. (Superseded) *Operation Test*. Test the equipment to be sure it operates satisfactorily by performing the services listed in paragraph 13.1.

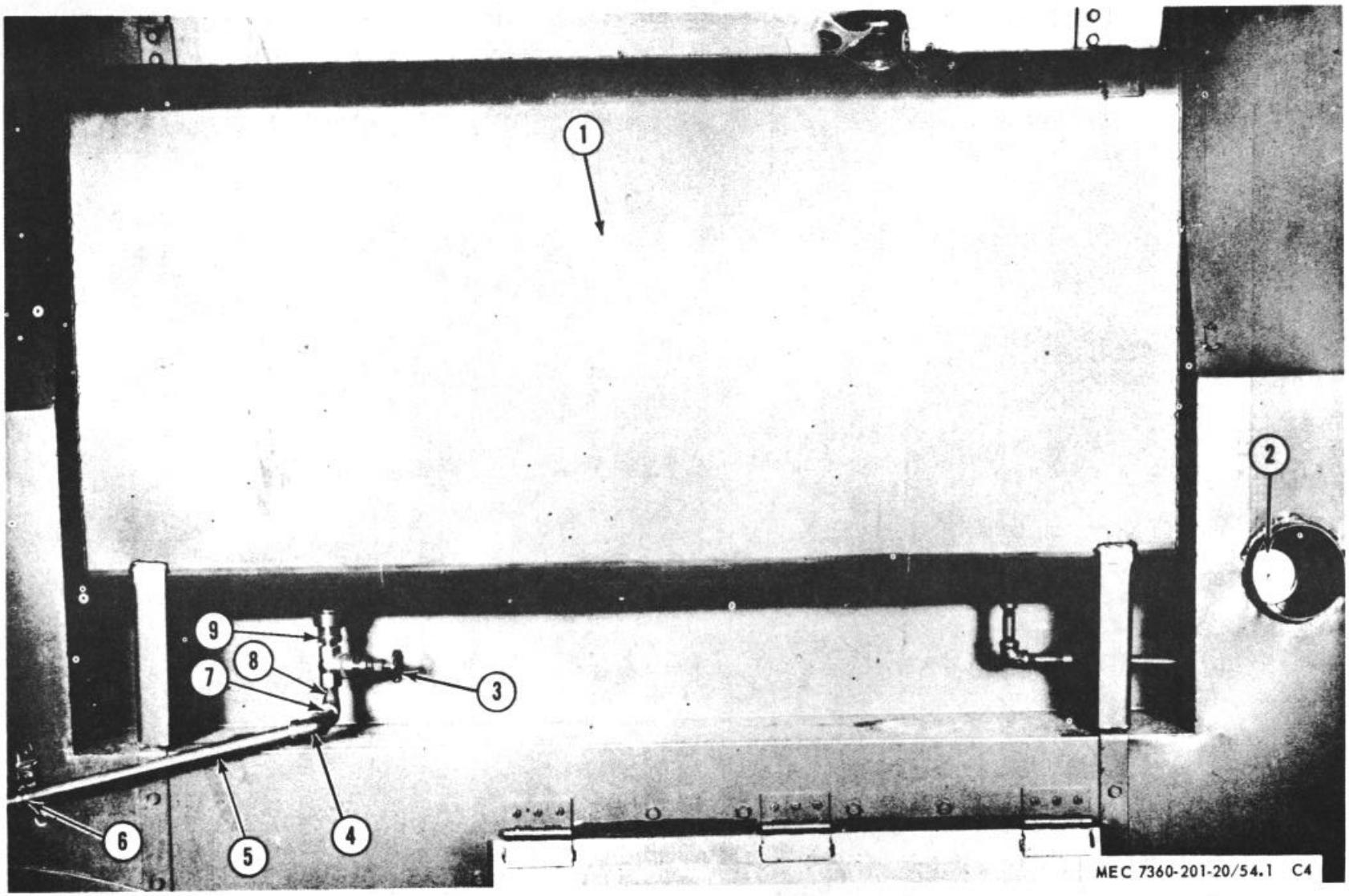
* * * * * *

186. Preparation of Equipment

* * * * * *

c. Lubrication. Lubricate the equipment * * * the lubrication orders (figs. 1, 3, 5, 7, 9, and 10).

* * * * * *



1	Tank, fuel.	4	Elbow, pipe.	7	Nipple, pipe.
2	Gage, fuel.	5	Line, supply, fuel.	8	Elbow, street.
3	Valve, shutoff, fuel.	6	Strap, pipe, upper.	9	Nipple, pipe.

Figure 54.1. (Added) Fuel shutoff valve, installed (Ml533 bakery oven).

APPENDIX I

REFERENCES

(Superseded)

1. Dictionaries of Terms and Abbreviations

AR 320-5	Dictionary of United States Army Terms.
AR 320-50	Authorized Abbreviations and Brevity Codes.

2. Preventive Maintenance

AR 750-5	Organization, Policies, and Responsibilities for maintenance operation.
TM 10-7360-201-10	Operators Manual: Bakery Plant, Trailer-Mounted, M-1945 (FSN 7360-221-2418).
TM 10-7360-201-20P	Organizational Maintenance Repair Parts ,and Special Tool Lists: Bakery Plant, Trailer-Mounted, MA-1945 (FSN 7360-221-2418).
TM 38-750	Army Equipment. Record Procedures.

3. Lubrication

LO 10-7360-201-20-1	Bakery Plant, Trailer-Mounted, M-1945: Dough Mixing and Makeup Outfit, Army Models SPV 18 and SPV 30 (Mixer).
LO 10-7360-201-20-2	Bakery Plant, Trailer-M], M-1945: Dough Mixing and Makeup Outfit, Army Models SPV 18 and SPV 30 (Divider).
LO 10-7360-201-20-3	Bakery Plant, Trailer-Mounted, M-1945: Dough Mixing and Makeup Outfit, Army Models SPV 18 and SPV 30 (Molder).
LO 10-7360-201-20-4	Bakery Plant, Trailer-Mounted, MA-1945: Dough Mixing and Makeup Outfit, Army Models SPV 18 and SPV 30 (Monorail and Trailer Chassis).
LO 10-7360-201-20-5	Bakery Plant., Trailer-Mounted, MA-1945: (Bakery Oven, Army Models SPV 26, SPV 31, and M533).
LO 10-7360-201-20-6	Bakery Plant,, Trailer-Mounted, M-1945: (Chassis Trailer: 21/2 Ton, 24VTheel, M537 used with Bakery Oven, M533).

4. Publication Indexes

DA Pam 108-1	Index of Army Motion Pictures, Filmstrips, Slides, and Phono-Recordings.
DA Pam 310-1	Military Publications: Index of Administrative Publications.
DA Pam 310-2	Military Publications: Index of Blank Forms.
DA Pam 310-4	Military Publications: Index of Technical Manuals, Technical Bulletins, Supply Manuals (types 7, 8, and 9), Supply Bulletins, Lubrication Orders, and Modification Work Orders.

5. Shipment and Limited Storage

AR 700-58	Report of Damaged or Improper Shipment.
AR 700-3900-5	Registration of Materials Handling Equipment and Special Purpose Vehicles.
AR 746-5	Color and Marking of Army Material.
TM 38-230	Preservations, Packaging, and Packing of Military Supplies and Equipment.

6. Supply Publications

FSC C9100-IL	Fuels, Lubricants, Oils and Waxes.

7. Training Aids

FM 21-5	Military Training Management.
FM 21-6	Techniques of Military Instruction.
FM 21-30	Military Symbols.
TM QM 63	Radio Suppression for Powered Materials Handling Equipment, Special-Purpose Vehicles, and Special-Purpose Equipment (CC5).
TM 11-661	Electrical Fundamentals (Direct Current).

APPENDIX II

MAINTENANCE ALLOCATION CHART

* * * * * * *

Maintenance Allocation Chart

* * * * * * *

OVEN TRAILER

GROUP 15. FRAME, AXLE, TOWING ATTACHMENTS

Following “Bumper, rubber, trailer axle" add "Support Assembly, retractable" and "Inspect, Repair, Replace"' in the second echelon.

GROUP 22. MISCELLANEOUS

Following "Jack Assemblies, leveling-support: add "Jacks and Jack Swivels, leveling" and "Inspect, Repair, and replace" in the, second echelon.

GROUP 48. BAKERY MACHINERY

Change "Light, oven indicator" to "Light, oven pilot".

Following "Cable Assemblies and Cord, extension" add "Conduit, flexible, oven light," and "Inspect, Replace" in the second echelon.

GROUP 56. FUEL OIL BURNER, FILTER, LINES, FITTINGS

Following "Tunnel, combustion" add "Gaskets, combustion tunnel" and "Inspect, Replace" in the third echelon.

Following "Gaskets, combustion tunnel" add "Tubes, heat exchanger" and "Inspect, Clean" in the second echelon, and "Repair" in the third echelon.

Following “Tubes, heat exchange” add "Pillows and Retainer Straps, insulation" and "Inspect" in the second echelon, and "Repair, Replace"' in the third echelon.

By Order of the Secretary of the Army:

HAROLD K. JOHNSON,
General, United States Army,
Chief of Staff.

Official:

J. C. LAMBERT,
Major General, United States Army,
The Adjutant General.

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CofSptS (6)	Armies (5)	QM Fld Maint Shops (2)			
CC-E (1)	NLABS (4)	Comb Fld Maintenance Shops, Ft. Knox (10)			
Dir of Trans (1)	DCTSC (10)				
USCONARC (2)	USAMEC (46)	Units organized under following TOE's (2 copies each)			
USAMC (12)	Svc Colleges (2)				
USAMOCOM (2)	Br Svc Sch (2) except	10-105	29-114		
USAWECOM (5)	USAQMS (10)	10-107	29-215		
USAMICOM (5)	USAQMCENFL (4)	10-445	29-216		
USAMUCOM (5)	USMA (1)	10-448			
USATECOM (5)	USACDCEC (10)	10-500 (Tm BH)			
USASMC (1)	Army Dep (4)				
POE (2)					

NG: State AG (3).

USAR: Same as Active Army except allowance is one copy to each unit.

For explanation of abbreviations used, see AR 320-50.

TECHNICAL MANUAL

Organizational Maintenance Manual

BAKERY PLANT, MOBILE, M1945
(FSN 7360-221-2418)

TM 10-7360-201-20

HEADQUARTERS,
DEPARTMENT OF THE ARMY
WASHINOTON, D.C., 26 September 1963

CHANGE No. 8

TM 10-7360-201-20, 17 March 1961, is changed as follows:

1. Scope

* * * * * *

c. (Superseded) The direct reporting by the individual user of errors, omissions, and recommendations for improving this manual is authorized and encouraged. DA Form 2028 (Recommended changes to DA Technical Manual Parts Lists or Supply Manual 7, 8, or 9), will be used for reporting these improvements. This form will be completed in triplicate using pencil, pen, or typewriter. The original and one copy will be forwarded direct to the Commanding Officer, U.S. Army Mobility Support Center, ATTN: SMOMS-MM, P. 0. Box 119. Columbus, Ohio 43216. One information copy will be provided to the individual's immediate supervisor, (e.g., officer, noncommissioned officer, supervisor, etc.).

d. (Added) Report all equipment improvement recommendations as prescribed by TM -750.

3. Record and Report Forms

(Superseded)

For record and report forms applicable to operator and organizational maintenance, refer to TM -750.

Note. Applicable forms, excluding Standard Form 46, which is carried by the operator, shall be kept in a canvas bag mounted on the equipment.

9. Preventive Maintenance Checks and Service

a. (Superseded) 'The organization mechanic will perform the services listed in paragraph 13.1. The services performed at this time will begin the cycle of regularly scheduled preventive maintenance services.

* * * * * *

11.1. Lubrication intervals

(Superseded)

Pending the publication of a revision to the lubrication orders, the changes listed below will be annotated on the lubrication orders.

a. Wherever it appears on the LO's, the interval symbol "I" will be changed to "Q". This symbol will designate those services which are to be performed every 3 months or 250 operating hours, whichever occurs first.

b. Wherever it appears on the LO's the interval symbol "5" will be changed to "S". This symbol will designate those services which are to be performed every 6 months or 500 operating hours, whichever occurs first.

13. General

(Superseded)

To insure. that the mobile bakery plant is ready for operation at all times, it must be inspected systematically, so that defects may be discovered and corrected before they result in serious damage or failure. The necessary Preventive Maintenance Services to be performed are listed and described in paragraph 13.1. The item numbers indicate the sequence of minimum inspection requirements. Defects discovered during operation of the unit shall be noted for future correction, to be made as soon as operation has ceased. Stop operation immediately if a deficiency is noted during operation which would damage the equipment

If operation were continued. All deficiencies and shortcomings will be recorded together with the corrective action taken, on DA Form 2404 (Equipment Inspector and Maintenance Work Sheet), at the earliest possible opportunity.

13.1. Quarterly Preventive Maintenance

(Superseded)

a. This paragraph contains an illustrated tabulated listing of preventive maintenance services which must be performed by Organizational Maintenance personnel at quarterly intervals. A quarterly interval is equal to 8 calendar months, or 250 hours of operation, whichever occurs first.

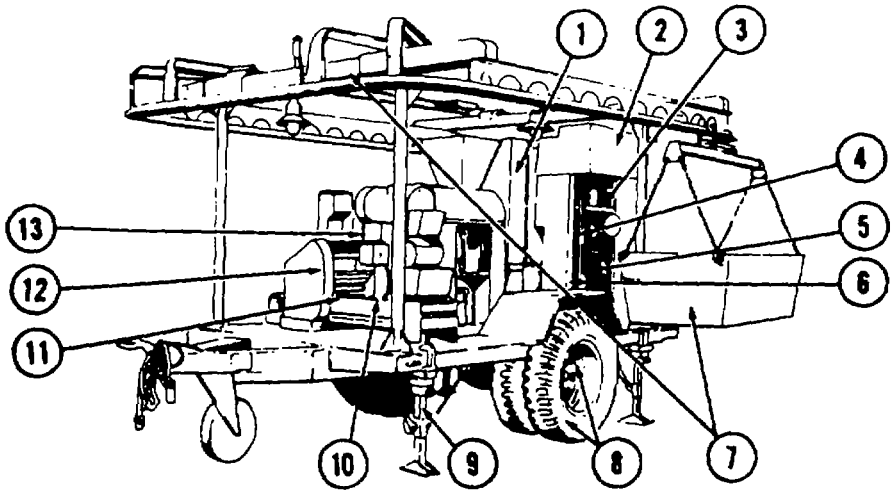
b. The item numbers are listed consecutively and indicate the sequence of minimum requirements. Refer to Figure 10.1 for the Quarterly Preventive Maintenance Service.

PREVENTIVE MAINTENANCE SERVICES

QUARTERLY

TM10-7360-201-20 MOBILE BAKERY PLANT

MODELS M-1945
M-1945-50, M-1945-53



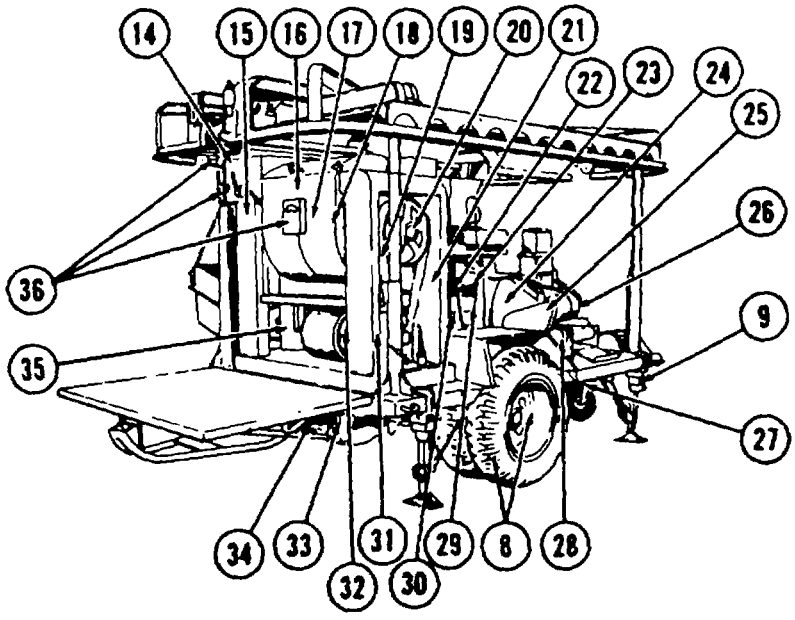
LUBRICATE IN ACCORDANCE WITH CURRENT LUBRICATION ORDER

ITEM		PAR REF
1	POWER PANEL CIRCUIT BREAKERS, PLUGS, CONNECTORS AND RECEPTACLES. Tighten loose mounting and electrical connections. Replace worn or frayed wiring. Replace worn, damaged, or defective breakers, plugs, connectors, and receptacles.	45 48 49
2	WATER TEMPERING TANK. Clean a dirty tank. Check tank for open seams and leaks. Tighten loose mounting and connections.	
3	VALVE. (CONTROL). Tighten loose mounting and connections. Replace worn, damaged, or defective valve.	95
4	WATER TRANSFER PUMP AND PIPING. Tighten loose mounting and connections. Replace worn, damaged, or defective pump or piping.	93
5	VALVES. (CHECK). Tighten loose mounting and connections. Replace worn, damaged, or defective valves.	94
6	WATER TRANSFER PUMP MOTOR. Tighten loose mounting and electrical connections. Replace worn, damaged, or defective motor.	93

MSC 7360-201-20/10.1 (1) C3

Figure 10.1 (Added) Quarterly preventive maintenance services.

ITEM		PAR REF
7	DOUGH TROUGH, CARRIER ASSEMBLY AND MONORAIL. Clean a dirty dough trough. Replace worn, damaged, or defective dough trough carrier assembly. Lubricate monorail wheels in accordance with current L.O. Replace worn, damaged or defective monorail latch springs. Check for worn, damaged, or defective monorail.	122 thru 124
8	WHEELS AND TIRES. Inflate 900-20 tires to 45 psi. Inflate 7.50-20 tires to 75 psi. Replace missing valve caps. Remove foreign matter from tires. Replace badly worn, damaged, or defective tires. Lubricate and adjust wheel bearings in accordance with current L.O. Replace worn, damaged, or defective seals, bearings, or wheels.	35 29 30
9	LEVELLING SUPPORT JACKS. Lubricate jacks in accordance with current L.O. Free-up binding jacks. Replace worn, damaged, or defective jacks.	41
10	DOUGH CURLER BELT. Clean a dirty belt. Replace a worn, damaged, or defective belt.	98
11	MOLDER CONVEYOR BELT. Clean a dirty belt. Replace a worn, damaged, or defective belt.	99
12	SHEETING ROLL SHAFTS AND SCRAPERS. Clean dirty roller shafts and coat with divider oil. Check roller shafts for cracks, chips, and other damage. Tighten scraper loose mounting. Check scrapers for chips and cracks.	114
13	DIVIDER CONVEYOR BELT. Clean a dirty belt. Adjust belt not to slip under the weight of three dough pieces. Clean a dirty belt. Replace worn, damaged, or defective belt.	58



MSC 7360-201-20/10.1 (2) C3

Figure 10.1 -continued

ITEM		PAR REF
14	TOGGLE SWITCH. Tighten loose mounting and connections. Replace worn, damaged, or defective switch.	90
15	VALVE, (OUTLET GATE). Replace packing if valve is leaking. Tighten loose mounting and connections. Replace worn, damaged, or defective valve.	98
16	AGITATOR. Turn agitator by hand and see that it does not scrape against mixer bowl. Clean a dirty agitator and coat with divider oil. Check for worn, damaged, or defective agitator and/or components.	
17	AGITATOR ROLLERS. Free-up binding rollers. Clean dirty rollers and coat with divider oil. Replace worn, damaged, or defective rollers.	75 76
18	MIXER BOWL ASSEMBLY. Clean a dirty bowl and coat with divider oil. Replace worn, damaged, or defective bowl cover latches. Check bowl for dents and open seams.	74
19	AGITATOR DRIVE CHAIN. Remove, clean, and oil drive chain. Reference current L.O. Proper adjustment is a deflection of 1/2 inch midway between sprocket and pinion. Replace worn, damaged, or defective chain.	51 72
20	AGITATOR SPROCKET WHEEL. Tighten loose mounting. Replace worn, damaged, or defective sprocket wheel.	81
21	DIVIDER SILENT CHAIN. Remove, clean, and oil chain. Reference current L.O. Proper adjustment is a deflection of 1/2 inch midway between sprockets. Replace worn, damaged, or defective chain.	51
22	DIVIDER MOTOR. Tighten loose mounting and connections. Replace worn, damaged, or defective motor.	42
23	DIVIDER COMPRESSION SPRINGS. Tighten loose mounting. Proper adjustment of springs is a 3/4-inch clearance between the knife, the plunger, and the dough box cylinder when the divider is operating. Replace worn, damaged, or defective springs.	
24	FRONT AND REAR SHEETING ROLL DRIVE CHAINS. Remove, clean, and oil chains. Reference current L.O. Replace idler sprocket spring if the idler sprocket does not hold front sheeting roll chain in proper tension. Proper adjustment, for rear sheeting roll chain, is a deflection of 1/2 inch midway between sprockets. Replace worn, damaged, or defective chains.	50 117
25	MOLDER DRIVE CHAIN. Remove, clean, and oil chain. Reference current L.O. Proper adjustment is a deflection of 1/2 inch midway between pinion and gear. Replace worn, damaged, or defective chain.	51
26	MOLDER MOTOR. Tighten loose mounting and electrical connections. Replace worn, damaged, or defective motor.	

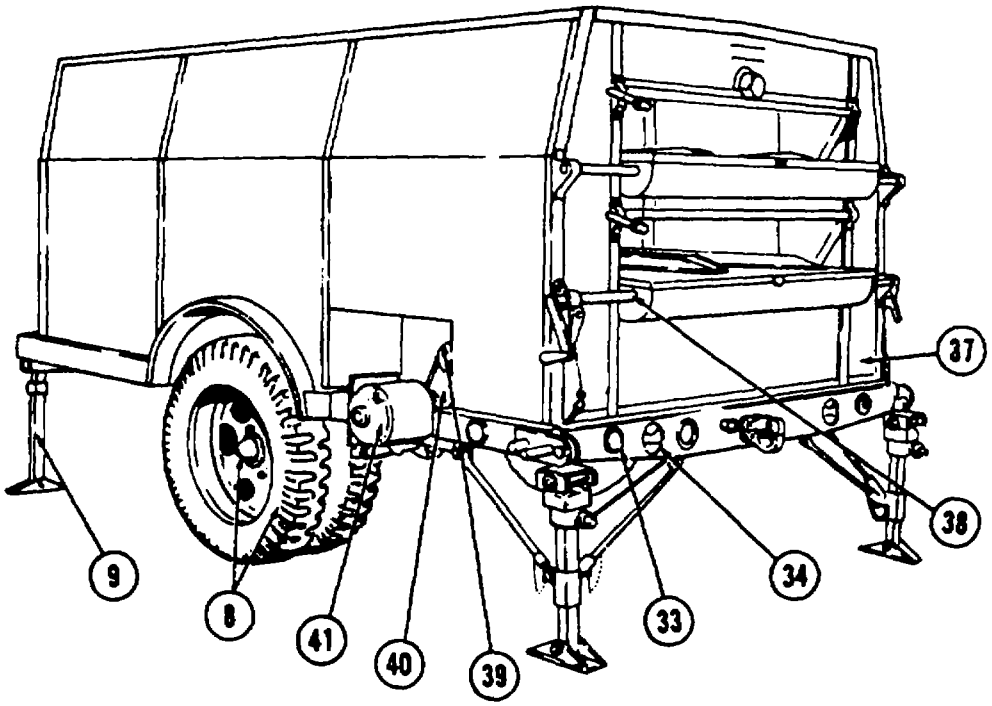
MSC 7380-201-20/10.1 (3) C3

Figure 10.1 -continued

ITEM		PAR REF
27	AIR OVER HYDRAULIC BRAKE ASSEMBLY. Adjust hydraulic brakes as necessary. Fill master cylinder with brake fluid. Clean dirty cap vent. Replace brake shoes if worn to within 1/16 inch of the rivets. Replace worn, damaged, or defective wheel cylinders or master cylinder.	23 24 25
28	MOLDER CONVEYOR BELT DRIVE CHAIN. Remove, clean and oil chain. Reference current L.O. Proper adjustment is a deflection of 1/2 inch midway between sprockets. Replace worn, damaged, or defective chain.	51
29	DIVIDER ROLLER CHAINS. Remove, clean, and oil chains. Reference current L.O. Proper adjustment is a deflection of 1/2 inch midway between sprockets. Replace worn, damaged, or defective chains.	50
30	DIVIDER GEAR REDUCTION UNIT. Add oil as indicated by level gage. Reference current L.O. Tighten loose mounting. Check for worn, damaged, or defective divider gear reduction unit.	67
31	MIXER GEAR REDUCTION UNIT. Add oil as indicated by level gage. Reference current L.O. Tighten loose mounting. Check for worn, damaged, or defective mixer gear reduction unit.	83 84
32	MIXER MOTOR. Tighten loose mounting and electrical connections. Replace worn, damaged, or defective motor.	42
33	REFLECTORS. Tighten loose mounting. Replace damaged or defective reflectors.	
34	SERVICE AND BLACKOUT LIGHTS (TRAILERS). Replace burned-out lamps. Replace worn, damaged, or defective light assemblies.	18 46
35	MAGNETIC STARTER PUSH-BUTTON UNIT. Tighten loose mounting and electrical connections. Replace worn, damaged, or defective magnetic starter push-button unit.	69
36	CONTROLS AND INSTRUMENTS. Replace damaged instruments. Tighten loose mounting. With the unit operating, check for proper operation. Normal operating readings for instruments are as follows: a. Mixer bowl dial thermometer — Indicates in degrees fahrenheit, the temperature of the dough being mixed. — 89 b. Water tempering tank measuring gage — Indicates in pounds, the amount of water in tank. — 91 c. Water tempering tank thermometer — Indicates in degrees fahrenheit, the temperature of the ingredient water. — 92 Reference TM10-7360-201-10, Par. 17.	

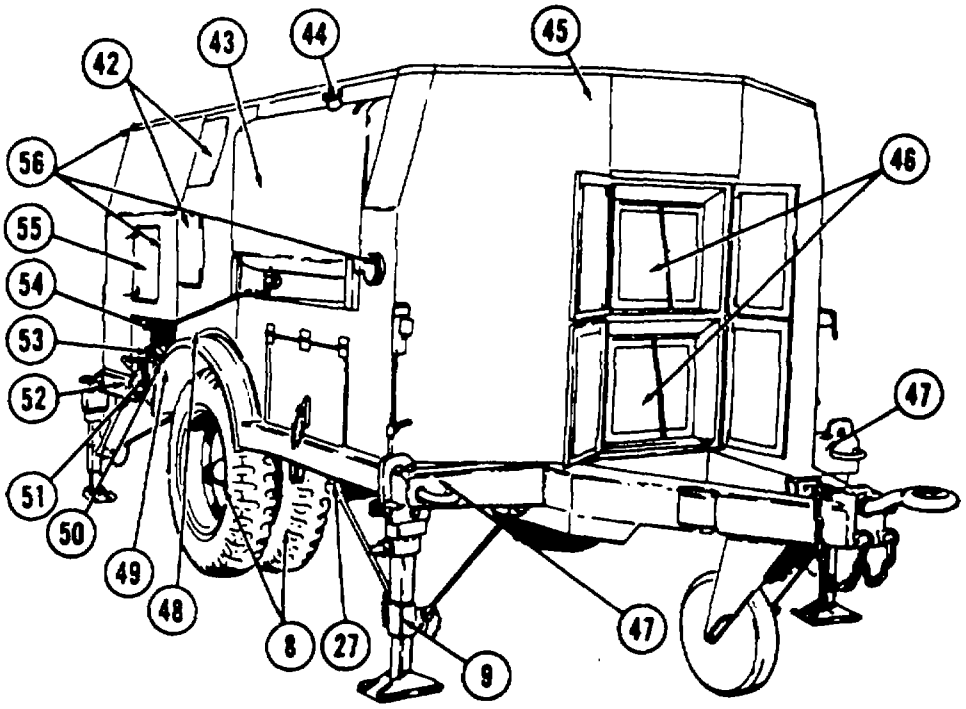
MSC 7360-201-20/10.1 (4) C3

Figure 10.1 -continued

ITEM		PAR REF
		
37	OVEN INDICATOR LIGHTS. Replaced burned-out lamps. Tighten loose mounting and electrical connections. Replace damaged or defective light assemblies.	143
38	OVEN CONVEYOR ROLLER CHAINS. Remove, clean, and oil chains. Reference current L.O. Adjust chains as necessary by moving springs to holes closer to end of takeup lever. Replace worn, damaged, or defective chains.	132
39	PILLOW BLOCK. Add oil as indicated by level gage. Reference current L.O. Clean a dirty liquid sight indicator. Tighten loose mounting. Replace worn, damaged, or defective pillow block or oil rings.	136
40	OVEN BLOWER V-BELT. Proper adjustment is a deflection of 1/2 inch midway between motor and blower pulleys. Replace worn, frayed, or cracked belt.	129
41	OVEN BLOWER MOTOR. Tighten loose mounting and electrical connections. Replace worn, damaged, or defective motor.	126

MSC 7380-201-20/10.1 (5) C3

Figure 10.1 -continued

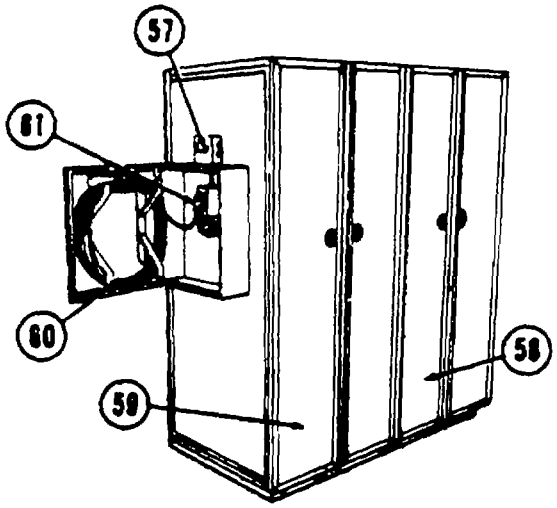


ITEM		PAR REF
42	OVEN LIGHTS. Replace burned-out lamps. Replace damaged or defective light assemblies.	148
43	FUEL TANK. Add fuel as required. Tighten loose mounting. Replace leaking fuel tank. Replace defective cap gasket. Clean cap vent.	131
44	FUEL SCREEN. Clean a dirty screen. Replace a damaged or defective screen.	
45	STOVE PIPE. Clean dirty stove pipe. Replace damaged or defective pipe.	
46	PRESSURE RELIEF SHEETS AND GASKETS. Replace worn, damaged, or defective sheets and gaskets.	133
47	HANDBRAKES AND CABLES. (OVEN TRAILER ONLY). Adjust hand brakes as necessary. Replace worn, damaged, or defective handbrakes and cables.	22
48	COMBUSTION TUNNEL. Clean soot from tunnel. Check for worn, damaged, or defective tunnel or flange.	152
49	FUEL FILTER. Tighten shell bolts if gasket is leaking. Replace a dirty filter element.	153

MSC 7330-201-20/10.1 (6) C3

Figure 10.1 -continued

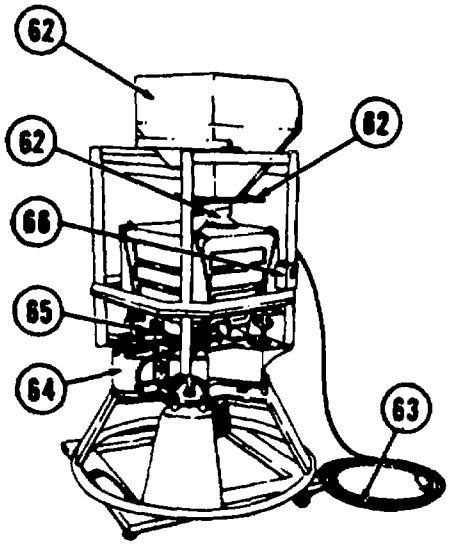
ITEM		PAR REF
50	FUEL METERING FLOAT VALVE. Clean a dirty strainer. Adjust valve as necessary. Tighten loose mounting and connections. Replace worn, damaged, or defective float valve.	154
51	HEATER ASSEMBLY GASKETS. Tighten loose mounting. Replace worn, damaged, or defective gaskets.	134 135
52	VALVES, (BY-PASS PLUG, FUEL SHUT-OFF, MAGNETIC). Tighten loose mounting and connections. Replace worn, damaged, or defective valves.	156 157 158
53	BURNER ASSEMBLY. Clean a dirty burner assembly. Tighten loose mounting and connections. Replace damaged or defective burner assembly.	151
54	BURNER HANDLE ADJUSTING SPRING. Adjust spring for proper tension. Replace damaged or defective spring.	142
55	OVEN BURNER AND OVEN LIGHT SWITCH. Tighten loose mounting and electrical connections. Replace damaged or defective switches.	147
56	CONTROLS AND INSTRUMENTS. Replace damaged instruments. Tighten loose mounting. With the unit operating, check for proper operation. Normal operating readings for instruments are as follows: a. Oven dial thermometer — 100°F less than the temperature registered on the temperature indicating control — 150 b. Temperature indicating control — Indicates flue temperature — 148 c. Fuel gage — Indicates amount of fuel in tank. — 160 Reference TM10-7360-201-10, Par. 18.	



MSC 7360-201-20/10.1 (7) C3

Figure 10.1 -continued

ITEM		PAR REF
57	INDICATOR LIGHT. Replace burned-out lamp. Tighten loose mounting and connections. Replace damaged or defective light.	181
58	HEATERS. Clean corroded heaters and terminals. Tighten loose terminal connections. Smooth heater surfaces if rough. Replace damaged or defective heaters.	187
59	WATER PANS. Clean corroded pans. Replace damaged or defective pans.	188
60	INPUT CABLE. Tighten loose electrical connections. Replace worn, damaged, or defective cable.	183
61	CONTROL, (PROOFING CABINET THERMOSTATIC SWITCH). Replace damaged control. Tighten loose mounting. With the unit operating, check for proper operation. Reference TM10-7360-201-10, par. 19.	182
62	HOPPER, TUBE, AND SLIDE. Clean a dirty hopper. Tighten loose mounting. Replace worn, damaged, or defective hopper, tube, or slide.	183
63	POWER CABLE. Tighten loose electrical connections. Replace worn, damaged, or defective cable.	
64	ELECTRIC MOTOR. Tighten loose mounting and connections. Replace worn, damaged, or defective motor.	170



MSC 7360-201-20/10.1 (B) C3

Figure 10.1 - continued

ITEM		PAR REF
65	DRIVE V-BELT. Proper adjustment is a deflection of 1/2 inch midway between sheaves. Replace worn, frayed, or cracked belt.	174
66	CONTROL. (SIFTER MANUAL STARTER). Replace damaged control. Tighten loose mounting. With the unit operating, check for proper operation. Reference TM10-7380-201-10, par.20.	170
	NOTE 1. OPERATIONAL TEST. During operation observe for any unusual noise or vibration.	
	NOTE 2. ADJUSTMENTS. Make all necessary adjustments during operational test.	
	NOTE 3. FIRE EXTINGUISHER. Inspect for broken seal. The dry chemical type must be weighed every 6 months. If the weight has decreased to less than 4 1/2 pounds or the pressure is below 125 psi, the extinguisher must be replaced.	

MSC 7380-201-20/10.1 (8) C3

Figure 10.1 - continued

"Table VIII. Maintenance Indicator Checklist for the Mixing and Make-up Trailer"
Rescinded

"Table IX. Maintenance Indicator Checklist for the Mixing and Make-up Machinery"
Rescinded.

"Table X. Maintenance Indictor Checklist for the Oven Trailer" Rescinded.

"Table XI. Maintenance Indicator Checklist for the Oven Machinery" Rescinded.

"Table XII. Maintenance Indicator Checklist for the Proofing Cabinet" Rescinded.

"Table XIII. Maintenance Indicator Checklist for the Flour Sifter" Rescinded.

185. Preliminary Services

*** * * * ***

b. (Superseded) Operational Test. Test the equipment to be sure it operates satisfactorily by performing the quarterly preventive maintenance services listed in paragraph 13.1.

APPENDIX I. The following references are changed to read:

AR 750-5	Maintenance Responsibilities and Shop Operation
TM 38-750	The Army Equipment Record System and Procedures
SB 38-5-3	List of Standard Lubricants, Hydraulic Fluids, Liquid Fuels, and Preservative Material Used by the Army

BY ORDER OF THE SECRETARY OF THE ARMY:

EARLE G. WHEELER,
Major General, United States Army,
Chief of Staff.

Official:

J. C. LAMBERT,
Major General, United States Army,
The Adjutant General

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Armies (5)
Svc Colleges (2)
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10-22
10-105
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NG: None.

USAR: None.

For explanation of abbreviation used, see AR 320-50

TECHNICAL MANUAL
Organizational Maintenance Manual
BAKERY PLANT, MOBILE M-1945 (FSN 7360-221-2418)

TM 10-7360-201-20
CHANGES No. 2

HEADQUARTERS,
DEPARTMENT OF THE ARMY
WASHINGTON 25, D.C., *2 August 1962*

TM 10-7360-201-20, 17 March 1961, is changed as follows:

1. Scope

a. (As superseded by C 1, 26 Apr 62) These instructions are published for the use of personnel responsible for the organizational (second echelon) maintenance of the Bakery Plant, Mobile (FSN 7360-221-2418), consisting of:

3 Bakery Ovens, Trailer-Mounted (Federal stock numbers 7310-215-5260 or 7310-255-8068)
1 Dough Mixing and Makeup Outfit, Trailer-Mounted (Federal stock numbers 7320255-7769 or 7320-215-5256)
3 Cabinets, Dough-Proofing (Federal stock numbers 7320-215-5189 or 7320-298-1380)
1 Sifter Machine, Flour, Electric (Federal stock number 7320-221-2386)
2 Generator Sets (Federal stock numbers 6115-376-7006, 6115-312-7865, 6115-635-8143, or 6115-538-8726) and Various accessories.

* * * * *

3. Forms, Records, and Reports

(Superseded)

The maintenance forms, records, and reports to be used in the second-echelon maintenance of this equipment are listed and described in TM 38-750.

9. Maintenance Inspection and Tests

(Superseded)

a. The organizational mechanic will perform the services and tests that are listed and described on the maintenance indicator checklists (par. 13.1). The services performed at this time will begin the cycle of regularly scheduled preventive maintenance services.

b. The services performed, the deficiencies and shortcomings noted, and the corrective action taken will be reported on the appropriate forms prescribed and explained in TM 38-750.

10. Run-in Test

(Rescinded)

11.1. Lubrication Intervals

(Added)

The following interval symbols will be used in lieu of those indicated on the lubrication orders:

(1) Interval symbol "M" (in lieu of "1") designates services performed every month or 100 operating hours, whichever occurs first.
(2) Interval symbol "S" (in lieu of "5") designates services performed every 6 months or 500 operating hours, whichever occurs first.

13. General

(Superseded)

a. Preventive maintenance is defined as the systematic care, inspection, and servicing of equipment to maintain it in serviceable condition, to prevent breakdowns, and to assure maximum operational capability.

b. The services described in this section are those which must be performed by second echelon maintenance personnel at regularly scheduled intervals. The organization mechanic may be assisted by the operator in performing these services.

***These changes supersede C 1, 26 April 1962**

13.1. Maintenance Indicator Checklists
(Added)

a. The maintenance indicator checklists prescribe the services that will be performed by the second-echelon mechanic at the indicated intervals, and they are Class CS serviceability standards. These checklists will also be used by the personnel who conduct formal, informal, technical, and command maintenance inspections; and by personnel engaged in materiel classification activities.

b. The intervals for performing these preventive maintenance services are as follows:

"M" - Every month or 100 operating hours, whichever occurs first.
"S" - Every 6 months or 500 operating hours, whichever occurs first.

c. The deficiencies or shortcomings noted and the corrective action taken or required will be reported on the appropriate forms prescribed and explained in TM 38-750.

d. Wherever possible, these preventive maintenance services have been fully described in the checklists. For detailed test or adjustment procedures, and for repair or replacement procedures, refer to the paragraph listed in the reference column of the checklist.

e. The checklists for the components of the mobile bakery plant are presented in the following sequence.

(1) Table VIII, Maintenance Indicator Checklist for the Mixing and Makeup Trailer.
(2) Table IX, Maintenance Indicator Checklist for the Mixing and Makeup Machinery.
(3) Table X, Maintenance Indicator Checklist for the Oven Trailer.
(4) Table XI, Maintenance Indicator Checklist for the Oven Machinery.
(5) Table XII, Maintenance Indicator Checklist for the Proofing Cabinet.
(6) Table XIII, Maintenance Indicator Checklist for the Flour Sifter.

Table VIII. Maintenance Indicator Checklist for the Mixing and Makeup Trailer

Key:
M-Every month or 100 operating hours, whichever occurs first.
S-Every 6 months or 500 operating hours, whichever occurs first.

Item No.	Interval M	Interval S	Procedure	Par. ref.
			Note. **The maintenance indicator checklist for the generator aft will be found in the pertinent technical manual for the generator net.**	
			PRELIMINARY SERVICES	
1	x	x	LUBRICATION. Lubricate trailer chassis and monorail in accordance with instructions given on LO 10-7360-201-20-4 and in paragraph 11.1.	11
2	x	x	PUBLICATIONS AND MODIFICATIONS. a. Be sure the log book and other necessary publications are either on or near the trailer. b. Check to be sure that all required modifications have been accomplished and that they have been recorded in the log book as required by TM 38-750.	
3	x	x	LUNETTE AND SAFETY CHAIN ASSEMBLIES. a. Inspect the lunette for secure mounting, bends, and cracks.	36
			b. Inspect the safety chain assembly for secure mounting and for cracked or broken links.	37
4	x	x	CASTER WHEEL. Inspect caster wheel assembly for secure mounting, damage, and mining parts.	34

Table VIII. Maintenance Indicator Checklist for the Mixing and Makeup Trailer-Continued

Item No.	Interval M	Interval S	Procedure	Par. ref.
5	x	x	WIRING AND INTERVEHICULAR CABLE.	
			Inspect the wiring and intervehicular cable for loose connectors, bare places, frays, wear, and other damage.	17
6	x	x	HANDBRAKE AND CABLE.	
			a. Inspect lever and strut for bends, breaks, and other defects.	22
			b. Inspect handbrake cable for kinks, fraying, and breaks.	22
			c. Inspect handbrake lever for broken spring and for worn pawl or sector.	22
7	x	x	EMERGENCY BRAKE BATTERY.	
			a. Inspect the battery case for cracks.	20
			b. Inspect cables, terminal posts, and straps for frayed condition, corrosion, damaged connectors, and other defects.	
			c. Test the battery. It should have 6 volts.	
8	x	x	TRAILER CHASSIS.	
			a. Inspect the trailer chassis for broken or missing parts and for dents and other damage.	
			b. Inspect the paint, markings, and identification plate for defects.	
			c. Inspect working platform and support for damage and broken welds.	
9	x	x	SERVICE AND BLACKOUT LIGHTS.	
			Inspect service and blackout lights for secure mounting and for any damage to lamps, receptacles, cover glasses, and preformed packing.	18, 46
10	x	x	SAFETY REFLECTORS.	
			Inspect safety reflectors for secure mounting and damaged lenses.	
11	x	x	LEVELING-SUPPORT JACKS.	
			a. Inspect all parts of jacks for bends or breaks.	41
			b. Check each brace rod and each retracting bracket for secure mounting.	
			c. Be sure the cranks for operating the leveling jacks are on the trailer and are serviceable.	
12	x	x	WHEEL ASSEMBLIES AND TIRES.	
			a. Inspect wheels for loose, dry, or damaged bearings; and for loose capscrews, bent or twisted rims, and secure mounting.	29
			b. Inspect tires for cuts, bruises, breaks, unusual wear, penetration of foreign objects, missing valve stem caps and proper inflation. The tires should be inflated to 45 psi for size 9.00-20 tires to 75 psi for size 7.50-20 tires.	35
13	x	x	FRAME AND CROSSMEMBERS.	
			Inspect frame and crossmembers for proper alinement, bends, and broken welds.	
14	x	x	SPRINGS.	
			a. Inspect spring leaves for looseness and damage. Look for broken or shifted spring leaves.	40
			b. Check hangers, brackets, and U-bolts for secure mounting.	
			c. Check front shackle bolt sleeve bearing for wear.	
15	x	x	AXLE ASSEMBLY AND RUBBER BUMPER.	
			a. Inspect axle assembly for leaks, bends and cracks.	38
			b. Inspect rubber bumper for loss of elasticity, dry rot, and cracks.	39

Table VIII. Maintenance Indicator Checklist for the Mixing and Makeup Trailer-Continued

Item No.	Interval M	Interval S	Procedure	Par. ref.
16	x	x	MASTER CYLINDER. Check the master cylinder for leaks. Be certain that it is mounted securely, that the filler plug vent is open fully, and that the boot is installed properly.	
17	x	x	BRAKE BACKING PLATE. Inspect brake backing plate for breaks, cracks, or warped condition.	32
18	x	x	HYDRAULIC BRAKESHOE LINING, AND WHEEL CYLINDERS. *a.* Inspect brakeshoe lining for glazing, oil, and wear. If the lining is worn to within 1/16 inch of the rivets, the brakeshoes must be replaced. *b.* Inspect wheel cylinders for secure mounting and for leaks.	23*b*
19	x	x	BRAKEDRUMS, BEARINGS, SEALS, AND HUBS. *a.* Inspect brakedrums for scoring, cracks, and warping. *b.* Inspect bearings for chipped rollers and cups and for heat discoloration. *c.* Inspect seals for leaks and deterioration. *d.* Inspect hubs for cracks, breaks, and other damage.	31 30 30 33
20	x	x	AIR CLEANER AND LINES. *a.* Inspect the air cleaner for secure mounting, moisture, and foreign matter. *b.* Inspect the lines for tight connections, air leaks, and obvious defects.	27
21	x	x	AIR CHAMBER AND LINES. *a.* Inspect the air chamber for leaks and secure mounting. *b.* Inspect the lines for tight connections, air leaks, and obvious defects.	27
22	x	x	HYDRAULIC LINES AND FITTINGS. Inspect all hydraulic lines and fittings for secure connections and for leaks.	
23	x	x	ELECTRIC BRAKE ASSEMBLY. *a.* Inspect springs for fatigue and check electric wiring for breaks, wear, and fraying. *b.* Inspect band and lining for wear. If the lining is worn to within 1/16 inch of the rivets, the band and lining must be replaced. *c.* Check all mechanical parts for breaks, cracks, and wear.	21
24	x	x	LIGHTING EXTENSION CORDS. *a.* Inspect extension cords for wear, fraying, and other damage. *b.* Inspect sockets, reflectors, lamps, and guards for damage.	47
25	x	x	POWER PANEL CIRCUIT BREAKERS, PLUGS, CONNECTORS, AND RECEPTACLES. *a.* Inspect circuit breakers on power panel to be sure they separate properly. *b.* Inspect plugs for short circuiting or other defects. *c.* Inspect receptacles for short circuiting and other defects. **OPERATIONAL TEST** Operate the trailer.	45 46 49
26	x	x	SERVICE AND BLACKOUT LIGHTS. Inspect service and blackout lights for proper operation.	18.
27	x	x	BLACKOUT SWITCH. Check blackout switch for proper operation.	19

Table VIII. Maintenance Indicator Checklist for the Mixing and Makeup Trailer-Continued

Item No.	Interval M	Interval S	Procedure	Par. ref.
28	x	x	ELECTRIC BRAKE ASSEMBLY. Test the electric brake for proper operation.	21
28	x	x	HANDBRAKE. Check handbrake lever to be certain it operates properly with one-third ratchet travel in reserve.	22
30	x	x	HYDRAULIC SERVICE BRAKES. *a.* Check hydraulic service brakes for proper operation. *b.* Adjust brakes as necessary.	28 28
31	x	x	CASTER WHEEL ASSEMBLY. Check the operation of the caster wheel assembly. Be certain the locking handle securely holds the caster wheel in the proper position.	
			FINAL INSPECTION	
32	x	x	OVERHEATING AND LEAKS. Immediately after the operational test is completed, check all appropriate components for overheating and oil leaks.	

Table IX. Maintenance Indicator Checklist for the -fixing and Makeup Machinery

KEY:
M-Every month or 100 operating hours, whichever occurs first.
S-Every 6 months or 500 operating hours, whichever occurs first.

Item No.	Interval M	Interval S	Procedure	Par. ref.
			MONORAIL SYSTEM	
			PRELIMINARY SERVICES	
1	x	x	MONORAIL LATCHES AND LATCH SPRINGS. a. Inspect latches for serviceability. b. Inspect latch springs for fatigue and damage.	 123
2	x	x	DOUGH TROUGH CARRIER ASSEMBLY. a. Inspect carrier assembly for damage and secure mounting. b. Inspect carrier wheels for cracks and secure mounting.	 122 124
3	x	x	DOUGH TROUGHS and COVERS. a. Inspect dough troughs and covers for dents and open seams. b. Inspect inside of dough troughs and covers for cleanness and be sure they are coated with divider oil.	
4	x	x	TRAILER LIGHTS. Inspect lamps, globes, guards, fixtures, and receptacles for dents, bends, and broken glass.	 46
5	x	x	PAINT. Inspect paint for visible defect.	
			OPERATIONAL TEST	
6	x	x	DOUGH TROUGH CARRIER ASSEMBLY. Test the monorail system and the carrier assembly to be sure they operate properly and smoothly.	
			Mixer Assembly	
			PRELIMINARY SERVICES	
7	x	x	CANVAS COVER. Inspect cover for rips, tears, holes, rotten material, and grease or oil spots Be sure straps and buckles are present and securely attached.	

Table IX. Maintenance Indicator Checklist for the -"Mixing and Makeup Machinery- Continued

Item No.	Interval M	Interval S	Procedure	Par. ref.
8	x	x	LUBRICATION. Lubricate mixer according to instructions on LO 10-7360-201-20-1 and in paragraph 11.1.	
9	x	x	MIXER BOWL DIAL THERMOMETER. Inspect thermometer for secure mounting and for a broken glass or dial.	89
10	x	x	MIXER ASSEMBLY HOUSING. *a.* Inspect finishing panels for bends, dents, and secure mounting. *b.* Inspect front door and catch for secure mounting and proper operation. *c.* Inspect front door leather cushions for deterioration. Be sure they keep the door from rattling.	73
11	x	x	MIXER BOWL ASSEMBLY. *a.* Inspect bowl cover to see that it operates and latches properly. *b.* Inspect bowl for dents and open seams. *c.* Be sure inside of bowl is clean and coated with divider oil.	74
12	x	x	AGITATOR ROLLERS. *a.* Inspect roller surfaces for chips, cracks, or other damage. *b.* Be sure that rollers are clean, turn freely, and are coated with divider oil.	75, 76
13	x	x	AGITATOR. *a.* Inspect agitator for burs and cleanness. Be sure agitator is coated with divider oil. *b.* Turn agitator by hand and see that it does not scrape against bowl.	
14	x	x	RIGHT AND LEFT AGITATOR SHAFT ROD NUTS. Inspect nuts on shaft rods for looseness.	80
15	x	x	AGITATOR DRIVE CHAIN. *a.* Inspect drive chain for damage, misalignment, and wear. *b.* Inspect chain for 1/2-inch finger-pressure deflection between the sprocket and pinion.	72 72*b*(1)
16	x	x	AGITATOR SPROCKET WHEEL. Inspect sprocket wheel for broken cogs, chips, and cracks.	81
17	x	x	MIXER PILLOW BLOCKS. Inspect pillow blocks for secure mounting and for wear.	85
18	x	x	AGITATOR RIGHT AND LEFT SHAFT BUSHINGS. Inspect shaft bushings for secure mounting, wear, and visible damage.	77
19	x	x	MIXER BOWL DUMP ASSEMBLY. Inspect dump assembly for proper operation and secure mounting.	82
20	x	x	VALVES. *a.* Inspect check valves for leaks and stripped threads. *b.* Inspect control valve for leaks and stripped threads. *c.* Inspect outlet gate valve for leaks and stripped threads.	94 95 96
21	x	x	WATER-TRANSFER PUMP, PIPING, AND TOGGLE SWITCH. *a.* Inspect water-transfer pump and piping for secure mounting and for leaks. *b.* Inspect toggle switch for secure mounting and serviceable wiring.	93
22	x	x	WATER-TEMPERING TANK, MEASURING GAGE AND DIAL THERMOMETER. *a.* Inspect tank for open seams and for leaks.	91

Table IX. Maintenance Indicator Checklist for the Mixing and Makeup Machinery-Continued

Item No.	Interval M	Interval S	Procedure	Par. ref.
			b. Inspect tank measuring gage for a cracked or chipped glass window. See that gaskets and connectors are serviceable. Be sure all rods are straight, and be sure pointers slide easily and are not bent or damaged.	
			c. Inspect dial thermometer for broken glass and for leaks around threads.	92
23	x	x	MIXER GEAR REDUCTION UNIT AND OIL LEVEL GAGE.	
			a. Check reduction unit for wear and misalignment.	83
			b. The oil level in the reduction unit should be at the hair line on the oil level gage.	
			c. Inspect oil level gage for a broken glass or other damage.	84
24	x	x	MIXER SILENT CHAIN.	
			a. Inspect silent chain for wear and damage.	51*b*
			b. Be sure chain is adjusted to 1/2-inch finger-pressure deflection midway between sprockets.	
25	x	x	MIXER MOTOR MAGNETIC STARTER.	
			a. Inspect magnetic starter for grease, dust, and dirt.	86
			b. Inspect contact points for pits or bad burns, Remove rough edges with fine sandpaper.	
			c. Inspect thermal release and cogs for serviceability.	
26	x	x	PAINT AND MARKINGS.	
			Inspect paint, markings and identification plate for visible defects.	
			OPERATIONAL TEST	
			Start mixer.	
27	x	x	CONTROLS AND INSTRUMENTS.	
			a. Check start pushbutton to see that it starts the mixer.	
			b. Check stop pushbutton to see that it stops the mixer.	
			c. Test jog pushbutton. It should jog agitator when the bowl is in the dump position.	
			d. Check accuracy of the bowl thermometer by comparing it with a hand thermometer.	
			e. Inspect water-tempering tank measuring gage for proper operation.	
			f. Inspect water-tempering tank outlet gage valve for proper operation. It should control the flow of water from the tank to the bowl.	
			g. Inspect water-transfer system control valve handle knob for proper operation. It should control the flow of hot and cold water to the water-tempering tank.	
			h. Inspect water-transfer pump drain valve for proper operation. It should drain water from the water-transfer system.	
			i. Inspect water-transfer pump motor switch for proper operation. It should start and stop the pump.	
			j. Inspect mixer limit switch for proper operation. It should not operate the agitator with the bowl in the dump position until the jog pushbutton is pushed.	88*b*
28	x	x	MIXER GEAR REDUCTION UNIT.	
			Inspect gear reduction unit for unusual noises.	83
29	x	x	MIXER MOTOR.	
			Check mixer motor for unusual noises, overheating, and smoke.	42*a*
30	x	x	WATER-TRANSFER PUMP AND MOTOR.	
			a. Inspect pump for proper operation and for leaks.	93
			b. Check pump motor for overheating, unusual noise, and smoke.	

Table IX. Maintenance Indicator Checklist for the -fixing and Makeup Machinery-Continued

Item No.	Interval M	Interval S	Procedure	Par. ref.
31	x		x VALVES.	
			a. Inspect check valves for proper operation. These valves should restrict the flow of water to one direction.	94*b*
			b. Inspect control valve for proper operation. It should control the flow of water to the tank.	95*b*
32	x	x	MIXER BOWL.	
			Inspect mixer bowl for lubricant leaks. If leaks are found, tighten agitator bushings.	77
			FINAL INSPECTION	
33	x	x	OVERHEATING AND LEAKS.	
			Immediately after the operational test is completed, inspect all appropriate components for leaks and for evidence of overheating.	
			Divide Assembly	
			PRELIMINARY SERVICES	
34	x	x	CANVAS COVER.	
			a. Inspect canvas cover for rips, tears, holes, rotten material, and grease or oil spots.	
			b. Be sure straps and buckles are present and securely attached.	
35	x	x	LUBRICATION.	
			Lubricate divider according to instructions on LO 10-7360-201-20-2 and in paragraph 11.1.	
36	x	x	DIVIDER ASSEMBLY HOUSING.	
			a. Inspect doors for bends, dents, and proper operation.	
			b. Inspect door catches for serviceability.	53
			c. Inspect door hinges for bends and cracks.	55
37	x	x	DIVIDER CHECKING SCALE AND MOUNTING CUSHIONS.	
			a. Inspect checking scale for damage such as distortion, bends, and breaks.	56
			b. Inspect mounting cushions for resilience and deterioration.	54
38	x	x	HOPPER.	
			a. Inspect hopper for dents, burs, cleanness, and proper mounting.	
			b. Be sure the inside of the hopper is coated with divider oil.	
39	x	x	DOUGH BOX ASSEMBLY.	
			a. Inspect dough box for cleanness and roughness.	66
			b. Be sure dough box is coated with divider oil.	
40	x	x	KNIFE AND PLUNGER.	
			a. Inspect knife and plunger for correct position, burs, and cleanness (TM 10-7360-201-10).	
			b. Check to see that the knife and plunger are coated with divider oil	
41	x	x	DOUGH BOX CYLINDER, KNOB, AND PISTON.	
			a. Inspect dough box cylinder for cleanness, excessive oil, and burs. Be sure the cylinder does not scrape against the dough box.	64
			b. Inspect piston for burs, cleanness, and proper position (TM 10-7360-201-20).	
			c. Be sure that the piston is coated with divider oil.	
			d. Inspect knob for ease of operation.	
42	x	x	DIVIDER CONVEYOR BELT.	
			a. Inspect conveyor belt for cleanness, looseness, and rust.	58
			b. Adjust belt so that it will not slip under the weight of three dough pieces.	58

Table IX. Maintenance Indicator Checklist for the Mixing and Makeup Machine--Continued

Item No.	Interval M	Interval S	Procedure	Par. ref.
43	x	x	DIVIDER COMPRESSION SPRINGS. *a*. Inspect compression springs for proper adjustment and secure mounting. *b*. The springs should be adjusted so that there is 3/4-inch clearance between the knife, the plunger, and the dough box cylinder when the divider is operating.	
44	x	x	DIVIDER CRANKSHAFT, LEVER, PILLOW BLOCKS, AND SPROCKET. Inspect crankshaft, lever, pillow blocks, and sprocket for wear, cracks, and distortions.	63
45	x	x	DIVIDER DUSTERS. *a.* Inspect inside of dusters for cleanness. *b*. Inspect dusters for secure mounting. *c*. Inspect agitator rod for proper spring action. *d*. Inspect duster screen for excessive wear and damage. *e*. See that flow plates and adjusting screws operate without binding.	62
46	x	x	DIVIDER OIL PUMP AND RESERVOIR. *a*. Inspect oil pump reservoir and lines for secure mounting. *b*. Be sure elements are not clogged.	68 68
47	x	x	MAGNETIC STARTER PUSHBUTTON UNIT. Inspect magnetic starter pushbutton unit for secure mounting and for burns.	69
48	x	x	MAGNETIC STARTER ASSEMBLY. *a*. Inspect parts of magnetic starter for dust, dirt, and grease. *b*. Inspect contact points for burns and pits. *c*. Inspect thermal release and cogs for serviceability.	70
49	x	x	MANUAL STARTER ASSEMBLY. *a*. Inspect wire terminals and heater coils for serviceability. *b*. Check assembly for broken or cracked parts. *c*. Be sure contacts are clean and are not pitted.	71
50	x	x	DIVIDER MOTOR. Inspect motor for secure mounting and for loose and frayed wiring.	42
51	x	x	DIVIDER SILENT CHAIN. *a*. Inspect roller chains for wear and damage. *b*. Inspect adjustment of silent chain. The proper adjustment is 1/2-inch deflection midway between sprockets.	51
52	x	x	DIVIDER ROLLER CHAINS. *a*. Inspect roller chains for wear and damage. *b*. Check adjustment of roller chains. The proper adjustment is 1/2-inch deflection midway between sprockets.	50
53	x	x	DIVIDER GEAR REDUCTION UNIT. *a*. Inspect gear reduction unit for secure mounting. *b*. Inspect the oil level gage for damage. *c*. See that there is no end play on worm shaft and worm wheel shaft.	67
54	x	x	PAINT AND MARKINGS. Inspect paint and identification plate for visible defects. OPERATIONAL TEST Operate the divider.	
56	x	x	MANUAL STARTER. See that manual starter starts and stops divider.	

Table IX. Maintenance Indicator Checklist for the Mixing and Makeup Machinery--Continued.

Item No.	Interval M	Interval S	Procedure	Par. ref.
56	x	x	MAGNETIC STARTER. Be sure magnetic starter starts and stops divider.	
57	x	x	DIVIDER MOTOR. Check divider motor for unusual noises, overheating, and smoke.	42
58	x	x	DIVIDER GEAR REDUCTION UNIT. Check the gear reduction unit for unusual noises.	67
59	x	x	DIVIDER CONVEYOR BELT. *a*. See that the conveyor belt is running true on the drum and roller. *b*. Be sure that the belt is not slipping.	58b(8)
60	x	x	OIL PUMP. Check to see if oil is being pumped into the dough box.	
			FINAL INSPECTION	
61	x	x	OVERHEATING AND LEAKS. Immediately after the operational test is completed, check all appropriate components for overheating and leaks.	
			Molder Assembly	
			PRELIMINARY SERVICES	
63	x	x	CANVAS COVER. Inspect cover for rips, tears, holes, rotten material, and grease or oil spots. Be sure straps and buckles are present and securely attached.	
63	x	x	LUBRICATION. Lubricate molder according to instructions on LO 10-7360-201-20-3 and in paragraph 11.1.	
64	x	x	PAINT AND MARKINGS. Inspect paint and identification plate for visible defects.	
65	x	x	MANUAL STARTER ASSEMBLY. Inspect manual starter assembly for secure mounting and burns.	121
66	x	x	MAGNETIC STARTER. Inspect magnetic starter for secure mounting and burns.	120
67	x	x	MAGNETIC STARTER BUSHBUTTON UNIT. Inspect magnetic starter bushbutton unit for secure mounting and burns.	119
68	x	x	FRONT AND REAR SHEETING ROLL DRIVE CHAINS. *a*. Remove right headframe cover plate and inspect front sheeting roll drive chain. *b*. Inspect idler sprocket spring to see that idler sprocket holds the front sheeting roll chain in proper tension. *c*. Remove left headframe cover plate and inspect rear sheeting roll drive chain for wear and damage. *d*. Inspect rear sheeting roll drive chain for 1/2-inch deflection midway between sprockets. The adjustment can be made by loosening the nut on the eccentric idler shaft, turning the shaft, and tightening the nut.	50 117 50
69	x	x	MOLDER CONVEYOR BELT DRIVE CHAIN. *a*. Inspect chain for wear, proper deflection, and damage. *b*. Inspect chain for 1/2-inch deflection midway between sprockets. The chain can be adjusted by either adding or removing shims between the headframe and the conveyor frame.	51

Table IX. Maintenance Indicator Checklist for the Mixing and Makeup Machinery--Continued

Item No.	Interval M	Interval S	Procedure	Paragraph reference
70	x	x	MOLDER DRIVE CHAIN.	
			a. Inspect drive chain for wear, proper deflection, and damage.	51
			b. Inspect drive chain for 1/2-inch deflection midway between pinion and gear. The adjustment can be made by raising or lowering the molder motor on the headframe crossmember.	
71	x	x	SHEETING ROLL SHAFT AND SCRAPERS.	
			a. Inspect roll shafts for cracks, chips, and other damage.	114
			b. Be sure roller shafts are clean and have a coat of divider oil.	
			c. Inspect scrapers for chips, cracks, and secure mounting.	
72	x	x	SHEETING ROLL HUBS WITH SPROCKETS, BEARINGS, PINIONS, AND SPROCKET WHEELS.	
			a. Inspect hubs with sprockets for cracks, breaks, and chipped teeth.	108
			b. Inspect bearings for chipped teeth, cracks, and wear.	105
			c. Inspect pinions for cracks, breaks, and chipped teeth.	110
			d. Inspect sprocket wheels for excessive wear, cracks, and broken teeth.	118
73	x	x	SHEETING ROLLS AND CONVEYOR DRIVE SHAFT.	
			Inspect shaft for excessive wear at bearing positions.	115
74	x	x	SHEETING ROLL ADJUSTING HANDWHEELS AND SPRINGS.	
			a. Inspect handwheels for cracks, secure mounting, and proper operation.	
			b. Be sure that handwheels are held securely in position.	
			c. Inspect springs for fatigue and breakage.	116
75	x	x	MOLDER DUSTERS.	
			a. Inspect drive rod for bends and other damage.	112
			b. Inspect regulating lever for bends, breaks, and other defects.	109
			c. Inspect screen for cleanness, breaks, and tears.	113
			d. Inspect duster boxes for cleanness.	
			e. Move stud shafts and check for wear in bearings.	104
76	x	x	MOLDER CONVEYOR BELT.	
			Inspect belt for splits, holes, tears, cleanness, proper tension, and proper alinement. The belt has proper tension if it does not slip while operating.	99
77	x	x	DOUGH CURLER BELT.	
			Inspect curler belt for tears, rips, rust, and other defects.	98
78	x	x	PRESSURE BOARD ASSEMBLY.	
			a. Inspect pressure board for warping, splits, loose screws, rust, and other defects.	101
			b. Inspect knobs, eccentrics, and shafts for secure mounting and proper operation.	
79	x	x	MOLDER ASSEMBLY.	
			a. Inspect headframes for cracks and secure mounting.	
			b. Inspect headframe covers for cracks and secure mounting.	
			OPERATIONAL TEST	
			Operate the molder.	
80	x	x	MANUAL STARTER.	
			Check the manual starter for proper operation.	
81	x	x	MAGNETIC STARTER.	
			Check the magnetic starter for proper operation.	

Table IX. Maintenance Indicator Checklist for the Mixing and Makeup Machinery--Continued

Item No.	Interval M	Interval S	Procedure	Par. ref.
82	x	x	MOLDER MOTOR. Check the molder motor for overheating, overloading, and smoke.	42
83	x	x	MOLDER CONVEYOR BELT. a. Inspect belt for proper tension. If the belt slips, move idler pulley away from drive pulley. b. Be sure that belt runs true on the pulleys.	
			FINAL INSPECTION	
84	x	x	OVERHEATIN1G AND LEAKS. Immediately after the operational test is completed, check all appropriate components for overheating and lubricant leaks.	

Table X. Maintenance Indicator Checklist for the Oven Trailer

Key:

M--Every month or 100 operating hours, whichever occurs first.

S--Every 6 months or 500 operating hours, whichever occurs first.

Item No.	Interval M	Interval S	Procedure	Par. ref.
			Note. **The maintenance indicator checklist for the generator met will be found in the pertinent technical manual for the generator set.**	
			PRELIMINARY SERVICES	
1	x	x	LUBRICATION Lubricate trailer chassis in accordance with instructions given on LO 10-7360-201-20-5 and in paragraph 11.1.	11
2	x	x	PUBLICATIONS AND MODIFICATIONS. *a*. Be sure the log book and other necessary publications are either on or near the trailer. *b*. Check to be sure that all required modifications have been accomplished and that they have been recorded in the log book as required by TM 38-750.	
3	x	x	LUNETTE AND SAFETY CHAIN ASSEMBLIES *a*. Inspect the lunette for secure mounting, bends, and cracks. *b*. Inspect the safety chain assembly for secure mounting and for cracked or broken links.	 36 37
4	x	x	CASTER WHEEL. Inspect caster wheel assembly for secure mounting, damage, and missing parts.	34
5	x	x	WIRING AND INTERVEHICULAR CABLE. Inspect the wiring and intervehicular cable for loose connectors, bare places, frays, wear, and other damage.	17
6	x	x	HANDBRAKE AND CABLE *a*. Inspect lever and strut for bends, breaks, and other defects. *b*. Inspect handbrake cable for kinks, fraying, and breaks. *c*. Inspect handbrake lever for broken spring and for worn pawl or sector.	 22 22 22

Table X. Maintenance Indicator Checklist for the Oven Trailer--Continued

Item No.	Interval M	Interval S	Procedure	Par. ref.
7	x	x	EMERGENCY BRAKE BATTERY.	
			a. Inspect the battery case for cracks.	20
			b. Inspect cables, terminal posts, and straps for frayed condition, corrosion, damaged connectors, and other defects.	
			c. Test the battery. It should have 6 volts.	
8	x	x	TRAILER CHASSIS.	
			a. Inspect the trailer chassis for broken or missing parts and for dents and other damage.	
			b. Inspect the paint, markings, and identification plate for defects.	
9	x	x	SERVICE AND BLACKOUT LIGHTS.	
			Inspect service and blackout lights for secure mounting and for any damage to lamps, receptacles, cover glasses and preformed packing.	18, 46
10	x	x	SAFETY REFLECTORS.	
			Inspect safety reflectors for secure mounting and for damaged lenses.	
11	x	x	LEVELING-SUPPORT JACKS.	
			a. Inspect all parts of jacks for bends or breaks.	41
			b. Check each brace rod and each retracting bracket for secure mounting.	
			c. Be sure the cranks for operating the leveling jacks are on the trailer and are serviceable.	
12	x	x	WHEEL ASSEMBLIES AND TIRES.	
			a. Inspect wheels for loose, dry, or damaged bearings; and for loose capscrews, bent or twisted rims, and secure mounting.	29
			b. Inspect tires for cuts, bruises, breaks, and unusual wear, penetration of foreign objects, missing valve stem caps, and proper inflation. The tires should be inflated to 45 psi for size 9.00-20 tires and to 75 psi for size 7.50-20 tires.	35
13	x	x	FRAME AND CROSSMEMBERS.	
			Inspect frame and crossmembers for proper alinement, bends, and broken welds.	
14	x	x	SPRINGS.	
			a. Inspect spring leaves for looseness and damage. Look for broken or shifted spring leaves.	40
			b. Check hangers, brackets, and U-bolts for secure mounting.	
			c. Check front shackle bolt sleeve bearing for wear.	
15	x	x	AXLE ASSEMBLY AND RUBBER BUMPER.	
			a. Inspect axle assembly for leaks, bends, and cracks.	38
			b. Inspect rubber bumper for loss of elasticity, dry rot, and cracks.	39
16	x	x	MASTER CYLINDER.	
			Check the master cylinder for leaks. Be certain that it is mounted securely, that the filler plug vent is opened fully, and that the boot is installed properly.	
17	x	x	BRAKE BACKING PLATE.	
			Inspect brake backing plate for breaks, tracks, or warped condition.	32
18	x	x	HYDRAULIC BRAKESHOE LINING AND WHEEL CYLINDERS.	
			a. Inspect brakeshoe lining for glazing, oil, and wear. If the lining is worn to within 1/16 inch of the rivets, the brakeshoes must be replaced.	23*b*
			b. Inspect wheel cylinders for secure mounting and for leaks.	

Table X. Maintenance Indicator Checklist for the Oven Trailer—Continued

Item No.	Interval M	Interval S	Procedure	Par. ref.
19	x	x	BRAKEDRUMS, BEARINGS, SEALS, AND HUBS.	
			a. Inspect brakedrums for scoring, cracks, and warping.	31
			b. Inspect bearings for chipped rollers and cups and for heat discoloration.	30
			c. Inspect seals for leaks and deterioration.	30
			d. Inspect hubs for cracks, breaks, and other damage.	33
20	x	x	AIR CLEANER AND LINES.	
			a. Inspect the air cleaner for secure mounting, moisture, and foreign matter.	
			b. Inspect the lines for tight connections, air leaks, and obvious defects.	
21	x	x	AIR CHAMBER AND LINES.	
			a. Inspect the air chamber for leaks and secure mounting.	27
			b. Inspect the lines for tight connections, air leaks, and obvious defects.	
22	x	x	HYDRAULIC LINES AND FITTINGS.	
			Inspect all hydraulic lines and fittings for secure connections and for leaks.	
23	x	x	ELECTRIC BRAKE ASSEMBLY.	
			a. Inspect springs for fatigue and check electric wiring for breaks, wear, and fraying.	21
			b. Inspect band and lining for wear. If the lining is worn to within 1/16 inch of the rivets, the band and lining must be replaced.	
			c. Check all mechanical parts for breaks, cracks, and wear.	
24	x	x	LIGHTING EXTENSION CORDS.	
			a. Inspect lighting extension cords for wear, fraying, and other damage.	47
			b. Inspect sockets, reflectors, lamps, and guards for damage.	
25	x	x	POWER PANEL CIRCUIT BREAKERS, PLUGS, CONNECTORS, AND RECEPTACLES.	
			a. Inspect circuit breakers on power panel to be sure they separate properly.	45
			b. Inspect plugs for short circuiting or other defects.	
			c. Inspect receptacles for short circuiting and other defects.	
			OPERATIONAL TEST	
			Operate the trailer.	
26	x	x	SERVICED AND BLACKOUT LIGHTS.	
			Inspect service and blackout lights for proper operation.	18
27	x	x	BLACKOUT SWITCH.	
			Check blackout switch for proper operation.	19
28	x	x	ELECTRIC BRAKE ASSEMBLY.	
			Test the electric brake for proper operation.	21
29	x	x	HANDBRAKE.	
			Check handbrake lever to be certain it operates properly with one-third ratchet travel in reserve.	22
30	x	x	HYDRAULIC SERVICE BRAKES.	
			a. Check hydraulic service brakes for proper operation.	23
			b. Adjust brakes as necessary.	23
31	x	x	CASTER WHEEL ASSEMBLY.	
			Check the operation of the caster wheel assembly. Be certain the locking handle securely holds the caster wheel in the proper position.	
			FINAL INSPECTION	
32	x	x	OVERHEATING AND LEAKS.	
			Immediately after the operational test is completed, check all appropriate components for overheating and oil leaks.	

Table XI. Maintenance Indicator Checklist For the Oven Machinery

Key:

M--Every month or 100 operating hours, whichever occurs first.

S--Every 6 months or 500 operating hours, whichever occurs first.

PRELIMINARY SERVICES

Item No.	Interval M	Interval S	Procedure	Par. ref.
1	x	x	LUBRICATION. Lubricate the oven machinery according to instructions given on LO 10-7360-201-20-5 and in paragraph 11.1.	
2	x	x	CANVAS COVERS. Inspect canvas covers for rips, tears, and holes. Also inspect covers for grease or oil, spots, and rotten material. Be certain all straps and buckles are present and are attached to the canvas securely.	
3	x	x	OVEN BLOWER MOTOR Inspect over blower motor for secure mounting.	126
4	x	x	OVEN BLOWER V-BELT Inspect v-belt for proper tension, wear, glazing, and fraying. The belt should have one-half inch deflection midway between pulleys.	129
5	x	x	BLOWER SHAFT PULLEY. Inspect blower shaft pulley for cracks, distortion, and secure mounting.	137
6	x	x	MOTOR SHAFT PULLEY. *a*. Inspect motor shaft pulley for cracks, distortion, and secure mounting. *b*. Be certain the motor shaft pulley is properly alined with the blower shaft pulley.	138 137
7	x	x	BLOWER MOTOR CABLE AND PLUG. Inspect blower motor cable and plug for wear, evidence of short circuiting, and other defects.	144
8	x	x	OVEN BLOWER. *a*. Inspect blower for secure mounting and see that it does not scrape against trailer body. *b*. Shake blower shaft to check for end play and wear in bearings.	139
9	x	x	HEATER ASSEMBLY GASKET. Inspect both the left-side heater assembly gasket and the right-side heater assembly gasket for air leaks.	134,135
10	x	x	PILLOW BLOCK. *a*. Inspect pillow block for cracks and secure mounting. *b*. Inspect oil rings for damage. *c*. See that liquid sight indicator is clean.	136
11	x	x	OVEN, DOOR SHAFT BEARINGS AND CONVEYOR DRIVE SHAFT BEARINGS. *a*. Inspect oven door shaft bearings for wear and secure mounting. *b*. Inspect conveyor drive shaft bearings for wear and secure mounting.	128 127
12	x	x	DOOR LOCKS AND HINGES. Inspect door hinges and locks for secure mounting and proper operation.	
18	x	x	OVEN DIAL THERMOMETER. Inspect the oven dial thermometer for secure mounting and for damage.	150

Table XI. Maintenance Indicator Checklist For the Oven Machinery--Continued

Item No.	Interval M	Interval S	Procedure	Par. ref.
14	x	x	OVEN INDICATOR LIGHT Inspect oven indicator light for damage and for broken or burned out lamp.	143
15	x	x	OVEN CONVEYOR ROLLER CHAINS. *a*. Inspect oven conveyor rollor chains for wear, broken links, and other damage. *b*. Adjust chains as necessary by moving springs to holes closer to end of takeup lever.	132
16	x	x	OVEN CONVEYOR CRANKS. Be certain that oven conveyor cranks are present and are serviceable.	
17	x	x	PRESSURE RELIEF SHEETS AND GASKETS. *a*. Inspect pressure relief sheets for holes, breaks, and rust. *b*. Inspect gaskets for serviceability for proper fit.	133
18	x	x	STOVEPIPE. Inspect stovepipe sections for rust, holes, and other evidences of deterioration.	
19	x	x	OVEN BURNER SWITCH AND OVEN LIGHT SWITCH. Inspect the switches for secure mounting, cleanness, good insulation, and proper wire connections.	147
20	x	x	MOTOR MANUAL STARTER. Inspect the motor manual starter for secure mounting, clean and serviceable contacts, and defective wiring.	71, 149
21	x	x	TEMPERATURE INDICATING CONTROL. Inspect temperature indicating control for dust, dirt, and broken glass.	148
22	x	x	BURNER ASSEMBLY. Inspect burner assembly for dust, dirt, grease, leaks, and secure mounting.	151
23	x	x	BURNER HANDLE ADJUSTING SPRING. Inspect the burner handle adjusting spring for proper tension, proper adjustment, and visible defects.	142
24	x	x	COMBUSTION TUNNEL. *a*. Inspect the combustion tunnel for holes and damage. *b*. Clean the combustion tunnel.	152
25	x	x	FUEL FILTER. *a*. Clean the fuel filter, and inspect the filter shell for cracks, rust, and sediment. *b*. Inspect the gaskets for serviceability. *c*. Replace the filter element.	153
26	x	x	FUEL METERING FLOAT VALVE, *a*. Inspect the fuel metering float valve for leaks around the gaskets. *b*. Check the strainer to be sure it is not plugged with sediment. *c*. Inspect the float for holes. Be sure it does not contain any liquid. If fuel flows from the overflow hose, the float valve is defective.	154
27	x	x	BYPASS PLUG VALVE, FUEL SHUTOFF VALVE, AND MAGNETIC VALVE. Inspect valves for leaks, secure mounting, and damage to threads.	156,157, 158

Table XI. Maintenance Indicator Checklist For the Oven Machine--Continued

Item No.	Interval M	Interval S	Procedure	Par. ref.
28	x	x	HOSES, LINES, AND FITTINGS. Inspect hoses, lines, and fittings for leaks, tight connections, and visible damages.	155
29	x	x	FLEXIBLE CONDUIT AND CONNECTORS. *a*. Inspect conduit for secure mounting and visible defects. *b*. Inspect connectors for damaged prongs and other obvious defects.	
30	x	x	OVEN LIGHTS. *a*. Inspect lamps to be sure they are serviceable. *b*. Inspect globes and porcelain sockets for damage. *c*. Check compression springs for adequate tension.	146
31	x	x	FUEL TANK, CAP, AND GASKET. *a*. Inspect fuel tank for leaks, rust, foreign matter, and secure mounting. *b*. Inspect tank cap to be certain that it is free of rust and dirt and that its vent holes are open. *c*. Inspect tank cap gasket for breaks, wear, and leaks.	131
32	x	x	FUEL SCREEN. Inspect fuel screen for holes, rust, and dirt.	
38	x	x	FUEL GAGE. Inspect fuel gage for secure mounting and visible damage.	160
34	x	x	OVEN POWER CABLE AND PLUG. Inspect the oven power cable and plug for wear, evidence of short circuits, and other damage.	145
			OPERATIONAL TEST Make the required electrical connections and operate the oven (TM 10-7360-201-10),	
35	x	x	INSTRUMENTS, VALVES, AND CONTROLS. *a*. Burner Fuel Tank Gage. Fill the burner fuel tank with fuel, and check to see that the gage registers full. *b*. Magnetic Valve. Check to see that the magnetic valve is operating properly. Whenever the oven reaches the desired operating temperature, a definite click should be heard; this click indicates that the valve is operative. *c*. Oven Light Switch. Check the oven light switch to see that it turns the oven lights on and off. *d*. Temperature Indicating Control. Check to see that the burner is firing on low flame whenever the indicating hand coincides with the setting pointer. If the burner is not firing on low flame, either the magnetic valve or the temperature indicating control is defective. *e*. Oven Indicator Light. Check to see that the oven indicator light glows whenever the burner is firing on high flame. If the light does not glow at this time, it is defective. *f*. Oven Door Locking Knobs. Check to see that the oven door locking knobs operate properly. *g*. Oven Door Handles and Catches. See that the oven door handles and catches operate properly. *h*. Oven Thermometer. Check the oven thermometer to see that it accurately registers the oven temperature.	
			FINAL INSPECTION	
36	x	x	OVERHEATING AND LEAKS. Immediately after the operational test is completed, examine all appropriate components for oil or fuel leaks. Check appropriate components for signs of overheating.	

Table XII. Maintenance Indicator Checklist for the Proofing Cabinet

Key:
M--Every month or 100 operating hours, whichever occurs first.
S--Every 6 months or 500 operating hours, whichever occurs first.

Item No.	Interval M	Interval S	Procedure	Par. ref.
			PRELIMINARY SERVICES	
1	x	x	CABINET, CONTROL BOX, DOORS, GASKETS, AND CATCHES.	
			a. Inspect cabinet for holes, dents. and cleanness.	
			b. Inspect control box for dents and check thumbscrews for stripped threads.	169
			c. Inspect doors to see that they close properly.	
			d. Inspect door gaskets for wear and damage. Be sure the gaskets are tightly joined.	166
			e. Inspect cam and catches for damage; be sure they hold door tightly shut.	165
2	x	x	HEATERS.	
			a. Inspect surface of heaters for rough places, and inspect heaters and terminals for corrosion.	167*a*
			b. Inspect terminals for secure connections.	
3	x	x	WATER PANS.	
			Inspect water pans for leaks and corrosion.	168
4	x	x	INDICATOR LIGHT.	
			a. Inspect indicator light for cracks, breaks, evidence of short circuits, and other defects.	161
			b. Check wires for bare places and fraying.	
5	x	x	WIRING HARNESSES.	
			Inspect wiring harnesses for fraying and bare places. Check terminals for corrosion.	164
6	x	x	POWER INPUT CABLE.	
			Inspect input cable for wear, breaks, and fraying.	163
7	x	x	PAINT.	
			Inspect paint for visible defects.	
			OPERATIONAL TEST	
			Operate proofing cabinet. Be sure that the water pans are half full of water.	
8	x	x	INDICATOR FLIGHT ASSEMBLY.	
			Inspect light assembly for proper operation.	161
9	x	x	THERMOSTATIC SWITCH.	
			Check temperature in cabinet with a thermometer to see if it agrees with setting of thermostatic switch dial.	162

Table XIII. Maintenance Indicator Checklist for the Flour Sifter

Key:
M--Every month or 100 operating hours, whichever occurs first.
S--Every 6 months or 500 operating hours, whichever occurs first.

Item No.	Interval M	Interval S	Procedure	Par. ref.
			PRELIMINARY SERVICES	
1	x	x	HOPPER, TUBE, AND SLIDE.	
			a. Inspect hopper for cleanness, dents, open seams, and secure mounting.	
			b. Inspect cloth tube for rips, tears, holes, and proper position.	183

Table XIII. Maintenance Indicator Checklist for the Flour Sifter-Continued

Item No.	Interval M	Interval S	Procedure	Par. ref.
			c. Check slide for damage. Be sure it moves freely.	
2	x	x	SIEVE FRAMES. HOLDDOWN BOX, RODS, SPURS, AND SHIMS.	
			a. Inspect sieve frames for dents, bends, tears, and other defects.	175
			b. Inspect holddown box for damage.	180
			c. Inspect hanger rods for breaks, bends, and secure mounting.	177
			d. Inspect holddown box rods for stripped threads, bends, and other defects.	181
			e. See that sack spurs are not damaged or missing.	
			f. Inspect rubber shims for resilience and deterioration.	178
3	x	x	DISCHARGE HOPPER DOOR SPRINGS.	
			Inspect hopper door springs for fatigue and proper tension.	179
4	x	x	COUNTERBALANCE SHEAVE ASSEMBLY.	
			Inspect sheave assembly for cracks, breaks, and other defects.	173
5	x	x	DRIVE V-BELT.	
			a. Inspect v-belt for wear, frays, cuts, and glazing.	174
			b. Inspect v-belt for 1/2-inch deflection midway between sheaves.	174
6	x	x	POWER CABLE.	
			Inspect power cable for cuts, wear, and fraying.	
7	x	x	ELECTRIC MOTOR AND MANUAL STARTER.	
			a. Inspect motor for secure mounting, and check wiring for secure connections.	170
			b. Inspect manual starter for secure mounting and for burns.	
8	x	x	STAKES.	
			See that three stakes are available and serviceable.	
9	x	x	PAINT.	
			Inspect paint for visible defects.	
			OPERATIONAL TEST	
10	x	x	MANUAL STARTER.	
			See that the manual starter will operate flour sifter.	
11	x	x	ELECTRIC MOTOR.	
			Inspect electric motor for overheating, smoke, and unusual noises.	170
12	x	x	STAKES.	
			Be sure that stakes hold flour sifter properly to reduce vibration.	

21. Electric Brake Assembly

* * * * *

d. Adjustment. (Rescinded)

30. Wheel Bearings and Seals

* * * * *

d. Adjustment. (Added) To adjust wheel bearings, draw axle nut tight enough to make the bearings bind slightly when the wheel is rotated. Back off nut 1/6 to 1/4 turn and lock it in place.

39. Trailer Axle Rubber Bumper

a. Inspection. Inspect rubber bumper for loss of elasticity, dry rot, or cracks.

* * * * *

50. Roller Chains

* * * * *

f. Adjustment (Added) Adjust roller chains to allow one-half inch of finger-pressure deflection midway between the sprockets.

51. Silent Chains

* * * * *

f. Adjustment. (Added) Adjust silent chains to allow one-half inch of finger-pressure deflection midway between sprockets.

72. Mixer Assembly

* * * * *

b. Adjustment.

(1) (Superseded) To adjust roller chain tension, loosen capscrews mounting gear reduction unit to mixer base and place shims under reduction unit.

* * * * *

129. Oven Blower V-Belt

* * * * *

c. Adjustment. (Added) Adjust V-belt to allow one-half inch of finger-pressure deflection midway between the pulleys.

174. Drive V-Belt

* * * * *

d. (Added) Adjust V-belt to allow one-half inch of finger-pressure deflection midway between the pulleys.

185. Preliminary Services

* * * * *

b. Operational Test. (Superseded) Test the equipment to be sure it operates satisfactorily by performing an operational test on each component (tables I through VI).

* * * * *

APPENDIX I (SUPERSEDED)
REFERENCES

AR 310-1	General Policies
AR 820-5	Dictionary of United States Army Terms
AR 320-50	Authorized Abbreviations and Brevity Codes
AF 700-58	Report of Damaged or Improper Shipment
AR 700-390(05	Registration of Materials Handling Equipment and Special Purpose Vehicles
AR 746-2300-1	Color and Marking of Vehicles and Equipment
AR 750-5	Organization, Policies, and Responsibilities for Maintenance Operation
DA Pam 108-1	Index of Army Motion Pictures, Film Strips, Slides, and Phono-Recordings.
DA Pam 310-1	Military Publications: Index of Administrative Publications
DA Pam 3102	Military Publications: Index of Blank Forms
DA Pam 310-4	Military Publications: Index of Technical Manuals, Technical Bulletins, Supply Bulletins, Lubrication Orders, and Modification Work Orders
FM 21-5	Military Training
FM 21-6	Techniques of Military Instruction
FM 21-30	Military Symbols
TM 10-7360-201-10	Operator's Manual: Bakery Plant, Mobile (FSN 7360-221-2418)
TM 10-7360-201-20P	Organizational Maintenance Repair Parts and Special Tool Lists: Bakery Plant, Mobile, M-1945 (FSN 7360-221-2418)
TM 11-661	Electrical Fundamentals (direct current)
TM 38-230	Preservation, Packaging and Packing of Military Supplies and Equipment
TM 38-750	The Army Equipment Records System; and Procedures.
TB QM 63	Radio Suppression for Materials Handling Equipment, Special-Purpose Vehicles, and Special-Purpose Equipment
SB 3-8-5-3	List of Standard Reference Fuels, Solvents and Preservative Material for which QMC is assigned Logistics Responsibility.
LO 10-7360-201-20-1	Bakery Plant, Mobile; Dough Mixing and Makeup Outfit (Mixer)
LO 10-7360-201-20-2	Bakery Plant, Mobile; Dough Mixing and Makeup Outfit (Divider)
LO 10-7360-201-20-3	Bakery Plant, Mobile; Dough Mixing and Makeup Outfit (Molder)
LO 10-7360-201-20-4	Bakery Plant, Mobile; Dough Mixing and Makeup Outfit (Monorail And Trailer Chassis)
LO 10-7360-201-20-5	Bakery Plant, Mobile (Bakery Oven, Trailer-Mounted)

Note

Publications referenced herein, other than those normally distributed to company-size units, will be requisitioned by unit commanders only when such publications are not readily available at higher headquarters for reference purposes.

BY ORDER OF THE SECRETARY OF THE ARMY:

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OSA (2)
Def Tfc Mgt Svc Rgn (1)
QM Fld Maint Shops (2)
JBUSMC (1)
Units org under fol TOE:
10-147 (3)
10-237 (2)
10-367 (2)
10-427 (2)
10-500 (BN,BQ,HQ,HV) (2)
10-521 (2)

NG: None.

USAR: None.

For explanation of abbreviations used, see AR 32-50.

TECHNICAL MANUAL
No. 10-7360-201-20

HEADQUARTERS,
DEPARTMENT OF THE ARMY
WASHINGTON 25, D.C., *17 March 1961*

Organizational Maintenance Manual

BAKERY PLANT, MOBILE, M-1945
(FSN 7360-221-2418)

* This manual supersedes so much of TM 10-1699A, 1 February 1950, including C 1, 7 March 1952; C 2, 13 January 1953; C 3, 26 May 1955; TM 10-1699C, 14 October 1949, including C 1, 14 May 1953; C 2, 14 November 1955; and C 3, 16 March 1956; TM 10-1699D, 29 June 1951; and TM 10-1699E, 20 November 1951, including C 1, 14 May 1953, as pertaining to organizational (second echelon) maintenance.

CHAPTER 1

INTRODUCTION

Section I. GENERAL

1. Scope

a. These instructions are published for the use of personnel responsible for the organizational (second echelon) maintenance of the Bakery Plant, Mobile (FSN 7360-221-2418), consisting of:

3 Bakery Ovens, Trailer-Mounted (FSN 7310-215-5260 or 7310-255-8068);
1 Dough Mixing and Makeup Outfit, Trailer-Mounted (FSN 7320-255-7769 or 7320-215-5256);
3 Cabinets, Dough-Proofing (FSN 7320-215-5189 or 7320-298-1380);
1 Sifting Machine, Flour, Electric (FSN 7320-221-2386);
2 Generator Sets (FSN 6115-295-0881, 6115-581-9317, or 6115-295-0880); and various accessories.

b. No information for the generators will be given in this manual. Technical manuals giving complete instructions on the second echelon maintenance of the generators are listed in DA Pam 310-4.

c. Users of this manual are encouraged to submit recommended changes or comments to improve the manual. Comments should be keyed to the specific page, paragraph, and line of the text in which the change is recommended. Reasons should be provided for each comment to insure understanding and complete evaluation. Comments should be forwarded direct to Commanding General, Quartermaster Training Command, US Army, Fort Lee, Va.

2. References

a. Appendix I contains a list of current references.

b. Appendix II contains the Maintenance Allocation Chart.

c. A list of repair parts and special tools authorized for second echelon maintenance will be published in TM 10-7360-201-20P.

3. Forms and Records

a. DA Form 10-46 (Registration and Historical Service Record of Materials Handling Equipment (Powered) and Special-Purpose Vehicles).

b. DA Form 10-103 (Worksheet for Special Purpose Vehicles and Equipment; Inspections and Preventive Maintenance Services).

c. DA Form 468 (Unsatisfactory Equipment Report).

d. DA Form 460 (Preventive Maintenance Roster).

e. DA Form 478 (Organizational Equipment File).

f. DA Form 811 (Work Request and Job Order).

g. DD Form 6 (Report of Damaged or Improper Shipment).

h. DD Form 314 (Preventive Maintenance Schedule and Record).

4. Orientation

a. Trailers. When the terms right, left, front, and rear are used in connection with the dough mixing and makeup outfit trailers and the oven trailers, they indicate positions from the viewpoint of the operators sitting in the towing vehicles.

b. Proofing Cabinet. When the terms right, left, front, and rear are used in connection with the proofing cabinet, they indicate positions from the viewpoint of the operator facing the cabinet doors and having the control panel and indicator light on his left.

c. Flour Sifter. When the terms *right*, *left*,

front, and *rear* are used in connection with the flour sifter, they indicate directions with the manual starting switch considered the front; the discharge hopper door, the rear; the motor side, the left; and the reject hopper door, the right.

Section II. DESCRIPTION AND DATA

5. Description

For information describing the major components of the mobile bakery plant, refer to (TM 10-7360-201-10).

6. Tablated Data

In addition to the data supplied in TM 10-7360-201-10, the following information is furnished for use by second echelon personnel.

a. Mixing and Makeup Outfit Trailer.

Mixer motor:

Current	60-cycle, 3-phase
Horsepower	7 1/2
Speed	1,750 rpm
Voltage	208

Water-transfer pump motor:

Current	60-cycle, 1-phase
Horsepower	1/2
Speed	3,450 rpm
Voltage	208

Divider motor:

Current	60-cycle, 3-phase
Horsepower	1 1/2
Speed	1,725 rpm
Voltage	208

Molder motor:

Current	60-cycle, 3-phase
Horsepower	1 1/2
Speed	1,725 rpm
Voltage	208

b. Oven Trailer.

Oven blower motor:

Current	60-cycle, 3-phase
Horsepower	1 1/2
Speed	1,725 rpm
Voltage	208

c. Flour Sifter.

Sifter motor:

Current	60-cycle, 1-phase
Horsepower	1/4
Speed	1,140 rpm
Voltage	110

CHAPTER 2

SERVICE UPON RECEIPT OF EQUIPMENT

7. General

a. The services performed upon receipt of the equipment are the responsibility of the using organization. The operator will assist the organization mechanic in these services when so directed by proper authority.

b. The services described in paragraphs 8 through 10 will apply to both new and used equipment.

8. Removal of Preservative

a. Remove the tape used to seal all openings.

b. Using SD (Solvent, drycleaning), remove the compound sprayed over metal surfaces. This compound is not a lubricant; be sure it is removed from wearing surfaces. Remove rust and corrosion inhibitors.

c. Remove paper and other packing from belts and pulleys.

9. Preliminary Services

a. Lubrication. Lubricate the equipment (par. 11) as necessary to prepare it for initial operation (par. 10).

b. Inspection. Inspect the equipment, following the applicable items outlined on DA Form 10-103 and in TM 10-1400. Write "Initial Inspection Upon Receipt" at the top of the form.

c. Deficiencies. Correct any deficiencies that are within the scope of organizational maintenance. Refer deficiencies beyond the scope of the organization to a higher echelon for correction.

10. Run-In Test

a. After completion of the preliminary services (par. 9), operate the equipment for approximately 4 hours. Do not use dough ingredients; the purpose of this test is to determine whether the mechanical and electrical equipment is functioning properly.

b. Operate the equipment according to the instructions in TM 10-7360-201-10, being sure to perform all before-, during-, and after-operation services.

c. Correct all deficiencies as directed in paragraph 9*c*.

CHAPTER 3

MAINTENANCE INSTRUCTIONS

Section I. LUBRICATION

11. Lubrication Under Usual Conditions

a. General. The lubrication orders listed below prescribe lubrication maintenance for the mobile bakery plant equipment. Compliance with the lubrication orders is mandatory at all levels of maintenance. If the equipment is received without copies of the orders, the using organization must requisition copies through normal channels as directed by AR 310-1.

(1) *LO 10-7360-201-20-1.* Lubrication Orders 10-7360-201-20-1 (fig. 1) prescribes lubrication for the *mixer* on the mixing and makeup outfit trailer. Specific lubrication points for the mixer assembly are illustrated on figure 2.

LUBRICATION ORDER

LO 10-7360-201-20-1

20 FEBRUARY 1961 (Supersedes LO 10-1699A-1, 3 Jan 1953)

BAKERY PLANT, MOBILE
DOUGH MIXING AND MAKEUP OUTFIT
(MIXER)

Reference: TM 10-7360-201-20

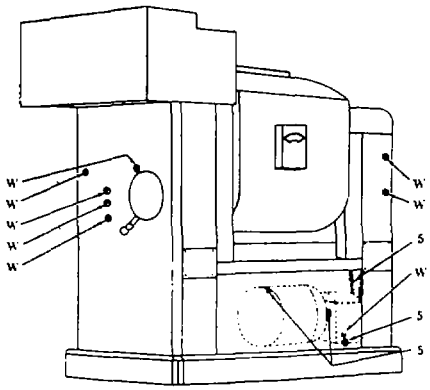
Intervals given are maximums for normal 8-hour operation. For abnormal conditions or activities, intervals should be shortened to compensate. During inactive periods, intervals may be extended commensurate with adequate preservation of the equipment.

Clean fittings before lubricating.

Clean parts with SD (Solvent, drycleaning). Dry before lubricating.

Broken arrow shafts indicate lubrication points on both sides of the equipment.

LUBRICANT	INTERVAL		LUBRICANT	INTERVAL	
GAA	W	A, fig. 2 — Wormshaft Bearing	GAA	W	B, fig. 2 — Right Shaft Agitator Bearing
GAA	W	A, fig. 2 — Left Shaft Agitator Bearing	GAA	W	B, fig. 2 — Right Support Trunnion Fitting
GAA	W	A, fig. 2 — Handwheel Shaft Bearing	OE	5	B, fig. 2 — Drive Chain (See Note 1)
GAA	W	A, fig. 2 — Left Support Trunnion Fitting	OE	W	C, fig. 2 — Gear Reduction Unit Oil Level Gage (See Note 3)
GAA	W	A, fig. 2 — Dump Shaft Sleeve Bushing		5	Gear Reduction Unit Drain (See Note 3)
			GAA	5	C, fig. 2 — Motor Bearings (See Note 2)



—KEY—

LUBRICANTS	EXPECTED TEMPERATURES		INTERVALS
	above + 32° F.	below + 32° F.	
OE—LUBRICATING OIL, Internal Combustion Engine	OE-30	At temperatures below + 32° F., operate the mixing and makeup outfit trailer in a heated shelter.	W—Weekly. 5—Semiannually or every 500 operating hours, whichever occurs first.
Drive Chain	OE-10		
GAA—GREASE, Automotive and Artillery	GAA		

NOTES:

1. DRIVE CHAIN—5, remove, soak and wash with SD, suspend to drain and dry; soak in OE-10, suspend, drain, and wipe off from outer surface.

2. MOTOR BEARINGS—5, grease sparingly with GAA; too much grease will cause bearings to overheat.

3. GEAR REDUCTION UNIT—W, check oil level and keep level up to center of gage. 5, drain oil, remove top of reduction unit, and refill with OE-30.

A copy of this lubrication order will remain with the equipment at all times; instructions contained herein are mandatory and supersede all conflicting orders issued prior to this date

By Order of the Secretary of the Army.

G. H. DECKER,
General, United States Army,
Chief of Staff.

Official.

R. V. LEE,
Major General, United States Army,
The Adjutant General.

3846-1

Figure 1. LO 10-7360-201-20-1.

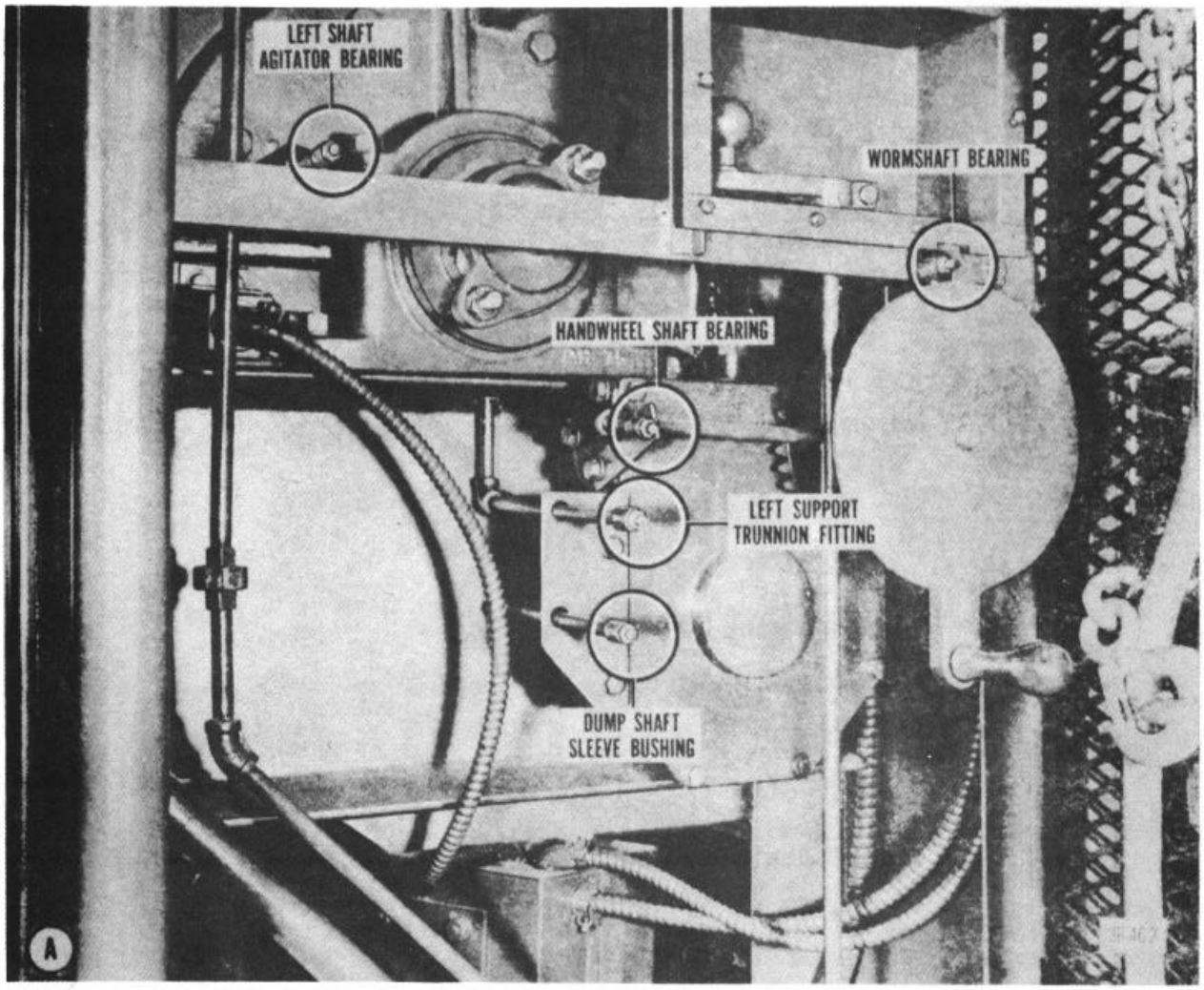


Figure 2. Mixer lubrication points.

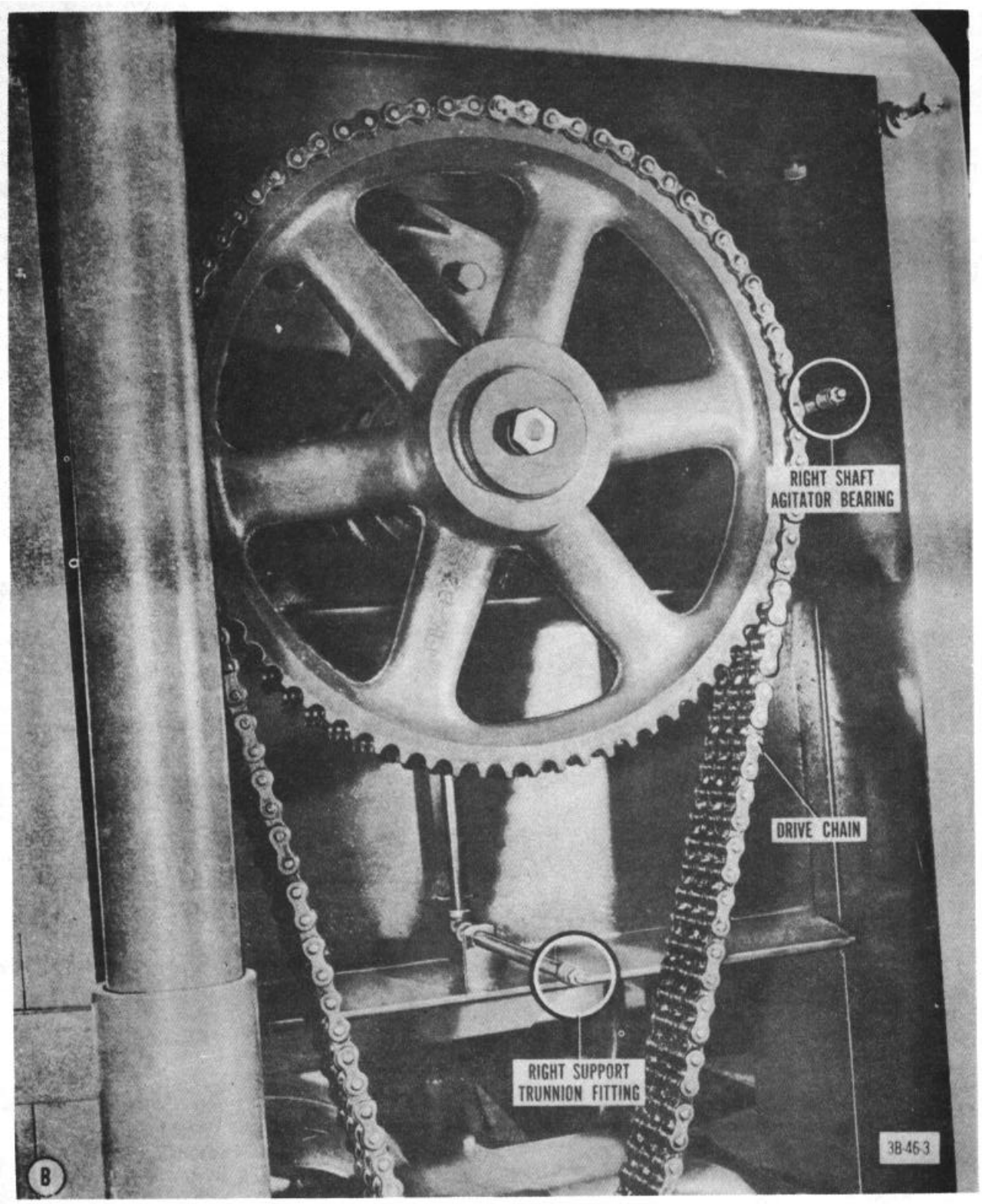


Figure 2--Continued.

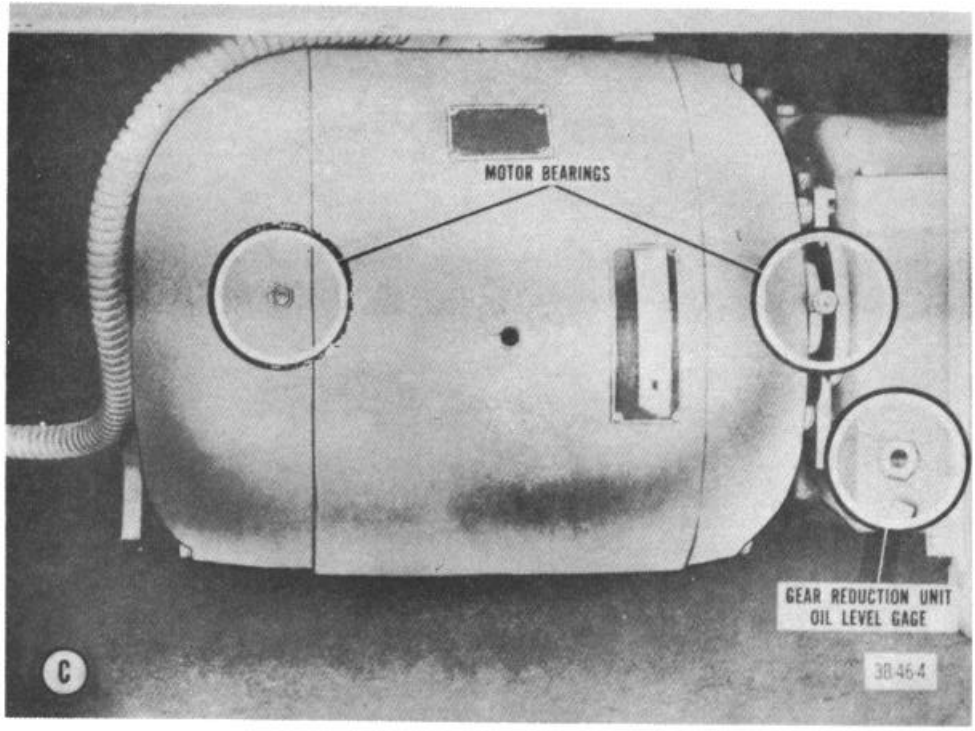


Figure 2--Continued.

LUBRICATION ORDER

LO 10-7360-201-20-2

28 FEBRUARY 1961 (Supersedes LO 10-1699A-2, 29 Dec 1952)

BAKERY PLANT, MOBILE
DOUGH MIXING AND MAKEUP OUTFIT
(DIVIDER)

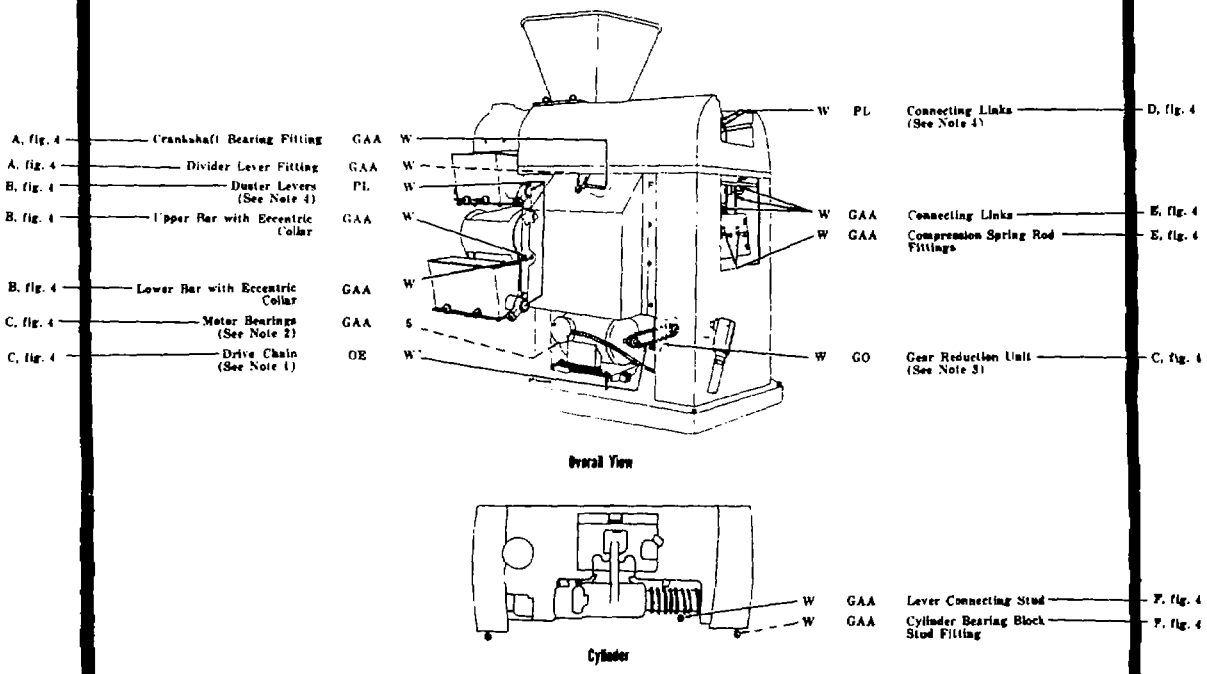
Reference: TM 10-7360-201-20

Intervals given are maximums for normal 8 hour operation. For abnormal conditions or activities, intervals should be shortened to compensate. During inactive periods, intervals may be extended commensurate with adequate preservation of the equipment.

Clean fittings before lubricating.

Clean parts with SD (Solvent, drycleaning). Dry before lubricating

Broken arrow shafts indicate lubrication points on both sides of the equipment.



—KEY—

LUBRICANTS	EXPECTED TEMPERATURES above + 32° F.	EXPECTED TEMPERATURES below + 32° F.	INTERVALS
OE—LUBRICATING OIL, Internal Combustion Engine	OE-30	At temperatures below + 32° F. operate the mixing and makeup outfit trailer in a heated shelter.	W—Weekly S—Semiannually or every 500 operating hours, whichever occurs first
Drive Chain	OE-10		
GO—LUBRICATING OIL, Gear	GO-90		
PL—LUBRICATING OIL, General Purpose Preservative	PL-Medium		
GAA—GREASE, Automotive and Artillery	GAA		

NOTES:

1. DRIVE CHAIN—S, remove, soak and wash with SD, suspend to drain and dry; soak in OE-10, suspend, drain, and wipe oil from outer surface.

2. MOTOR BEARINGS—S, grease sparingly with GAA; too much grease will cause bearings to overheat.

3. GEAR REDUCTION UNIT—W, check oil level and keep level up to center of worm wheel shaft. S, drain oil and refill with GO.

4. OILCAN POINTS—Use a squirt-type oiler to apply PL.

A copy of this lubrication order will remain with the equipment at all times; instructions contained herein are mandatory and supersede all conflicting orders issued prior to this date.

By Order of the Secretary of the Army:

G. H. DECKER,
General, United States Army,
Chief of Staff.

Official

R. V. LEE,
Major General, United States Army,
The Adjutant General

38 465

Figure 3. LO 10-7360-201-20-2.

(2) *LO 10-7360-201-20-2.* Lubrications Order 10-7360-201-20 (fig 3) prescribes lubrication for the divider on the mixing and makeup outfit trailer Specific lubrication points for the divider assembly are illustrated on figure 4.

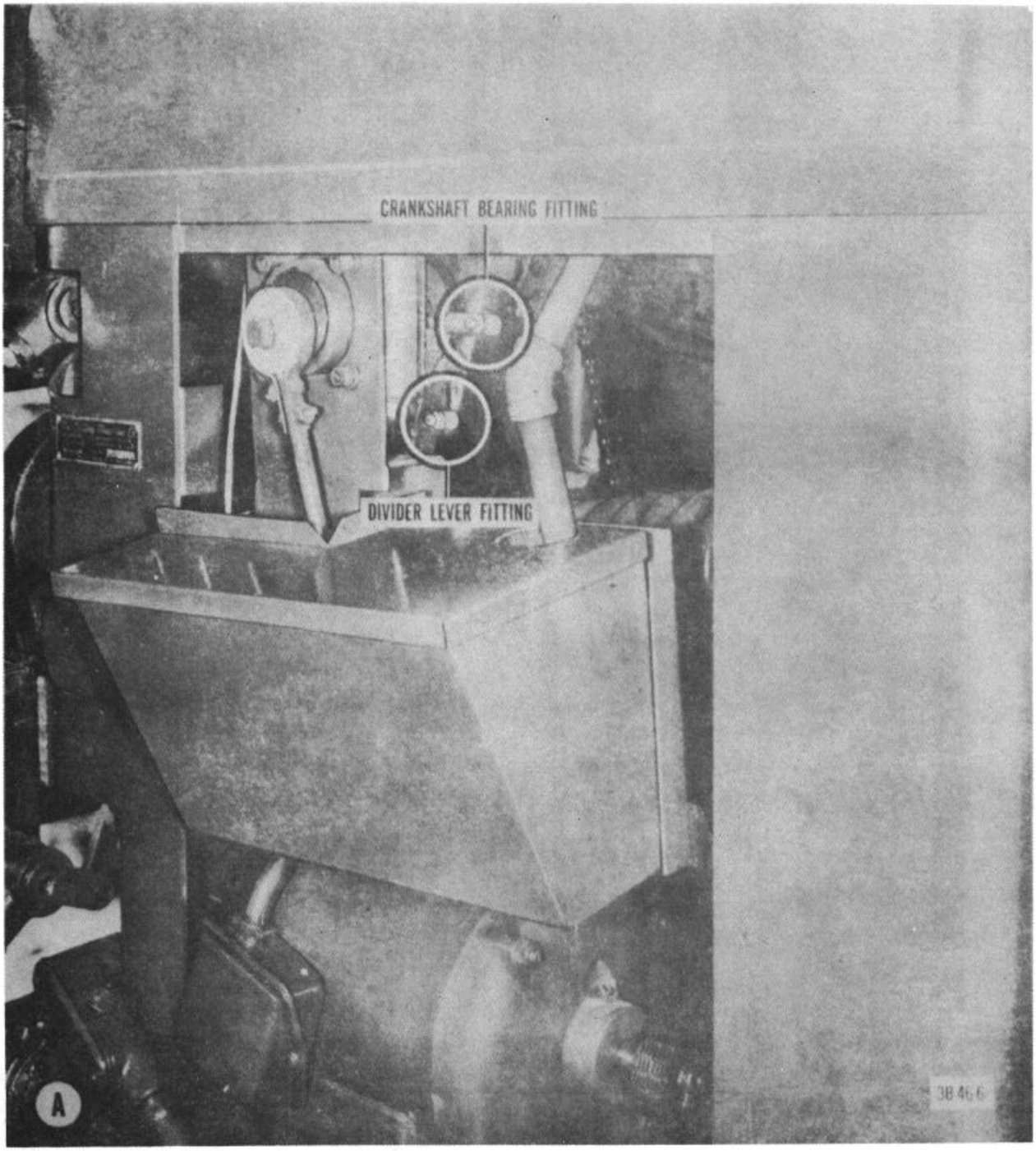


Figure 4. Divider lubrication points

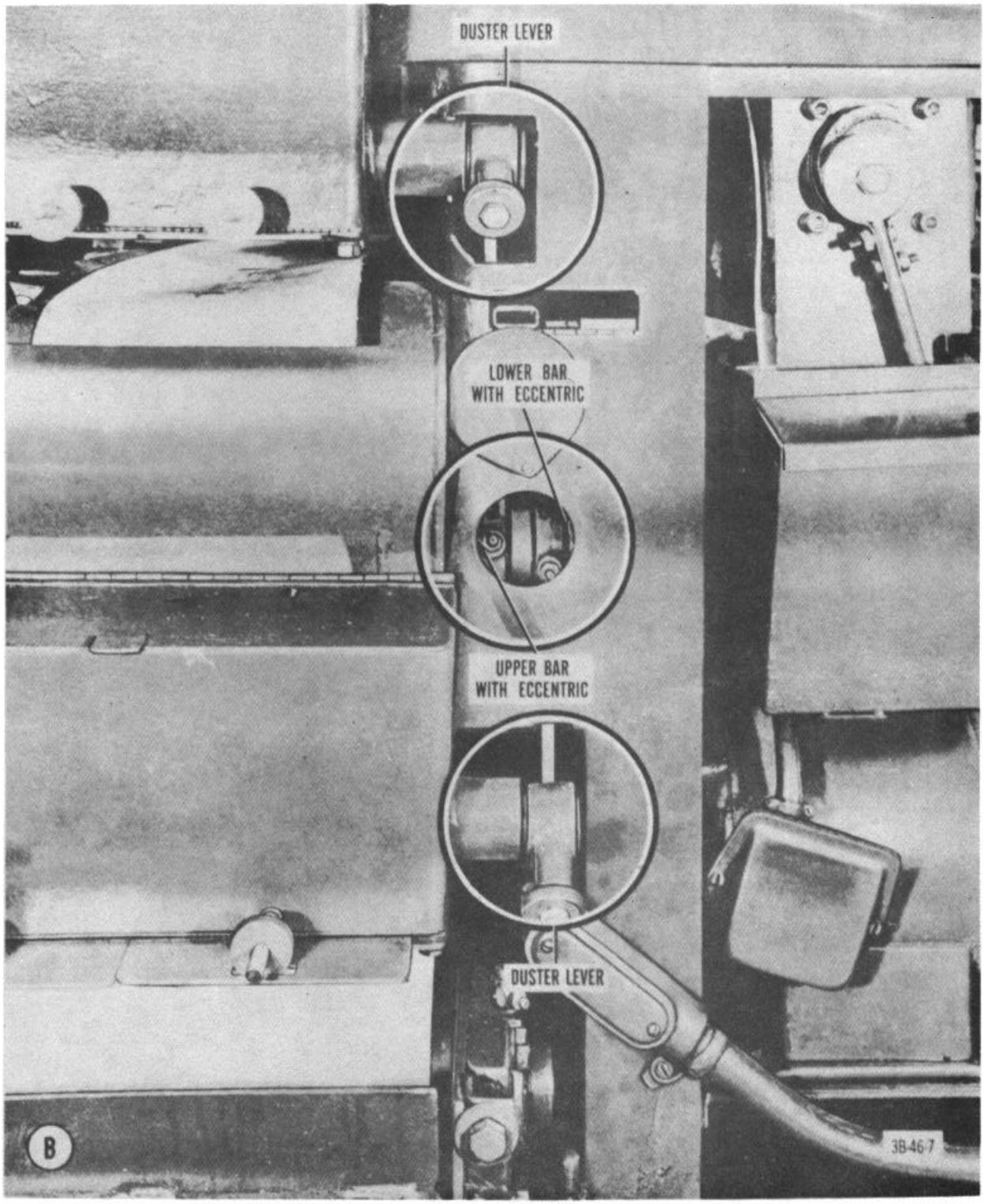


Figure 4--Continued.

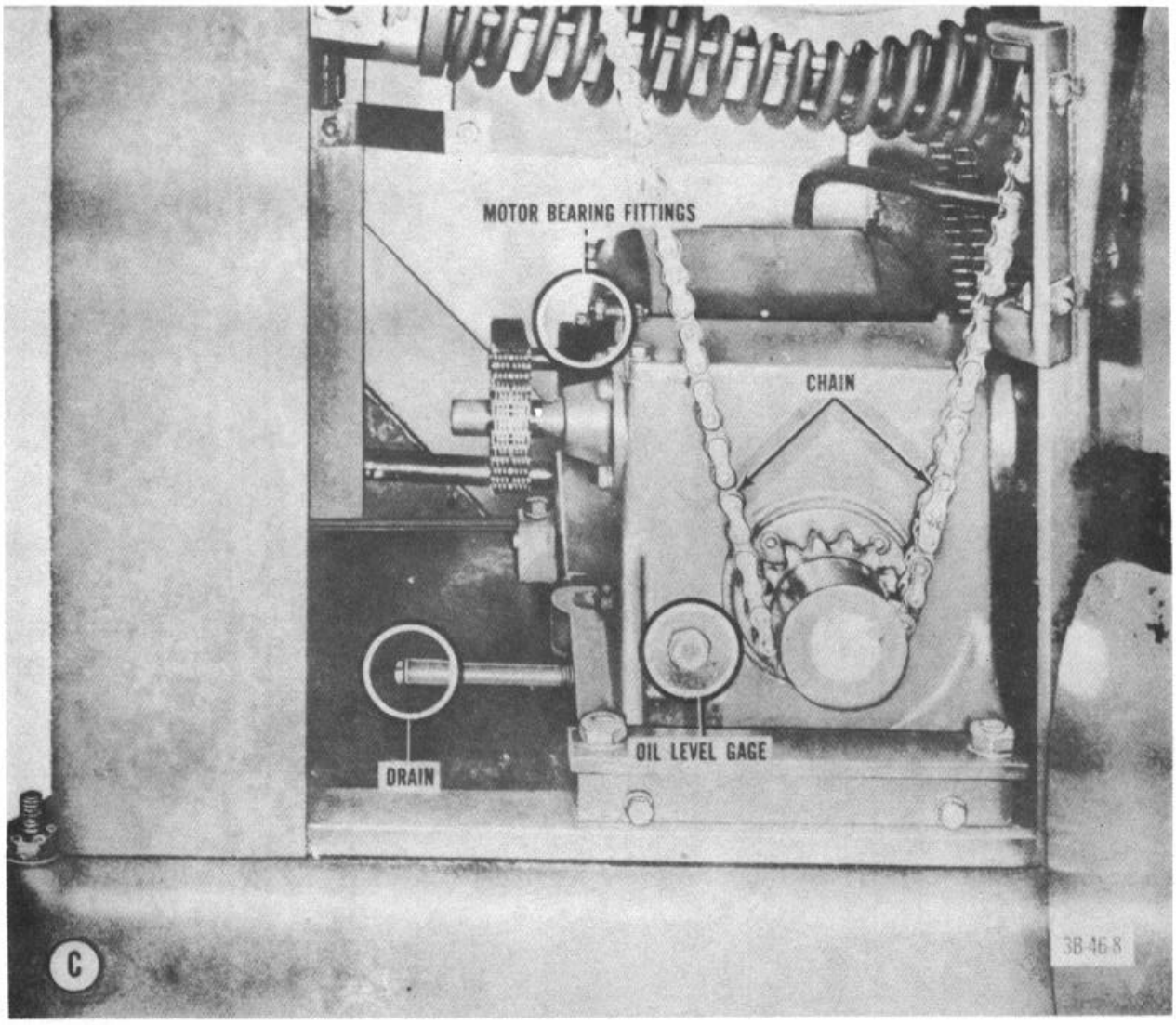


Figure 4--Continued.

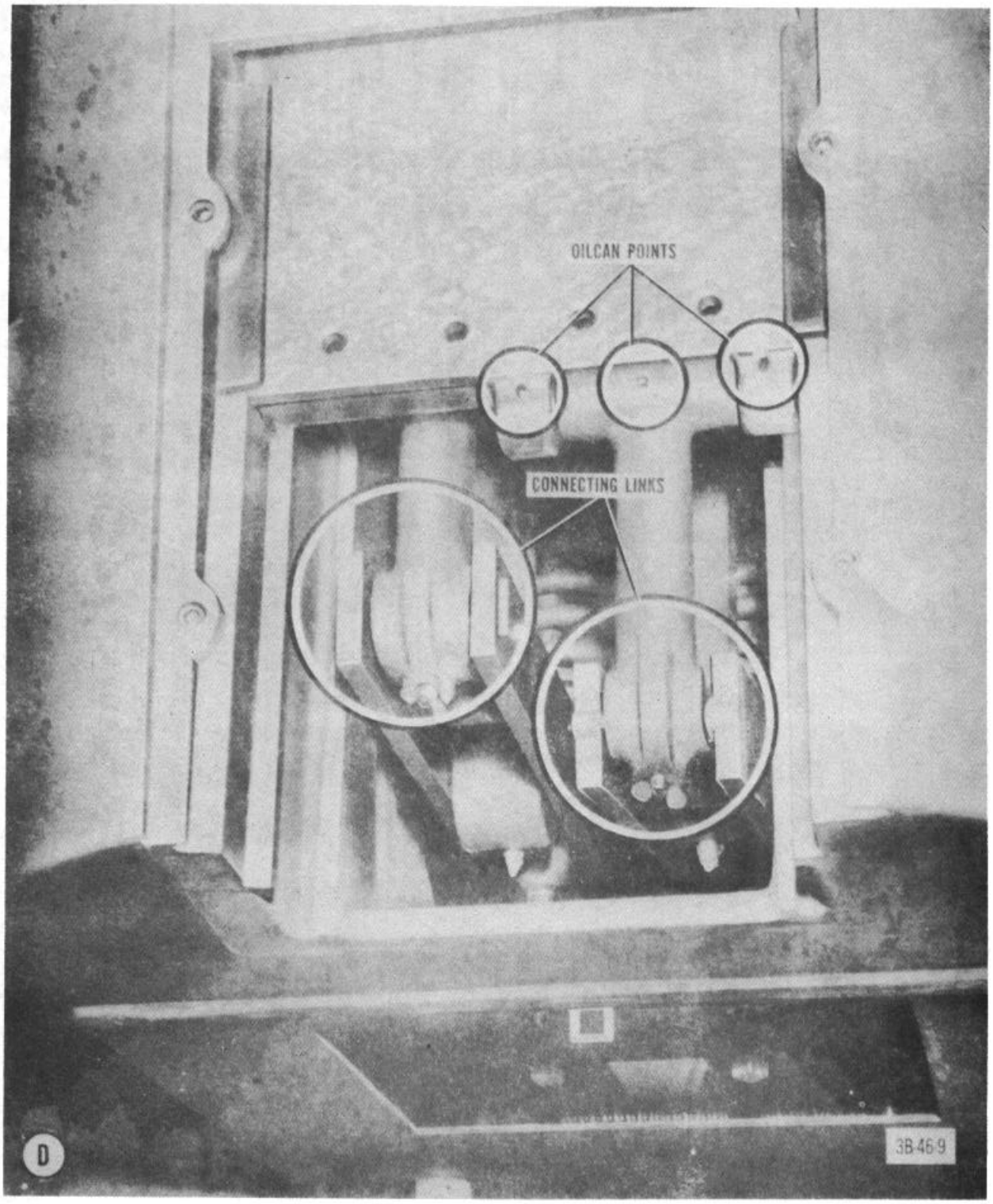


Figure 4--Continued

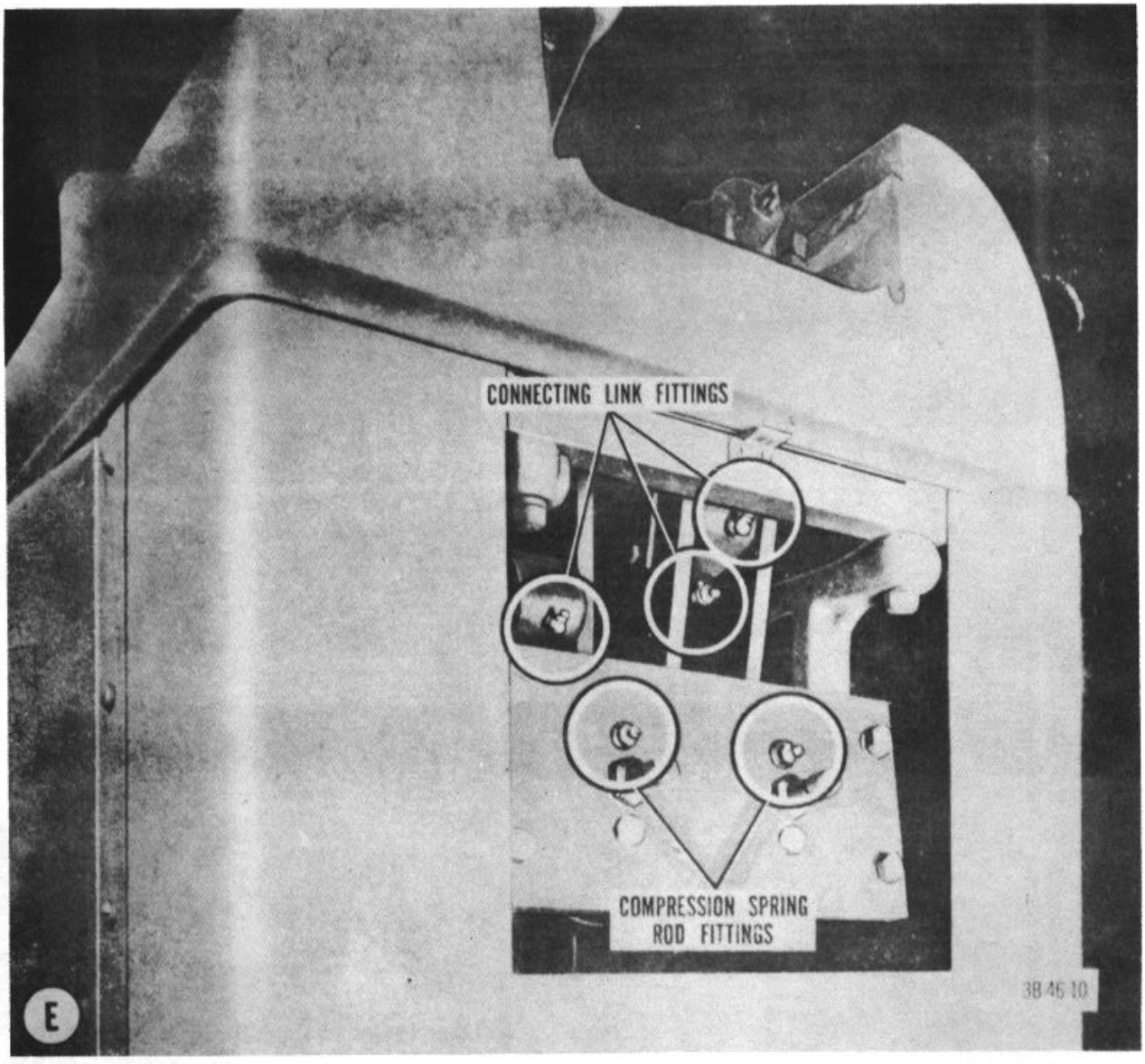


Figure 4--Continued.

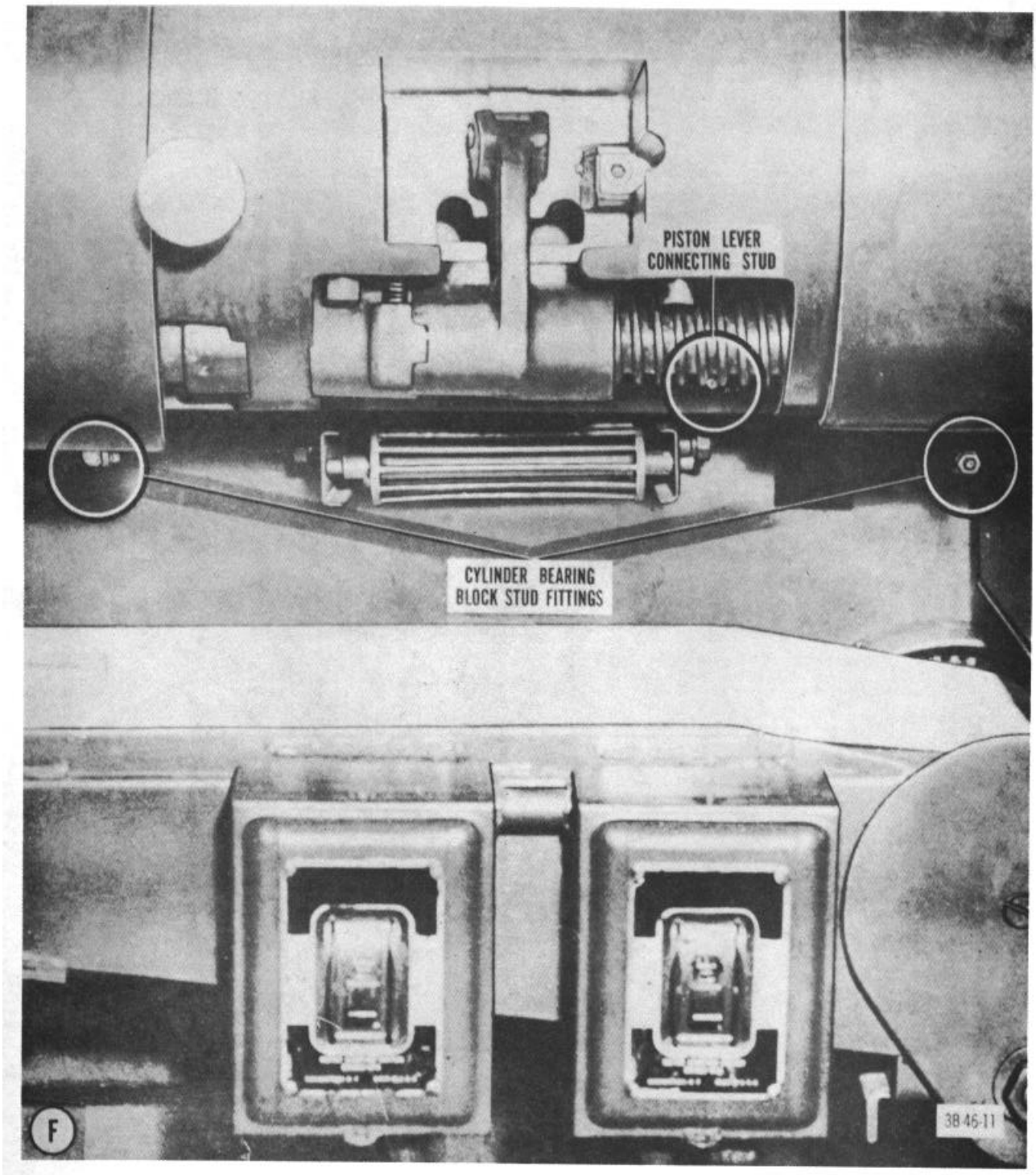


Figure 4--Continued.

(3) LO 10-7360-201-20-3. Lubrication Order 10-7360-201-20-3 (fig. 5) prescribes lubrication for the *molder* on the mixing and makeup outfit trailers. Specific lubrication points for the molder assembly are illustrated on figure 6.

LUBRICATION ORDER **LO 10-7360-201-20-3**

28 FEBRUARY 1961 (Supersedes LO 10-1699A-3, 8 Jan 1953)

BAKERY PLANT, MOBILE
DOUGH MIXING AND MAKEUP OUTFIT
(MOLDER)

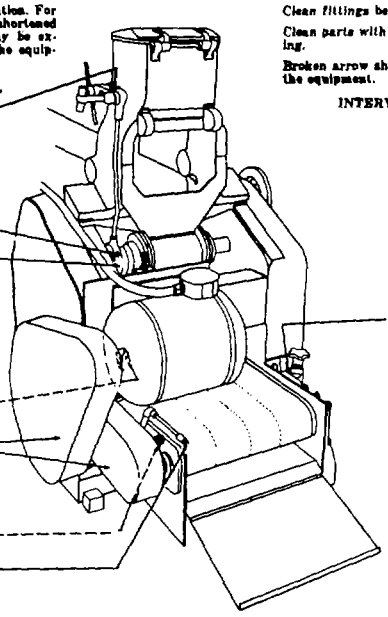
Reference: TM 10-7360-201-20

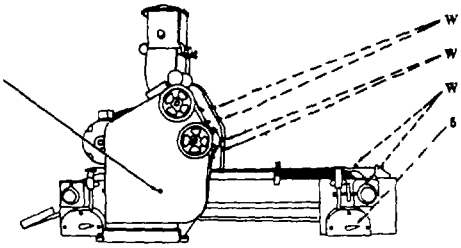
Intervals given are maximums for normal 8-hour operation. For abnormal conditions or activities, intervals should be shortened to compensate. During inactive periods, intervals may be extended commensurate with adequate preservation of the equipment.

Clean fittings before lubricating.

Clean parts with SD (Solvent, drycleaning). Dry before lubricating.

Broken arrow shafts indicate lubrication points on both sides of the equipment.





		LUBRICANT	INTERVAL
fig. 4	Duster Regulating Lever (See Note 4)	PL	W
A, fig. 6	Upper Rear Sheeting Roll Eccentric	GAA	W
A, fig. 6	Eccentric Shaft Idler Sprocket with Bushing	GAA	W
B, fig. 6 C, fig. 6	Motor Bearings (See Note 2)	GAA	5
B, fig. 6	Drive Chains (See Note 1)	OE	W
C, fig. 6	Conveyor Pulley Shaft Bearings	GAA	W
C, fig. 6	Main Drive Shaft Bearing	GAA	W
D, fig. 6	Front Sheeting Roll Idler Sprocket with Bushing	GAA	W

INTERVAL	LUBRICANT		
W	GAA	Main Drive Shaft Bearing	C, fig. 6
W	GAA	Upper Sheeting Roll Shaft Bearings	E, fig. 6
W	GAA	Lower Sheeting Roll Shaft Bearings	E, fig. 6
W	GAA	Conveyor Pulley Shaft Bearings	C, fig. 6
5	GAA	Worm Gear Bearings (See Note 3)	

—KEY—

LUBRICANTS	EXPECTED TEMPERATURES		INTERVALS
	above + 32° F.	below + 32° F.	
OE—LUBRICATING OIL, Internal Combustion Engine	OE-50	At temperatures below + 32° F., operate the mixing and makeup outfit trailer in a heated shelter.	W—Weekly 5—Semiannually or every 500 operating hours, whichever occurs first
GAA—GREASE, Automotive and Artillery	GAA		
PL—LUBRICATING OIL, General Purpose Preservative	PL-Medium		

NOTES:

1. DRIVE CHAINS—5, remove, soak and wash with SD, suspend to drain and dry; soak in OE-50, suspend, drain, and wipe off from outer surfaces.
2. MOTOR BEARINGS—5, grease sparingly with GAA; too much grease will cause bearings to overheat.
3. WORM GEAR BEARINGS—5, remove housings, clean, and repack with GAA.
4. OILCAN POINTS—Use a squirt-type oiler to apply PL.

A copy of this lubrication order will remain with the equipment at all times; instructions contained herein are mandatory and supersede all conflicting orders issued prior to this date.

By Order of the Secretary of the Army:

G. H. DECKER,
General, United States Army,
Chief of Staff.

Official:

R. V. LEE,
Major General, United States Army,
The Adjutant General.

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Figure 5. LO 10-7860-201-20-3.

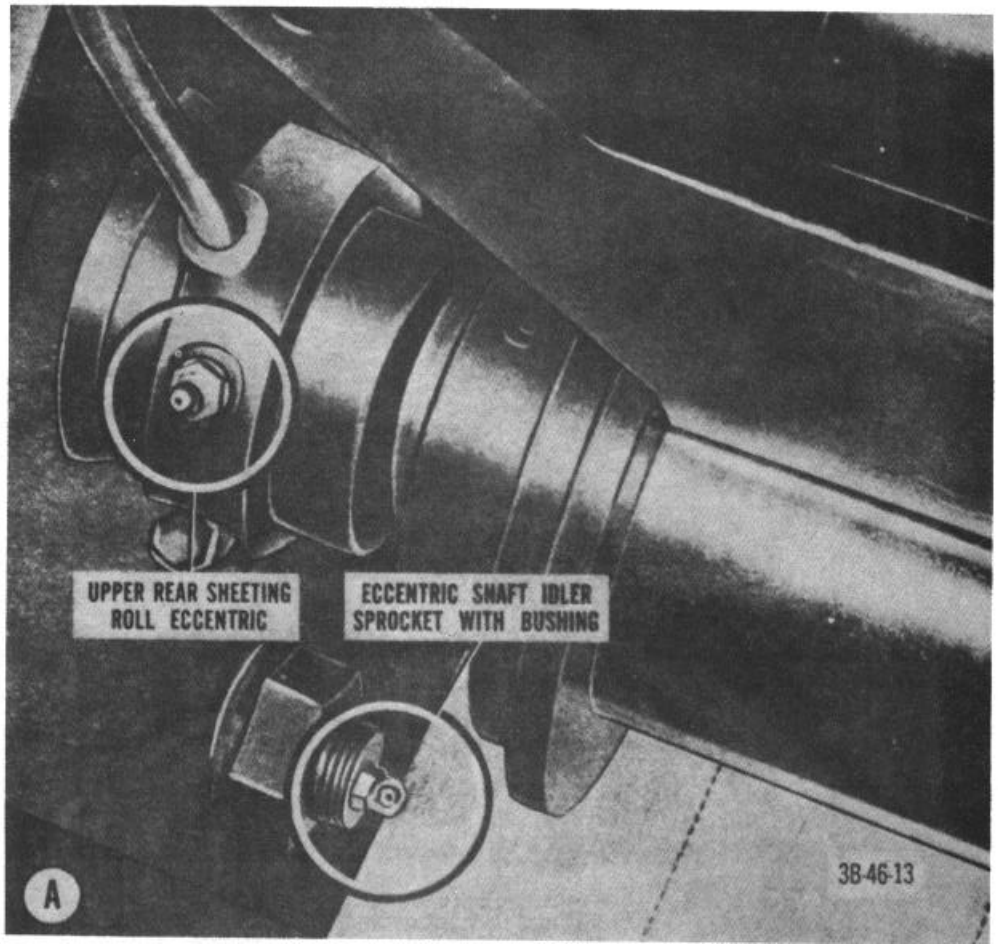


Figure 6. Molder lubrication points.

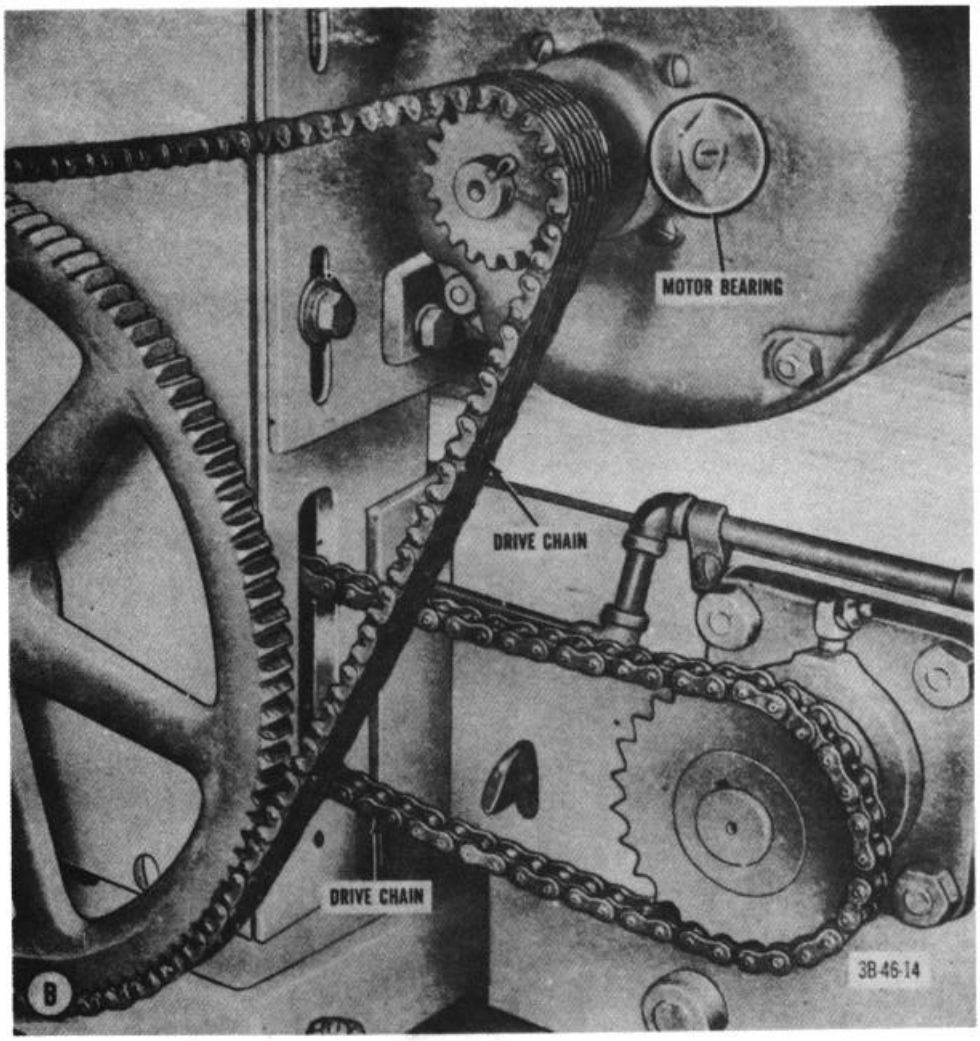


Figure 6--Continued.

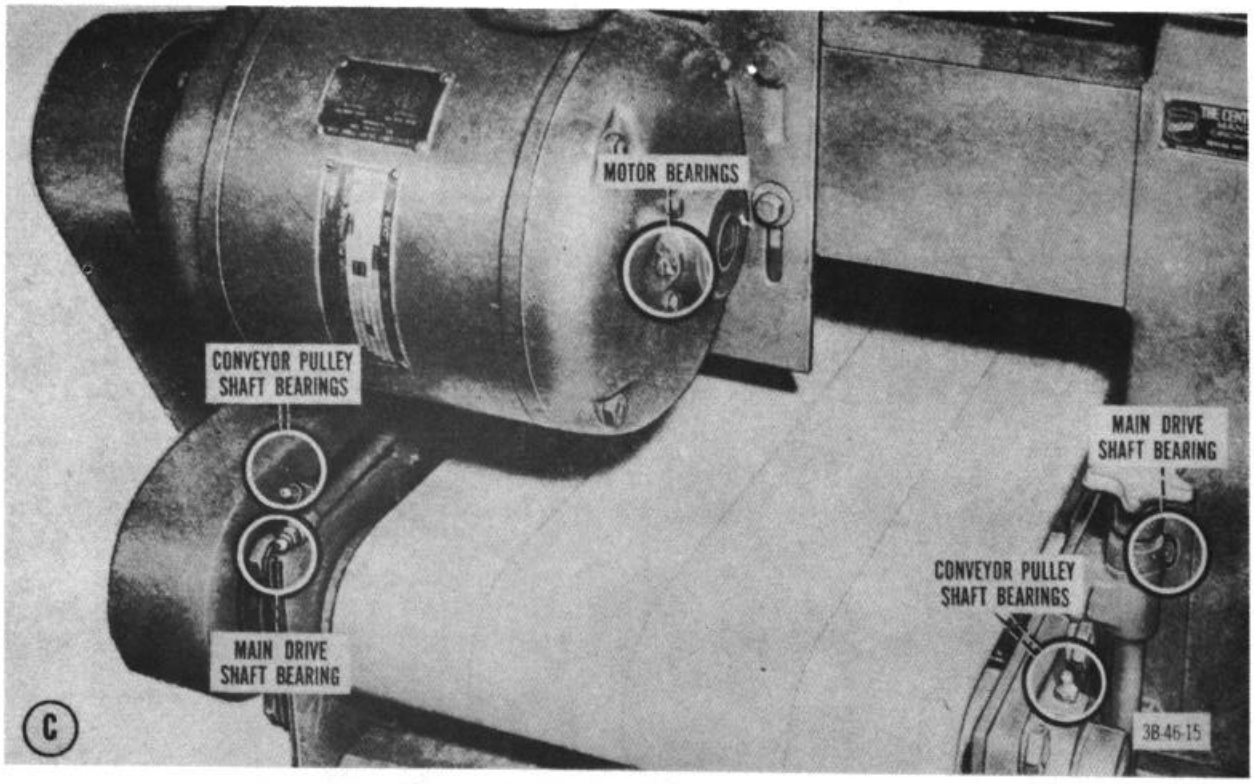


Figure 6--Continued.

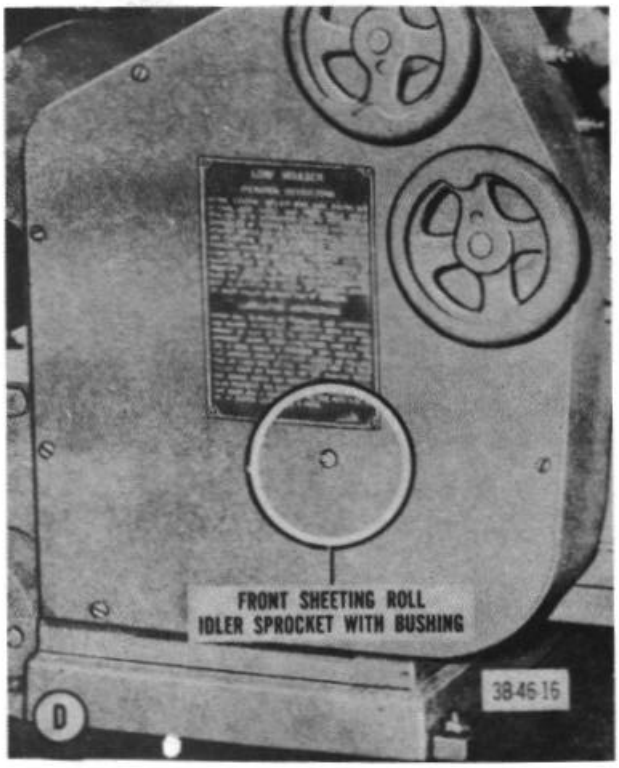


Figure 6--Continued.

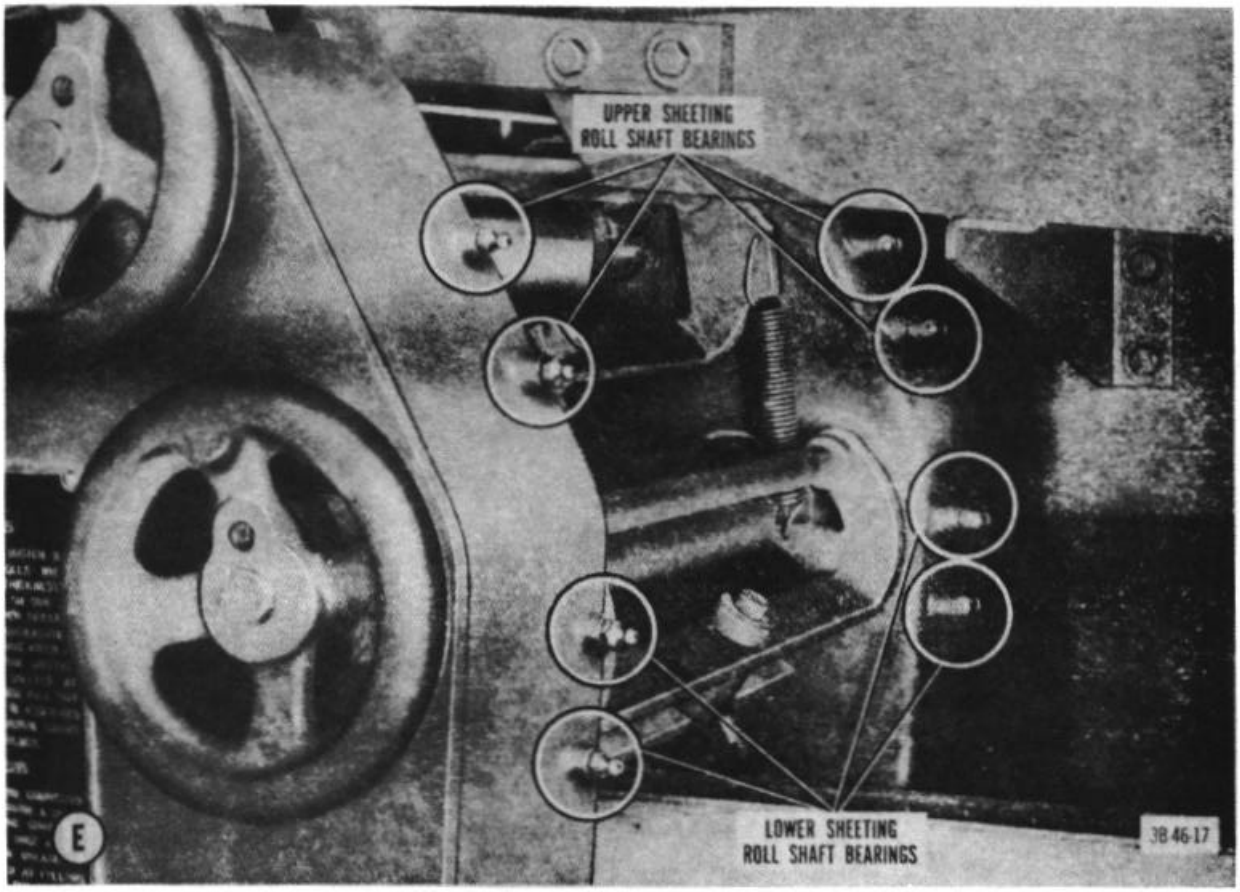


Figure 6--Continued.

LUBRICATION ORDER

LO 10-7360-201-20-4

28 FEBRUARY 1961 (Supersedes LO 10-1699A-4, 8 Jan 1953)

BAKERY PLANT, MOBILE
DOUGH MIXING AND MAKEUP OUTFIT
(MONORAIL AND TRAILER CHASSIS)

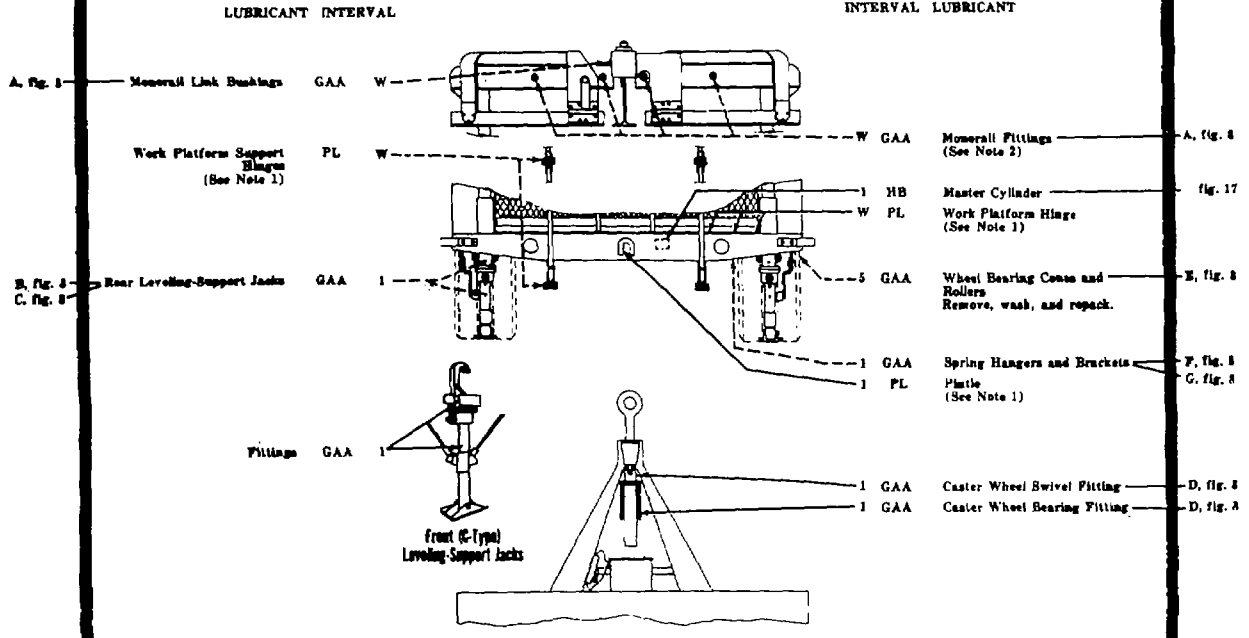
Reference: TM 10-7360-201-20

Intervals given are maximums for normal 8-hour operation. For abnormal conditions or activities, intervals should be shortened to compensate. During inactive periods, intervals may be extended commensurate with adequate preservation of the equipment.

Clean fittings before lubricating.

Clean parts with SD (Solvent, drycleaning). Dry before lubricating.

Broken arrow shafts indicate lubrication points on both sides of the equipment.



—KEY—

LUBRICANTS	EXPECTED TEMPERATURES		INTERVALS
	above + 32° F.	below + 32° F.	
PL—LUBRICATING OIL, General Purpose Preservative	PL-Medium	At temperatures below + 32° F., operate the mixing and makeup outfit trailer in a heated shelter.	W—Weekly 1—Monthly or every 100 operating hours, whichever occurs first 5—Semiannually or every 500 operating hours, whichever occurs first
GAA—GREASE, Automotive and Artillery	GAA		
HB—HYDRAULIC FLUID, Nonpetroleum	HB		

NOTES:

1. OILCAN POINTS—Use a squirt-type oiler to apply PL.
2. MONORAIL FITTINGS—Inspect and grease sparingly. If necessary; be sure grease does not drip into dough carriers.

A copy of this lubrication order will remain with the equipment at all times; instructions contained herein are mandatory and supersede all conflicting orders issued prior to this date.

By Order of the Secretary of the Army:

G. H. DECKER,
General, United States Army,
Chief of Staff.

Official:

R. V. LEE,
Major General, United States Army,
The Adjutant General.

38-46 11

Figure 7. LO 10-7360-201-20-4

(4) *LO 10-7360-201-20-4*. Lubrication Order 10-7360-201-20-4 (fig. 7) prescribes lubrication for the *monorail* and trailer chassis of the mixing and makeup outfit trailer. Specific lubrication points for the monorail and trailer chassis are illustrated on figure 8.

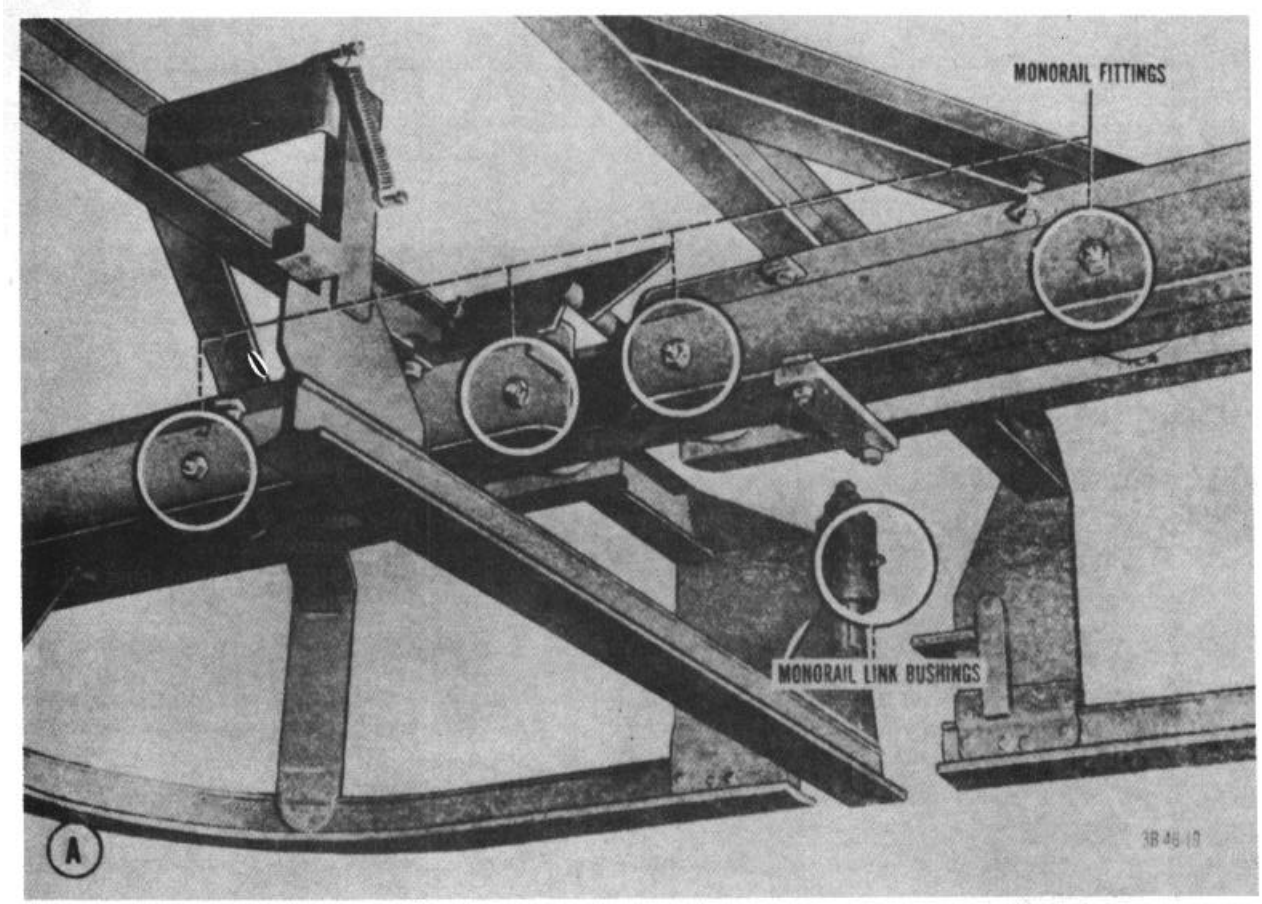


Figure 8. Monorail and trailer chassis lubrication points.

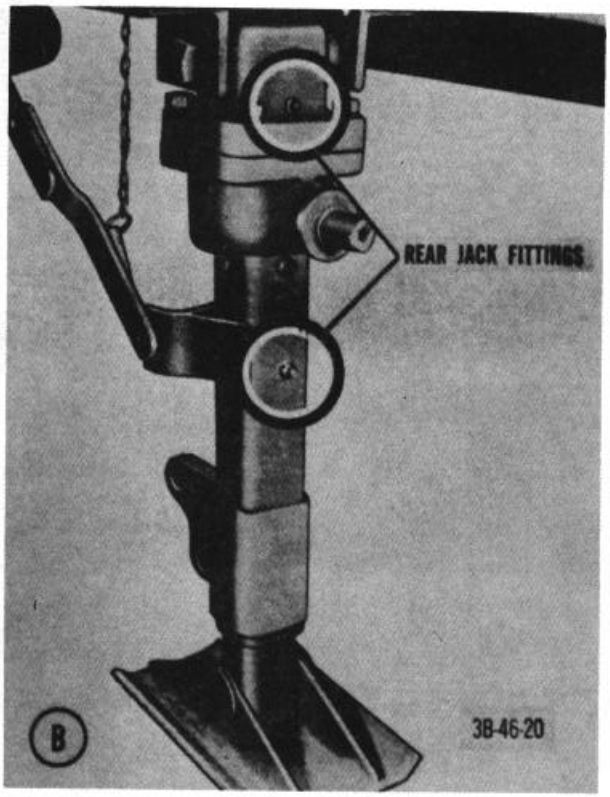


Figure 8--Continued.

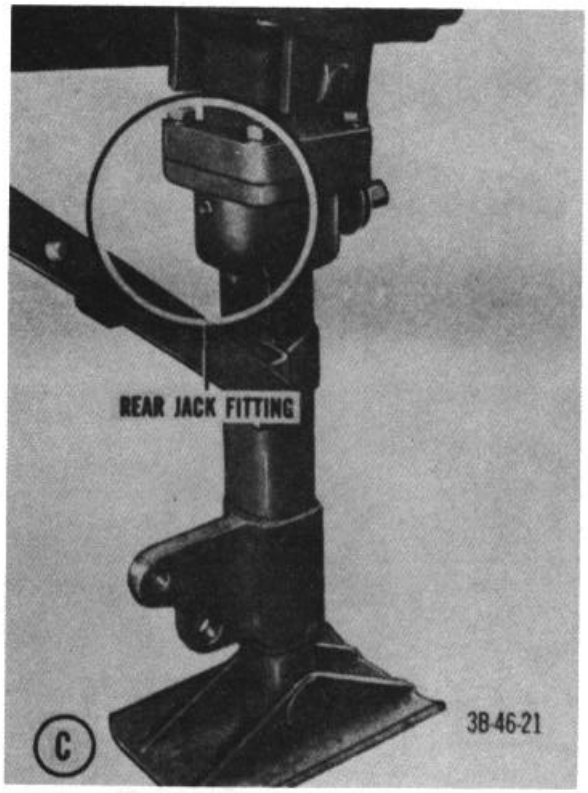


Figure 8--Continued.

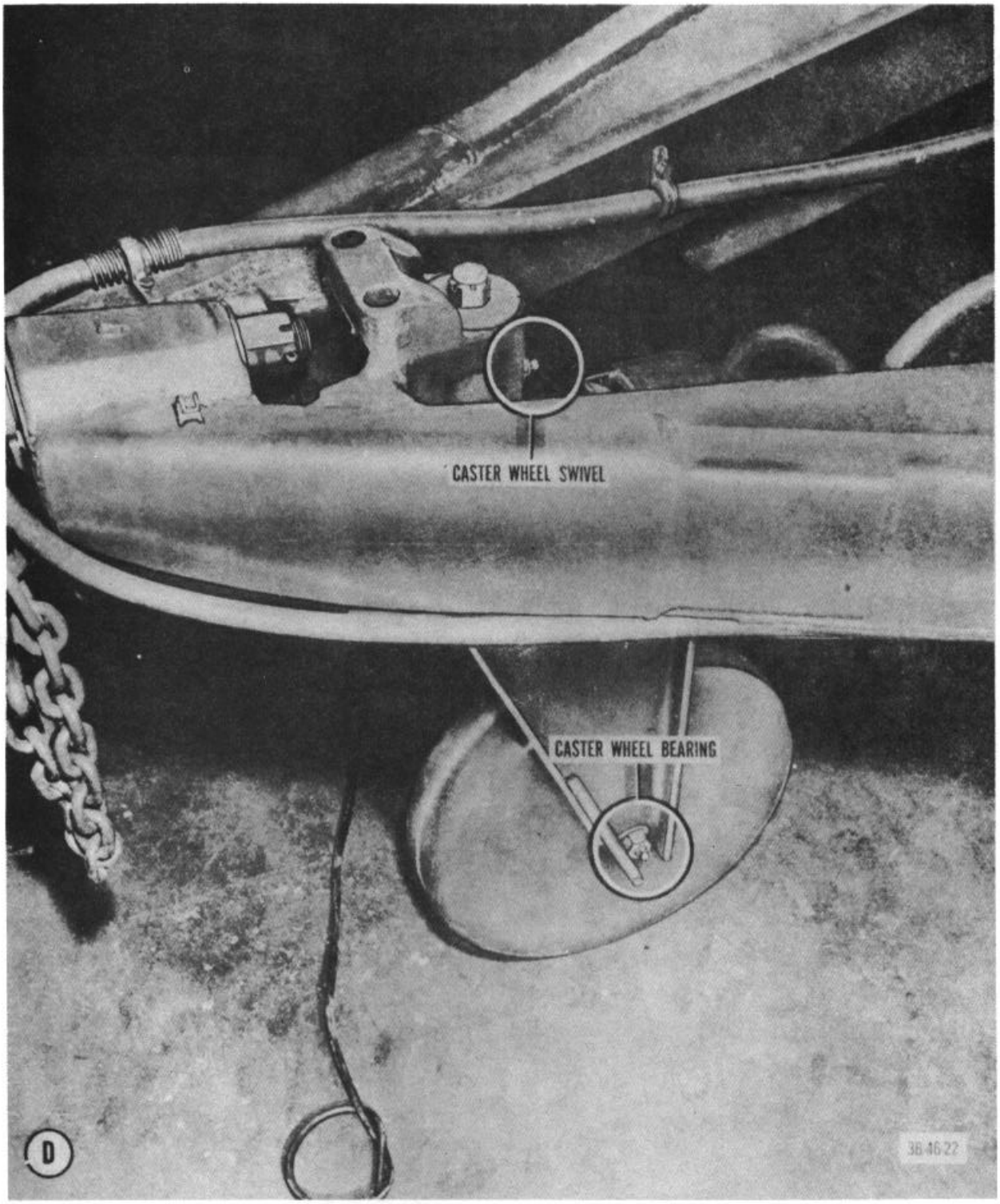


Figure 8--Continued.

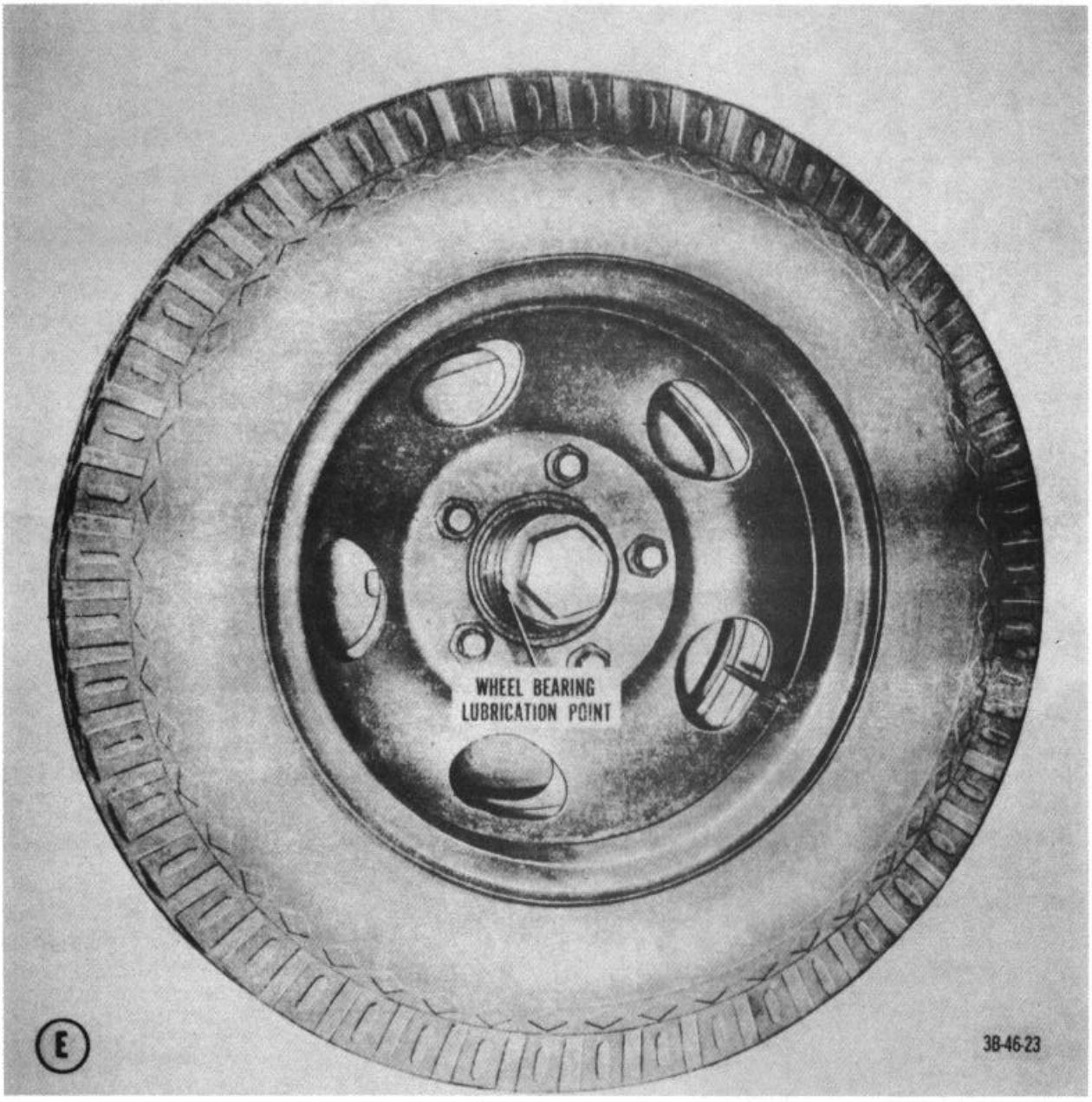


Figure 8--Continued.

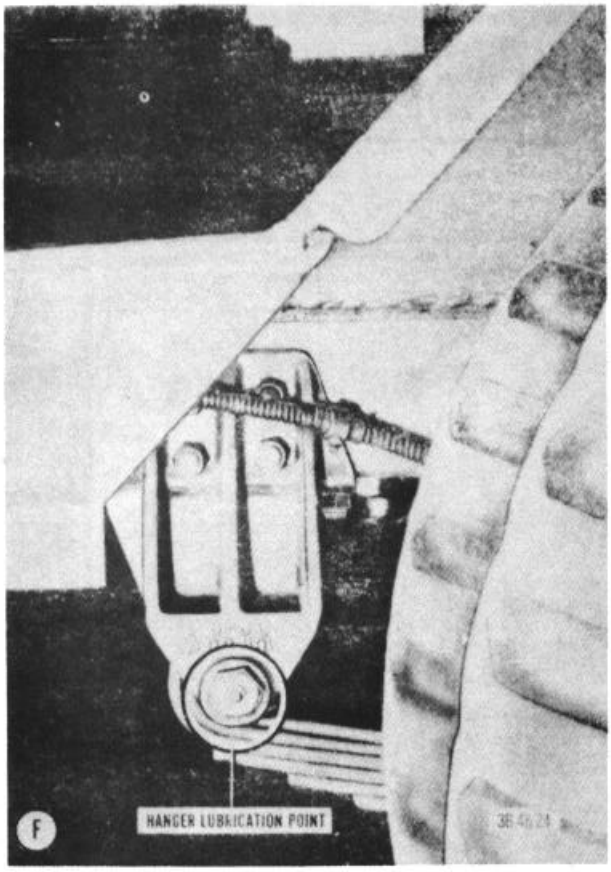


Figure 8-Continued.

(5) *LO 10-7360-201-20-5*. Lubrication Order 10-7360-201-20-5 (fig. 9) prescribes lubrication for the complete *bakery oven trailer*. Specific lubrication points for the oven trailer are illustrated on figure 10.

b. Proofing Cabinet. There is no lubrication necessary for the proofing cabinet, except for occasional oiling of the cabinet door hinges and latches.

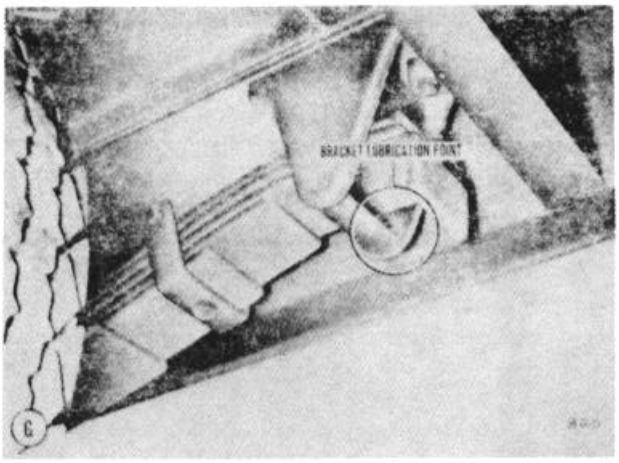


Figure 8-Continued

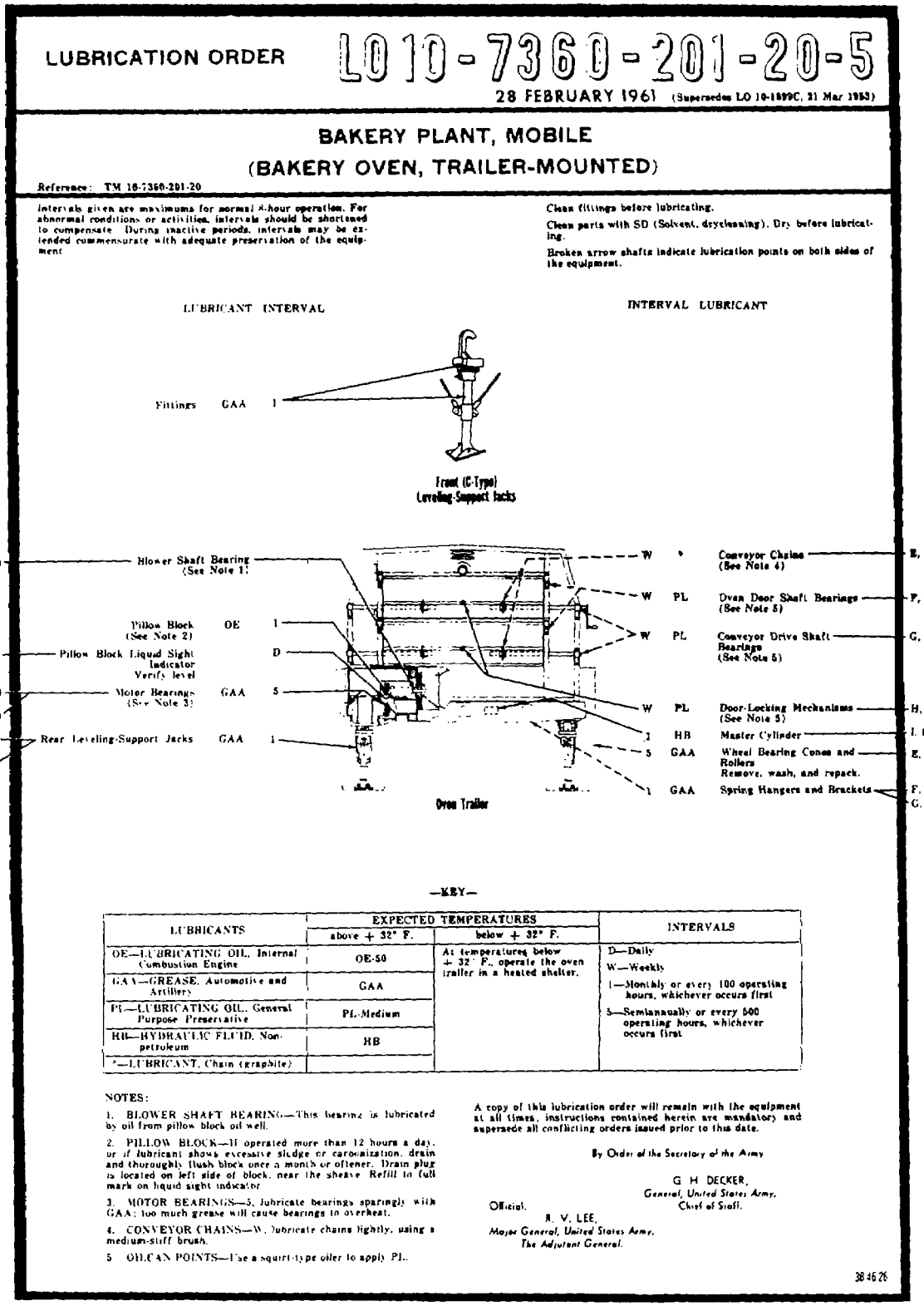
c. Flour Sifter. There is no lubrication necessary for the flour sifter. The bearings are prelubricated and sealed.

12. Lubrication Under Unusual Conditions

a. General. At temperatures below 32° F., operate the mobile bakery plant in a heated shelter and it will not be necessary to change grades of lubricant to conform to outside temperatures.

b. Intervals. Shorten lubrication intervals when operating for prolonged periods of time, in extremely high or low temperatures, in very sandy or dusty areas, or under wet or humid conditions. During inactive periods, extend intervals commensurate with adequate protection of the equipment.

c. Sand and Dust. When located in sandy or dusty areas, inspect lubrication points for fouled lubricants. Clean and relubricate as necessary.



LUBRICATION ORDER

LO 10-7360-201-20-5

28 FEBRUARY 1961 (Supersedes LO 10-1899C, 21 Mar 1958)

BAKERY PLANT, MOBILE

(BAKERY OVEN, TRAILER-MOUNTED)

Reference: TM 10-7360-201-20

Intervals given are maximums for normal 8-hour operation. For abnormal conditions or activities, intervals should be shortened to compensate. During inactive periods, intervals may be extended commensurate with adequate preservation of the equipment.

Clean fittings before lubricating.

Clean parts with SD (Solvent, drycleaning). Dry before lubricating.

Broken arrow shafts indicate lubrication points on both sides of the equipment.

LUBRICANT INTERVAL

INTERVAL LUBRICANT

Fittings GAA 1

Front (C-Type) Leveling-Support Jacks

A, fig. 10 — Blower Shaft Bearing (See Note 1) — 1

Pillow Block (See Note 2) OE 1

B, fig. 10 — Pillow Block Liquid Sight Indicator Verify level D

C, fig. 10 — Motor Bearings (See Note 3) GAA 5

D, fig. 10

B, fig. 8 — Rear Leveling-Support Jacks GAA 1

C, fig. 8

W * Conveyor Chains (See Note 4) — E, fig. 10

W PL Oven Door Shaft Bearings (See Note 5) — F, fig. 10

W PL Conveyor Drive Shaft Bearings (See Note 5) — G, fig. 10

W PL Door-Locking Mechanisms (See Note 5) — H, fig. 10

1 HB Master Cylinder — I, fig. 17

5 GAA Wheel Bearing Cones and Rollers Remove, wash, and repack. — E, fig. 8

1 GAA Spring Hangers and Brackets — F, fig. 8; G, fig. 8

Oven Trailer

—KEY—

LUBRICANTS	EXPECTED TEMPERATURES		INTERVALS
	above + 32° F.	below + 32° F.	
OE—LUBRICATING OIL, Internal Combustion Engine	OE-50	At temperatures below + 32° F., operate the oven trailer in a heated shelter.	D—Daily W—Weekly 1—Monthly or every 100 operating hours, whichever occurs first 5—Semiannually or every 500 operating hours, whichever occurs first
GAA—GREASE, Automotive and Artillery	GAA		
PL—LUBRICATING OIL, General Purpose Preservative	PL-Medium		
HB—HYDRAULIC FLUID, Non-petroleum	HB		
*—LUBRICANT, Chain (graphite)			

NOTES:

1. BLOWER SHAFT BEARING—This bearing is lubricated by oil from pillow block oil well.

2. PILLOW BLOCK—If operated more than 12 hours a day, or if lubricant shows excessive sludge or carbonization, drain and thoroughly flush block once a month or oftener. Drain plug is located on left side of block, near the sheave. Refill to full mark on liquid sight indicator.

3. MOTOR BEARINGS—5. Lubricate bearings sparingly with GAA; too much grease will cause bearings to overheat.

4. CONVEYOR CHAINS—W. Lubricate chains lightly, using a medium-stiff brush.

5. OILCAN POINTS—Use a squirt-type oiler to apply PL.

A copy of this lubrication order will remain with the equipment at all times; instructions contained herein are mandatory and supersede all conflicting orders issued prior to this date.

By Order of the Secretary of the Army

G. H. DECKER,
General, United States Army,
Chief of Staff.

Official:

R. V. LEE,
Major General, United States Army,
The Adjutant General.

38 46 26

Figure 9. LO 10-7360-201-20-5.

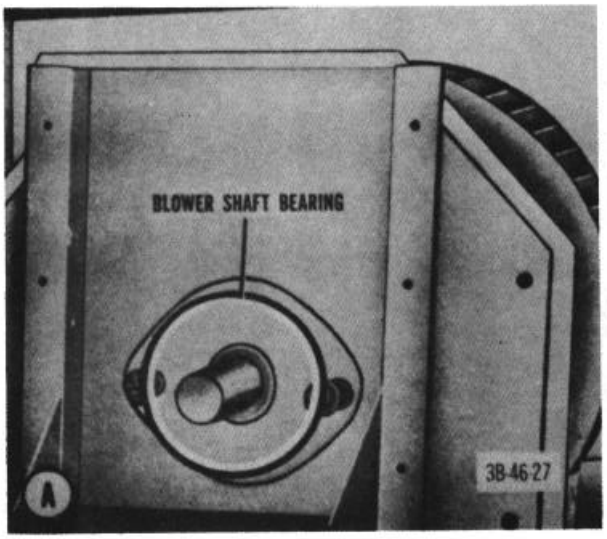
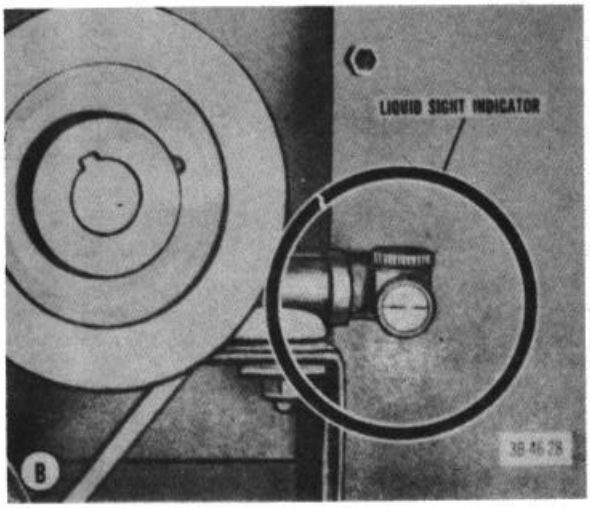


Figure 10. Oven trailer lubrication points.



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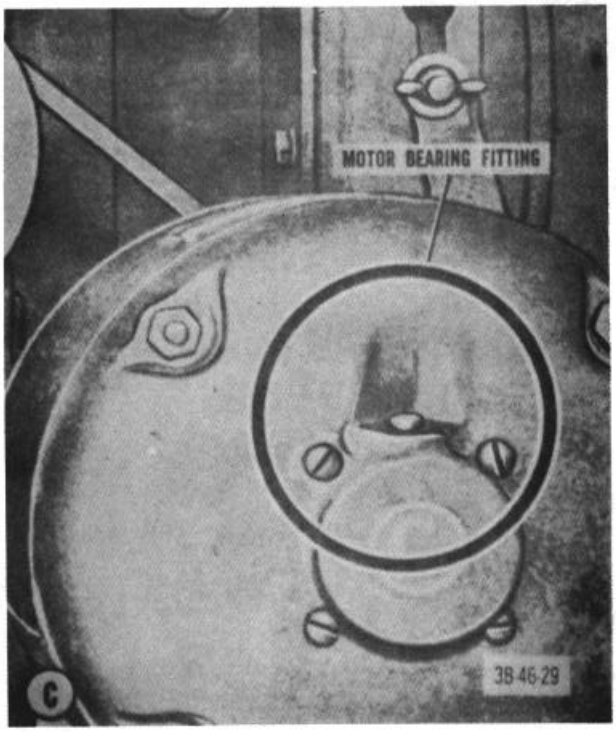

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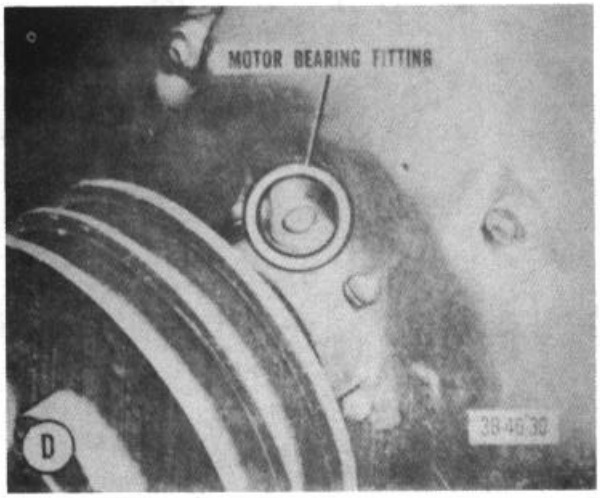

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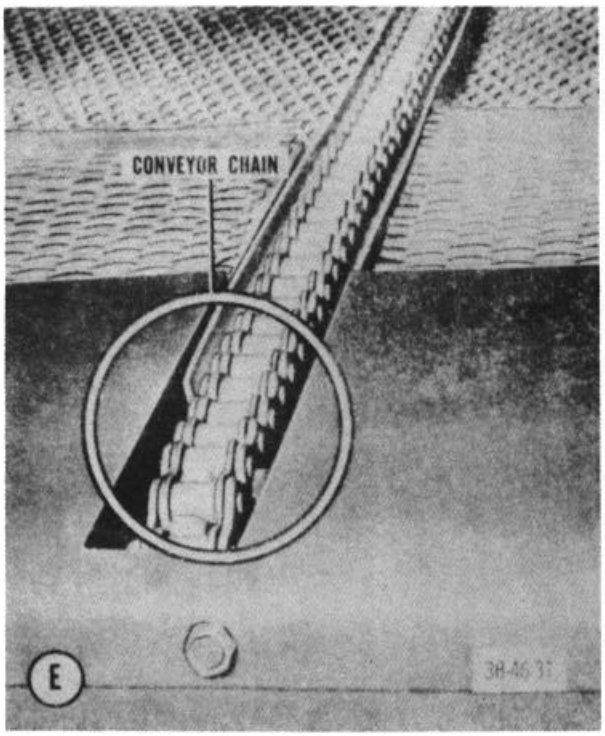

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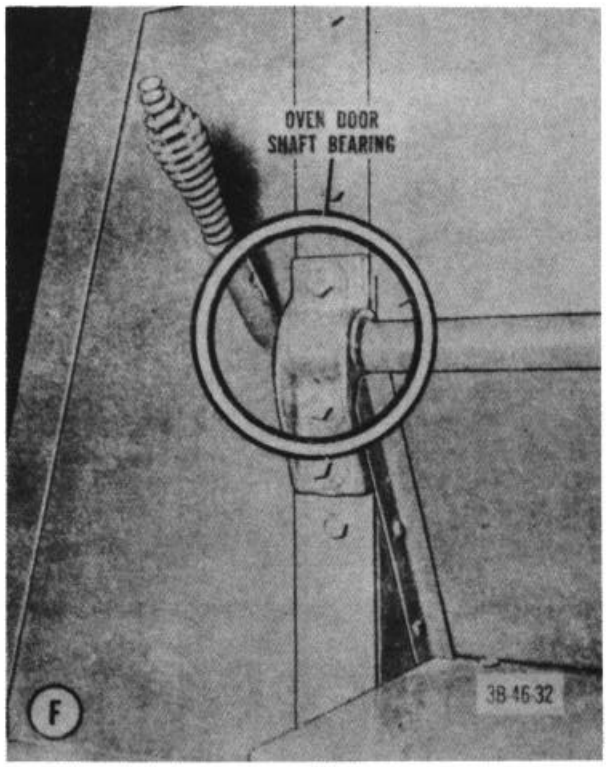


Figure 10-Continued

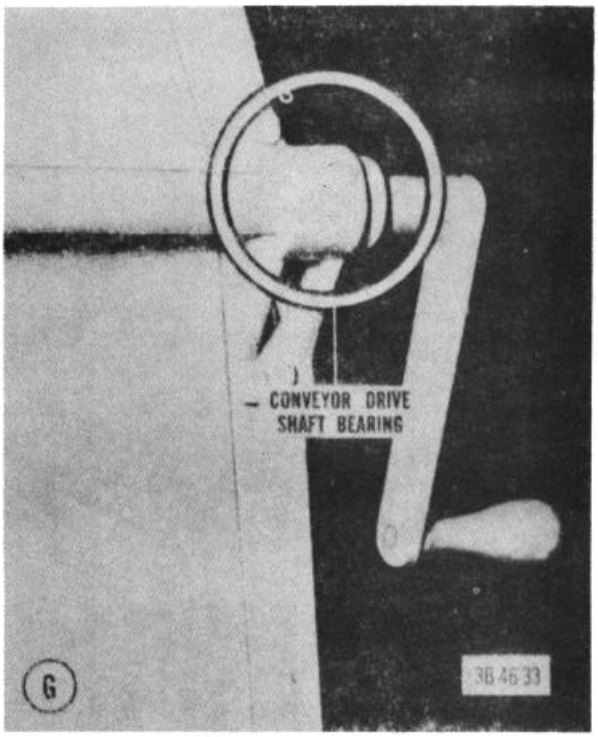


Figure 10-Continued

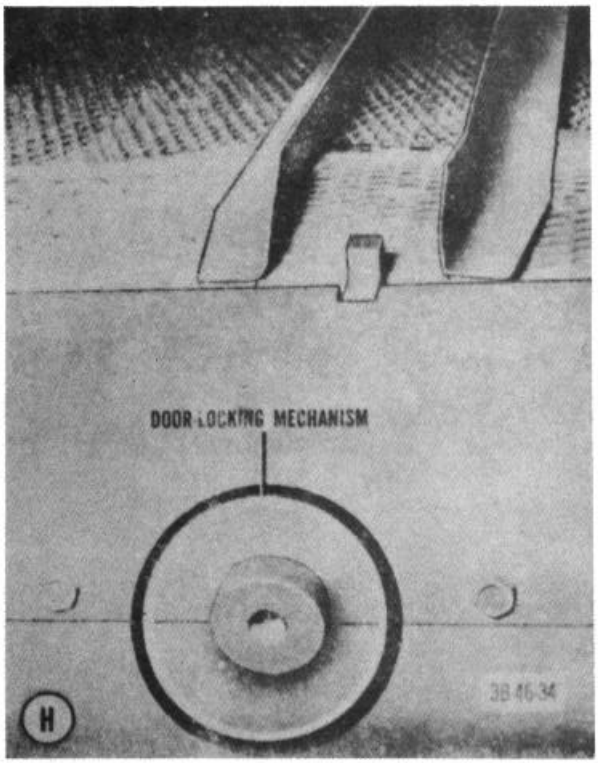


Figure 10-Continued

Section II. PREVENTIVE MAINTENANCE SERVICES

Note. Organization mechanics (second echelon personnel) are responsible for the performance of the regularly scheduled preventive maintenance services that are designed to detect and correct defects before they result in serious damage or breakdown.

13. Services Under Usual Conditions

a. Intervals. Prescribed intervals for performing preventive maintenance services are:

1-Monthly or every 100 operating hours, whichever occurs first

5-Semiannually or every 500 operating hours, whichever occurs first

b. Procedures. Applicable procedures outlined in TM 10-1400 will be used as a guide in performing preventive maintenance services. DA Form 10-103 will be used to record the services performed and to note any defects that must be corrected.

14. Services Under Unusual Conditions

When operating the mobile bakery plant under unusual conditions, shorten intervals for performing preventive maintenance services to insure adequate maintenance of the equipment.

Section III. TROUBLESHOOTING

15. General

This section contains information useful in diagnosing and correcting common troubles, and is confined to those defects that can be determined and corrected by second echelon personnel, within the limits of the organization.

The importance of questioning the operator to obtain as many definite symptoms as possible must not be overlooked.

16. Troubleshooting Chart

In the following tables, each symptom of trouble is followed by a list of probable causes and suggested procedures for locating and remedying the trouble.

Table I. Troubleshooting Chart
(Mixer Assembly and Water-Transfer System)

Trouble	Cause	Remedy
Mixer motor fails to start	Faulty start pushbutton.	Replace pushbutton (par. 87).
	Overloaded circuit.	Decrease load.
	Burned out motor.	Replace motor (par. 44).
	Defective external wiring.	Check and repair wiring (par. 17).
	Damaged magnetic starter.	Repair or replace starter (par. 86).
	Magnetic starter points are pitted.	Clean contact points (par. 86).
Mixer motor is noisy.	Insufficient or incorrect lubricant.	Follow LO 10-7360-201-20-1.
	Excessive end play.	Be sure end caps are tight.
Mixer motor rotates in wrong direct: tion.	Improper power connection.	Reverse any two connections other than ground connection.
Mixer motor operates intermittently.	Dirty or worn contacts in magnetic starter.	Clean or replace contacts (par. 86).
Gear reduction unit is noisy.	Insufficient or improper lubricant.	Follow LO 10-736O-201-20-1.
Loud noise on starting.	Mixer bowl cover not closed.	Latch cover.
	Foreign object in drive chain.	Stop mixer and remove object.
Agitator refuses to start.	Power supply disconnected.	Connect power (TM 10-7360-201-10).
	Foreign objects in bowl.	Remove objects.
	Bowl not in upright position.	Return bowl to upright position.
Thermal overload mechanism shuts off current.	Short circuit in motor wiring.	Replace motor (par. 44).
	Motor is overloaded.	Decrease load.
Bowl dump mechanism does not operate properly.	Dump handwheel is loose.	Secure handwheel.
	Pillow block is damaged.	Have pillow block replaced.
	Bushings are dry.	Follow LO 10-7360-201--20-1.

Table I-Continued

Trouble	Cause	Remedy
Grinding, whining, or scraping sound at start of or during operation.	Defective motor or agitator bearings.	Have bearings replaced.
	Gear reduction unit or agitator is dry.	Follow LO 10-7360-2ul-20-1.
	Drive chain is badly worn.	Replace chain (par. 51).
Agitator action is sluggish.	Agitator is not properly cleaned and lubricated.	Clean and lubricate agitator.
Water-measuring tank leaks.	Defective outlet gate valve.	Replace valve (par. 96).

Table II. Troubleshooting Chart (Divider Assembly)

Trouble	Cause	Remedy
Divider motor fails to start.	Faulty starter.	Replace starter (par. 71).
	Overloaded circuit.	Decrease load.
	Burned out motor.	Replace motor (par. 42).
	Defective external wiring.	Check and repair wiring (par. 17).
Motor is noisy.	Drive chain is loose or badly worn.	Tighten or replace chain (par. 50).
	Defective bearings.	Have bearing replaced.
	Insufficient lubricant.	Follow LO 10-7360-201-20-2.
Gear reduction unit is noisy.	Insufficient lubricant.	Follow LO 10-7360-201-20-2.
Thermal overload mechanism shuts off current.	Shirt circuit in motor wiring.	Replace motor (par. 42).
	Motor is overloaded.	Decrease load.
Divider action is sluggish.	Divider is not properly cleaned and lubricated.	Clean and lubricate.
	Foreign object in hopper.	Remove object.
	Oil pump is not operating properly.	Adjust or repair pump (par. 68).
Conveyor does not operate.	Conveyor drive chain is broken.	Repair or replace chain (par. 50).
	Belt slips on pulley.	Tighten belt (par. 58).
Flour dusters do not operate.	Duster screens are clogged.	Clean screens.
Cylinder piston does not operate properly.	Piston lever spring is broken.	Have spring replaced.
	Burs on surface of piston.	Remove burs.

Table III. Troubleshooting Chart (Molder Assembly)

Trouble	Cause	Remedy
Molder motor fails to start.	Faulty starter.	Replace starter (par. 121).
	Overloaded circuit.	Decrease load.
	Burned out motor.	Replace motor (par. 43).
	Defective external wiring.	Check and repair wiring (par. 17).
Motor is noisy.	Drive chains are loose or badly worn.	Tighten or replace chains (pars. 50 and 51).
	Defective bearings.	Have bearings replaced.
	Insufficient lubricant	Follow LO 10-7360-201-2w.
Drive chains are noisy.	Insufficient lubricant.	Follow LO 10-7360-201-203.
	Broken sprocket teeth.	Have hub with sprocket replaced.
	Damaged chains.	Repair or replace chains (pars. 50 and 51).
Loud noise at starting.	Foreign objects in assembly.	Stop molder and remove objects.
	Drive chains are too loose.	Adjust slack in chains.
Thermal overload mechanism shuts off current.	Short circuit in motor wiring.	Replace motor (par. 43).
	Motor overloaded.	Reduce load.

Table III-Continued

Trouble	Cause	Remedy
Grinding, whining, or scraping sound at start of or during operation.	Improper lubrication.	Follow LO 10-7360-201-20-3.
	Defective bearings.	Have bearings replaced.
	Drive chains badly worn.	Replace chains (pars. 50 and 51).
Action of molder is sluggish.	Molder not properly cleaned and lubricated.	Clean and lubricate.
	Foreign object in molder.	Remove objects.
Conveyor belt does not operate.	Conveyor drive chain is broken.	Repair or replace chain (par. 50).
	Belt slips on drive pulley.	Tighten conveyor belt (par. 99).
Flour duster does not operate.	Duster agitator is loose.	Tighten agitator.
	Duster screen is not clean.	Clean duster screen (par. 113).

Table IV. Troubleshooting Chart (Trailer Chassis)

Trouble	Cause	Remedy
Trailer rides hard.	Springs and hangers are broken or defective.	Replace springs and hangers as necessay (par. 40).
Excessive noise.	Loose spring U-bolt nuts.	Aline axle on spring seats and tighten nuts (par. 40).
	Corner jacks fastenings are loose or broken.	Secure or replace fastenings (par. 41).
Trailer pulls hard.	Excessive bend in axle.	Have axle repaired.
	Wheel bearings are improperly adjusted.	Adjust bearings (par. 30).
	Worn wheel bearings.	Replace bearings (par. 30).
	Emergency brake lever is in ON position.	Release lever.
Emergency brakes are weak.	Battery is weak.	Replace battery (par. 20).
	Wiring is defective.	Repair wiring (par. 17).
Tires are excessively worn and scuffed.	Axle is bent.	Have axle repaired.
	Rim or wheel is bent.	Replace wheel (par. 29).
	Tire pressure is low.	Inflate tires to proper pressure.
Tires are cupped.	Wheel bearings are loose.	Adjust wheel bearings (par. 30).
	Wheels are loose.	Tighten wheel stud nuts (par. 29).
Faulty operation of caster wheel.	Lack of lubrication.	Follow LO 10-7360-201-20-4.
	Wheel is broken.	Replace wheel (par. 34).
	Fork is defective.	Replace fork (par. 34).
	Locking device is broken.	Have locking device replaced.
Taillights and stoplights do not Operate.	Defective wiring.	Repair wiring (par. 17).
	Damaged jumper cable or plug.	Repair cable or plug (par. 17).
	Terminals are dirty, loose, or corroded.	Clean and tighten terminals.
	Lamps are burned out.	Replace lamps (par. 18).
Brakes will not release.	Weak or broken return spring.	Replace spring (par. 23).
Brakes are weak or do not operate.	Intervehicular hose is improperly connected to towing vehicle.	Connect hose properly.
	Low air pressure.	Test for leaks and restrictions in air lines.
	Clogged air cleaner.	Clean or replace air cleaner (par. 26).
	Air in hydraulic system.	Bleed brakes (par. 25).
	Leaks in hydraulic system.	Locate and correct leak.
	Excessive travel of brake chamber push rod.	Check operation; if travel is more than % inch, adjust brakes (par. 23).
Brakes grab.	Moisture in filter.	Drain air cleaner (par. 26).

Table IV-Continued

Trouble	Cause	Remedy
Handbrake does not operate properly.	Handbrake cable is loose.	Secure cable (par. 22).
	Cable is stuck.	Free cable.
	Sector pawl is defective.	Replace pawl.
	Defective brakeshoe return spring.	Replace spring (par. 23).
	Service brakes are out of adjustment.	Adjust brakes (par. 23).

Table V. Troubleshooting Chart (Oven Trailer)

Note. Refer to Table IV for troubleshooting for the trailer chassis.

Trouble	Cause	Remedy
Blower motor fails to start.	Faulty starter.	Repair or replace starter (par. 149).
	Overloaded circuit.	Decrease load.
	Burned out motor.	Replace motor (par. 126).
	Defective external wiring.	Check and repair wiring (par. 17).
Blower motor is noisy.	Insufficient or incorrect lubricant.	Follow LO 10-7360-201-20-5.
Excessive bearing wear.	Motor pulley is' not in same plane as blower shaft pulley.	Aline pulleys (par. 137).
	V-belt tension is too great.	Reduce belt tension (par. 129).
Motor runs too hot. (Check with a thermometer; normal operating temperature should not exceed 190° F.)	Excessive friction in bearings.	Have bearings replaced or reduce belt tensions (par. 129).
Motor operates intermittently.	Dirty or worn contacts in starter.	Clean and repair starter (par. 149).
Blower wheel is noisy.	Insufficient or improper lubricant.	Follow LO 10-7360-201-20-5.
	Blower shaft is sprung.	Replace shaft (par. 139).
	Blower wheel is damaged or off balance.	Replace wheel (par. 139).
	Water or other foreign matter in combustion tunnel.	Siphon or dry out water with a cloth.
Burner does not fire.	Fuel tank is empty.	Fill tank.
	Fuel shutoff valve is closed.	Open valve.
	Vent hole in fuel tank cap is clogged.	Clean out vent hole with solvent.
	Fuel lines are clogged.	Clean out lines (par. 155).
	Burner cleanout rod is at IN position.	Pull rod to OUT position.
	Float valve cutoff knob is at OFF position or valve is improperly set.	Adjust valve (TM 10-7360-201-10).
	Magnetic valve is defective.	Replace valve (par. 158).
Incomplete combustion.	Excessive carbon in burner.	Swing burner to OPEN position with blower operating, remove lighting port cover, and return burner to CLOSED position. Air forced through lighting port will burn out carbon in vaporizing cup.
	Dirt in fuel tank.	Clean strainer at fuel tank outlet with SD or compressed air.
	Dirt in fuel filter.	Clean filter (par. 153).
	Dirt in line to float valve.	Clean strainer at valve inlet with SD or compressed air.
	Burner is not latched against mounting plate.	Lock burner in position.
	Blower is not operating.	Check and repair wiring (par. 17).
	Relief sheets are defective.	Replace relief sheets (par. 133).

Table V-Continued

Trouble	Cause	Remedy
Excessive, dark smoke.	Too much fuel flowing from metering float valve.	Adjust valve (par. 154).
	Soot in burner.	Clean burner (par. 151).
Excessive flow of fuel from overflow hose.	Defective or dirty float valve.	Repair or replace valve (par. 154).
Magnetic valve fails to operate.	Defective valve.	Replace valve (par. 158).
	Defective temperature indicating control.	Have control repaired or replaced.
	Bypass valve is closed.	Open bypass valve.
Burner will not operate at low or pilot flame.	Adjusting setscrew on back of magnetic valve is too tight.	Turn setscrew counterclockwise to increase flow of fuel.
	Fuel passage is clogged.	Clean passage.
Conveyor chains are difficult to operate.	Damaged links in chains.	Repair or replace chains (par. 132).
	Takeup mechanism is not properly adjusted.	Adjust takeup mechanism (par. 132).
	Conveyor sprockets are damaged.	Replace sprockets.
Oven does not heat properly.	Oven doors are open.	Close and latch doors.
	Temperature indicating control is not set properly.	Adjust control setting (TM 10-7360 201-10).
	Pressure relief sheets are leaking.	Check sheets and gaskets and replace as necessary (par. 133).
	Blower is revolving in wrong direction.	Reverse any two of the three motor leads.
	Air ducts are obstructed or damaged.	Remove pressure relief sheets (par. 133) and remove obstructions. If ducts are damaged, have them re paired.
Oven overheats.	Temperature indicating control is damaged or dirty.	Have control repaired or replaced.
	Magnetic valve is defective.	Replace valve (par. 158).

Table VI. Troubleshooting Chart (Proofing Cabinet)

Trouble	Cause	Remedy
Indicator lamp fails to light.	Lamp is burned out.	Replace lamp (par. 161).
	Power is not connected.	Connect power input cable.
	Defective power input cable.	Repair cable (par. 163).
Lack of heat and humidity in cabinet.	Cabinet doors are not latched.	Latch doors tightly.
	Door gaskets are defective.	Replace gaskets (par. 166).
	Too much water in pans.	Pans should be just half full of water.
	Thermostatic switch is defective.	Have thermostatic switch repaired or replaced.

Table VII. Troubleshooting Chart (Sifter)

Trouble	Cause	Remedy
Motor fails to start.	Power source is not connected.	Connect power cable.
	Manual starter is defective.	Replace starter (par. 171).
	Motor is overloaded.	Reduce load.
	Motor is defective.	Replace motor (par. 170).

Table VII-Continued

Trouble	Cause	Remedy
Motor is noisy.	Bearings are worn.	Have bearings replaced.
	Excessive end play.	Be sure end caps are tight,
	Motor sheave is not on same plane as counterbalance sheave.	Have sheaves alined.
Excessive bearing wear.	Too much V-belt tension.	Reduce tension on V-belt.
Motor runs too hot.	Short circuit in motor wiring.	Replace motor (par. 170).
	Excessive friction in bearings.	Check for worn bearings and excessive V-belt tension.
Motor runs intermittently.	Loose wiring connections.	Check and tighten connections.
Excessive vibration in gyratory mechanism.	Sieve box is filled with flour and discharge doors are closed.	Open discharge doors.
Flour leaks from sides of sieve box.	Holddown nuts are loose.	Tighten nuts.
Sifter is very noisy during operation.	Hanger rod shims are loose.	Tighten shims (par. 178).
	Spider or spindle bearings are damaged.	Have bearings replaced,

Section IV. MIXING AND MAKEUP OUTFIT TRAILER

17. Wiring

a. Inspection, Inspect trailer wiring and intervehicular cable for loose connections, bare places, frays, wear, or other damage.

b. Replacement. To replace wiring, use the applicable wiring diagram as a guide. Figure 11 is the chassis wiring diagram for the M1945-53 mixing and makeup outfit trailer. Figure 12 is a wiring diagram for all the equipment of the mobile bakery plant.

18. Service and Blackout Lights

There are two service and blackout lights; the left light has three incandescent lamps and the right has two.

a. Inspection.

(1) Inspect lights to be sure they operate properly.

(2) Check for any damage to parts such as receptacles, cover glasses, and preformed packing.

(3) Inspect the lamps (d below) to be sure they are not defective.

b. Removal.

(1) Remove two capscrews and washers holding light unit on left side of trailer to support bracket on frame. Remove light unit.

(2) Remove six screws holding cover to light housing and lift off cover.

(3) Unscrew four screws holding upper and lower replaces in place.

(4) Remove three screws holding bracket which separates taillight and stoplight receptacles from blackout receptao1.

(5) Disconnect wires at connectors behind light housing and pull wires and receptacles forward from housing.

(6) Repeat procedures to remove light on right side of trailer.

c. Repair.

(1) Replace preformed packing if it is dry rotted.

(2) Replace any defective lamps (d below).

d. Lamp Replacement.

(1) Remove six screws holding cover to light.

(2) Twist and remove any unserviceable lamp.

(3) Install new lamp by inserting and twisting it to lock lamp in receptacle.

e. Installation. Reverse procedures in b (1) through (5) above.

19. Blackout Switch

The blackout switch is located in the front of the trailer, just under the trailer bed and behind the caster assembly.

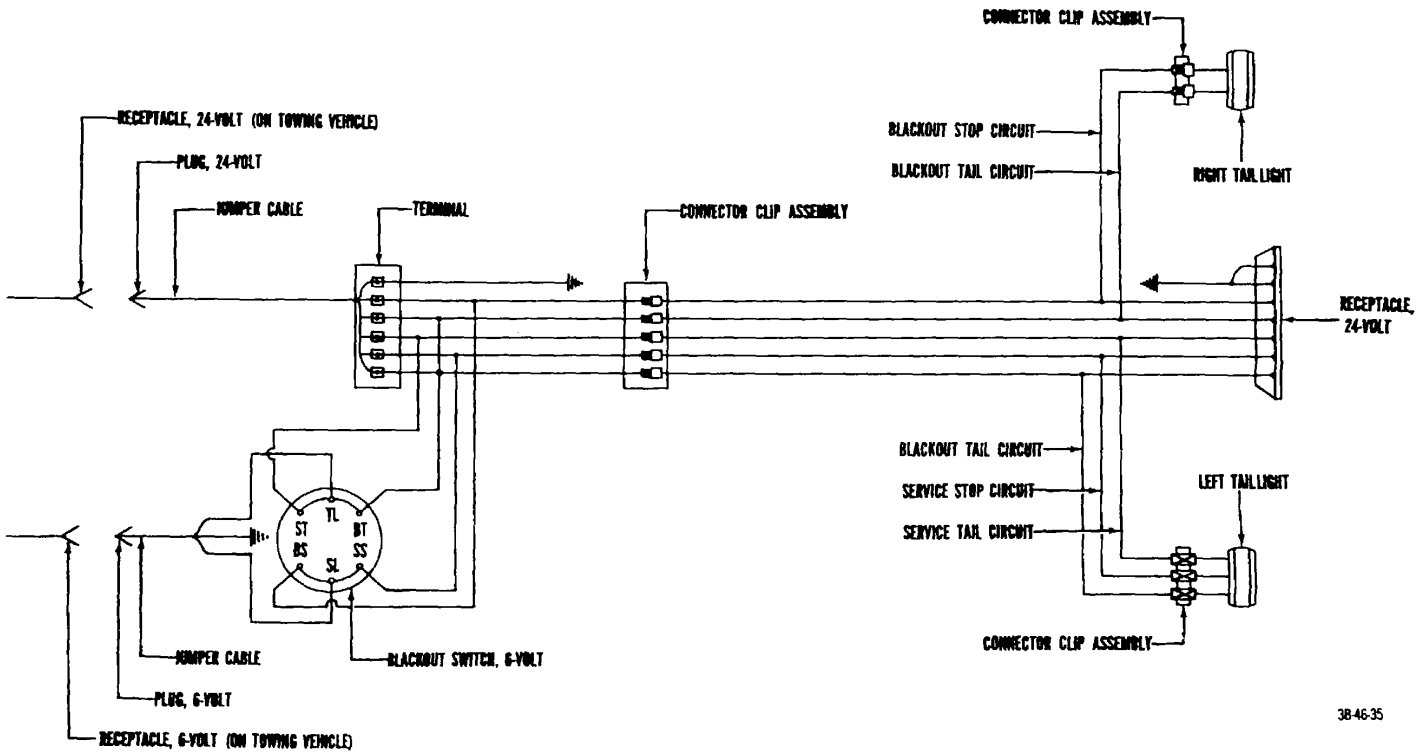


Figure 11. Wiring diagram, mixing and makeup outfit trailer chassis (M-1945-53).

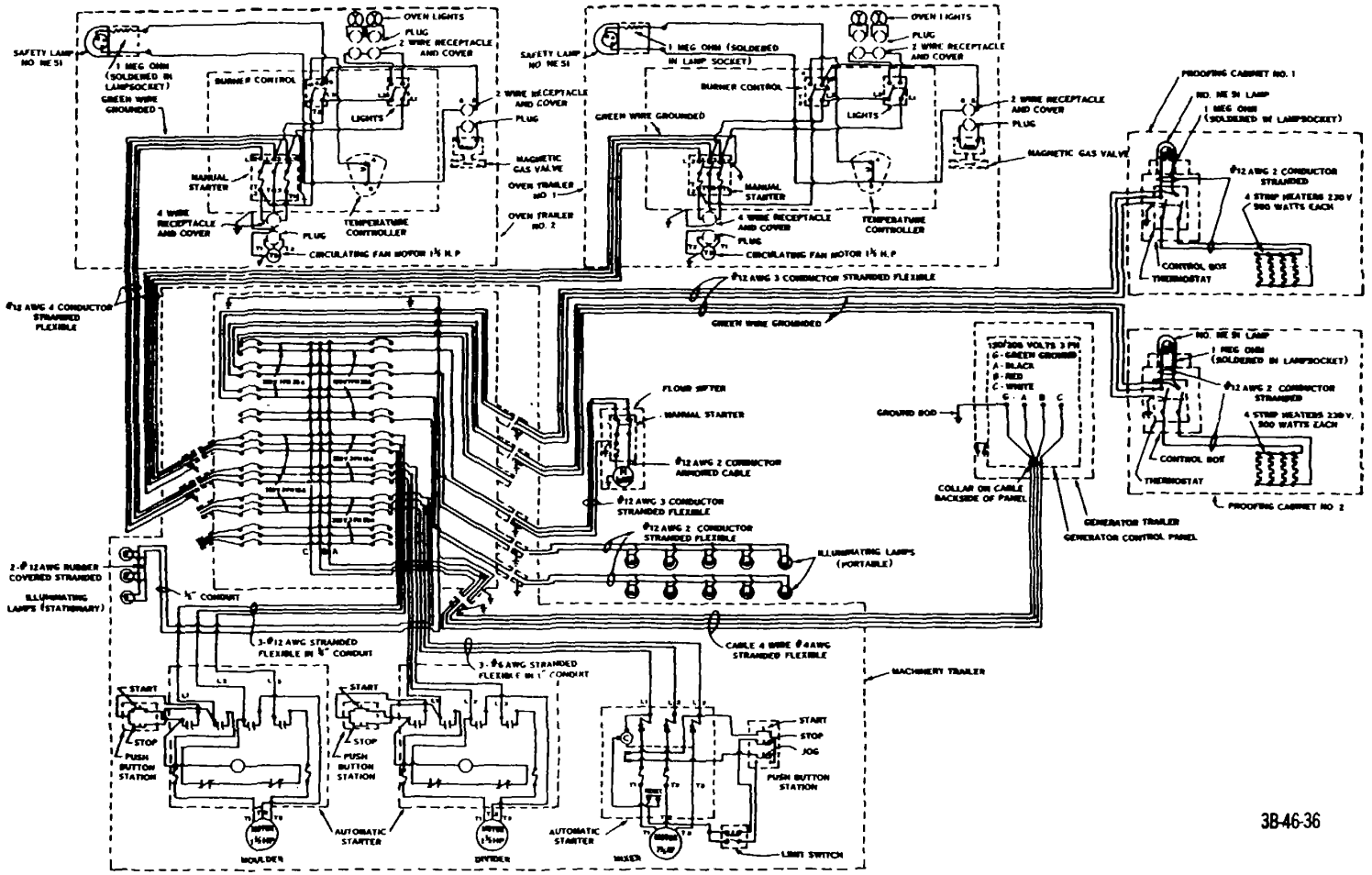


Figure 12. Wiring diagrams, mobile bakery plant.

a. Inspection. Slide small cover aside and use a screwdriver to turn switch on to see if it operates.

b. Removal.

(1) Remove hexagon nut and lockwasher holding switch to bed of trailer.

(2) Remove switchbox cover.

(3) Disconnect wires to switch and remove switch from switchbox.

c. Installation. Reverse procedure in b above.

20. Emergency Brake Battery

The emergency brake battery (older models only) is located on the front end of the trailer, under the trailer bed, in a battery box.

a. Removal.

(1) Remove wingnuts from battery box.

(2) Remove metal cover plate and wooden insulator.

(3) Disconnect wires from battery, mark polarity for identification, and remove the battery.

b. Installation. Reverse procedure in a above.

21. Electric Brake Assembly

The electric brake controller (model M-1945 trailers) is mounted in the driver's compartment. As the brake pedal is depressed, the variable resistance in the controller causes a greater amount of current to flow to the brakes. A maximum amount of current flows when the brake is fully depressed. The armature assembly of the brake revolves with the brakedrum and is kept in constant contact with the electromagnet by means of springs. The more the brake pedal is depressed, the tighter the magnet clings to the armature. This attraction of the magnet to the armature causes the magnet to start turning with the armature. The magnet engages a cam lever, which in turn expands the brake band evenly against the brakedrum to stop the vehicle.

a. Removal and Disassembly.

(1) Remove wheel (par. 29a).

(2) Remove nut (22, fig. 13), terminal (23), lockwasher (24), nut (25), lockwasher (26), brass washer (27), and fiber washer (28).

(3) Remove stud (32) and insulator (30).

(4) Remove two wires (34) from magnet (10) and clamp (29).

(5) Remove screws (36) and remove armature assembly (1).

(6) Remove cotter pin (2), nut (3), and spring clip (4).

(7) Remove band and lining assembly (8).

(8) Remove return spring (35), magnet assembly (10), and bushing (11).

(9) Remove holddown bar (31) and spring (33).

(10) Remove nut (20), lockwasher (19), and bolt (17).

(11) Remove levers (18 and 12) and cams (14 and 13).

(12) Remove backing plate assembly (15).

b. Inspection and Repair.

(1) Inspect springs for fatigue and electric wires for breaks, wear, and fraying.

(2) Inspect armature (1) and magnet (10) to be sure they are not burned out. (See TM 9-8218.) (3) Inspect band and lining assembly (8) for wear.

(4) Check all mechanical parts for breaks, tracks, or wear.

(5) Replace unserviceable items with serviceable ones.

c. Assembly and Installation. Reverse procedures in a above.

d. Adjustment. To adjust grabbing brakes, draw the axle nut tight enough to make the bearings bind slightly when wheel is rotated. Back nut off ¼ to 1/4 turn and lock it in place.

22. Handbrake

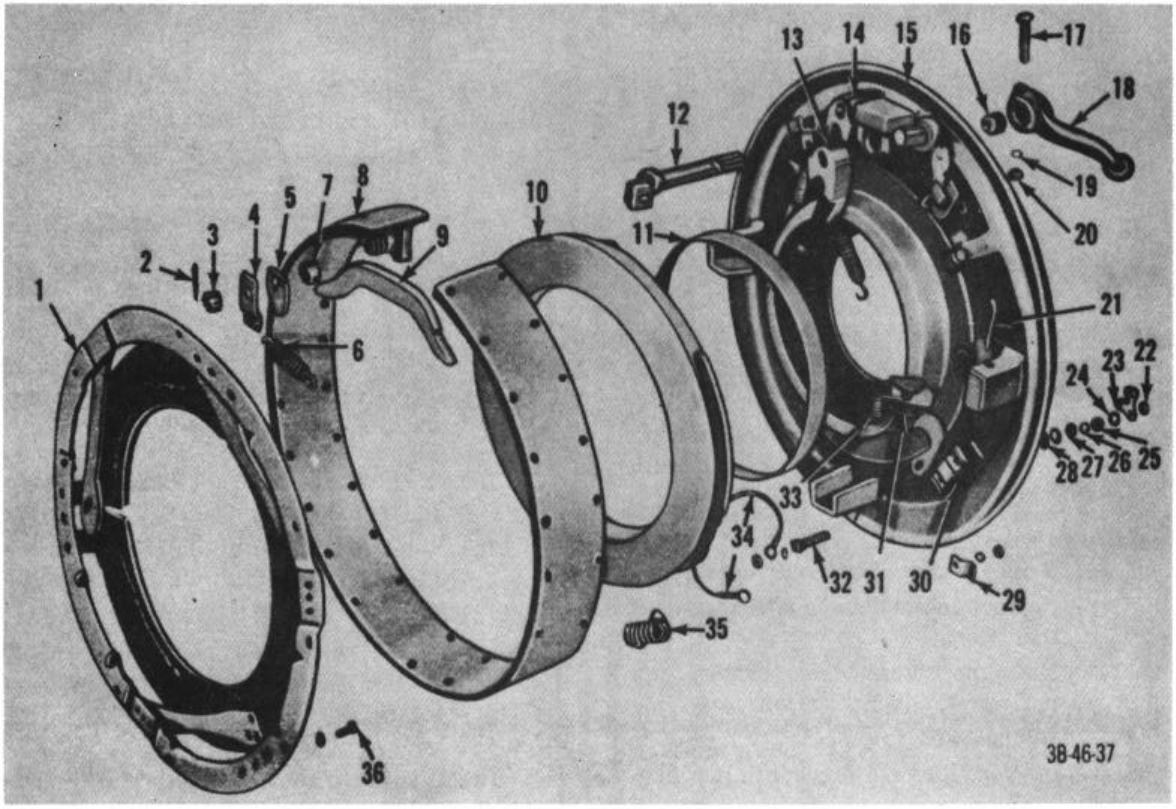
a. Removal and Disassembly.

(1) Remove disk wheel with brakedrum attached (par. 29a).

(2) Disconnect handbrake cable (8, fig. 14) from brakeshoe actuating lever (23, fig. 15).

(3) Remove lever cotter pin (25), nut (26), and lockwasher (24).

(4) Remove actuating lever (23).



1.	Armature assembly	13	Cam, left-hand	25	Nut
2	Pin, cotter	14	Cam, right-hand	26	Lockwasher
3	Nut, slotted	15	Plate assembly, backing	27	Washer, brass
4	Clip, spring	16	Bushing	28	Washer, fiber
5	Washer, retainer	17	Bolt	29	Clamp, wire
6	Spring, band return	18	Lever, parking camshaft	30	Insulator, inside contact
7	Roller	19	Lockwasher	31	Bar, magnetic holddown
8	Band and lining assembly	20	Nut	32	Stud
9	Lever, parking thrust	21	Pin, cotter	33	Spring, magnetic holddown
10	Magnet assembly	22	Nut	34	Wire, magnet
11	Bushing, magnet	23	Terminal	35	Spring, magnetic return
12	Lever, parking camshaft	24	Lockwasher	36	Screw

Figure 13. Electric brakes, exploded view.

(5) Remove lever strut (22).

(6) Remove two cable strap bolts (12, fig. (14), nuts (14), and lockwasher (11), and remove handbrake cable retaining strap (13).

(7) Push handbrake cable (8) through service brake backing plate (9, fig. 15)

(8) Disconnect handbrake cable support spring from chassis.

(9) Disconnect handbrake cable from support brake by removing two bolts, nuts, and lockwashers.

(10) Remove cotter pin and clevis pin to 40 disconnect lever rod from handbrake lever.

(11) Remove handbrake rod, turnbuckle, and handbrake cable from trailer.

(12) Separate rod and handbrake cable 'at turnbuckle.

(13) Remove two bolts, nuts, and lockwashers that fasten handbrake lever to trailer frame and remove handbrake lever.

(14) Remove rivet attaching pawl to handbrake lever and remove pawl.

(15) Repeat these procedures for other handbrake.

b. Inspection and Repair.

(1) Inspect lever and strut for bends, breaks, and other defects.

(2) Inspect handbrake cable for kinks, fraying, and breaks.

(3) Inspect handbrake lever for broken spring and worn pawl or sector.

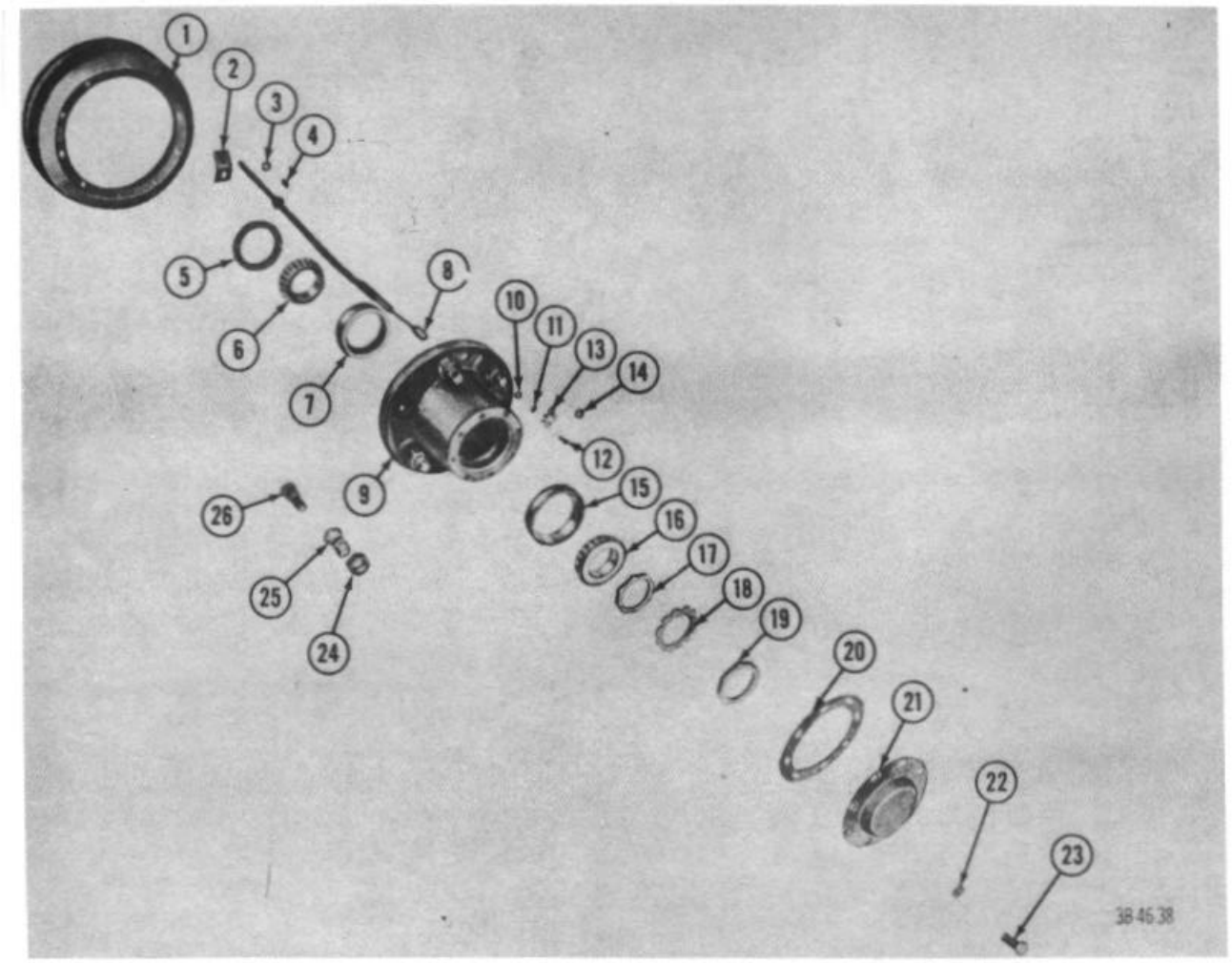
(4) If possible, straighten and repair any parts that are bent or twisted.

(5) Replace unserviceable parts with serviceable items.

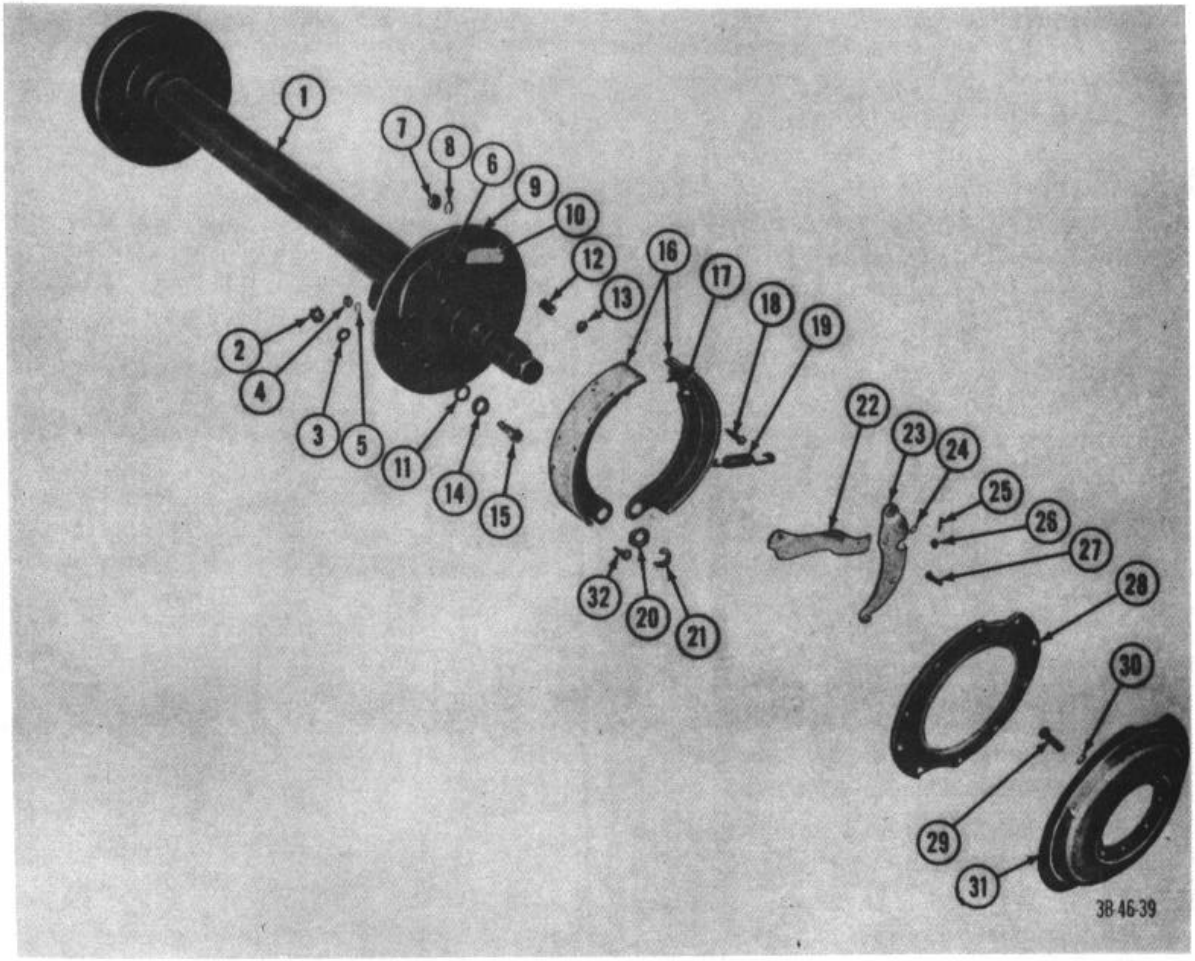
c. Assembly and Installation. Reverse procedures in a above.

23. Service Brakeshoes

The hydraulic wheel cylinders are mounted on the brake backing plates, between the upper ends of the brakeshoes and inside the brake



1 Brakedrum
2 Cover, hole, brakedrurn inspection
3 Nut, capscrew, backing plate
4 Lockwasher, nut, backing plate
5 Sea], grease, wheel hub
6 Cone and rollers, wheel hub, inner
7 Cup, tapered roller bearing, inner and outer
8 Cable, handbrake
9 Hub, wheel
10 Washer, anchor pin
11 Lockwasher, retaining strap
12 Bolt, retaining strap
13 Strap, retaining, handbrake cable-to-backing plate
14 Nut, retaining strap
15 Cup, tapered roller bearing, inner and outer
16 Cone and rollers, wheel hub, outer
17 Nut, bearing adjusting
18 Lockwasher, nut, bearing adjusting
19 Nut, bearing adjusting
20 Gasket, wheel hubcap
21 Hubcap, wheel
22 Lockwasher, hubcap
23 Capscrew, hubcap
24 Nut, bolt, outer wheel
25 Nut, bolt, inner wheel
26 Bolt, wheel Figure



1	Axle, vehicular	17	Brakeshoe with lining, hydraulic service brake
2	Nut, anchor pin	18	Pin, long guide
3	Lockwasher, anchor pin	19	Spring, return
4	Nut, anchor pin	20	Washer, anchor pin
5	Lockwasher, anchor pin	21	C-washer, brakeshoe pin
6	Stud with washer, cam adjusting	22	Strut, actuating lever
7	Nut, anchor pin	23	Lever, actuating
8	Lockwasher, anchor pin	24	Lockwasher, actuating lever
9	Plate, backing, service brake	25	Pin, cotter, actuating lever
10	Shield, wheel cylinder	26	Nut, actuating lever
11	Felt, anchor pin	27	Bolt, wheel hub
12	Spring, pin, brakeshoe guide	28	Deflector, hub grease
13	Washer, pin, brakeshoe guide	29	Bolt, deflector
14	Retainer, anchor pin	30	Nut, deflector bolt
15	Pin, brakeshoe anchor	31	Adapter with ring, brakedrum
16	Lining, brakeshoe	32	Pin, short guide Figure

Figure 15. Backing plate and brake shoes, exploded view.

drums. The cylinders are fitted with opposing pistons. Hydraulic fluid entering the cylinders between the pistons causes the pistons to move outward and push their connecting links against the ends of the brakeshoes to bring them in contact with the brakedrums.

a. Removal.

(1) Remove disk wheel with brakedrum attached (par. 29*a*).

(2) Place clamp on wheel cylinder to prevent pistons and hydraulic fluid from escaping from cylinder.

(3) Remove actuating lever cotter pin (25, fig. 15), nut (26), and lockwasher (24).
(4) Remove actuating lever (23).
(5) Remove actuating lever strut (22).
(6) Remove return spring (19).
(7) Remove nut and lockwasher from long guide pin (18).
(8) Remove nut and lockwasher from short guide pin (32).
(9) Remove short guide pin (32) and washer from brakeshoe with lining (17).
(10) Remove C-washer (21) from anchor pin (15).
(11) Remove anchor pin washer (20) from anchor pin (15).
(12) Remove shoe with lining (17) from backing plate (9).
(13) Remove felt (11) and retainer (14) from anchor pin (15).

b. Inspection and Repair. Inspect brake linings for wear. If linings are worn or oil soaked, install new brakeshoes.

c. Installation. Reverse procedures in a above, bleed brakes (par. 24f), and adjust as necessary (d and e below).

d. Minor Service Brake Adjustment.
(1) Raise trailer until wheels are free from the floor.
(2) Turn cam studs until a drag is felt on wheel.
(3) Back off cam studs until wheel turns free without drag.
(4) Repeat procedures for other wheel.

e. Major Service Brake Adjustment.
(1) Raise trailer until wheels are free from the floor.
(2) Rotate anchor pin to move heel of brakeshoe out to brakedrum.
(3) Rotate wheel until drag is felt.
(4) Release anchor pin until wheel rotates freely.
(5) Adjust toe of brakeshoe (minor service brake adjustment).
(6) Repeat procedures for all service brakeshoes.

24. Wheel Cylinder and Linkage

a. Removal.
(1) Remove disk wheel with brakedrum attached (par. 29a,).
(2) Install wheel cylinder clamp.
(3) Remove brakeshoe return spring (19, fig. 15).
(4) Disconnect brake line at wheel cylinder housing.
(5) Remove two capscrews and lockwashers that fasten wheel cylinder to backing plate and remove cylinder and linkage.

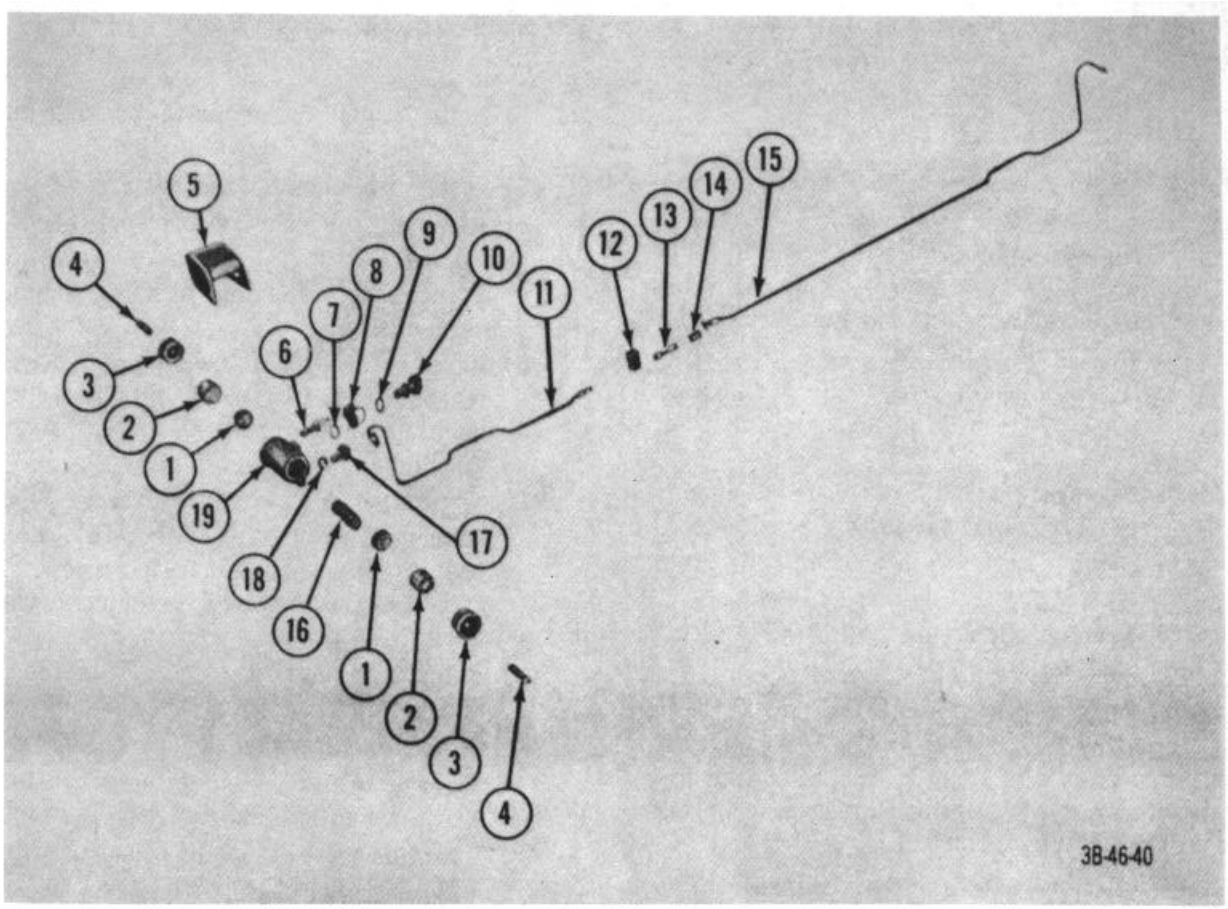
b. Disassembly.
(1) Remove two links (4, fig. 16), two boots (3), two pistons (2), and two cups (1) from wheel cylinder housing.
(2) Remove one spring (16) and one dust shield (5) from housing.

c. Inspection and Repair.
(1) Inspect wheel cylinder housing for scoring, dents, or abrasions.
(2) Examine pistons, springs, boots, cups, and dust shield for defects and replace unserviceable items with serviceable ones.

d. Assembly. Reverse procedures in b above.

e. Installation. Reverse procedures in a above.

f. Bleeding Brakes.
(1) Provide an air source for the air hose.
(2) Remove plate in trailer floor and remove filler plug of master cylinder.
(3) Connect a hose between bleeder screw of wheel cylinder and a container holding a small amount of HB (Hydraulic Fluid, nonpetroleum).
(4) Make certain master cylinder is filled with HB.
(5) Apply air pressure and open bleeder screw. Close bleeder screw and release air pressure.
(6) Repeat instructions in (4) and (5) above until bubbles cease to appear in container. Disconnect bleeder hose, install master cylinder filler plug, and install floor plate.



1	Cup, piston	11	Line with fittings, right wheel cylinder
2	Piston	12	Tee, flexible line, master cylinder
3	Boot	13	Line with fittings, service brake cylinder-to-tee
4	Link	14	Union, hydraulic line
5	Shield	15	Line with fittings, left wheel cylinder
6	Valve, bleeder	16	Spring, piston return
7	Gasket, inlet fitting	17	Capscrew
8	Fitting, inlet	18	Lockwasher
9	Gasket, bolt, inlet fitting	19	Housing, wheel cylinder
10	Bolt, inlet fitting		

Figure 16. Wheel cylinder and linkage, exploded view.

25. Master Cylinder

When compressed air is admitted into the brake air chamber, it actuates a diaphragm and push rod. This push rod enters the hydraulic master cylinder where its movement is converted into the hydraulic pressure that actuates the wheel cylinders. The reservoir of the master cylinder is fitted with a device that permits it to breathe without admitting water when the vehicle is submerged. The device consists of a gooseneck tube to which a length of hose is attached. A door is located on the 44 trailer floor, near the divider base, to permit servicing of the master cylinder.

a. Removal.

(1) Disconnect hose (26, fig. 17).

(2) Remove hose clamp (5) and hose (7).

(3) Remove three nuts and lockwashers that fasten master cylinder to mounting bracket (19).

(4) Separate master cylinder from bracket (19) and air chamber.

b. Disassembly.

(1) Remove vent tube (3).

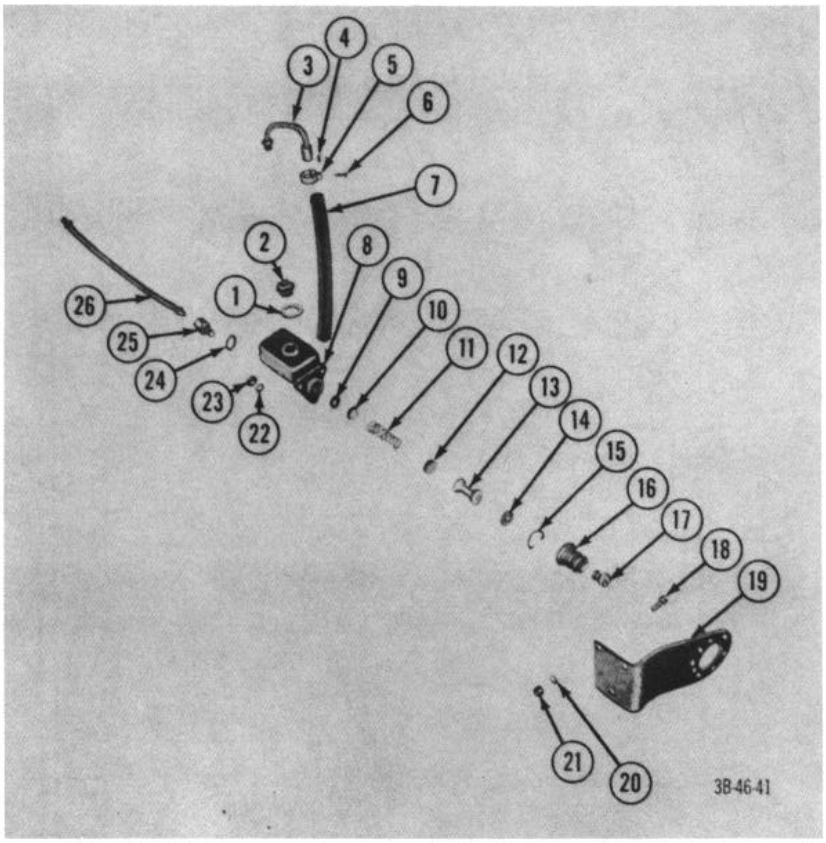
(2) Remove filler plug (2) and washer (1).
(3) Remove boot (16) and collar (17) from housing (8).
(4) Remove lock wire (15) and piston stop (14) from housing (8).
(5) Remove piston assembly (13), primary cup (12), return spring (11), and valve assembly (10) from housing (8).

a. Inspection and Repair.

(1) Inspect cylinder bore for scratches, grooves, and other damage.
(2) Replace defective parts with serviceable items.
(3) Coat all parts with clean HB.

d. Assembly. Reverse procedures in b above.

e. Installation. Reverse procedures in a above.



	Washer, filler plug	14	Stop, piston
2	Plug, filler	15	Wire, lock, stop plate
3	Tube, vent	16	Boot
4	Nut, clamp screw	17	Collar, stop, chamber push rod
5	Clamp, hose, vent tube	18	Capscrew, chamber bracket
6	Screw, clamp	19	Bracket, chamber mounting
7	Hose, vent tube	20	Lockwasher, nut, mounting bracket
8	Housing, master cylinder	21	Nut, bracket capscrew
9	Seat, valve (part of item 10)	22	Lockwasher
10	Valve assembly	23	Nut
11	Spring, piston return	24	Gasket, reducer
12	Cup, piston primary	25	Reducer, tube, master cylinder line
13	Piston assembly	26	Hose assembly, master cylinder

Figure 17. Master cylinder, exploded view.

f. Bleeding Brakes. Refer to paragraph 24f.

26. Air Cleaner

The air cleaner is connected in the service air line, ahead of the brake air chamber. The purpose of the air cleaner is to remove any moisture or foreign matter from the air passing through the system. The air cleaner has a removable element and is fitted with a plug for draining off moisture.

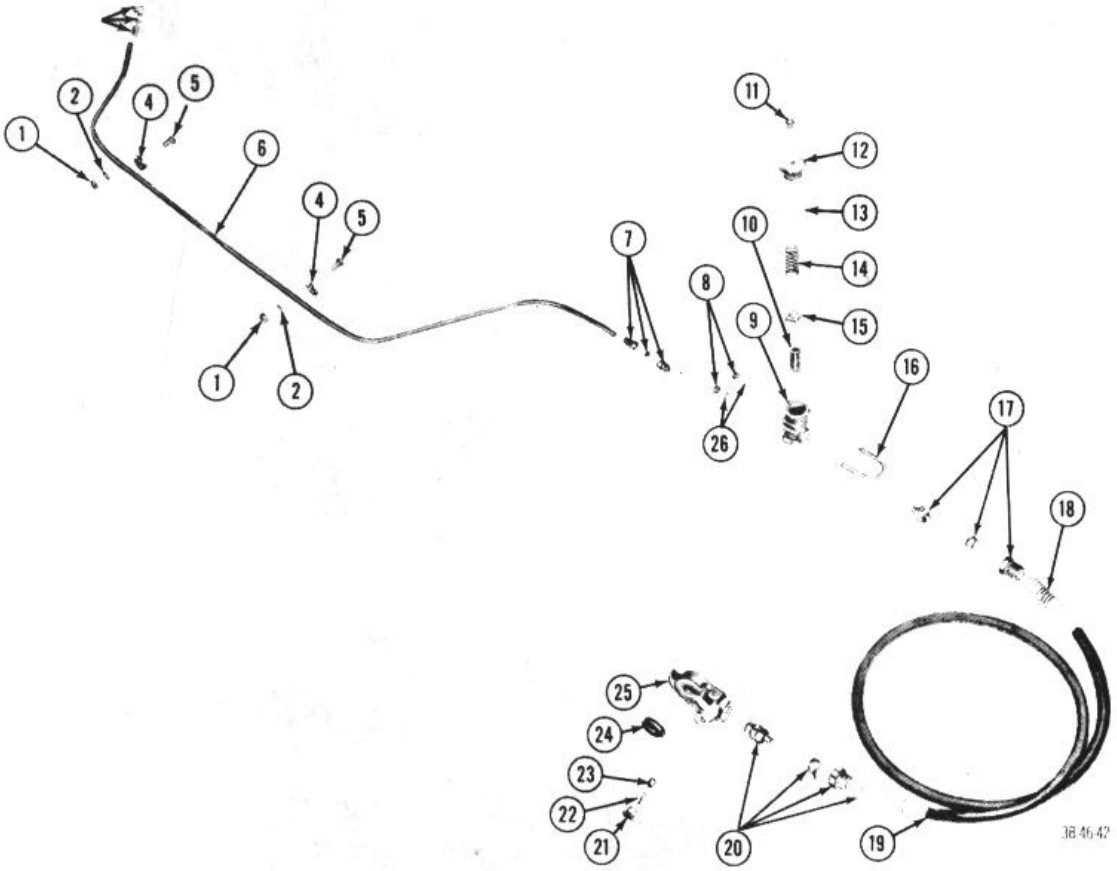
a. Removal.

(1) Disconnect hydraulic hose from air cleaner assembly.

(2) Disconnect cleaner-to-brake chamber line from air cleaner assembly.

(3) Remove U-bolt (16, fig. 18).

(4) Remove air cleaner from trailer.



1 Nut, screw, air line clip
2 Lockwasher, clip screw
3 Elbow, line, brake chamber
4 Clip, air line
5 Screw, clip, air line
6 Line, cleaner-to-brake chamber
7 Connector
8 Nut, U-bolt
9 Housing
10 Washer, element centering
11 Plug, drain
12 Cover
13 Washer, cover nut
14 Spring
15 Element
16 U-bolt
17 Connection assembly, air hose
18 Spring, guard, air hose
19 Hose assembly, air
20 Connection assembly, air hose
21 Retainer, hose coupler
22 Spring, hose coupler
23 Plunger, hose coupler
24 Packing, performed, hose coupler
25 Body, hose coupler
26 Lockwasher, U-bolt

Figure 18. Air cleaner and fittings, exploded view.

b. Disassembly.

(1) Remove drain plug (11).

(2) Remove cover (12) and washer (13) from housing (9).

(3) Remove spring (14) from housing.

(4) Remove element (15) and washer (10).

c. Inspection and Repair.

(1) Inspect all parts for defects.

(2) Replace defective items with serviceable parts.

d. Assembly. Reverse procedures in b above.

e. Installation. Reverse procedures in a above.

27. Air Chamber

a. Removal.

(1) Disconnect chamber-to-filter line.

(2) Remove three nuts and lockwashers that mount air chamber to bracket (19, fig. 17).

(3) Remove air chamber.

b. Disassembly.

(1) Remove 16 bolts, nuts (1, fig. 19), and lockwashers (2) and separate cover from body of chamber.

(2) Remove spring (4), retainer (6), packing (5), and push rod with plate (7).

(3) Remove diaphragm (8).

c. Inspection and Repair.

(1) Inspect spring (4) for fatigue and diaphragm (8) for holes.

(2) Replace defective items with serviceable parts.

d. Assembly. Reverse procedures in b above.

e. Installation. Reverse procedures in a above.

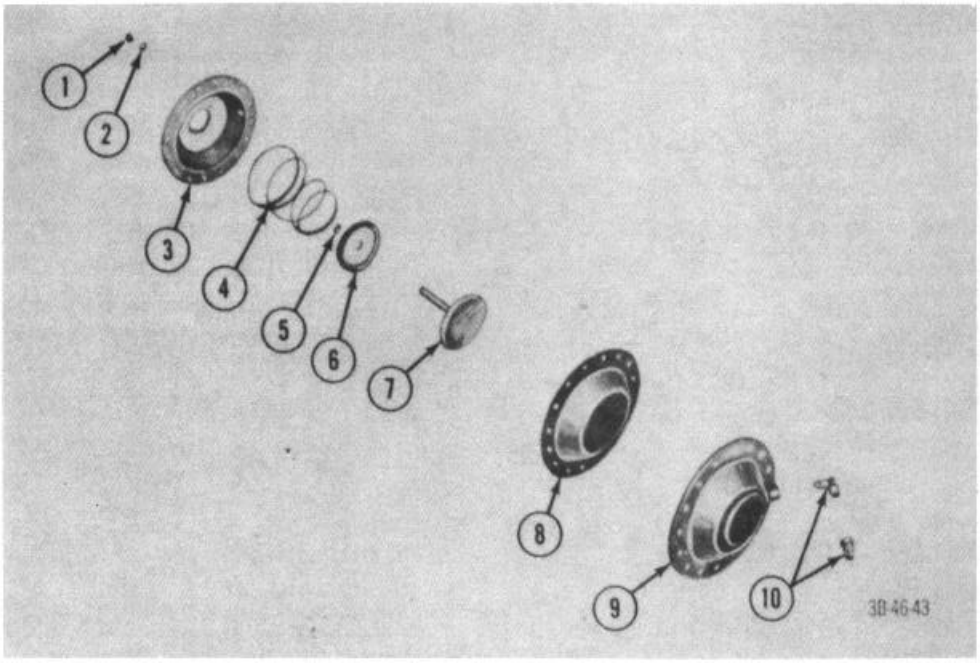
28. Air System Lines and Fittings

To identify and replace defective lines and fittings, refer to figure 13.

29. Wheel Assemblies

a. Removal.

(1) Jack up trailer and remove eight capscrews (23, fig. 14) and eight lockwashers (22) from hubcap.



1 Nut, bolt
2 Lockwasher, nut
3 Body
4 Spring
5 Packing, preformed, chamber cup
6 Retainer, spring
7 Rod with plate, push
8 Diaphragm
9 Cover
10 Elbow, pipe-to-tube

Figure 19. Air chamber, exploded view.

(2) Remove hubcap (21) and gasket (20) from hub (9).
(3) Straighten tang on lockwasher (18).
(4) Remove lockwasher (18) and nuts (17 and 19).
(5) Remove cone and rollers (16).
(6) Remove hub (9) with wheel assembly attached.

b. Installation. Reverse procedures in a above.

30. Wheel Bearings and Seals

a. Removal.
(1) Remove wheel assembly (par. 29a).
(2) Remove seal (5, fig. 14), cone and rollers (6), and cup (7) from hub (9).
(3) Remove cup (15) from hub (9).
(4) Repeat this procedure for other wheel bearings.

b. Inspection and Repair.
(1) Inspect bearings for roughness, high spots, chipped rollers and cups, and heat discoloration.
(2) Inspect seal for evidence of leaks.
(3) Replace defective parts with serviceable items.

c. Installation. Reverse procedures in a above and service according to LO 10-7360201-20-4.

31. Brakedrum

a. Removal.
(1) Remove wheel assembly (par. 29a).
(2) Dismount tire and rim assembly.
(3) Remove 10 bolts (27, fig. 15), nuts (30), and lockwashers.
(4) Separate grease deflector (28) from adapter with ring (31).
(5) Remove eight bolts (29) and lockwashers.
(6) Remove adapter with ring (31), grease deflector (28), and brakedrum (1, fig. 14) from hub (9).

b. Inspection and Repair. Inspect brakedrum for scoring, cracks, and warping.

c. Installation. Reverse procedures in a above.

32. Backing Plate

a. Removal.
(1) Remove wheel assembly (par. 29a).
(2) Disconnect hydraulic brake line.
(3) Remove two handbrake cable strap bolts (12, fig. 14), nuts (14), and lockwasher (11), and remove handbrake cable retaining strap (13).
(4) Push handbrake cable (8) through service brake backing plate (9, fig. 15).
(5) Remove nuts, capscrews, and lockwashers securing backing plate.
(6) Separate backing plate from axle shaft.

b. Inspection.
(1) Inspect breaking plate for breaks, bends, or warped condition.
(2) If backing plate is defective, replace it with a serviceable item.

c. Installation. Reverse procedures in a above.

33. Hub

a. Removal.
(1) Remove wheel assembly (par. 29a).
(2) Dismount tire and rim assembly.
(3) Remove seal (5, fig. 14), cone and rollers (6), and cups (7 and 15) from hub.
(4) Remove 10 bolts (27, fig. 15), nuts (30), and lockwashers.
(5) Separate grease deflector (28) from adapter with ring (31).
(6) Remove eight bolts (29) and lockwashers.
(7) Remove adapter with ring (31), grease deflector (28), and brakedrum (1, fig. 14) from hub (9).

b. Inspection and Repair. Inspect hub for cracks, breaks, and other damage.

c. Installation. Reverse procedures in a above.

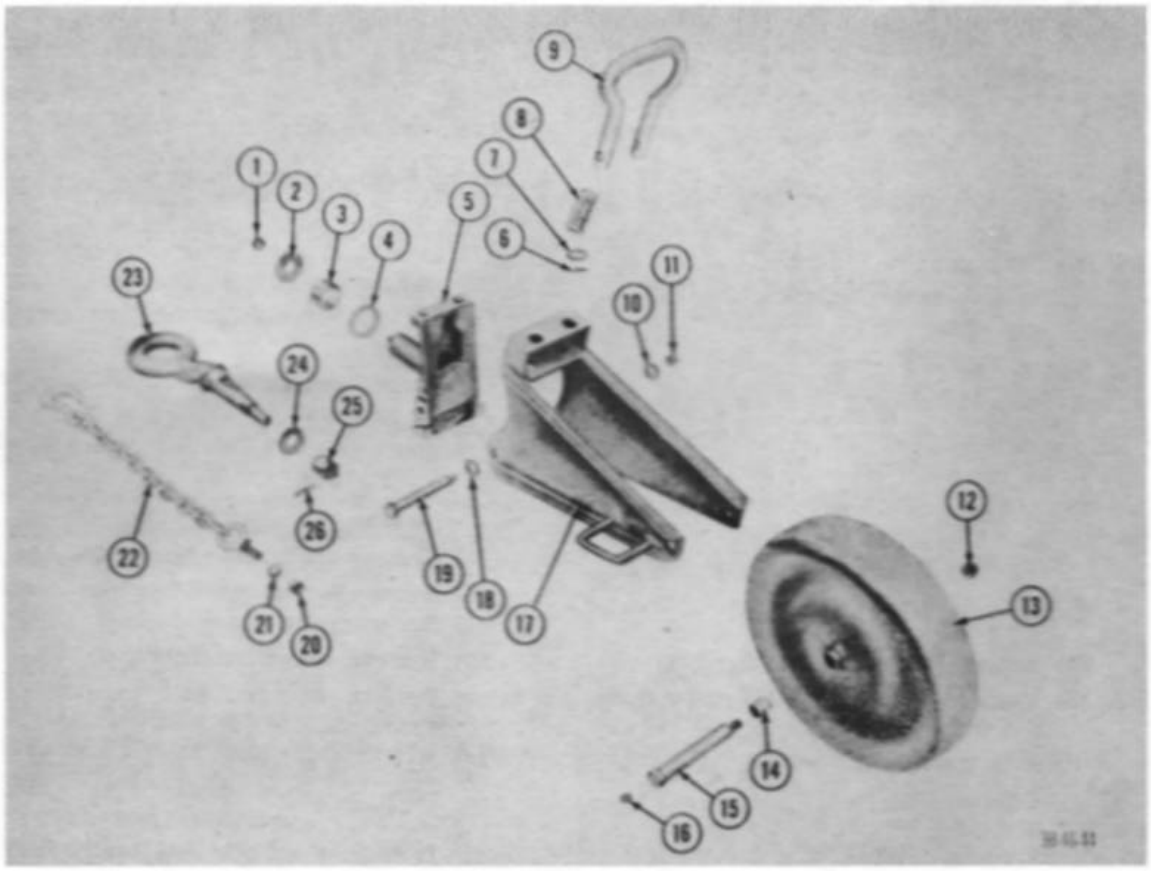
34. Caster Wheel Assembly

a. Removal and Disassembly.
(1) Jack up front end of trailer.

(2) Remove locknut (12, fig. 20) from caster wheel axle (15).
(3) Remove caster wheel axle (15) and remove wheel (13).
(4) Remove lubrication fitting (16) from axle.
(5) Remove two bushings-type bearings (14) from wheel.
(6) Remove locknut (1) from bracket and spindle assembly (5).
(7) Remove flat washer (2).
(8) Remove bracket and spindle (5) and leg assembly (17).
(9) Remove bronze thrust washer (4) from bracket and spindle (5).
(10) Remove nut (11), bolt (19), and two washers (10 and 18) from spindle and leg assembly.
(11) Remove handle (9) by pulling out two pins (6).
(12) Remove two springs (8) and spring cups (7).

b. Inspection and Repair,

(1) Inspect axle and bearings for wear.
(2) Inspect bracket with spindle for breaks, scoring, and stripped threads.



1 Locknut
2 Washer, flat
3 Bearing
4 Washer, thrust
5 Bracket with spindle, swivel
6 Pin, straight
7 Cup, locking spring
8 Spring, locking, caster leg
9 Handle
10 Washer, flat
11 Nut
12 Locknut, axle, caster wheel
13 Wheel, disk, front caster
14 Bearing, caster wheel
15 Axle, caster wheel, front
16 Fitting, lubrication
17 Leg assembly, caster
18 Washer, fiat
19 Bolt, shoulder
20 Nut, plain
21 Lockwasher
22 Chain, safety
23 Lunette
24 Washer, flat
25 Nut, slotted
26 Pin, cotter

Figure 20. Caster wheel and towing attachments, exploded view.

(3) Inspect springs for fatigue.
(4) Replace defective items with serviceable ones.

c. Assembly and Installation. Reverse procedures in a above.

35. Pneumatic Tires and Tubes

a. Removal.
(1) Jack up trailer and remove six nuts (24, fig. 14) from inner wheel bolt nuts (25); nuts on left side of trailer have left-hand threads and nuts on right side of trailer have right-hand threads.
(2) Remove outer wheel and tire assembly.
(3) Remove six inner wheel nuts (25) from trailer wheel hub bolts.
(4) Remove inner wheel and tire assembly.
(5) Deflate tire and remove bead lock ring.
(6) Dismount tire and tube.
(7) Remove inner flap from tire and remove tube.

c. Inspection and Repair.
(1) Inspect tires and tubes for defects.
(2) If tires or tubes are unserviceable, install new ones.

d. Installation. Reverse procedures in a above.

36. Lunette

a. Removal.
(1) Remove cotter pin (26, fig. 20).
(2) Unscrew slotted nut (25) and remove flat washer (24).
(3) Pull lunette (23) out.

b. Installation. Reverse procedures in a above.

37. Safety Chain Assemblies

a. Removal.
(1) Remove plain nut (20, fig. 20) holding eyebolt to chassis.
(2) Remove lockwasher (21).
(3) Remove chain and attached eyebolt (22).
(4) Repeat procedures to remove chain on other side of drawbar.

b. Installation. Reverse procedures in a(1) through (3) above.

38. Trailer Axle

Inspect axle for any evidence of damage such as bends or cracks.

39. Trailer Axle Rubber Bumper

a. Inspection. Inspect rubber bumper for loss of electricity, dry rot, or cracks.

b. Removal.
(1) Remove plain nut from capscrew holding rubber bumper to chassis.
(2) Remove washer and capscrew and remove bumper.
(3) Repeat procedures for other bumper.

40. Spring Assemblies and Hangers

a. Inspection.
(1) Inspect spring leaves for looseness and damage.
(2) Look for broken or shifted spring leaves.
(3) Check hangers, brackets, and U-bolts for looseness.
(4) Check front shackle bolt sleeve bearing for wear.

b. Removal and Disassembly.
(1) Jack up trailer and block axle.
(2) Remove four nuts and two U-bolts that fasten spring to axle.
(3) Remove spring retainer plate.
(4) Remove nut and bolt from trailer spring shackle.
(5) On later models, springs may now be removed from trailer. On older models, remove capscrew and nut from rear shackle and then remove springs.
(6) Remove hangers by removing capscrews and nuts from each hanger.
(7) Press out front shackle bolt sleeve bearing from spring eye.
(8) Repeat procedures for other spring assembly.

c. Repair.

(1) If front shackle bolt sleeve bearing shows signs of wear, install a new bearing.

(2) If spring return plate is broken or damaged, install a serviceable plate.

d. Assembly and Installation. Reverse procedures in b above.

41. Leveling-Support Jack Assemblies

The leveling-support jacks (fig. 21) used on newer models of these trailers are fitted with special hinges shaped like the letter C. The jacks can be retracted and raised above the trailer floor.

a. Inspection.

(1) Check jacks to be sure they operate properly.

(2) Inspect all parts of the jacks for damage.

b. Removal and Disassembly.

(1) Remove cotter key and slotted nut from end of brace rod that is attached to chassis and remove capscrew from brace retracting bracket.

(2) Turn toggle bolt (on other end of rod) parallel to rod, remove bolt, and release rod.

(3) Remove cotter key and washer, drive out pin holding jack body to hinge, and remove jack.

(4) Remove nut, capscrew, and washer holding footplate to jack and remove footplate.

(5) Repeat these procedures for other three jacks.

c. Repair. Replace defective parts with serviceable items.

d. Assembly and Installation. Reverse procedures in b above.

42. Divider Motor

The divider motor (1, fig. 22) is interchangeable with the molder and oven motors.

a. Inspection.

(1) Inspect divider motor for overheating and overload.

(2) Check for proper lubrication and ventilation.

(3) Listen for grinding noises which indicate worn bearings causing rotor to drag against stator.

(4) Check for objects retarding free operation.

b. Removal.

(1) Remove cover from junction box and disconnect wiring to release cable. Tag wires for identification.

(2) Remove four capscrews and lockwashers that secure motor to base.

(3) Rock motor forward to loosen silent chain (5) and remove chain.

(4) Pull motor forward and lift it from base.

c. Installation. Reverse procedures in b above.

43. Molder Motor

The molder motor (7, fig. 23) is interchangeable with the divider and oven motors.

a. Inspection. Refer to paragraph 42a.

b. Removal.

(1) Remove three roundhead screws holding chain guard (7) to molder and remove chain guard.

(2) Remove cover from junction box (9), disconnect wiring, and tag wires for identification.

(3) Remove four capscrews and washers holding motor (8) to base and turn adjusting screw to loosen silent chain.

(4) Remove chain and motor.

c. Installation. Reverse procedures in b above.

44. Mixer Motor

a. Inspection. Refer to paragraph 42a.

b. Removal.

(1) Remove capscrews and washers from right finish panel of mixer and remove panel.

(2) Loosen hinges on front door and slide door off.

(3) Find master link on agitator drive

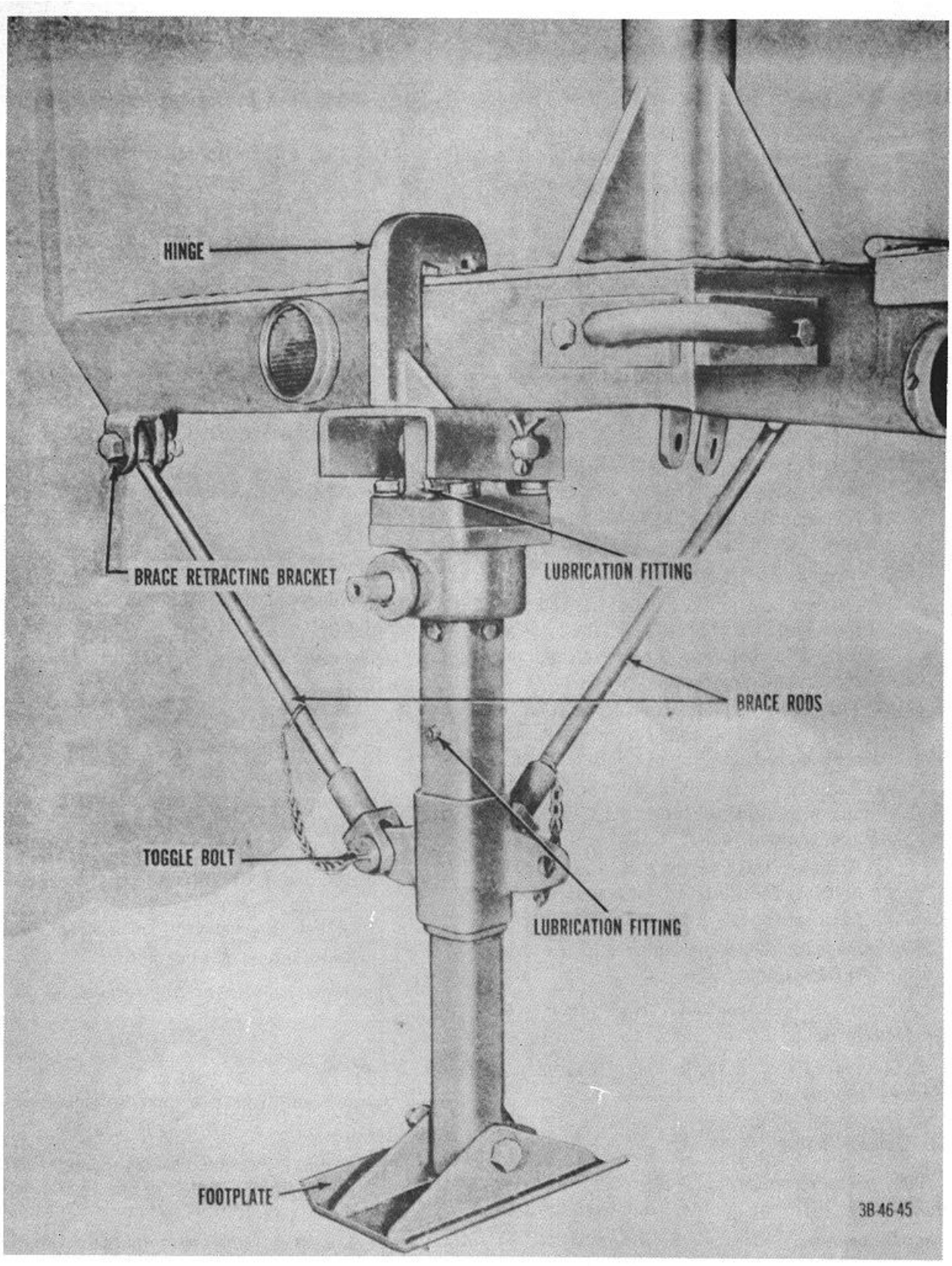
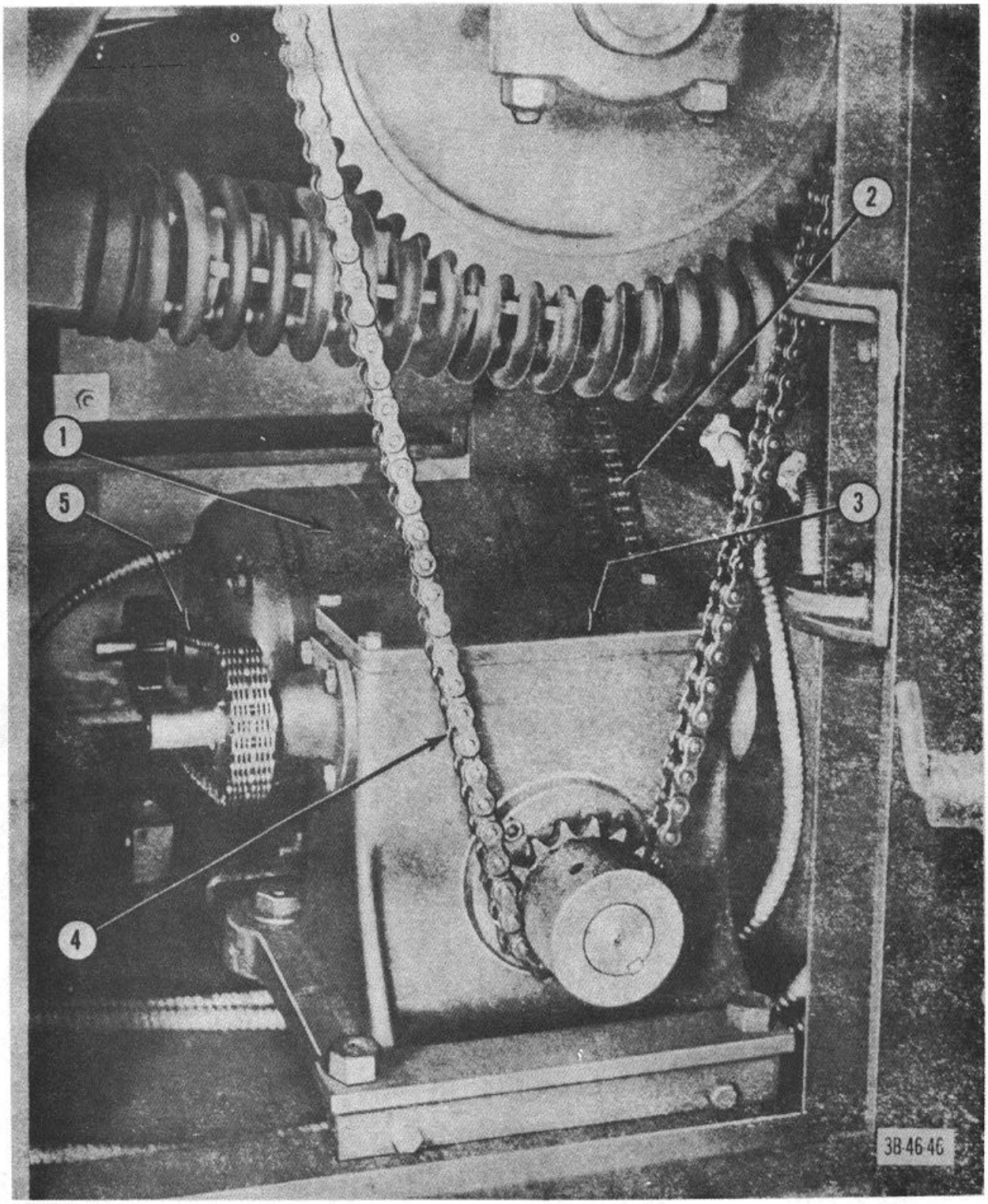
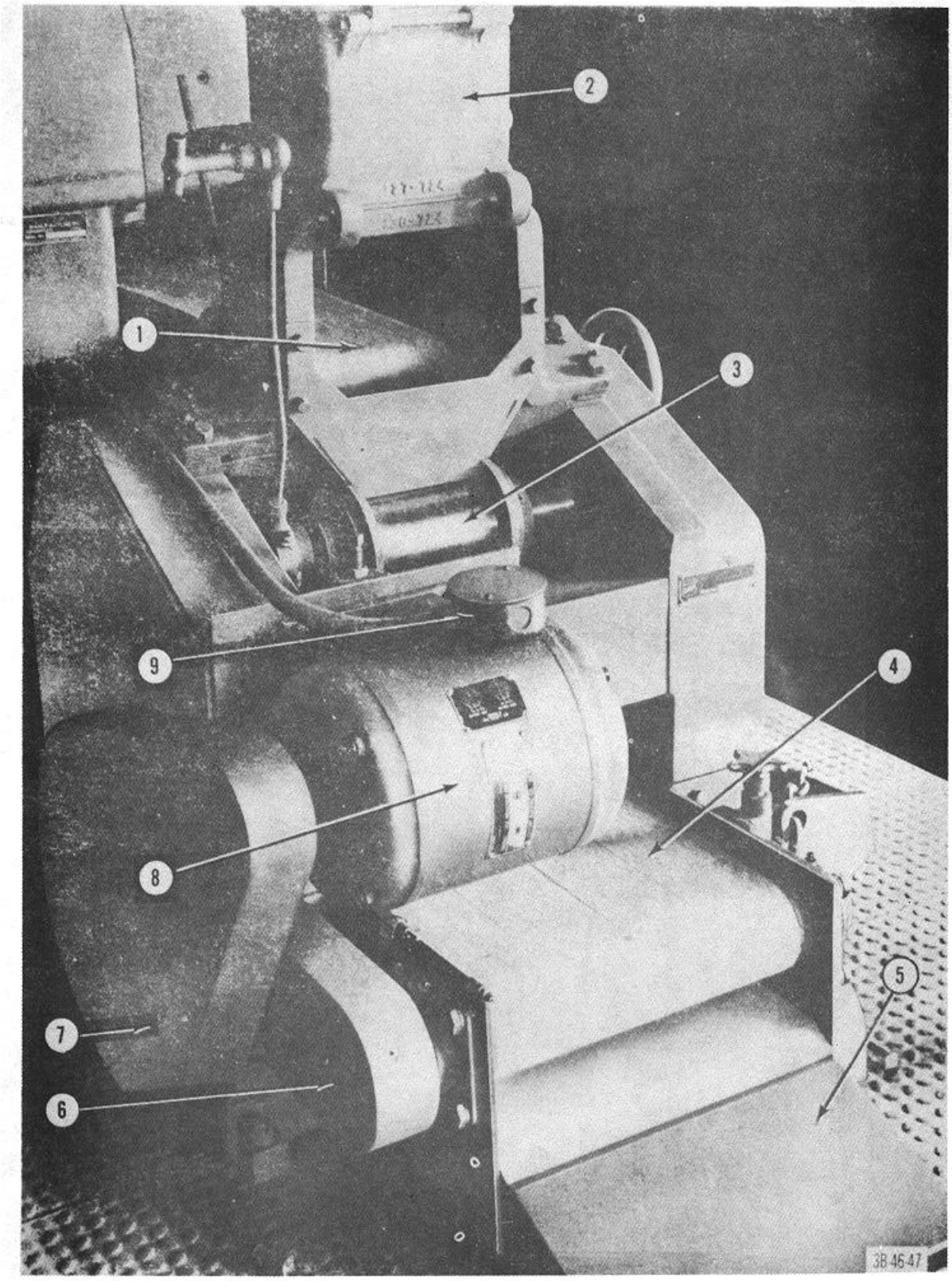


Figure 21. Leveling-support jack in support position.



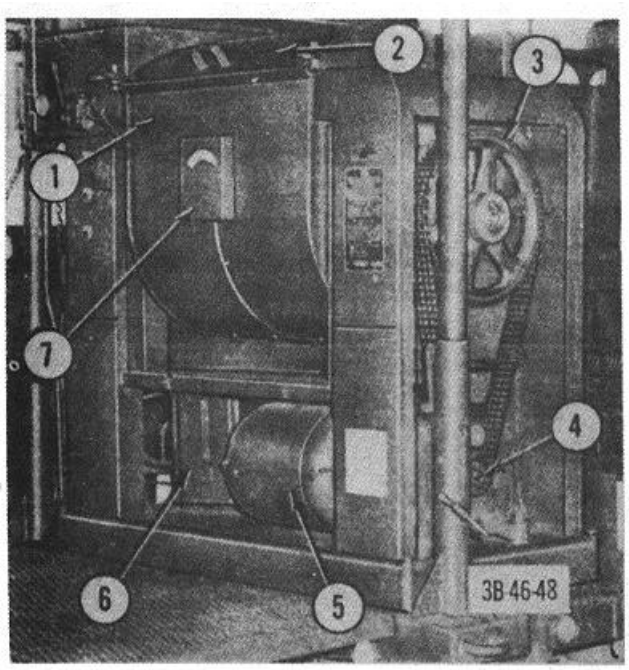
1 Motor
2 Chain, drive, conveyor belt
3 Reduction unit, gear
4 Chain, crankshaft drive
6 Chain, drive, gear reduction unit

Figure 22. Divider drive assembly.



1 Belt, divider conveyor
2 Duster, sheeting roll
3 Roll, sheeting
4 Belt, molder conveyor
5 Plate, discharge
6 Guard, chain
7 Guard, chain
8 Motor, molder
9 Box, junction

Figure 23. Molder motor, installed.



1 Bowl, mixer
2 Cover, bowl
3 Chain, agitator drive
4 Reduction unit, gear
5 Motor
6 Starter assembly, motor manual
7 Thermometer, bowl dial

Figure 24. Mixer motor and gear reduction unit, installed.

chain (3, fig. 24), remove cotter pin from link, and drive out pin. Remove chain.

(4) Remove two capscrews, washers, and shims from right side of gear reduction unit (4).

(5) Remove capscrew holding motor (5) to chassis on left side of motor.

(6) Lift out motor with gear reduction unit attached.

c. Installation. Reverse procedures in b above.

45. Power Panel Circuit Breakers

Warning:
Be sure current is OFF before working on the circuit breakers.

a. Inspection. Inspect all circuit breakers on power panel (fig. 25) to be sure they separate properly.

b. Removal.

(1) Remove 26 screws holding main cover of panel and remove cover.

(2) Remove 17 screws holding panel center cover plate and remove plate.

(3) Remove screws holding circuit breaker to copper connector plates.

(4) Disconnect wires from contacts and remove breaker.

c. Installation. Reverse procedures in b above.

46. Trailer Lights

a. Removal and Disassembly.

(1) Remove screw holding guard to lighting fixture and remove guard.

(2) Unscrew globe and incandescent lamp.

(3) Remove nut on top of fixture and separate fixture from support strap.

(4) Disconnect fixture from conduit.

(5) Disconnect lead-in wires from receptacle.

b. Inspection. Inspect lamps, globes, guards, fixtures, and receptacles for dents, bends, and other damage.

c. Assembly and Installation. Reverse procedures in a above.

47. Lighting Extension Cords

The lighting extension cord has five socket outlets that are connected to pigtails spliced onto the cord.

a. Disassembly.

(1) Remove guard with shield and hook.

(2) Remove incandescent lamp.

(3) Remove reflector.

(4) Disconnect socket.

b. Inspection and Repair.

(1) Inspect cord for wear, fraying, and other damage.

(2) Inspect socket, reflector, incandescent lamp, and guard to be sure they are in good condition.

(3) Replace defective items with serviceable parts.

c. Assembly. Reverse procedures in a above.

48. Power and Lighting Panel Plugs and Connector

Older models with two panels have two 3pole plugs attached to cables. New models with

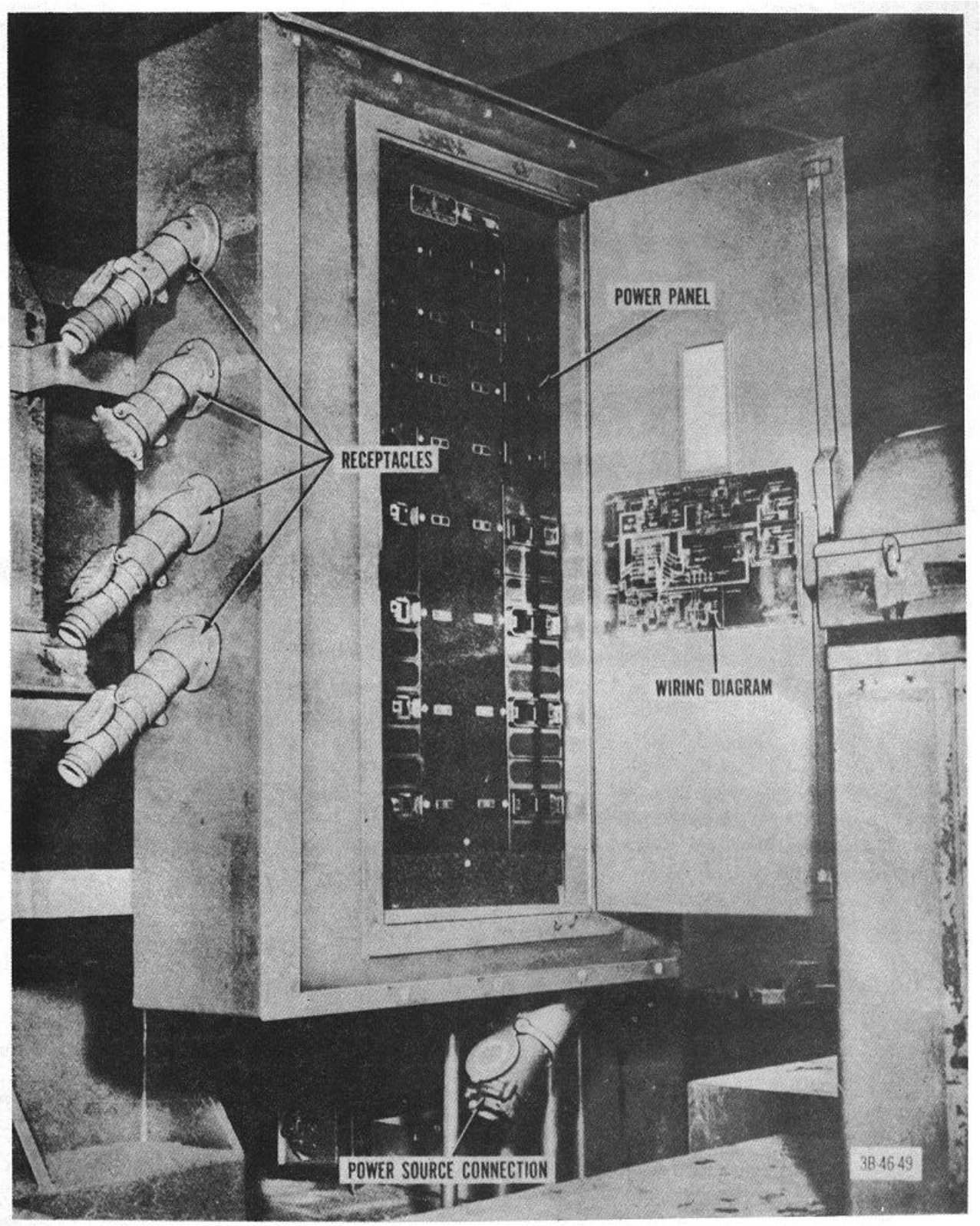


Figure 25. Power panel.

a central power and light panel have one 4-pole plug connector on the power lead-in cable.

a. 3-Pole Plugs.

(1) *Inspection*. Inspect plug for any evidence of short circuit or other damage.

(2) *Removal*.

(a) Loosen knurled collar on cable end of plug.

(b) Loosen setscrew on clamp around plug.

(c) Unscrew end of plug that is pushed into receptacle.

(d) Slide plug back on cable to expose wires and brass jack plug ends.

(e) Melt solder from brass contacts in order to remove wires.

(3) *Installation.* Resolder each wire into position and reverse procedures in (2) *(a)* through *(d)* above.

b. 4-Pole Plug Connector.

(1) *Inspection*. Refer to a(1) above.

(2) *Removal.*

(a) Remove clamp from around cable end of plug by removing a screw on each side of clamp.

(b) Remove three screws from rear plate of plug and remove plate.

(c) Remove setscrew from shield at opposite end of plug and slide shield off.

(d) Slide inside of plug down on cable to expose four wires and the brass jacks on wire ends.

(e) Remove two bakelite insulator disks from jack plugs.

(f) Melt solder from connector tips to remove wires.

(3) *Installation.*

(a) Replace wire ends in connector tips and resolder them into position.

(b) Reverse procedures in (2) *(a)* through *(e)* above.

49. Power and Lighting Panel Receptacles

a. Inspection. Inspect power and lighting panel receptacles for any damage or evidence of short circuits.

b. Removal.

(1) Remove screw holding spring cover to receptacle and remove cover.

(2) Remove setscrew from plate holding receptacle.

(3) Unscrew body of receptacle and remove it from plate.

(4) Pull inner part containing brass connections forward.

(5) Heat connections to melt solder and free cable wires.

c. Installation. Solder wires back into position and reverse procedure in *b*(1) through (4) above.

50. Roller Chains

a. Location.

(1) *Divider roller chains*. To gain access to the divider crankshaft drive chain (4, fig. 22) and the divider conveyor belt drive chain (2), open both side doors.

(2) *Molder roller chains*.

(a) To gain access to the molder conveyor belt drive chain (5, fi4. 26), remove screws securing chain guards (6 and 7, fig. 23) and remove guards.

(b) To gain access to the front and rear sheeting roll drive chains (4, fig. 27 and 11, fig. 28), remove the molder headframe cover plates (par. 105a).

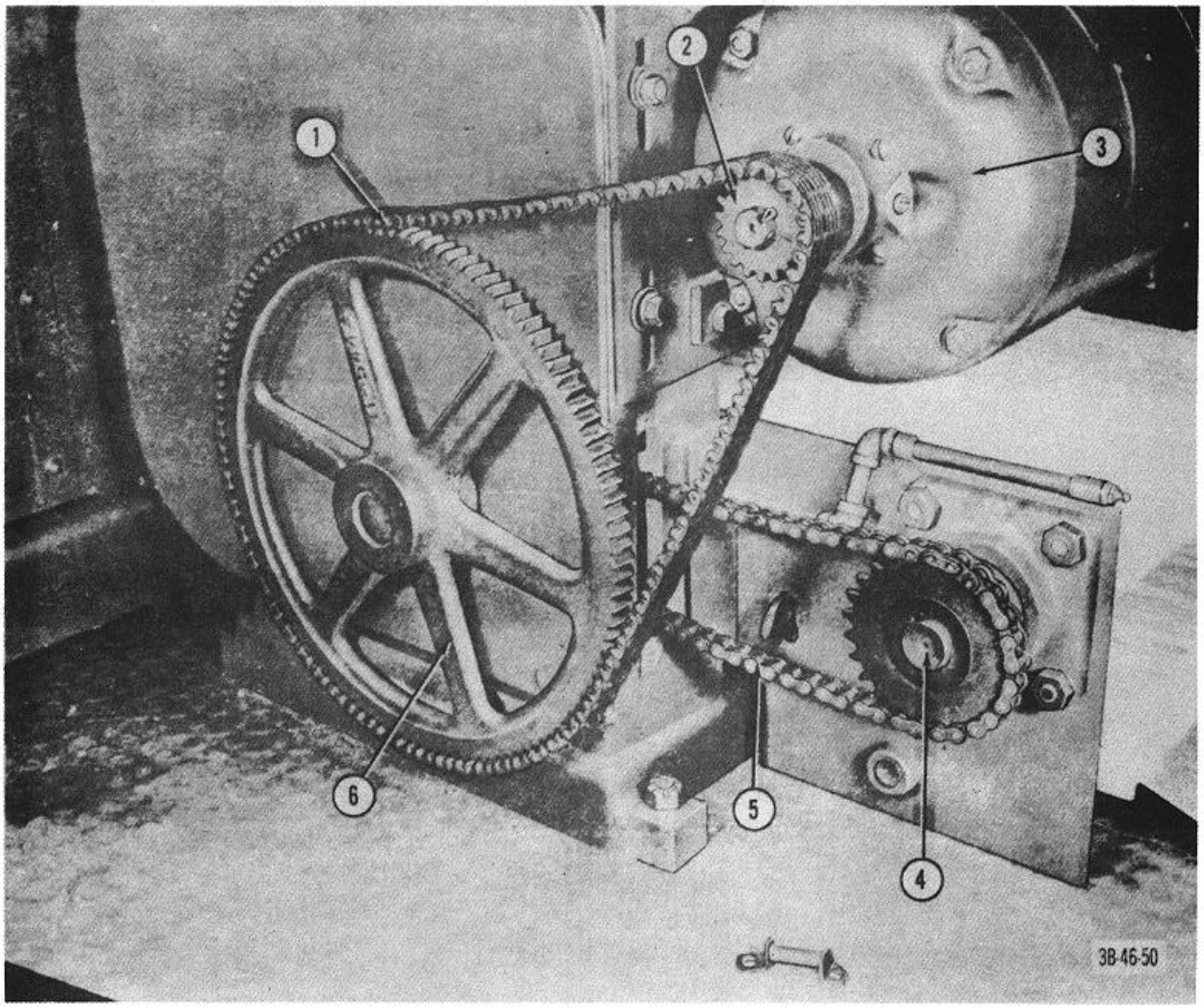
(3) *Mixer roller chain*. To gain access to the mixer agitator drive chain (3, fig. 24), remove capscrews and washers from right finish panel of mixer and remove panel.

b. Inspection. Inspect roller chains for wear and damage, and be sure chains are properly lubricated.

c. Removal. To remove the roller chains, find the connecting link, tap on link with a brass drift, remove link, and remove chain. The mixer roller chain (*a* (3) above) has cotter pins that must be removed from the links.

d. Repair. If links are worn or damaged, replace them with new links. If chain is unserviceable, install a new chain.

e. Installation. Reverse procedures in *c* above.



1 Chain, molder drive
2 Pinion, motor shaft
3 Motor
4 Hub with sprocket, drive shaft, conveyor belt
5 Chain, drive, conveyor belt
6 Gear, drive, conveyor belt

Figure 26. Molder chains.

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1 Pinion, adjusting shaft, upper front sheeting roll
2 Bearing with gear and pin stop, eccentric
3 Hub with sprocket, shaft, upper rear sheeting roll
4 Chain, drive, rear sheeting roll
5 Sprocket, drive, conveyor belt
6 Chain, drive, conveyor belt
7 Shaft, main drive
8 Shaft, eccentric, idler sprocket
9 Wheel, shaft sprocket, lower rear sheeting roll
10 Bearing with gear and pin stop, eccentric
11 Pinion, adjusting shaft, lower front sheeting roll

Figure 27. Molder headframe, left side.

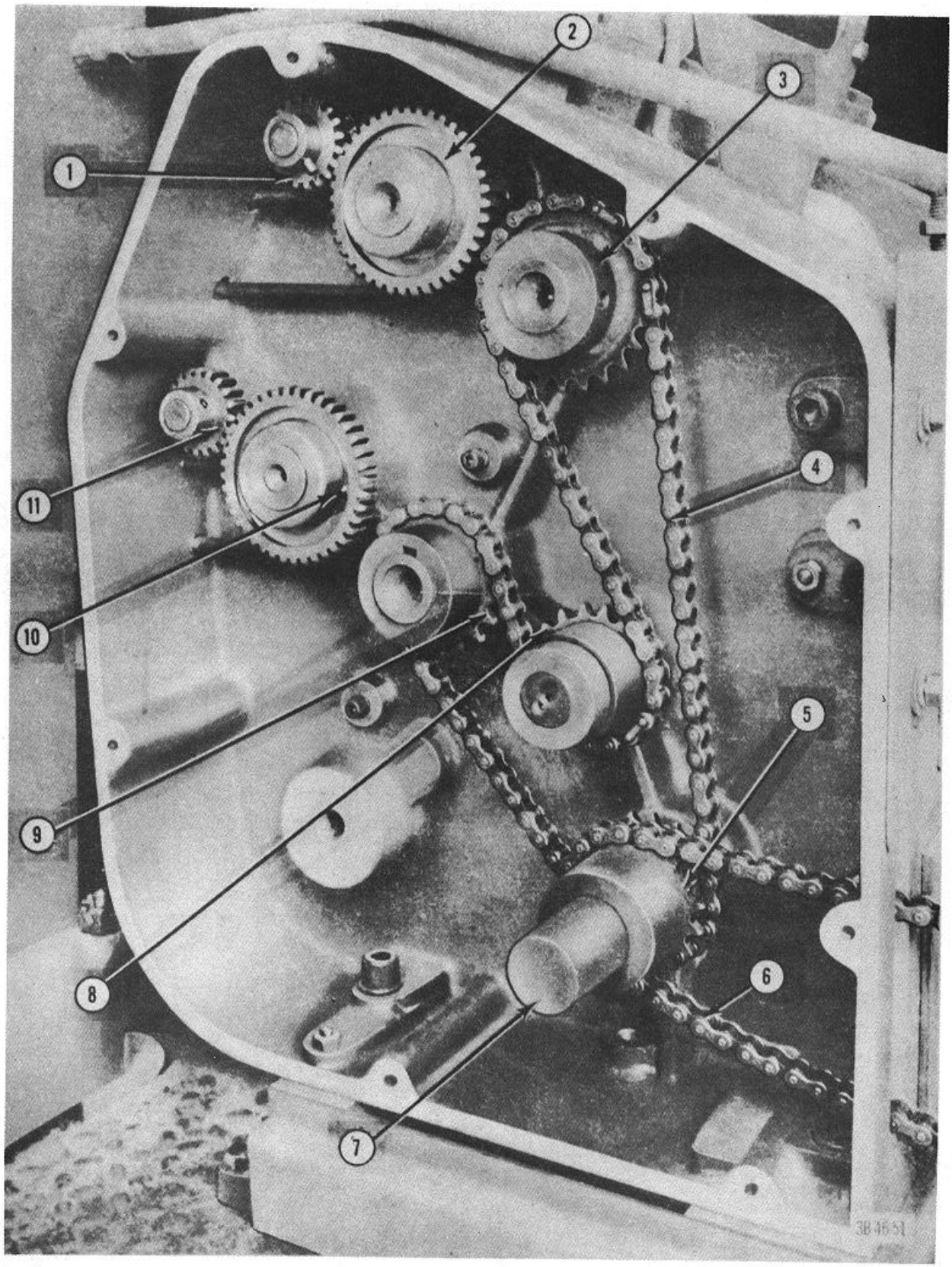


Figure 27--Continued.

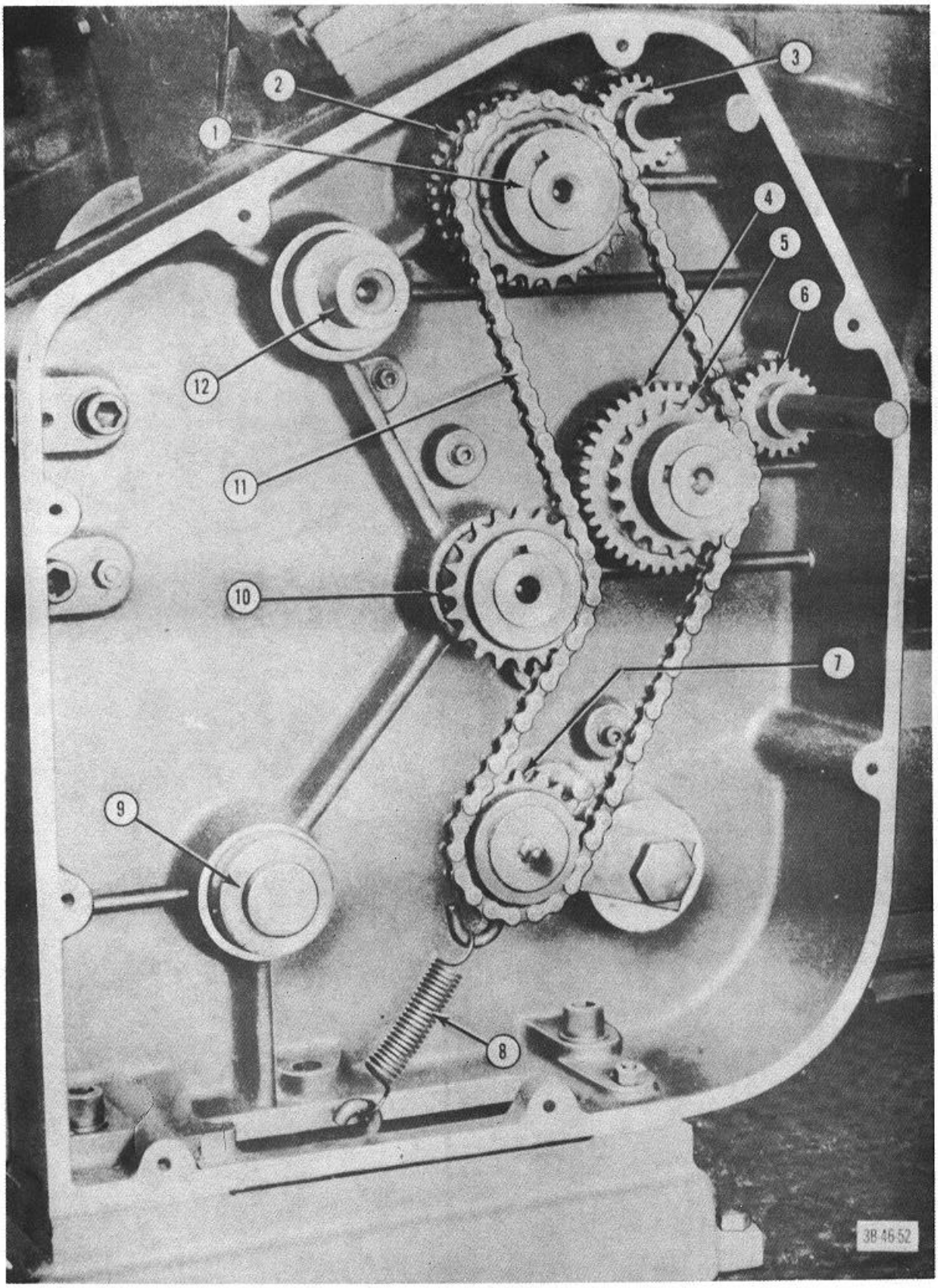


Figure 28. Molder headframe, right side.

1 Hub with sprocket, shaft, upper front sheeting roll
2 Bearing with gear and pin stop, eccentric
3 Pinion, adjusting shaft, upper front sheeting roll
4 Bearing with gear and pin stop, eccentric
5 Wheel, shaft sprocket, lower front sheeting roll
6 Pinion, adjusting shaft, lower front sheeting roll
7 Sprocket with bushing, idler, front sheeting roll
8 Spring, bar, idler sprocket
9 Shaft, drive, sheeting rolls and conveyor
10 Wheel, shaft sprocket, lower rear sheeting roll
11 Chain, drive, front sheeting roll
12 Shaft, upper rear sheeting roll

Figure 28-Continued.

51. Silent Chains

a. Location.

(1) *Divider silent chain*. To gain access to the divider gear reduction unit drive chain (5, fig. 22), open both side doors.

(2) *Molder silent chain*. To gain access to the molder drive chain (1, fig. 26), remove screws holding chain guards (6 and 7, fig. 23) and remove guards.

(3) *Mixer silent chain*. To gain access to the mixer gear reduction unit drive chain, proceed as follows:

(a) Remove capscrews and washers from right finish panel of mixer and remove panel.

(b) Remove bolts securing cover of gear reduction unit and remove cover and gasket.

b. Inspection. Inspect silent chains for wear and damage, and be sure chains are properly lubricated.

c. Removal. To remove the silent chain, find connector link, file ends of pins, pull out pins, and remove chain.

d. Repair-. If links are worn or damaged, replace them with new links. If chain is unserviceable, install a new chain.

e. Installation. To install chain, insert two pins through connector link, with one pin protruding on one side of link and other pin protruding other side of link. Peen pins.

Section V. DIVIDER

52. Divider Assembly

a. Inspection.

(1) Inspect the divider assembly to be sure all components and accessories are clean, properly assembled and lubricated, and securely installed.

(2) Check oil reservoir to be sure it is filled with divider oil.

b. Adjustment. Adjust the components of the divider assembly by following directions given in TM 10-7360-201-10.

53. Rear Door Transom Latch Catch

a. Inspection. Inspect catch to be sure it is serviceable.

b. Replacement. If catch is defective, remove two machine screws holding it to divider, remove catch, and reverse procedure to install a new catch.

54. Divider Scale Mounting Cushions

a. Inspection. Inspect scale mounting cushions (fig. 29) to be sure they absorb shock and are not cracked or dry rotted.

b. Replacement. If cushions are defective, remove four nuts under support, lift off scale, and remove cushions. Install serviceable cushions, set scale in place, and install four nuts.

55. Divider Door Hinges

a. Inspection.

(1) Inspect front part of hinge that is attached to door and be sure it is not bent, cracked, or broken.

(2) Examine pins on inside of hinge to be sure they are secure and in serviceable condition.

b. Removal.

(1) Remove two nuts, bolts, and lockwashers that attach female hinge to door.

(2) Remove cotter pin and straight pin and separate female hinge from male hinge.

(3) Remove two capscrews and lockwashers that attach male hinge to divider and remove male hinge.

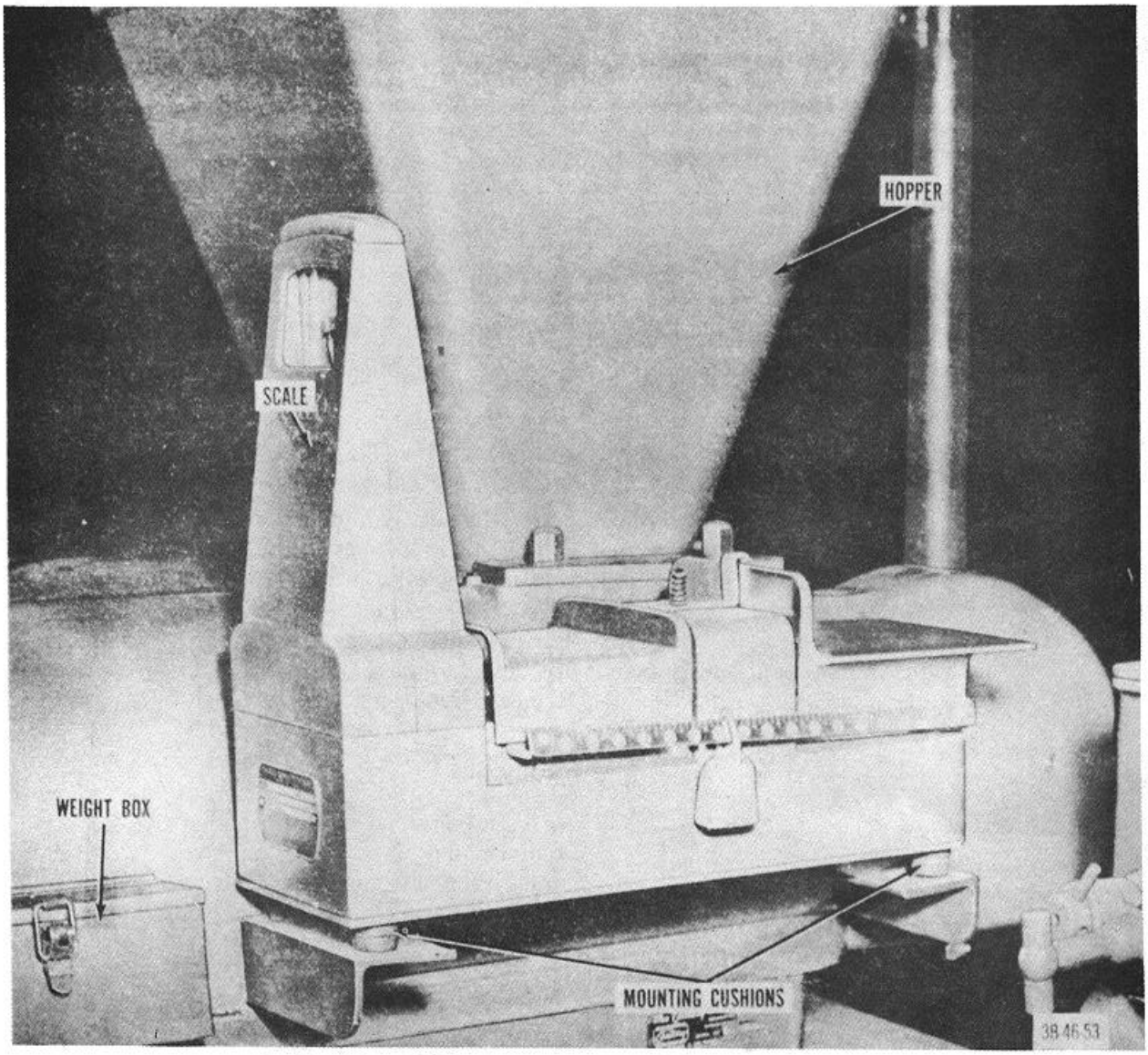


Figure 29. Divider scale.

(4) Repeat procedures for other door hinge.

c. Installation. Reverse procedures in b(1) through (3) above, 56. Divider Checking Scale a. Inspection.

(1) Inspect scale (fig. 29) for damage such as distortion, bends, or breaks.

(2) If holddown clamp is attached, remove nut from screw that secures clamp and remove clamp. Check balance of scale to be sure lever arm comes to rest with slide set at proper place.

(3) Check for presence of all weights.

b. Removal. With holddown clamp removed, remove four hexagon nuts under support and lift off scale.

c. Installation. Reverse procedure in b above.

57. Divider Conveyor Duster Bar Assemblies

The flour duster drive mechanism consists of two eccentric collars mounted on the conveyor belt drive shaft and a bar and lever from each

eccentric collar to each of the flour duster agitators. The up-and-down movement of the drive bar and agitator lever, caused by the motion of the eccentric collars, gives a rocker motion to the duster agitator.

a. Removal.

(1) Remove capscrews from one end of upper duster bar.

(2) Remove setscrews from pin end of bar.

(3) Drive out straight pin and remove upper duster bar from divider.

(4) Repeat procedures (1) through (3) above for lower duster bar.

b. Inspection and Repair.

(1) Inspect bars for breaks, cracks, or other imperfections.

(2) Inspect eccentric collars for wear and proper adjustment.

(3) If bars are worn or damaged, install serviceable items.

c. Installation. Reverse procedures in a(1) through (3) above.

58. Divider Conveyor Belt

a. Inspection. Inspect conveyor belt (2, fig. 30) for looseness due to stretching and wear.

b. Replacement.

(1) Stop conveyor belt so that lacing is over the drive pulley and move belt adjustment as far to the left, or loose, position as possible.

(2) Withdraw belt pins.

(3) Attach lacing on one end of new belt to one end of old belt and run through pulleys until new belt is in position to mark for cutting. After marking belt, run old belt back over pulleys and detach it from new belt.

(4) Cut new belt as marked, making sure both ends of new belt are cut squarely at right angles to side of belt.

(5) Apply fasteners to cut ends of new belt by carefully following these steps:

(a) Place finger at check mark between teeth and break two pieces of lacing of equal length, narrower than AGO 5028A belt. Insert gage pin (step 1, fig. 31).

(b) Center bar of lacing on top side of belt, placing it on wood or iron block. Drive end prongs half through belt, holding lacing firmly against gage pin. Then drive all prongs on top side halfway through belt. Reverse belt and drive the other prongs in full length (step 2).

(c) On wood block, turn belt again and hammer lacing until teeth stick into wood block. Clinch under teeth sideways as they come through (step 3).

(d) On iron block, turn belt and clinch all teeth sideways, and then beat lacing down smooth and flush with belt (step 4).

(e) Cut two hinge pins just alike, the same length as bar of lacing. For a perfect joint two pins must be used.

Note

that smooth faces are together and the lugs alternate (step 5).

(6) Run belt into position over pulleys, bringing both laced ends of belt together so that lacings mesh.

(7) Join belt, using two pins with smooth faces together and lugs alternating (step 6).

(8) Adjust belt tension by moving conveyor drive pulley backward or forward as necessary. Tighten pivot screw to secure adjustment.

59. Divider Duster Stud Bearings

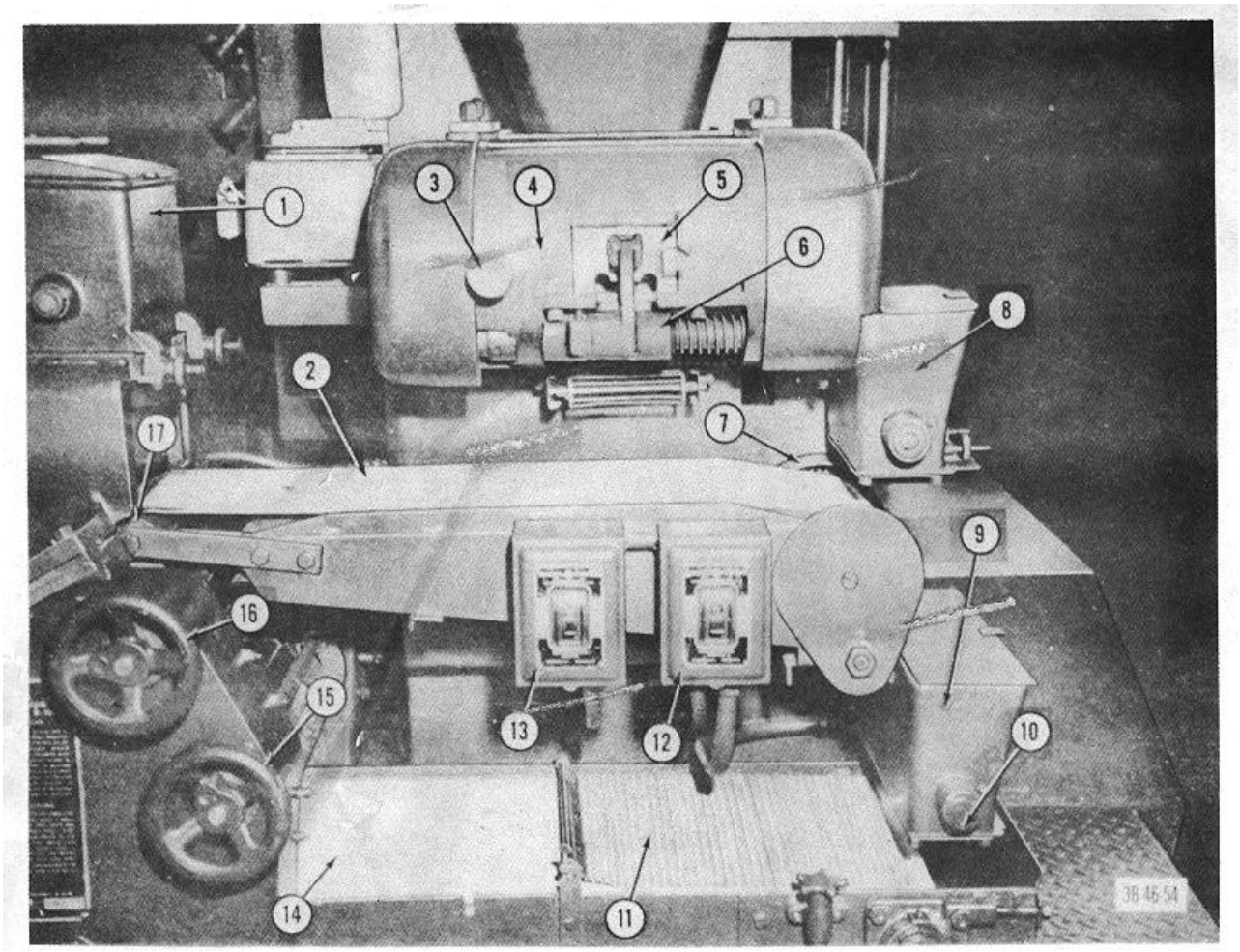
Inspect conveyor duster stud bearings (10, fig. 30) by pushing on duster levers to determine the amount of play.

60. Conveyor Belt Idler and Pinion Bearings

Inspect conveyor belt idler and pinion bearings (17, fig. 30) for wear by checking the play around them.

61. Conveyor Drive Gear With Pulley, Pinion, Shafts, and Collars

Inspect the drive gear (7, fig. 30), pulley, pinion, shafts, and collars for wear or damage.



1 Duster, sheeting roll
2 Belt, divider conveyor
3 Knob, screw, cylinder adjusting
4 Cylinder, dough box
5 Piston, dough measuring
6 Lever, piston discharge
7 Gear with pulley, drive
8 Duster, upper
9 Duster, lower
10 Bearing, stud, lower duster
11 Belt, dough curler
12 Starter, manual, divider motor
13 Starter, manual, molder motor
14 Belt, molder conveyor
15 Handwheel, adjusting, lower sheeting roll
16 Handwheel, adjusting, upper sheeting roll
17 Bearing, pinion, pulley drive

Figure 30. Divider assembly, front view.

Check to see that these items are securely installed.

62. Divider Duster Screens

a. Removal.

(1) Remove all flour from duster box.

(2) Remove four capscrews, lockwashers, and flat washers from bottom of duster.

(3) Remove bottom plate, screen, and dust flow plates.

(4) Repeat procedures (1) through (3) above for other duster.

b. Inspection. Inspect duster screen for excessive wear or damage.

c. Installation. Reverse procedures in *a*(1) through (3) above.

63. Divider Crankshaft, Lever, Pillow Blocks, and Sprocket

a. Inspect divider crankshaft, lever, pillow blocks, and sprocket for wear, cracks, or distortions.

b. Be sure all parts fit snugly and that there is no excessive lost motion or looseness in the linkage.

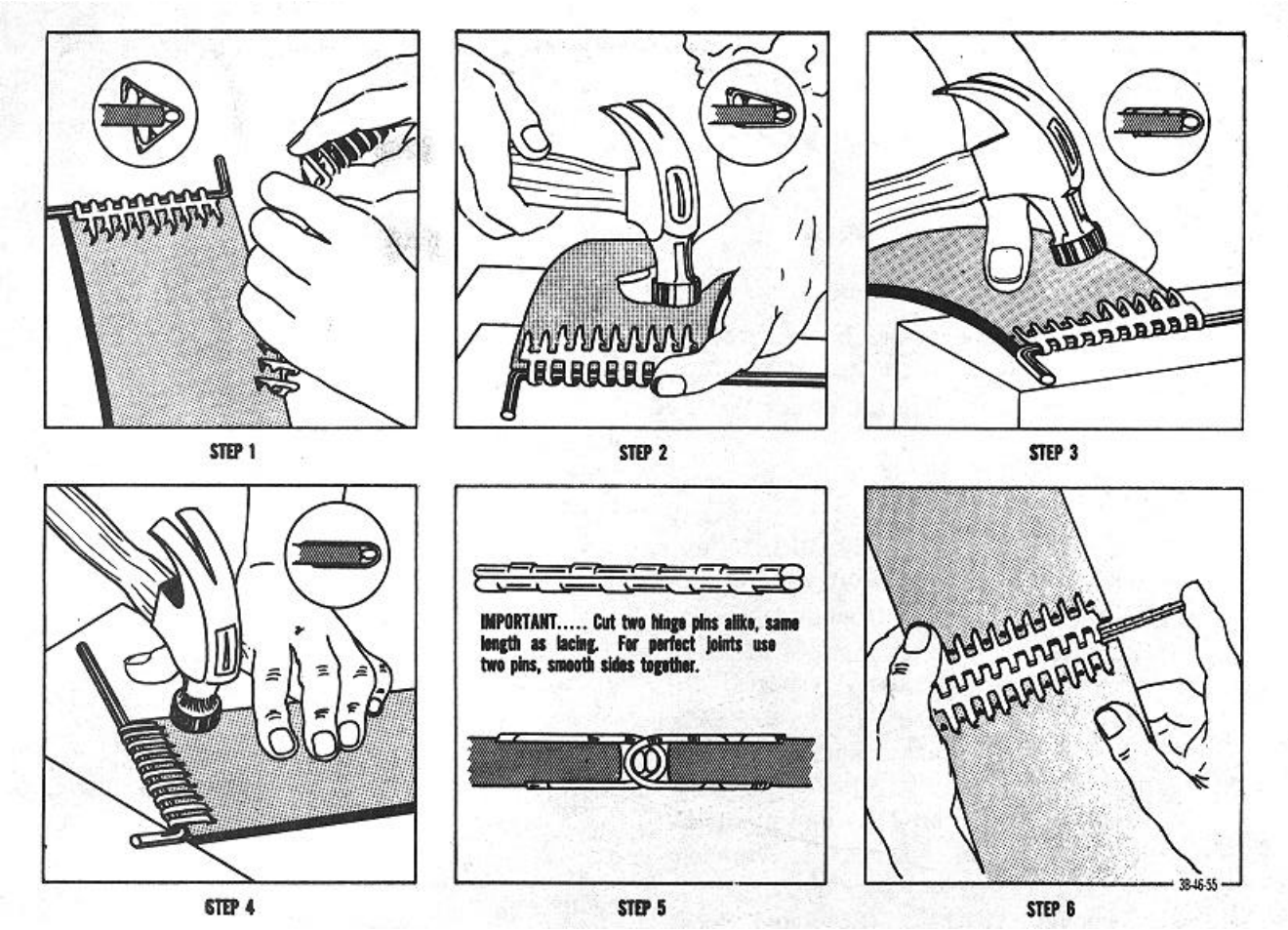


Figure 31. Lacing conveyor belt.

64. Dough Box Cylinder

a. Inspection.

(1) Inspect dough box cylinder (4, fig. 30) for cleanliness, excessive oil, and mechanical defects.

(2) Be sure cylinder is not scraping dough box as it rotates.

b. Adjustment. Adjust bearing blocks by placing shims both under and behind the blocks. Loosen a capscrew which holds divider block to divider on each side of cylinder and insert shims carefully until cylinder does not rub.

65. Dough Knife, Plunger, Links, and Piston

To replace the knife, plunger, links, or piston, follow instructions in TM 10-7360-201-10.

66. Dough Box Assembly

a. Removal.

(1) Remove four acorn nuts and two clamp bars from divider hopper.

(2) Slide hopper to rear and lift it off.

(3) Remove four bolts from dough box.

(4) Lift out dough box, being careful not to bend pins.

(5) Remove knife and plunger (TM 107360-201-10).

b. Inspection. Inspect inside of dough box for cleanliness and any signs of damage.

c. Cleaning.

(1) Scrape off as much dough as possible with scraper.

(2) Remove remaining particles of dough with a cloth dipped in divider oil.

(3) Finish cleaning dough box with another clean cloth dipped in divider oil.

d. Installation. Reverse procedures in *a* above.

67. Divider Gear Reduction Unit

a. To gain access to the gear reduction unit (3, fig. 22), open side access doors.

b. Listen for unusual noises in gear reduction unit when divider motor is operating.

c. Check bearings for excessive play.

68. Divider Oil Pump Assembly

a. Removal.

(1) Raise oil reservoir (fig. 32) to unhook it, and lift reservoir off.

(2) Disconnect feeder line at pump body.

(3) Remove two nuts (16, fig. 33) at lower end of drive rod (18).

(4) Remove two capscrews (12) and nuts (15) holding bracket and pump body (7) to support.

(5) Remove lever stud (11) and nut (14) and free pump lever (17). Remove lower part of pump assembly.

(6) Remove capscrew (24) and lockwasher (23) from rod bearing collar (22).

(7) Remove drive rod (18) with bearing clamp (20).

b. Disassembly.

(1) Remove two capscrews (19) and nuts (25) from rod and clamp.

(2) Remove clamp (20) and bearing (21) from drive rod.

(3) Press out collar (22) and bearing (21).

(4) Remove cotter pin from shaft with piston (13) and remove shaft with piston, compression spring (10), and washer.

(5) Remove pump body nut (9).

(6) Remove snap ring (1) and clamp ring (2).

(7) Remove elements (8 and 4) and gasket (5).

(8) Remove inlet valve, gasket (6), and outlet valve (8).

c. Cleaning. Wash all parts in SD.

d. Inspection and Repair. Check all parts carefully for wear or damage that would make them unserviceable. Install new parts as necessary.

e. Assembly. Reverse procedures in b above.

f. Installation. Reverse procedures in *a* above.

69. Magnetic Starter Pushbutton Unit

The magnetic starter pushbutton unit (older models) is located on the front of the divider conveyor, to the right of the 'molder pushbutton unit.

a. Removal and Disassembly.

(1) Disconnect source of current.

(2) Remove cover of pushbutton unit.

(3) Remove switch from box.

(4) Disconnect three wires from contacts by loosening screws.

b. Inspection. Inspect switch for proper operation. Check for evidence of burning 'tom short circuits.

c. Assembly and Installation. Reverse procedures in a above.

70. Magnetic Starter Assembly

The magnetic starter assembly (older units) is located just behind the divider motor, close to the motor drive shaft and to the right of the molder magnetic starter.

a. Removal and Disassembly.

(1) Disconnect leads and tag them for identification.

(2) Remove rear stationary contacts by disconnecting four .leads to flash guard unit and removing screw and lockwasher from each contact.

(3) Remove movable contact fingers by removing two screws and lockwashers and taking movable contact block from contactor.

(4) Remove movable contacts and springs by removing screw and lockwasher from each contact.

(5) Remove two screws, lockwashers, and flat washers from each thermal release and remove both releases.

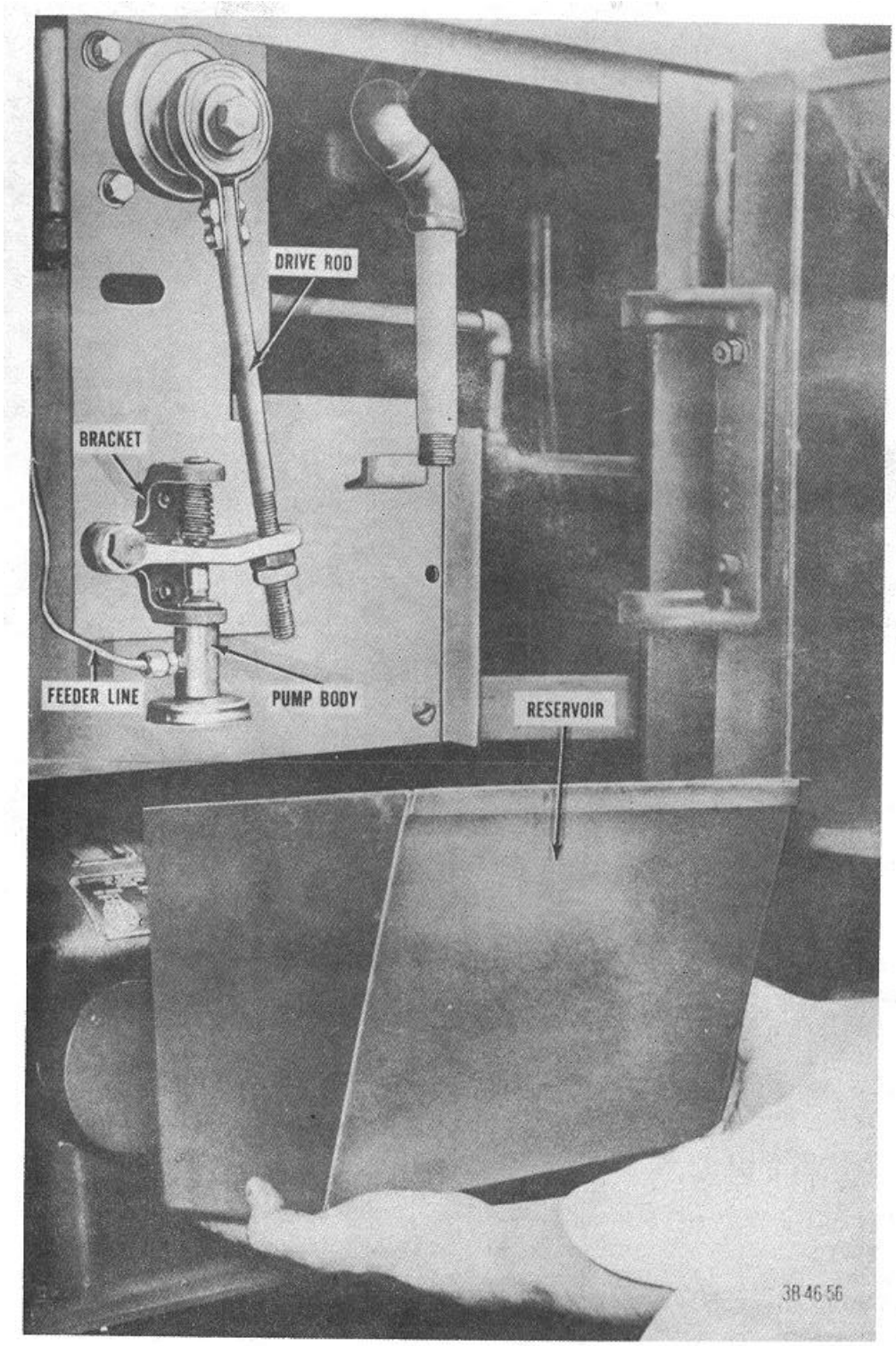
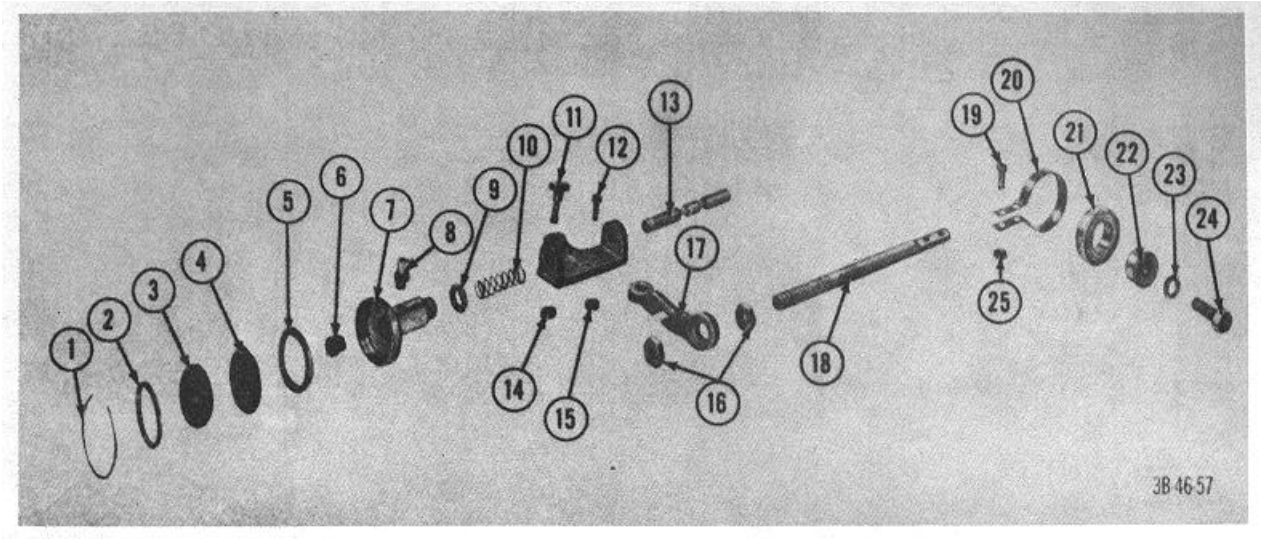


Figure 32. Removing divider oil reservoir.



1 Ring snap, filter disk
2 Ring, clamp, filter disk
3 element, sediment strainer, filter disk
4 Element, sediment strainer, filter disk support
5 Gasket, filter disk
6 Gasket, inlet valve
7 Body, pump
8 Valve, outlet
9 Nut, body
10 Spring, compression helical
11 Stud, lever
12 Capscrew
13 Shaft with piston
14 Nut
15 Nut
16 Nut
17 Lever, oil pump
18 Rod, drive
19 Capscrew, clamp, drive rod bearing
20 Clamp, loop, drive rod bearing
21 Bearing, ball, drive rod
22 Collar, shaft, drive rod bearing
23 Lockwasher
24 Capscrew, collar, drive rod bearing
25 Nut

Figure 33. Divider oil pump, exploded view.

(6) On units having heater coils, remove two screws from each side of coil and remove coil.

b. Inspection and Repair.

(1) Inspect parts for dust, dirt, and grease.

(2) Inspect contact points for burns or bad pits.

(3) Inspect condition of thermal release and cogs.

(4) Replace defective items with serviceable parts.

c. Assembly and Installation. Reverse procedures in *b* above.

71. Manual Starter Assembly

The manual starter (newer models) is located on the front of the divider conveyor (12, fig. 30).

a. Removal.

(1) Be sure current is off.

(2) Remove cover from box and disconnect wires from terminals.

(3) Remove setscrews holding switch to box and remove starter.

b. Inspection.

(1) Inspect condition of wire terminals and heater coils.

(2) Check for any broken or cracked parts.

(3) Be sure contacts are clean and serviceable.

c. Repair.

(1) Replace any burned out heater coil with another of correct rating. To replace coil, remove two setscrews holding coil to starter.

(2) Use fine sandpaper (00) to clean contact points.

d. Installation. Reverse procedures in *a* above.

Section VI. MIXER

72. Mixer Assembly

a. Inspection. Inspect components of mixer assembly to be sure they operate properly, are clean, and are securely installed.

b. Adjustment.

(1) To adjust drive chain tension, loosen capscrews mounting motor and gear reduction unit and place shims undereduction unit.

(2) To correct alinement of drive sprocket and chain, place shims under motor support on left side of motor.

73. Mixer Front Door Leather Cushions

a. Inspection. Inspect small leather cushions on either side of mixer front door to be sure they extend far enough to keep the door from rattling. Check cushions for deterioration.

b. Removal.

(1) Drill or drive out rivets holding leather cushions to door.

(2) Remove cushions.

c. Installation. Reverse procedures in *b* above.

74. Mixer Bowl Assembly

a. Inspect bowl cover to see that it operates and latches properly.

b. Check bowl for dents and open seams.

75. Agitator Eccentric Roller and Bushings

a. Removal.

(1) Remove small screws from caps enclosing eccentric roller bushings (fig. 34).

(2) Lift out roller and bushings.

(3) Remove bushing from each end of roller.

b. Inspection.

(1) Inspect roller surface for chips, cracks, or other damage.

(2) Inspect bushings for excessive wear and surface damage.

c. Installation. Reverse procedures in *a* above.

76. Agitator Small Roller and Bushings

Follow the procedures in paragraph 75.

77. Agitator Right and Left Shaft Bushings

a. Removal.

(1) Follow procedures in paragraph 93*a* (1) and (2).

(2) Remove water-transfer pump control valve handle by removing setscrew and loosening nut on bolt.

(3) Remove two nuts, lockwashers, and machine bolts on each end of brace supporting handle recess. Remove brace.

(4) Remove nut, washer, and machine screw from rod fork and remove rod and fork.

(5) Remove nut from left shaft rod.

(6) Remove agitator sprocket wheel (par. 81*a*).

(7) Remove left and right shaft bushings by prying them out evenly with a bar. Use a gear puller if necessary.

b. Inspection. Inspect bushings for wear, abrasions, and other damage.

c. Installation. Reverse procedures in *a* above, being sure bushing grease sump is facing upward.

78. Agitator Shaft Packing and Glands

a. To gain access to the packing and glands (fig. 35), remove agitator left and right shaft assemblies (par. 79*a*).

b. Inspect glands for wear and abrasions.

c. Inspect packing for glazed condition.

d. Check to be sure there is enough packing and that the joints are staggered.

79. Agitator Right and Left Shaft Assemblies

a. Removal.

(1) Remove shaft bushings (par. 77*a*).

(2) Remove left and right shafts (fig. 35).

b. Inspection. Inspect shafts for wear and leaking grease.

c. Installation. Reverse procedures in a above.

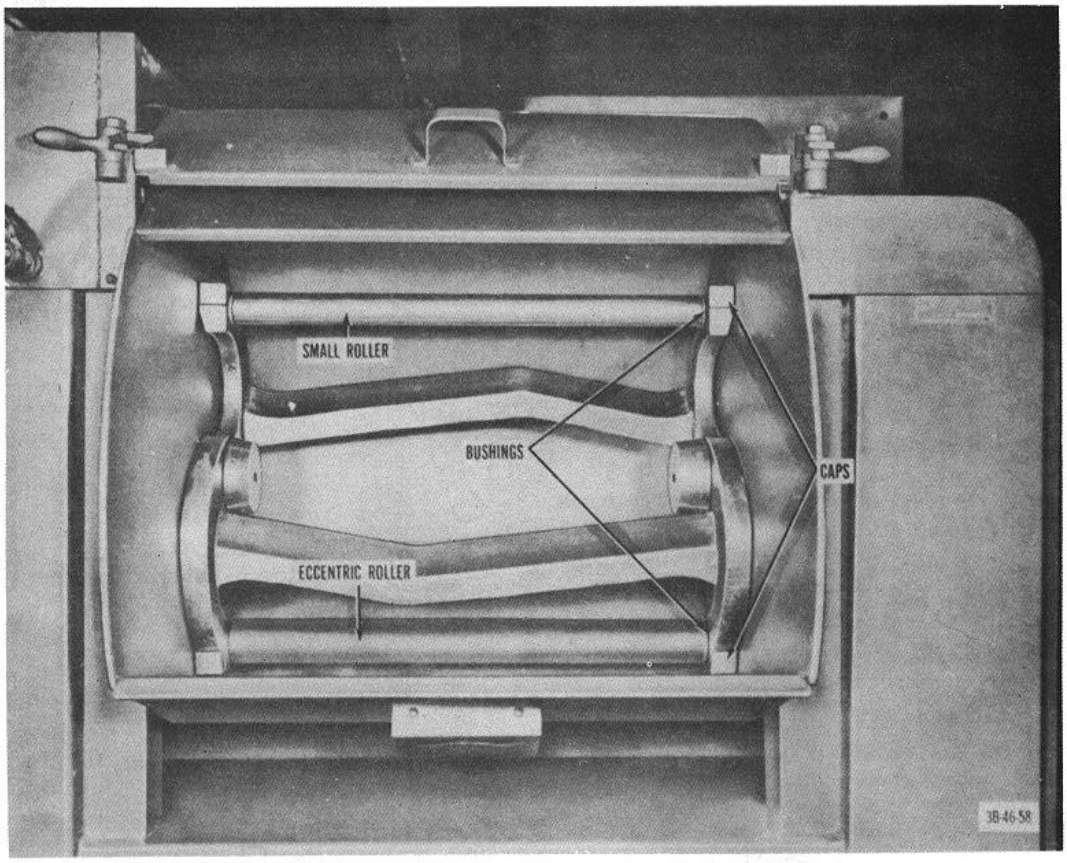


Figure 34. Agitator rollers.

80. Agitator Shaft Rods

a. Removal.

(1) *Right shaft rod.*

(a) Remove capscrews and washers from right finish panel of mixer and remove panel.

(b) Remove nut (fig. 35) at end of threaded rod.

(c) Drive rod back into mixer bowl and remove rod.

(2) *Left shaft rod.*

(a) Follow procedures in paragraph 77*a*(1) through (5).

(b) Drive rod back into mixer bowl and remove rod.

b. Inspection. Inspect rods for bends, breaks, and other damage and check condition of threads.

c. Installation. Reverse procedures in *a* above.

81. Agitator Sprocket Wheel

a. Removal.

(1) Remove agitator drive chain (par. 51).

(2) Remove nut, lockwasher, and flat washer from right shaft threaded rod (fig. 35).

(3) Remove sprocket wheel and key.

b. Inspection. Inspect wheel for broken cogs, chips, or cracks.

c. Installation. Reverse procedures in a above.

82. Mixer Bowl Dump Assembly

Operate mixer bowl dump handwheel (fig.

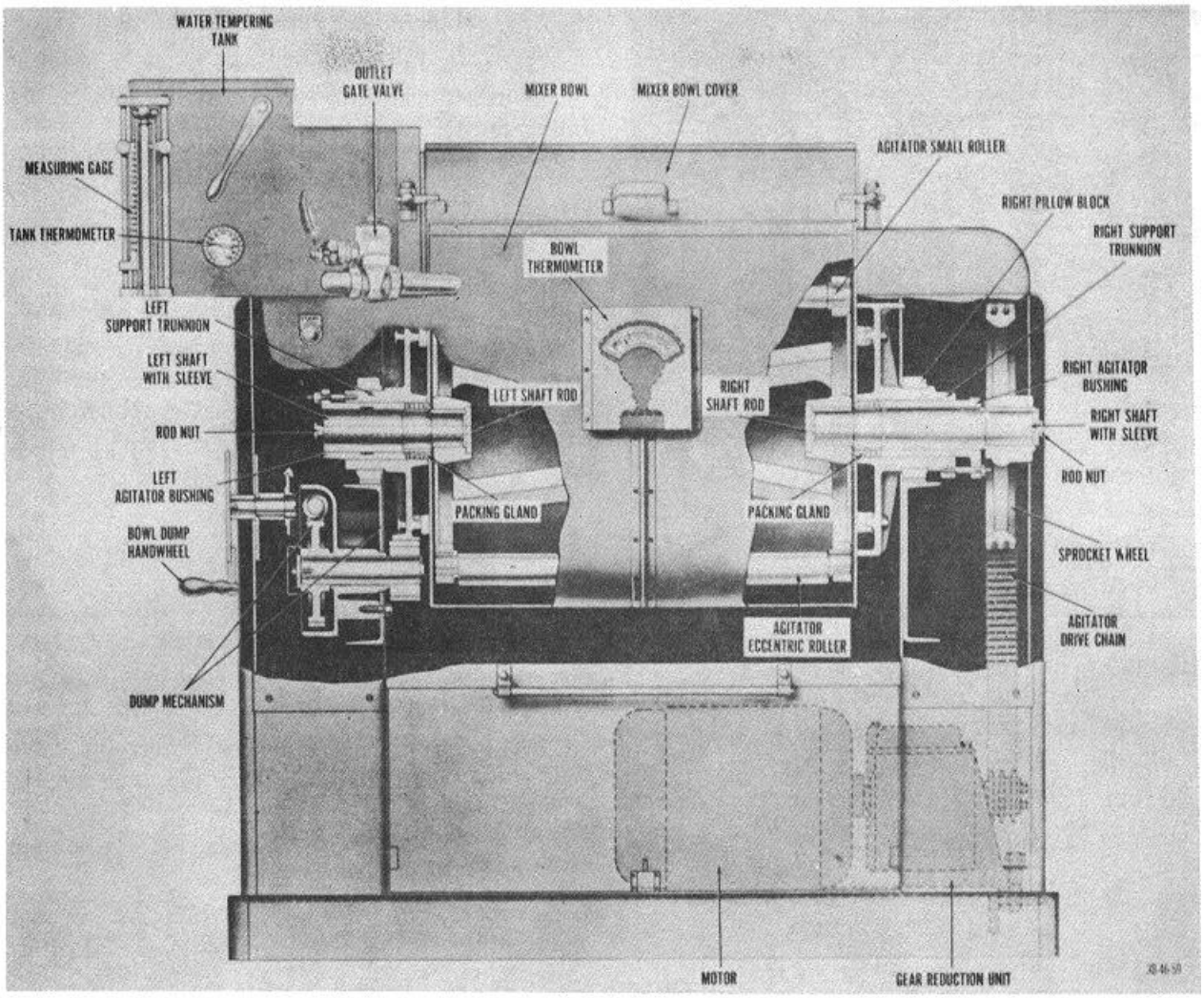


Figure 35. Mixer assembly, phantom view.

35) to be sure it moves freely. Check capscrew holding handwheel to wormshaft to be sure it is secure.

83. Mixer Gear Reduction Unit

a. Remove bolts from cover of reduction unit (fig. 35) and remove cover and gasket.

b. Check unit for sufficient lubricant, signs of wear, and misalinement.

c. Shake shafts and check for bearing wear.

d. Install gasket, cover, and cover bolts.

84. Gear Reduction Unit Oil Level Gage

a. *Inspection*. Check gage for broken glass or other damage.

b. *Replacement*. If gage is defective, unscrew it from housing and install a serviceable gage.

85. Mixer Pillow Blocks

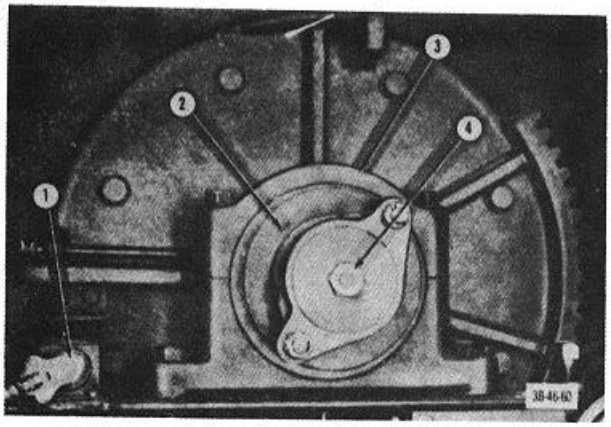
a. To gain access to the right pillow block (fig. 35), remove agitator sprocket wheel (par. 81*a*).

b. To gain access to the left pillow block (3, fig. 36), follow procedures in paragraph 93*a*(1) and (2).

c. Be sure pillow blocks are securely installed and shake shafts to check for pillow block wear.

86. Mixer Motor Magnetic Starter

To gain access to the mixer motor magnetic starter, raise mixer front door.



1 Switch, limit
2 Trunnion, left support
3 Block, left pillow
4 Nut, shaft rod

Figure 36. Pillow block, left side.

a. Removal.

(1) Remove lead wires and tag them for identification.
(2) Remove four capscrews and lockwashers from reset unit and remove reset unit.

b. Disassembly.

(1) Remove two screws from each of the three clamps holding movable contacts to bar.
(2) Remove three capscrews and take off three stationary contacts.
(3) Remove arc guards, remove two screws from guard on back of relay, and remove guard.
(4) Remove cotter pin and nut from relay end of bar, pull bar to right, and remove relay armature and coil.
(5) Remove and tag leads from relay coil.

c. Inspection and Repair.

(1) Inspect all parts for grease, dust, or dirt.
(2) Inspect contact points for pits or bad burns and remove rough edges with fine sandpaper.
(3) Inspect heater coils; if defective, install new coils of proper rating.
(4) Replace defective parts with serviceable items.

d. Assembly. Reverse procedures in *b* above.

e. Installation. Reverse procedures in *a* above.

87. Magnetic Starter Pushbutton Units

The magnetic starter jog, start, and stop pushbutton units are located at the left of the mixer bowl.

a. Removal.

(1) Remove cover from unit.
(2) Turn knurled knob on front of unit counterclockwise and release unit.
(3) Disconnect lead wires and free unit.

b. Inspection. Inspect unit for proper operation. Check for burns caused by short circuits. If unit is defective, install serviceable item.

c. Installation. Reverse procedures in *a* above.

88. Mixer Limit Switch

a. Removal.

(1) Remove two setscrews and washers from cover of limit switch (1, fig. 36), remove cover, and remove insulating cover.
(2) Disconnect leads, disconnect BX cable from connector at switch, and remove cable.
(3) Remove two screws in center of switch and lift switch from box.

b. Inspection. Inspect switch for proper operation and check for any evidence of short circuits.

c. Repair. If either finger support contact or contact assembly is defective, install a serviceable item.

d. Installation. Reverse procedures in *a* above.

89. Mixer Bowl Dial Thermometer

a. Removal.

Note. The indicator, sensitive element, and capillary tube are a unit and must be handled without kinking or straining the tubing.

(1) Remove four screws and lockwashers from cover plate of mixer bowl thermometer (fig. 35) and take off cover plate.
(2) Turn dump handwheel until thermometer bulb holder is in good position for removal.
(3) Remove six screws from bulb plate

and four small screws near center of plate.

(4) Remove plate and gasket.
(5) Remove two capscrews and lockwashers holding thermometer dial to support.
(6) Remove 12 screws in capillary tube cover strip, between dial and bulb, and remove cover strip.
(7) Remove entire thermometer assembly.

b. Inspection.
(1) Inspect glass cover of thermometer for breakage.
(2) Inspect condition of gasket.
(3) Inspect capillary tube for breaks, flat spots, or other damage.

c. Repair.
(1) If gasket is defective, install a new one.
(2) Install a new thermometer assembly if any part is unserviceable.

d. Installation. Reverse procedures in a above.

90. Water-Transfer Pump Toggle Switch

The pump toggle switch is located at the left of the mixer bowl, between the bowl and pushbuttons.

a. Removal.
(1) Remove four setscrews on outside of switch and take off cover plate.
(2) Remove four setscrews on inside of cover plate and remove gasket.
(3) Remove two setscrews holding switch, disconnect leads, and remove entire switch.

b. Inspection. Inspect switch for proper operation and be sure wires are in good condition.

c. Repair. If switch, gasket, or cover plate are damaged, install serviceable items.

d. Installation. Reverse procedures in a above.

91. Water-Tempering Tank Measuring Gage

a. Removal and Disassembly.
(1) Loosen setscrews in top of support and slide large rods down and off gage (fig. 35).
(2) Remove two nuts from lower ends of small rods, lift rods up, and remove rods from bar.
(3) Slide pointers off rods and remove knurled adjusting knobs.
(4) Unscrew hexagon bosses with gaskets that hold gage window to elbows and remove window.
(5) Unscrew and remove elbows.

b. Inspection.
(1) Inspect glass window for cracks or chips.
(2) Check gaskets and threaded connections.
(3) Be sure all rods are straight and that pointers slide easily and are not bent or damaged.

c. Repair. If window, elbows, pointers, or knobs are damaged, replace them with serviceable items.

d.. Assembly and Installation. Reverse procedures in *a* above.

92. Water-Tempering Tank Dial Thermometer

a. Removal.
(1) Unscrew nut holding thermometer (fig. 35) to nipple.
(2) Remove thermometer.

b. Inspection and Repair. Inspect the thermometer glass to be sure it is not broken and check to see that there are no leaks around threads. If defective, install a serviceable thermometer.

c. Installation. Reverse procedures in a above.

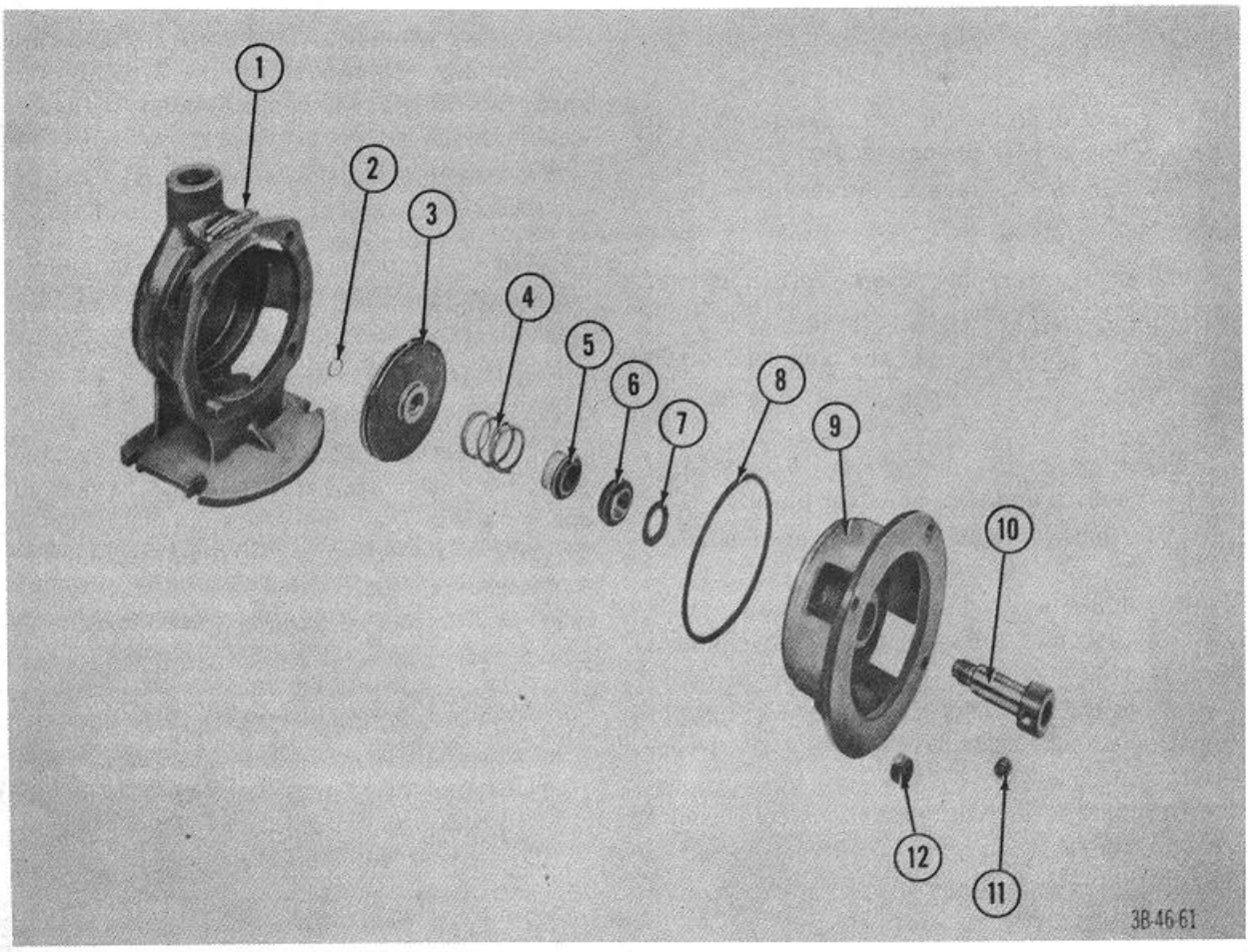
93. Water-Transfer Pump Assembly

a. Removal.
(1) Remove dump handwheel (fig. 35) from side of mixer by removing center capscrew and key.
(2) Take out four capscrews, washers, and lockwashers from mixer left finish panel. Remove panel.
(3) Remove nut, washer, and machine screw from fork on control valve rod, and free rod from valve.

(4) Remove three bolts and lockwashers from control valve support.
(5) Rotate control valve support and connections, unscrew valve from elbow located on outlet side of valve, and remove control valve.
(6) Break water supply pipe and primer pipe at their unions.
(7) Disconnect wiring from switchbox.
(8) Remove four mounting bolts and washers and lift motor, pump, and attached pipes and connections from trailer.
(9) Remove pipes and connections from pump.
(10) Remove two setscrews holding pump shaft to motor.
(11) Remove four nuts and separate pump from motor.

b. Disassembly.

(1) Remove pump packing cover from volute.
(2) Remove performed packing (8, fig. 37) from cover.
(3) Remove impeller retaining ring (2), unscrew impeller shaft (10), and remove impeller (3).
(4) Remove spring (4) and seal (5).
(5) Remove wear ring (6), gasket (7), and impeller shaft slinger.



1	Body, pump	5	Seal, shaft	9	Cover
2	Ring, impeller retaining	6	Ring, wear	10	Shaft, impeller
3	Impeller	7	Gasket	11	Slinger, oil
4	Spring	8	Packing, performed, pump cover	12	Nut

Figure 37. Water-transfer pump, exploded view.

c. Inspection and Repair.
(1) Inspect shaft for scoring.
(2) Check impeller for wear, cracks, or stripped threads.
(3) Inspect condition of packing.
(4) Inspect wear ring for damage and check spring tension.
(5) Replace defective items with serviceable parts.

d. Assembly. Reverse procedures in *b* above.

e. Installation. Reverse procedures in *a* above.

94. Check Valves

a. Removal.
(1) Remove -nipples from check valves.
(2) Remove valves.

b. Inspection. Inspect valves for leaks and check condition of threads.

c. Installation. Reverse procedures in a above.

95. Control Valve

a. Removal. Follow procedures in paragraph 93a(1) through (5).

b. Inspection. Inspect valve for leaks and check condition of threads.

c. Installation. Reverse procedures in paragraph 93*a*(1) through (5).

96. Outlet Gate Valve

The outlet gate valve (fig. 35) is located on the front of the water-tempering tank, next to the mixer bowl.

a. Removal and Disassembly.
(1) Remove nut that secures valve handle to stem.
(2) Remove valve handle.
(3) Remove two nuts, U-bolt, and three capscrews from support and remove support from mixer.
(4) Unscrew and remove valve.
(5) Remove valve cap.
(6) Remove packing gland nut on shaft.
(7) Remove locknut holding shaft to valve and free shaft.

b. Inspection.
(1) Inspect all connections for stripped threads, leaks, and other defects.
(2) Check condition of packing.

c. Assembly and Installation. Reverse procedures in *a* above.

Section VII. MOLDER

97. Molder Assembly

Inspect components of molder assembly to be sure they operate properly, are clean, and are securely installed.

98. Dough Curler Belt

a. Inspection.
(1) Check belt (11, fig. 30) for broken links and frayed edges.
(2) Be .sure fastening rivets are secure.

b. Replacement.
(1) Loosen end support thumbscrews and lift bolt off.
(2) Instill serviceable belt and tighten thumbscrews.

99. Molder Conveyor Belt

a. Inspection.
(1) Inspect belt (14, fig. 30) for tears, rips, and other damage.
(2) Be sure belt is clean.
(3) Check belt tension, alinement, and lacing.

b. Replacement. To replace belt, withdraw hinge -pins, remove belt, and follow procedures in paragraph 58*b*.

100. Conveyor Belt Drive Shaft Hub With Sprocket

a. Removal.
(1) Remove conveyor belt drive chain (par. 50*a*(2) and *c*).
(2) Loosen setscrew in hub and remove hub with sprocket (4, fig. 26) and woodruff key.

b. Inspection. Inspect hub with sprocket for cracks, broken or worn teeth, and chipped places.

c. Installation. Reverse procedures in *a* above.

101. Pressure Board Assembly

a. Inspection.

(1) Inspect board for surface damage.

(2) Be sure metal plate on board is securely fastened and that wood screws do not protrude.

b. Replacement. Follow procedures in TM 10-7360-201-10.

102. Conveyor Belt Drive Pulley

a. Removal.

(1) Withdraw hinge pins from conveyor belt and remove belt.

(2) Remove setscrew from hub with sprocket on rear of drive pulley shaft (fig. 38). Remove hub with sprocket and woodruff key.

(3) Remove setscrew in collar on each end of shaft and remove both collars.

(4) Remove bearing from each end of shaft.

(5) Lift shaft with pulley from molder.

(6) Drive out tapered pins from wooden pulley.

(7) Slide shaft out of pulley.

b. Inspection. Inspect pulley for cracks, splinters, rough surface, and other damage. Be sure pulley is clean.

c. Installation. Reverse procedures in a above.

103. Conveyor Belt Idler Pulley

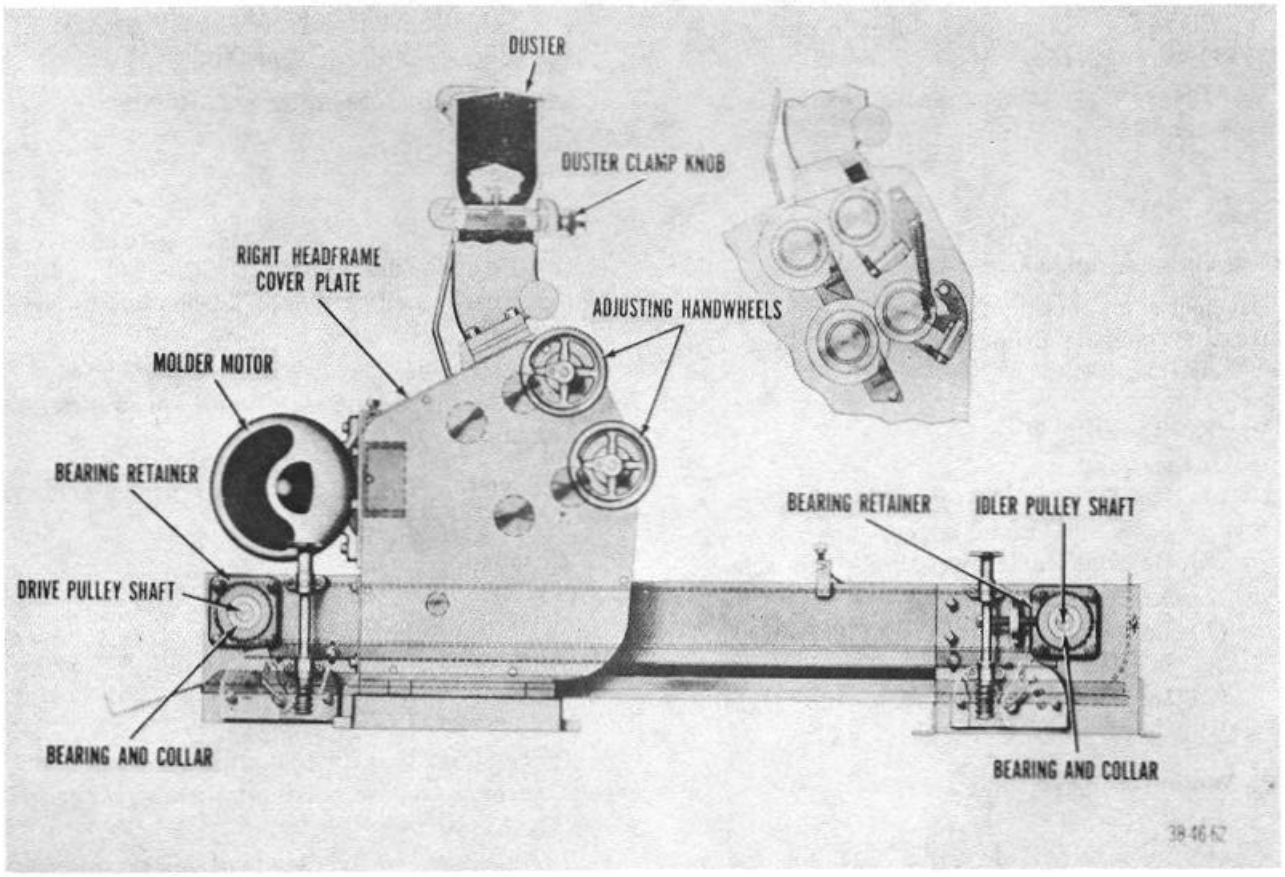
a. Removal.

(1) Withdraw hinge pins from conveyor belt and remove belt.

(2) Remove setscrew in collar on each end of idler pulley shaft (fig. 38), and remove both collars.

(3) Remove bearing from each end of shaft.

(4) Lift shaft with pulley from molder.



(5) Drive out tapered pins from pulley.
(6) Slide shaft out of pulley.

b. Inspection. Refer to paragraph 102*b*.

c. Installation. Reverse procedures in a above.

d. Adjustment. Refer to the operator's manual (TM 10-7360-201-10).

104. Sheeting Roll Duster Bearings

a. To gain access to the duster bearings (fig. 39), remove duster agitator regulating lever (par. 109*a*).

b. Move shaft and check bearings for wear.

c. Install regulating lever (par. 109*c*).

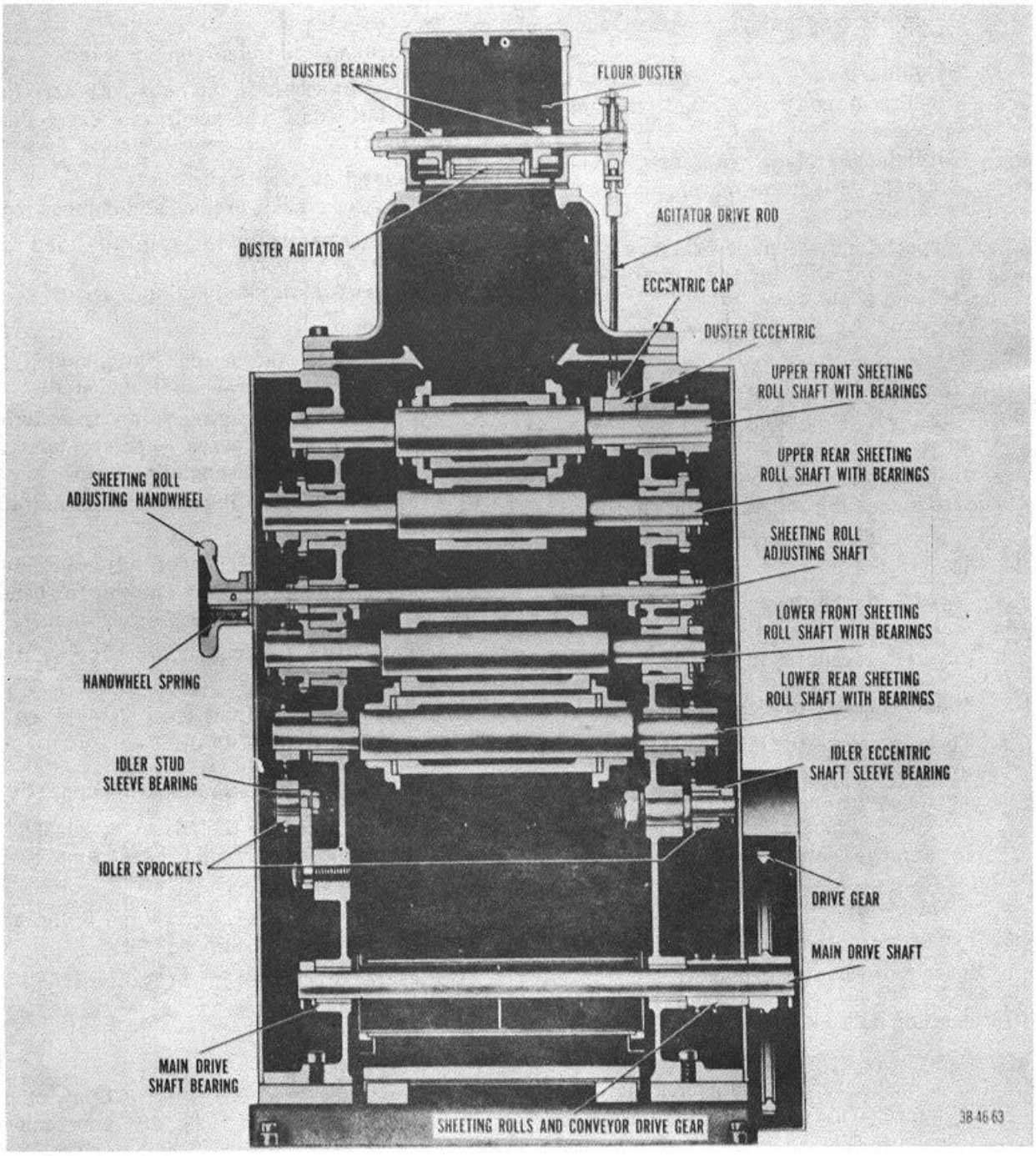


Figure 39. Molder sheeting rolls, phantom view.

105. Sheeting Roll Shaft Bearings

a. To gain access to these bearings, remove left and right headframe cover plates as follows:

(1) Remove drive gear (par. 107*a*).
(2) Remove eight capscrews securing left headframe cover plate and remove plate.
(3) Free adjusting headwheels (fig. 38) by driving out pins with a punch of proper size.
(4) Slide handwheels off shafts, being careful not to lose ball clicking devices.
(5) Remove eight capscrews securing right headframe cover plate and remove plate.

b. Inspect four eccentric bearings on lower and upper front sheeting roll shafts (10 and 2, fig. 27, and 2 and 4, fig. 28).

c. Inspect two drive shaft sleeve bearings (fig. 39).

d. Inspect four rear sheeting roll shaft bearings (fig. 39) by moving shafts to check for bearing wear.

e. Inspect four sleeve bearings on lower and upper front sheeting roll adjusting shafts.

f. Inspect idler eccentric shaft sleeve bearing (fig. 39).

g. Inspect idler sprocket stud sleeve bearing (fig. 39).

h. Reverse procedures in *a* above.

106. Sheeting Roll Shaft Eccentric

a. To gain access to the eccentric (fig. 39), proceed as follows:

(1) Remove duster agitator drive rod (par. 112*a*).
(2) Remove setscrews from upper and lower eccentric caps (fig. 39) and remove caps.

b. Inspect eccentric for chips and cracks.

c. Reverse procedures in *a* above.

107. Sheeting Rolls and Conveyor Drive Gear

a. Removal.

(1) Remove capscrews holding chain guards (6 and 7, fig. 23) and remove guards.
(2) Lower motor (3, fig. 26) on base and remove drive chain (1).
(3) Remove setscrews holding drive gear (6) to shaft and remove gear and woodruff key.

b. Inspection. Inspect gear for cracks, breaks, and chipped teeth.

c. Installation. Reverse procedures in *a* above.

108. Sheeting Roll Hubs With Sprockets

a. To gain access to the hubs with sprockets, remove left and right headframe cover plates (par. 105a).

b. Inspect hubs with sprockets (3, fig. 27 and 1, fig. 28) for cracks, breaks, and chipped teeth.

c. Reverse procedure in paragraph 105*a*.

109. Duster Agitator Regulating Lever

a. Removal.

(1) Unscrew adjusting stud handle (fig. 40) and remove handle and stud.
(2) Unscrew engaging screw from agitator shaft. Loosen setscrews and remove pin from engaging screw.
(3) Slide regulating lever off agitator shaft.

b. Inspection. Inspect lever, adjusting stud, stud handle, engaging screw and pin for bends, breaks, stripped threads, and other damage.

c. Installation. Reverse procedures in *a* above.

d. Adjustment. Adjust lever as directed in operator's manual (TM 10-7360-201-10).

110. Sheeting Roll Adjusting Shaft Pinions

a. To gain access to the adjusting shaft pinions, remove left and right headframe cover plates (par. 105*a*).

b. Inspect pinions (1, fig. 27 and 3, fig. 28) for cracks, breaks, and chipped teeth.

c. Reverse procedures in paragraph 105*a*.

111. Motor Shaft Pinion

a. Removal.

(1) Remove capscrews holding chain guards (6 and 7, fig. 23) and remove guards.

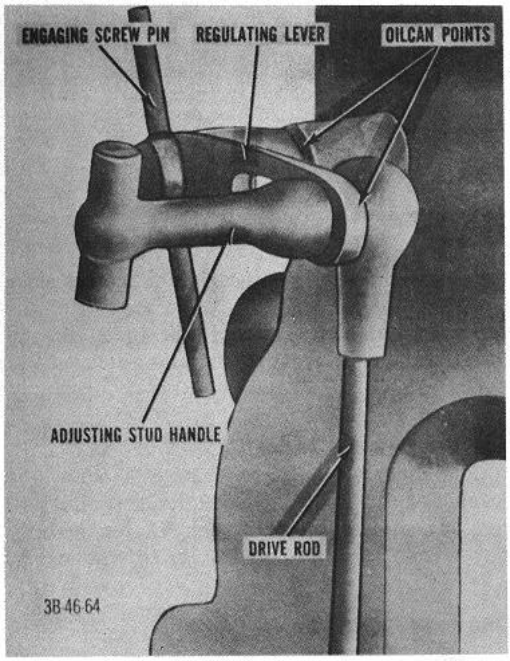


Figure 40. Duster agitator regulating lever.

(2) Lower motor (3, fig. 26) on adjustable base and remove drive chain (1).
(3) Remove two cotter pins from pinion (2) and slide pinion off shaft.

b. Inspection. Inspect pinion for breaks, cracks, and chipped teeth.

c. Installation. Reverse procedures in a above.

112. Duster Drive Rod

a. Removal.

(1) Unscrew adjusting stud handle (fig. 40) and remove handle and stud.
(2) Unscrew drive rod to free it from the eccentric cap (fig. 39).

b. Inspection. Inspect rod for bends and other damage and be sure threads are not stripped.

c. Installation. Reverse procedures in a above.

113. Sheeting Roll Duster Screen

a. Removal.

(1) Remove duster agitator regulating lever (par. 109*a*).
(2) Loosen duster clamp knobs (fig. 38).
(3) Slide clamps out of the way.
(4) Remove duster and empty flour from it.
(5) Remove four screws holding screen to bottom of duster and remove screen.

b. Inspection. Inspect screen for breaks and tears and be sure it is clean.

c. Installation. Reverse procedures in *a* above.

114. Sheeting Roll Shaft Assemblies

Inspect sheeting roll shafts (fig. 39) for cracks, chips, and other damage. Check shafts for looseness.

115. Sheeting Rolls and Conveyor Drive Shaft

a. Removal.

(1) Remove left and right headframe cover plates (par. 105*a*).
(2) Drive shaft (7, fig. 27) from left side, out through right headframe.

b. Inspection. Inspect shaft for wear at bearing positions.

c. Installation. Reverse procedures in a above.

116. Sheeting Roll Adjusting Handwheel Springs

a. Removal.

(1) Remove setscrew from front of handwheel (fig. 39).
(2) Remove spring.
(3) Repeat procedure for other handwheel spring.

b. Inspection. Inspect springs for fatigue or breakage.

c. Installation. Reverse procedures in *a*(1) and (2) above.

117. Idler Sprocket Tension Spring

a. Removal.

(1) Remove right headframe cover plate (par. 105*a*(3) through (5)).
(2) Disconnect tension spring (8, fig. 28).

b. Inspection. Inspect spring for fatigue or breakage.

c. Installation. Reverse procedures in *a* above.

118. Sheeting Roll Shaft Sprocket Wheels

a. Removal.

(1) Remove left and right headframe cover plates (par. 105*a*).
(2) Remove master link in chain (4, fig. 27) and remove chain from sprocket wheel (9).
(3) Remove setscrew from sprocket wheel and remove wheel.
(4) Remove master link in chain (11, fig. 28) and remove chain from sprocket wheels (5 and 10).
(5) Remove setscrews from sprocket wheels and remove wheels.

b. Inspection. Inspect sprocket wheels for excessive wear, cracks, and broken teeth.

c. Installation. Reverse procedures in *a* above.

119. Magnetic Starter Pushbutton Unit

The magnetic starter pushbutton unit (older models) is located on the front of the divider conveyor, to the left of the divider pushbutton unit. Refer to paragraph 69 for maintenance instructions applicable to this pushbutton unit.

120. Magnetic Starter Assembly

The magnetic starter assembly (older units) is located just behind the divider motor, close to the motor drive shaft and to the left of the divider magnetic starter. Refer to paragraph 70 for maintenance instructions applicable to this assembly.

121. Manual Starter Assembly

The manual starter (newer models) is located on the front of the divider conveyor (13, fig. 30). Refer to paragraph 71 for maintenance instructions applicable to this assembly.

Section VIII. MONORAIL SYSTEM

122. Dough Trough Carrier Assembly

a. Removal and Disassembly.

(1) Remove snap ring from carrier wheel bearing (fig. 41).
(2) Remove nut and washer from shoulder bolt.
(3) Remove bearing and grease seal.
(4) Remove shoulder bolt and carrier wheel.
(5) Remove nut, washer, and capscrew securing carrier headframe and remove frame.

b. Inspection and Repair. Inspect carrier assembly for damaged parts and install serviceable items as necessary.

c. Assembly and Installation. Reverse procedures in *a* above.

123. Monorail Latch Springs

a. Inspection. Inspect latch springs for fatigue and damage.

b. Replacement. If springs are defective, unhook them and install serviceable springs.

124. Monorail Wheels

Inspect the 16 monorail wheels with lubrication fittings to be sure they are not damaged and are properly lubricated.

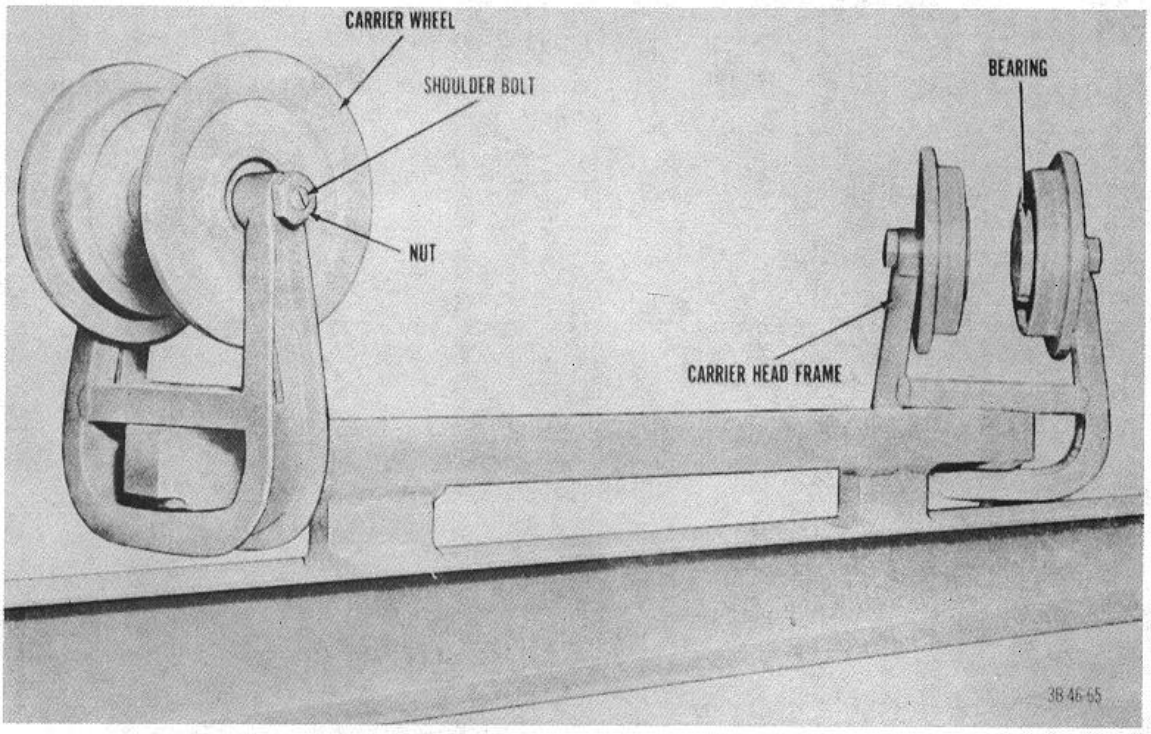


Figure 41. Dough trough carrier.

Section IX. OVEN TRAILER

125. General

The oven trailer is similar to the trailer used for the mixing and makeup outfit. Maintenance instructions for the oven blower motor are given in paragraph 126. Refer to paragraphs 17 through 41 for all other maintenance instruction applicable to the oven trailer chassis.

126. Oven Blower Motor

The blower motor (fig. 42) is interchangeable with the divider and molder motors.

a. Inspection.

(1) Inspect blower motor for overheating and overload.
(2) Check for proper lubrication and ventilation.
(3) Listen for grinding noises which indicate worn bearings causing rotor to drag against stator.
(4) Check for objects retarding free operation.

b. Removal.

(1) Remove cover from junction box and disconnect wiring to release cable. Tag wires for identification.
(2) Turn wingnut on motor adjustment to loosen V-belt.
(3) Remove V-belt.
(4) Remove nuts, capscrews, lockwashers, and flat washers holding motor to support and remove motor.

c. Installation. Reverse procedures in *b* above.

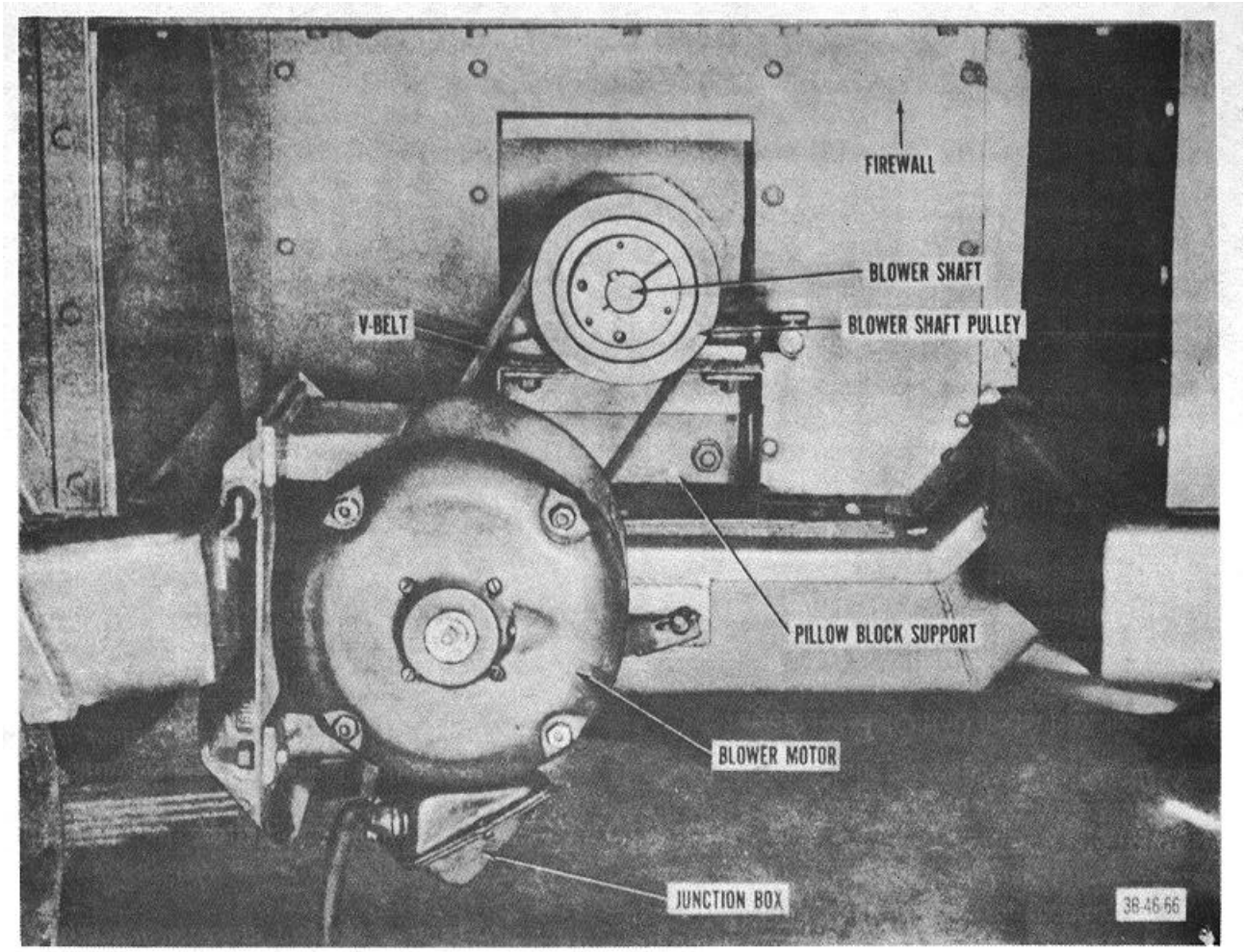


Figure 42. Blower motor, installed.

Section X. OVEN MACHINERY

127. Conveyor Drive Shaft Bearings

a. Removal.
(1) Remove takeup shaft collar (par. 130*a*(1) through (3)).
(2) Remove tapered pin from conveyor chain drive sprocket.
(3) Drive out shaft with drift and hammer.
(4) Remove capscrew and lockwasher from drive shaft bearing (G, fig. 10) and remove bearing.
(5) Repeat procedures to remove other three drive shaft bearings.

b. Inspection. Inspect condition of bearing surface and check for wear.

c. Installation. Reverse procedures in *a*(1) through (4) above.

128. Oven Door Shaft Bearings

a. Removal.
(1) Remove nuts holding oven door shaft bearing (F, fig. 10).
(2) Remove bearing from shaft and door.
(3) Repeat procedures for other three bearings.

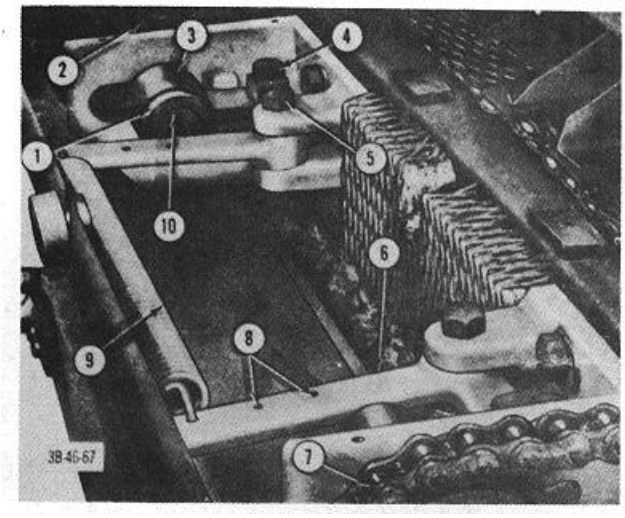
b. Inspection. Inspect condition of bearing surface and check for wear.

c. Installation. Repeat procedures in *a*(1) and (2) above.

129. Oven Blower V-Belt

a. Inspection. Inspect V-belt for stretching and wear.

b. Replacement. If V-belt is defective, turn wingnut on motor adjustment, slacken and remove



1 Collar, drive shaft
2 Wheel, sprocket, chain drive
3 Bracket with bearing
4 Capscrew, bracket
5 Capscrew, takeup lever
6 Lever, chain takeup
7 Chain, conveyor
8 Slots, adjustment, tension spring
9 Spring, tension
10 Shaft, drive, chain sprocket

Figure 43. Conveyor takeup mechanism.

V-belt, install new V-belt, and tighten wingnut.

130. Conveyor Takeup Bearings and Shaft Collars

a. Removal.

(1) Remove screws from edges and top of oven loading plate and loosen grooved strips on each side of plate. Remove plate.
(2) Disconnect tension spring and remove bolt from takeup lever.
(3) Remove setscrew from shaft collar and remove collar.
(4) Remove capscrew holding chain takeup bracket and lever and remove bracket with bearing. Press out bearing.
(5) Repeat procedures for other three bearings and collars.

b. Inspection. Inspect condition of bearings and collars; check for wear or damage.

c. Installation. Reverse procedures in *a*(1) through (4) above.

131. Fuel Tank Cap

Inspect the fuel tank cap for damage and install new cap if necessary.

132. Oven Conveyor Roller Chains

a. Removal.

(1) Using handcrank, turn conveyor roller chains until connecting links appear.
(2) Unhook tension spring (par. 130*a*(1) and (2)).
(3) Remove connecting links from chains and remove chains.
(4) Repeat procedure for chains on other deck.

b. Inspection. Inspect chains for wear, broken links, or other damage.

c. Installation. Reverse procedures in *a*(1) through (3) above.

d. Adjustment. To adjust chains, change location of tension spring.

133. Pressure Relief Sheets and Gaskets

a. Removal.

(1) Open upper relief sheet door on front of trailer.
(2) Remove eight wingnuts from studs holding retaining frame and remove frame.
(3) Lift off asbestos gasket and remove pressure relief sheet.
(4) Repeat procedures for lower relief sheet and gasket.

b. Inspection.

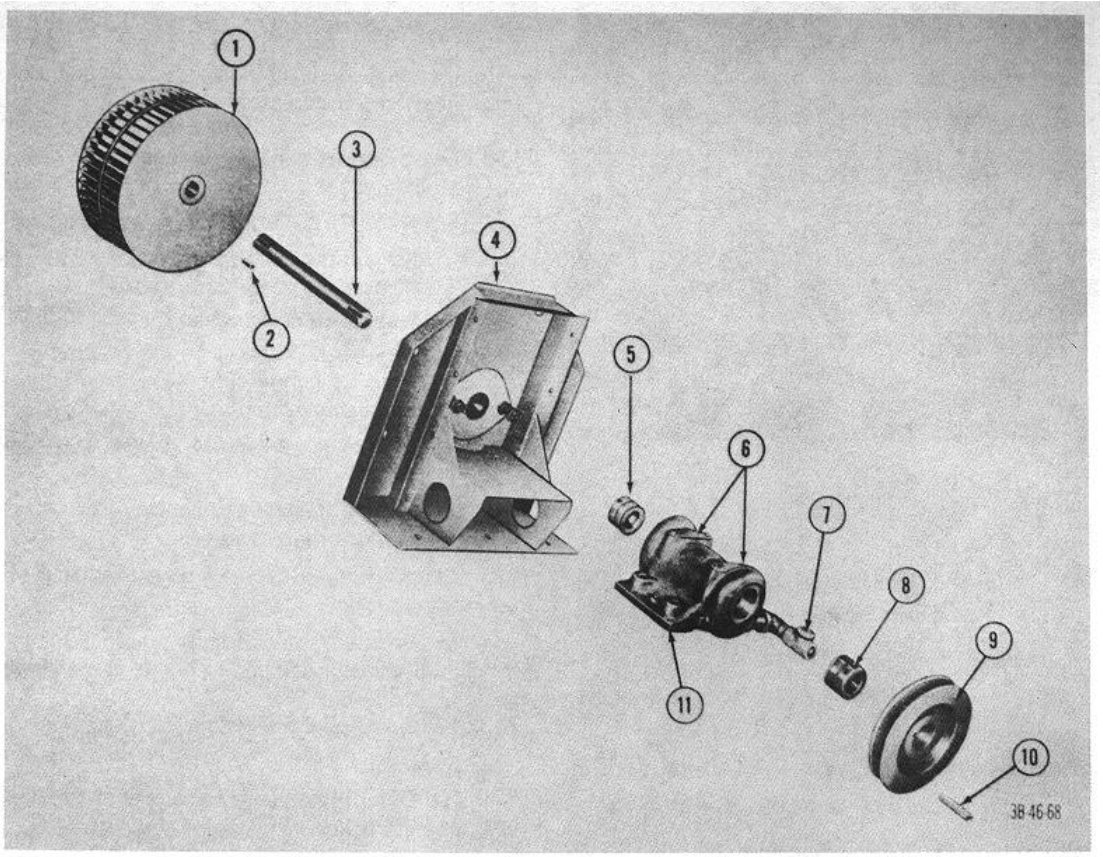
(1) Inspect pressure relief sheets for holes, breaks, or other damage.
(2) Inspect condition of metal-covered, asbestos gaskets and be sure gaskets fit properly.

c. Installation. Reverse procedures in *a* above.

134. Right Side Heater Assembly Gasket

a. Removal.

(1) Remove burner assembly (par. 151*a*).
(2) Remove nut and washer from burner door handle and remove handle.



1	Wheel, blower	5	Collar, thrust	9	Pulley, groove, oven blower shaft
2	Key, wheel, blower shaft	6	Nameplates	10	Key, machine, shaft pulley
S	Shaft, wheel, oven blower	7	Indicator, liquid sight	11	Block with bushings, pillow
4	Support, pillow block	8	Collar, thrust		

Figure 44. Blower assembly, exploded view.

(3) Remove three nuts and washers securing burner headplate and lift off plate.
(4) Remove gasket.

b. Inspection. Inspect gasket to be sure it is serviceable and that it fits properly.

c. Installation. Reverse procedures in *a* above.

135. Left Side Heater Assembly Gasket

a. Removal.
(1) Remove blower motor (par. 126*a*).
(2) Remove 25 capscrews from outer firewall and lift off firewall.
(3) Remove three bolts and washers from lower frame of pillow block support.
(4) Remove eight nuts from blower housing studs and remove entire blower assembly.
(5) Remove gasket.

b. Inspection. Inspect gasket to be sure it is serviceable and that it fits properly.

c. Installation. Reverse procedures in a above.

136. Pillow Block

a. Removal.

(1) Remove blower shaft pulley (par. 137*a*).

(2) Loosen setscrews in thrust collar (8, fig. 44) and remove collar.
(3) Remove four nuts, capscrews, and lockwashers holding pillow block to support (fig. 42).
(4) Remove pillow block as shown in figure 45 and remove asbestos insulation underneath pillow block.

b. Disassembly.
(1) Remove screws from nameplates (6, fig. 44) and remove nameplates from pillow block.
(2) Unsnap and remove oil rings as shown in figure 46.
(3) Loosen setscrews in thrust collar (5, fig. 44) and remove collar.
(4) Remove piston ring from each collar (8 and 5). Do not remove preformed packing inside collars unless it is unserviceable.
(5) Unscrew liquid sight indicator (7) and remove it from pillow block.

c. Inspection and Repair. Inspect pillow block parts for wear and damage; if defective, install serviceable items.

d. Assembly. Reverse procedures in *b* above.

e. Installation. Reverse procedures in *a* above.

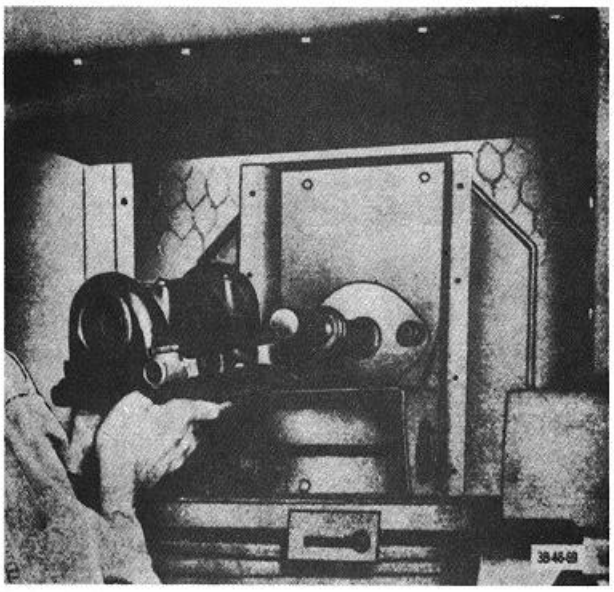


Figure 45. Removing pillow block.

137. Blower Shaft Pulley

a. Removal.
(1) Turn wingnut on motor adjustment, relieve tension on V-belt, and remove V-belt (fig. 42) from pulley.
(2) Remove pulley (9, fig. 44) and key (10) from blower shaft.

b. Inspection. Inspect pulley for damage and be sure it fits snugly and evenly on shaft.

c. Installation. Reverse procedures in *a* above.

d. Alinement. Check alinement of motor pulley and blower shaft pulley to be sure they are parallel. Move motor in slots until pulleys are alined and tighten nuts.

138. Motor Shaft Pulley

a. Removal.
(1) Turn wingnut on motor adjustment, relieve tension on V-belt, and remove V-belt (fig. 42) from lower pulley.
(2) Remove pulley and key from motor shaft.

b. Inspection. Inspect pulley for damage and be sure it fits snugly and evenly on shaft.

c. Installation. Reverse procedures in *a* above.

d. Alinement. Refer to paragraph 137*d*.

139. Oven Blower Assembly

a. Removal. Follow procedures in paragraph 135a(1) through (4).

b. Disassembly.

(1) Remove blower shaft pulley (9, fig. 44) and key (10) from blower shaft (3).
(2) Loosen setscrews holding blower wheel (1) to shaft (3) and remove wheel and key (2) from blower shaft.
(3) Remove four nuts, capscrews, and lockwashers holding pillow block (11) to support (4) and remove pillow block and shaft (3) from support.
(4) Loosen setscrews in collar (8) and remove collar from shaft.
(5) Withdraw shaft (3) from pillow block.

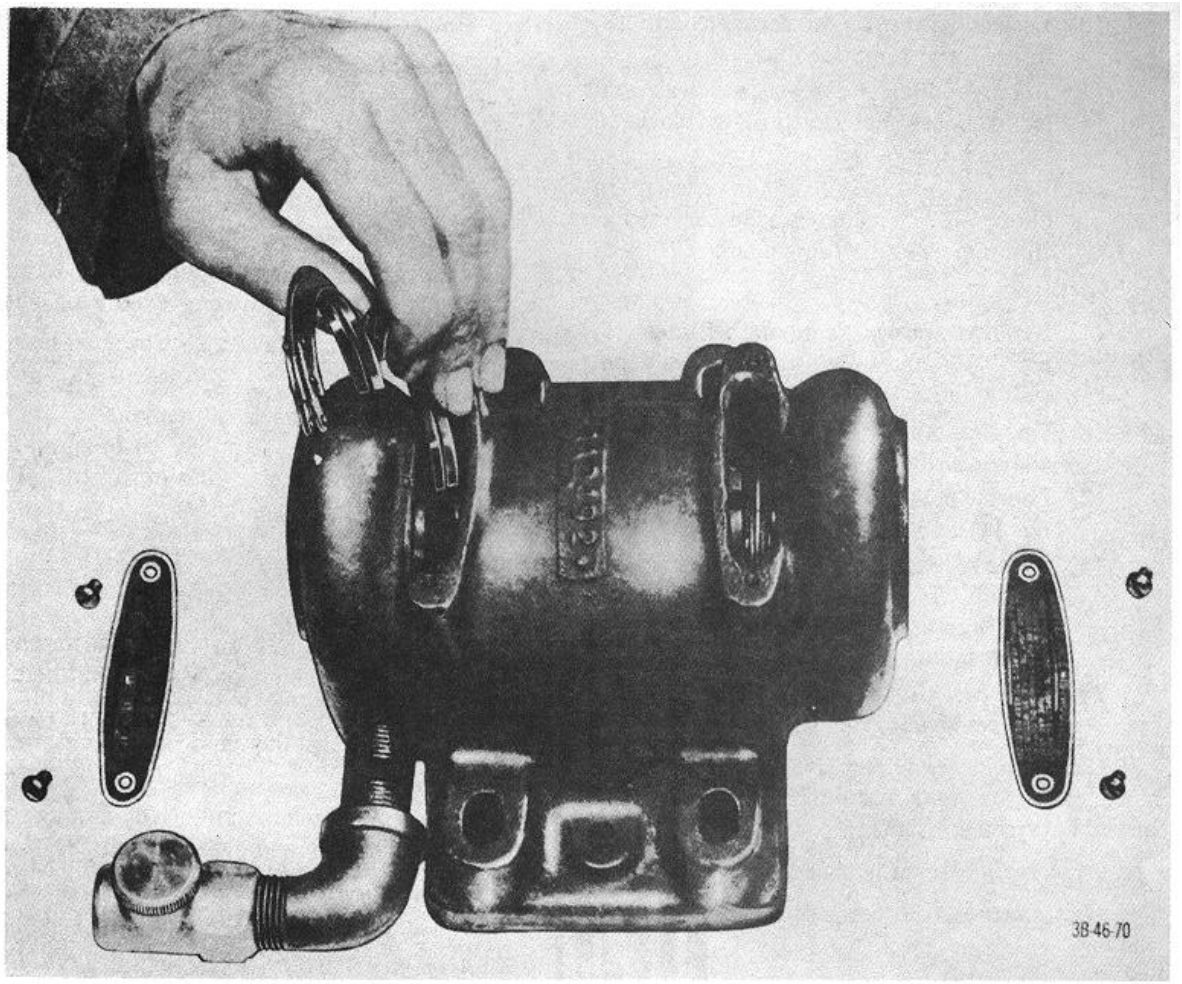


Figure 46. Removing oil Rings from pillow block.

(6) Remove cotter pins, nuts, and flat washers holding springs to blower shaft end plate. Remove springs and flat washers.
(7) Remove end plate from support (4).

c. Inspection and Repair. Inspect all parts of the blower assembly for wear and damage. Install serviceable parts for defective items.

d. Assembly. Reverse procedures in *b* above.

e. Installation. Reverse procedures in paragraph 135*a*(1) through (4), being careful that the fan wheel does not rub against the body of the trailer.

140. Blower Shaft End Plate Compression Springs

a. Removal.
(1) Remove cotter pin, nut, and flat 86 washer holding spring to blower shaft end plate.
(2) Remove spring and flat washer.
(3) Repeat procedure for other spring.

b. Inspection. Inspect springs for breakage and check tension.

c. Installation. Reverse procedures in *a* above.

141. Conveyor Chain Tension Springs

a. Removal.

(1) Remove screws from edges and top of oven loading plate and loosen grooved strips on each side of plate. Remove plate.
(2) Disconnect tension spring.
(3) Repeat procedures for spring in other deck.

b. Inspection. Inspect springs for breakage and check tension.

c.. Adjustment. To adjust the tension on the conveyor chains, connect the springs to the holes on the bracket levers that will allow desired tension.

d. Installation. Reverse procedures in *a* above.

142. Burner Handle Adjusting Spring

Inspect the fiat, steel spring, at the left of the oven burner handle, for damage and install serviceable spring if necessary.

143. Oven Indicator Light

a. Inspection. Inspect indicator light, located on the right rear of trailer, for damage. Check to be sure lamp is not broken or burned out.

b. Repair. Tighten receptacle cover if it has become loose. If a new lamp does not make good contact, install new receptacle.

c. Replacement.

(1) To replace incandescent lamp, push lamp into receptacle and give it a slight twist.

(2) To replace receptacle, remove cover plate, disconnect wires to receptacle, connect new receptacle, and install cover plate.

144. Blower Motor Cable and Plug

The blower motor cable extends from the motor junction box (fig. 42) to the power receptacle on the opposite side of the trailer.

a. Inspection. Inspect cable and plug for wear, evidence of short circuits, and other damage.

b. Repair.

(1) Make new connections in motor junction box if wires are broken or disconnected.

(2) If plug is damaged, replace it as follows:

(a) Loosen clamp around cable, remove two long screws, separate parts of plug, and disconnect wires.

(b) Connect wires to contacts of new plug, being sure white ground wire is on same contact as it was on old plug.

(c) Install two long screws and tighten clamp around cable.

145. Oven Power Cable and Plug

The oven power cable extends from the oven power panel to the power panel on the mixing and makeup outfit trailer.

a. Inspection. Inspect cable and plug for wear, evidence of short circuits, and other damage.

b. Repair.

(1) Tighten any loose connections or cable support clamps.

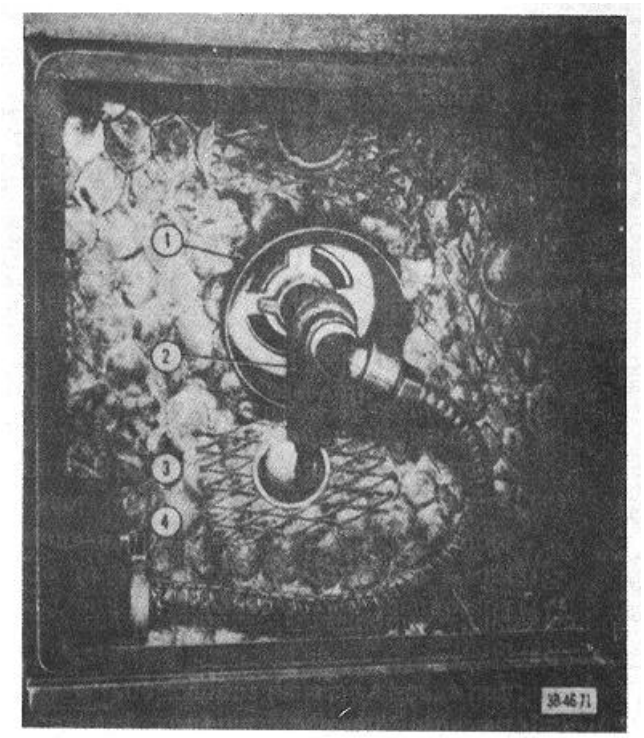
(2) If cable is unserviceable, install a new one.

(3) If plug is defective, replace it as follows:

(*a*) Unscrew knurled nut at cable end of plug.

(*b*) Loosen setscrew-in side of plug and unscrew brass collar on "plug-in" end of plug.

(*c*) Pull plug apart and unsolder brass contact points.



1	Housing, light	3	Box, receptacle
2	Clamp, mounting	4	Plug, twistlock

Figure 47. Upper deck light.

(*d*) Reverse procedures in (*a*) through (*c*) above to install new plug.

146. Oven Lights

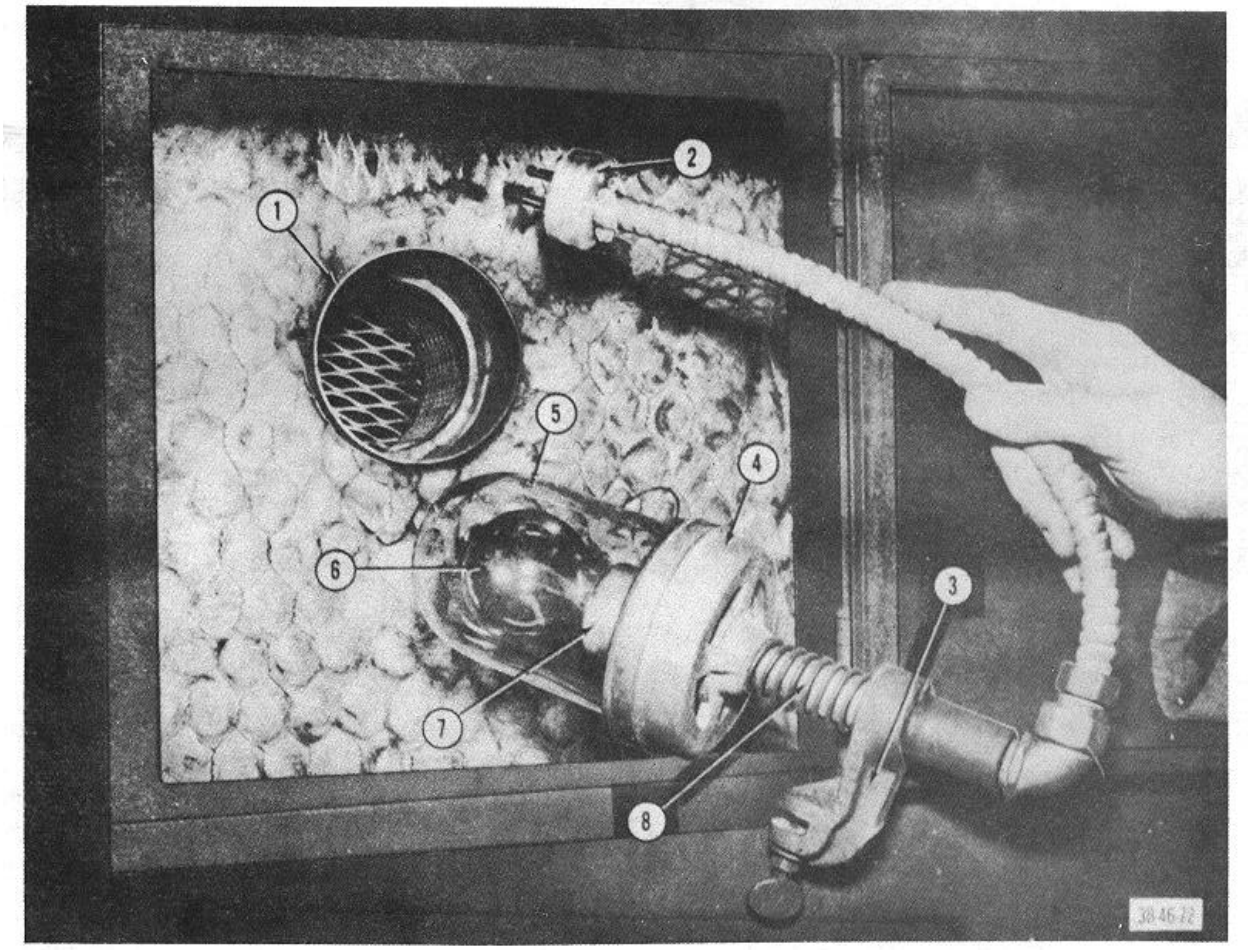
a. Removal and Disassembly.

(1) Disconnect oven power cable.
(2) Twist and withdraw upper deck light twistlock plug (4, fig. 47) from receptacle box (3).
(3) Loosen oven light mounting clamp (2) and withdraw light from housing (1).
(4) Unscrew globe (5, fig. 48) and remove incandescent lamp (6).
(5) Remove two screw, holding socket (7) and porcelain cover to lower porcelain section.
(6) Remove two screws holding lower porcelain section to globe holder (4).
(7) Lift off gasket and packing ring.
(8) Separate globe holder (4) from clamp (3) and remove compression spring (8).
(9) Repeat procedures for lower deck light.

b. Inspection.

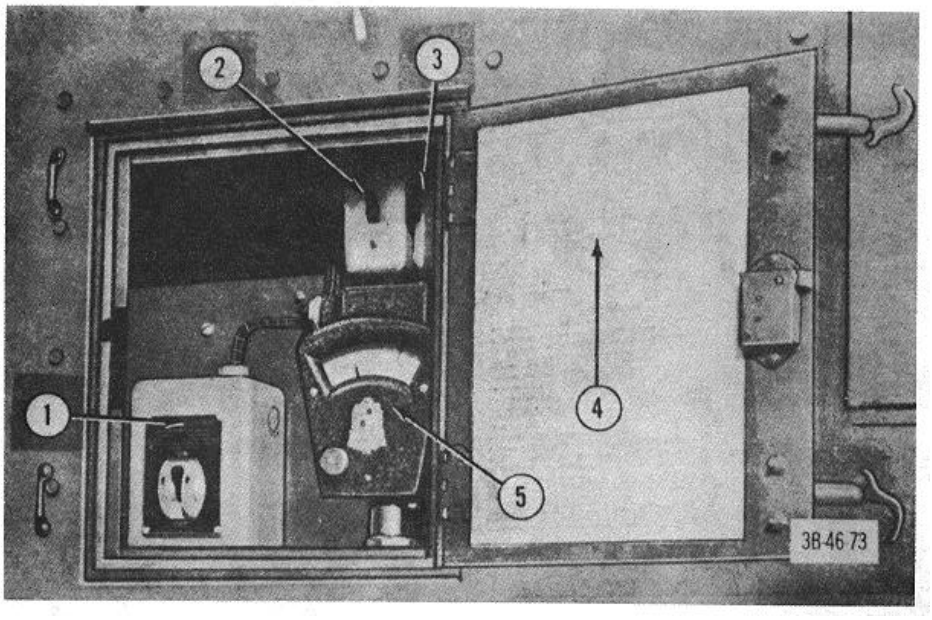
(1) Inspect lamps to be sure they are serviceable.
(2) Inspect globes and porcelain sockets for damage.
(3) Check compression springs for tension.

c. Assembly and Installation. Reverse procedures in *a* above.



1	Housing, light	4	Holder, globe	7	Socket, porcelain
2	Plug, twistlock	5	Globe, protecting	8	Spring, compression
3	Clamp, mounting	6	Lamp, incandescent		

Figure 48. Lower deck light.



1 Starter, manual, blower motor
2 Switch, toggle, oven burner
3 Switch, toggle, oven lights
4 Diagram, wiring
5 Control, temperature indicating

Figure 49. Control box.

147. Oven Light Switch

a Inspection. Inspect oven light switch (3, fig. 49) for proper operation.

b. Removal

(1) Remove two small screws holding cover plate and remove plate.

(2) Disconnect wires to switch terminals.

(3) Remove retaining screws and unscrew switch.

(4) Lift switch from switchbox.

c. Installation. Reverse procedures in b above.

148. Temperature Indicating Control

Inspect temperature indicating control (5, fig. 49) for proper operation and be sure it is not damaged.

149. Motor Manual Starter

The blower motor manual starter (1, fig. 49) is similar to the divider and molder motor manual starters. Refer to paragraph 71 for maintenance instructions applicable to this assembly.

150. Oven Dial Thermometer

a. Removal.

(1) Remove screws from weather shield above thermometer and remove shield.

(2) Unscrew coupling holding thermometer to oven and carefully withdraw sensitive element from oven chamber as shown in figure 50.

b. Inspection.

(1) Inspect glass covering over dial and sensitive element for damage.

(2) Check accuracy of thermometer.

c. Installation. Reverse procedures in a above.

151. Burner Assembly

a. Removal.

(1) Close shutoff valve at fuel tank.

(2) Disconnect fuel line (5, fig. 51) from tank to filter.

(3) Unplug magnetic valve cable (2) from receptacle.

(4) Lift entire assembly off pivot pins.

(5) Disconnect unions between filter (6)

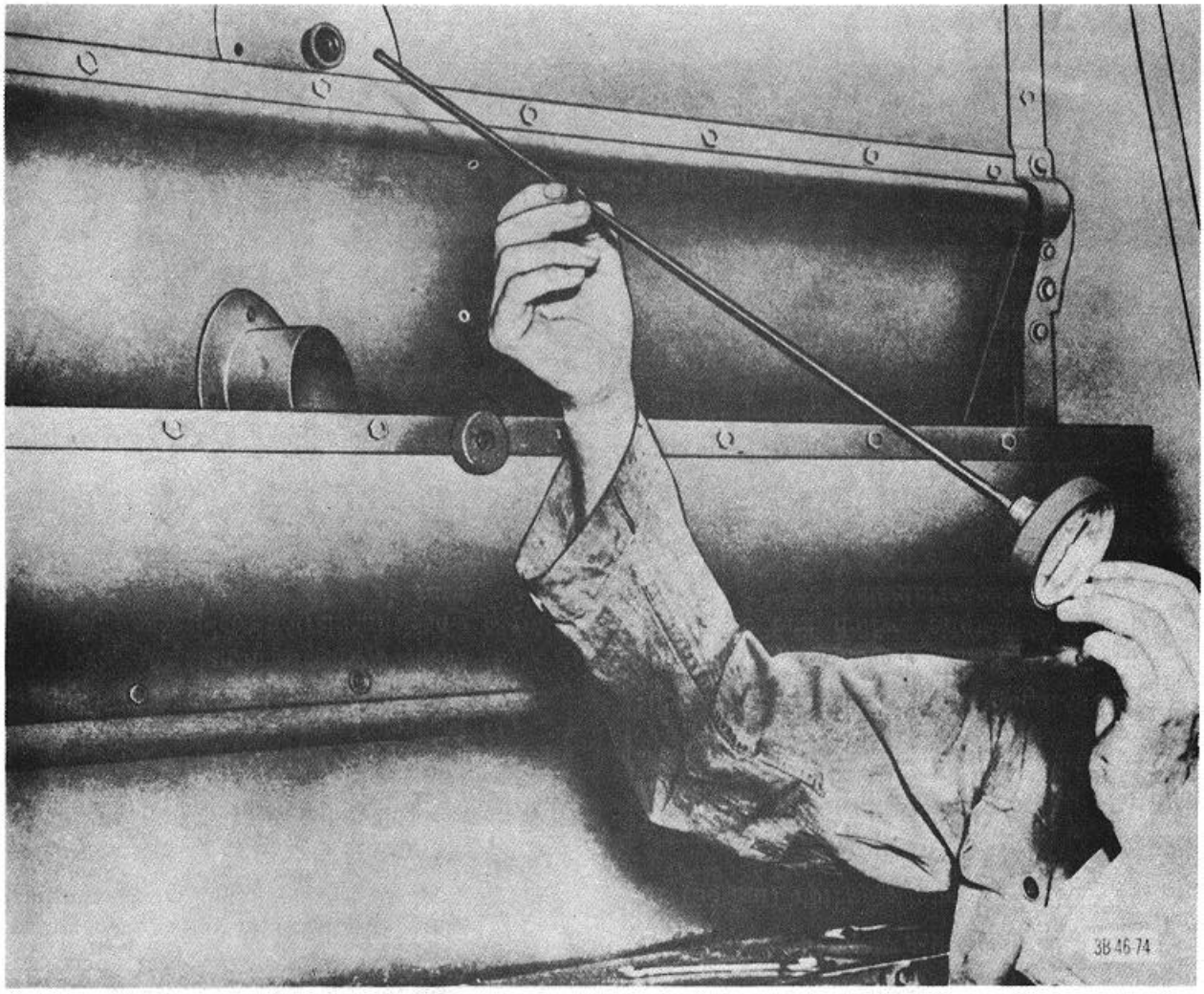


Figure 50. Removing oven dial thermometer.

And mete ring float valve 12 and remove filter and line.

(6) Remove two capscrews securing float valve 12 to mounting on burner baffle plate.

(7) Disconnect union at float valve outlet.

(8) Remove float valve 12.

(9) Disconnect fuel line tee between fuel line and bypass valve.

(10) Disconnect fitting at left of float valve 9 and remove float valve, bypass valve 10, and lines from burner.

b. Disassembly.

(1) Unscrew clean out rod (12, fig. 52) and nut (11) from clean out pipe tee (10).

(2) Unscrew clean out pipe tee (11) and nipple with nut (9) from burner (8). Separate nipple, nut, and tee.

(3) Unscrew and separate nipple and nut (6) on opposite side of burner.

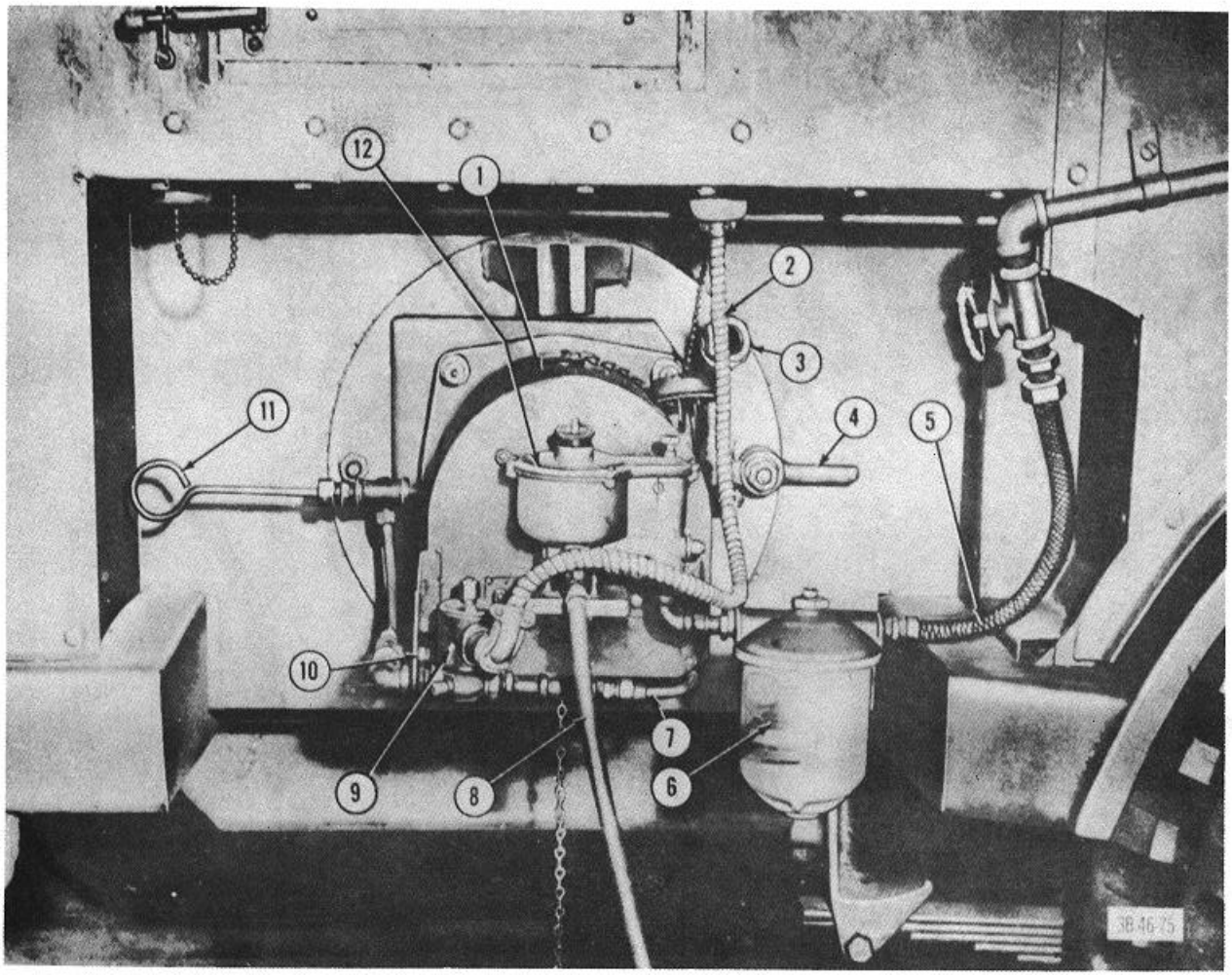
(4) Remove four machine screws securing adapter plate and separate -plate from burner.

(5) Unhook chain and remove lighting port cover (5) from housing.

(6) Remove three screws and clips from combustion ring support (1) and lift out combustion and recirculator ring (3).

(7) Remove vaporizing cup (4).

(8) Remove three screws and remove support ring (1) and gasket (2).



1	Burner assembly	7	Line, fuel, magnetic valve-to-bypass valve
2	Cable, magnetic valve	8	Hose, overflow, metering valve
3	Gage, burner sight	9	Valve, magnetic
4	Handle, burner	10	Valve, bypass
5	Line, fuel, tank-to-filter	11	Rod, cleanout
6	Filter, fuel	12	Valve, float, fuel metering

Figure 51. Burner assembly, installed.

c. Cleaning. Using a cloth moistened in SD, remove all dust, dirt, and grease from exterior of burner.

d. Inspection. Inspect all parts of burner assembly for damage.

e. Assembly. Reverse procedures in b above.

f. Installation. Reverse procedures in a above.

152. Combustion Tunnel

To inspect or clean the combustion tunnel, remove burner assembly (par. 151a), remove nuts from burner headplate, and lift off head-plate.

a. Inspection. Inspect tunnel wall to be sure it is not burned through. Check flange for damage.

b. Cleaning. Using a brush, remove loose soot from tunnel.

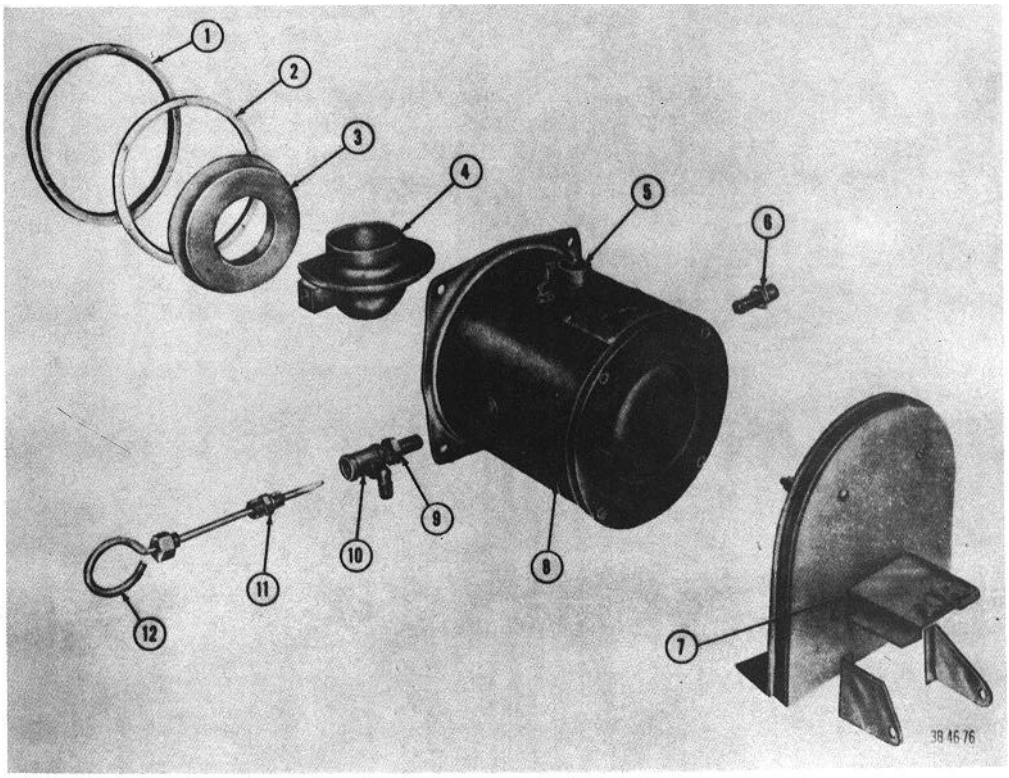
153. Fuel Filter

a. Removal.

(1) Close shut off valve at fuel tank.

(2) Disconnect fuel line from tank to filter.

(3) Unscrew union connecting filter to metering valve line and remove filter.



1	Support, combustion ring	5	Cover, lighting port	9	Nipple with nut
2	Gasket, combustion ring	6	Nipple with nut	10	Tee, cleanout pipe
3	Ring, combustion and recirculator	7	Support, float valve	11	Nut
4	Cup, vaporizing	8	Burner assembly	12	Rod, cleanout

Figure 52. Burner assembly, exploded view.

b. Disassembly.

(1) Remove filter head nut and remove nut and gasket.

(2) Remove vent screw and gasket from filter head (fig. 53).

(3) Remove filter head and shell gasket from shell.

(4) Remove filter element.

c. Inspection.

(1) Inspect shell for cracks and sediment.

(2) Inspect condition of element and gaskets.

d. Cleaning. Clean shell with a clean cloth dipped in SD.

e. Assembly. Reverse procedures in b above. Always use a new shell gasket when installing a new element.

f. Installation. Reverse procedures in a above.

154. Fuel Metering Float Valve

a. Removal.

(1) Remove fuel filter (par. 153a).

(2) Disconnect union at float valve outlet.

(3) Remove two capscrews securing float valve to adapter plate and remove float valve (12, fig. 51).

b. Disassembly.

(1) Remove overflow tube at adapter (6, fig. 54).

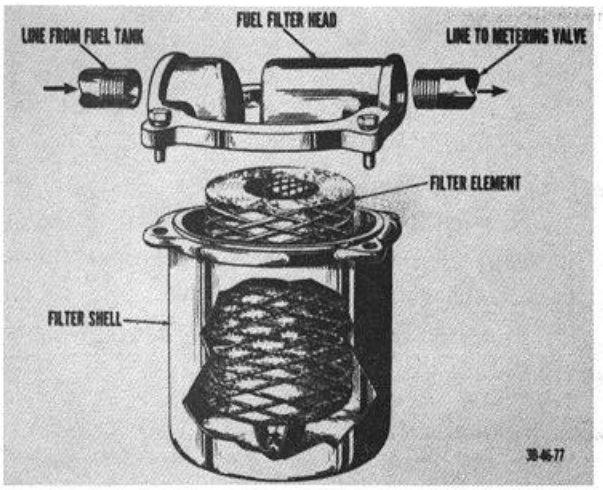


Figure 53. Fuel filter, phantom view.

(2) Remove four screws (17) from valve cover (14) and remove cover and gasket (12).

(3) Loosen fulcrum setscrew (5) and remove valve float (11).

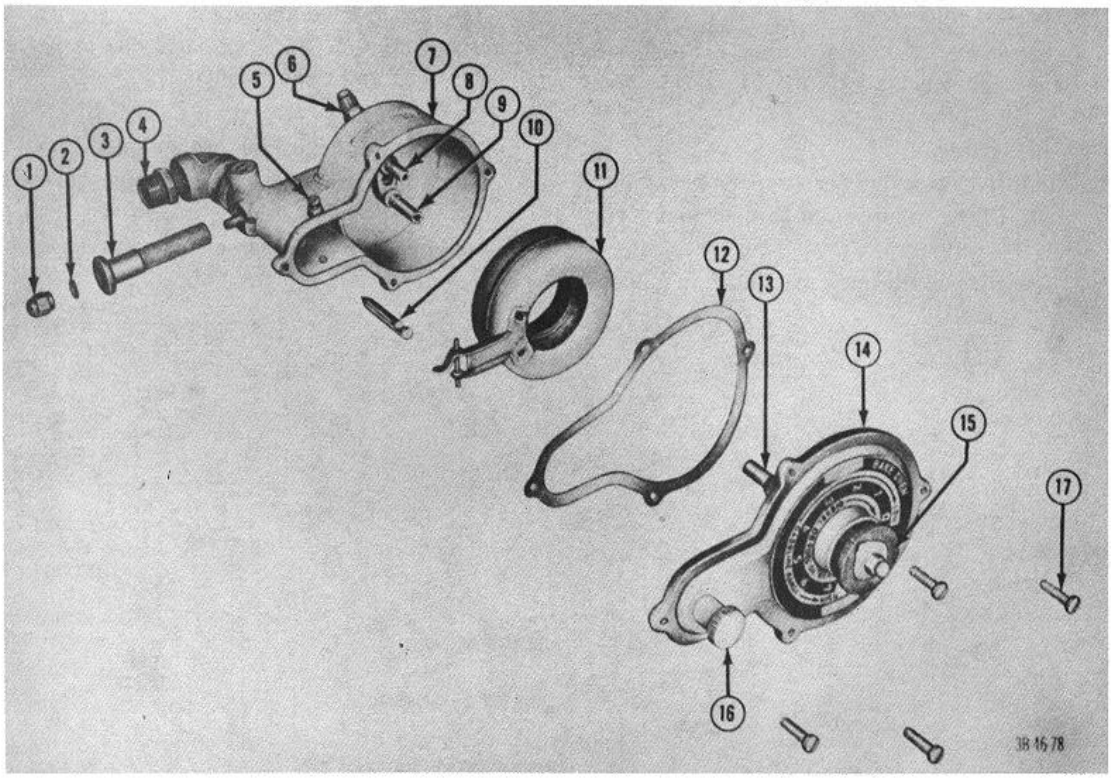
(4) Remove needle valve stem (10).

(5) Remove nut (1), lockwasher (2), fuel strainer with plug (3), and strainer gasket from valve body.

c. Inspection and Repair.

(1) Inspect gaskets for damage and install new gaskets if necessary.

(2) Check strainer to be sure it is not plugged with sediment.



1	Nut	10	Stem, cutoff
2	Lockwasher	11	Float
3	Strainer with plug	12	Gasket, valve cover
4	Fitting, inlet	13	Stem, regulating
5	Screw, fulcrum	14	Cover assembly, valve
6	Adapter, overflow hose	15	Knob, regulating
7	Chamber, float	16	Knob, cutoff
8	Tube, overflow	17	Screw, valve cover
9	Tube, outlet		

Figure 54. Fuel metering float valve, exploded view.

(3) Inspect condition of all parts and install new items as necessary.

d. Adjustment. To adjust 'float valve, refer to instructions in the operator's manual (TM 10-7630-201-10).

e. Assembly. Reverse procedures in b above.

f. Installation. Reverse procedures in a above.

155. Hoses, Lines, and Fittings

Inspect condition of all hoses, lines, pipes, and fittings. Be sure connections are tight and that there are no leaks. Refer to figure 55 to replace any of these items.

156. Bypass Plug Valve

a. Removal. Unscrew fittings on each side of bypass plug valve (10, fig. 51) and remove valve.

b Inspection.

(1) Inspect valve for proper operation.

(2) Check condition of threads and spring tension.

c. Installation. Reverse procedure in a above.

157. Fuel Shutoff Valve

a. Removal.

(1) Close shutoff valve and disconnect fitting to flexible line.

(2) Drain fuel.

(3) Unscrew valve from nipple.

b. Inspection. Inspect valve for proper operation and check condition of threads.

c Installation. Reverse procedures in a above.

158. Magnetic Valve

a. Removal.

(1) Close shutoff valve at fuel tank.

(2) Disconnect magnetic valve cable (2, fig. 51) from receptacle.

(3) Unscrew unions at each side of valve (9) and remove valve.

b. Inspection.

(1) Inspect valve for proper operation.

(2) Check valve body and valve threads for damage.

c. Installation. Reverse procedures in a above.

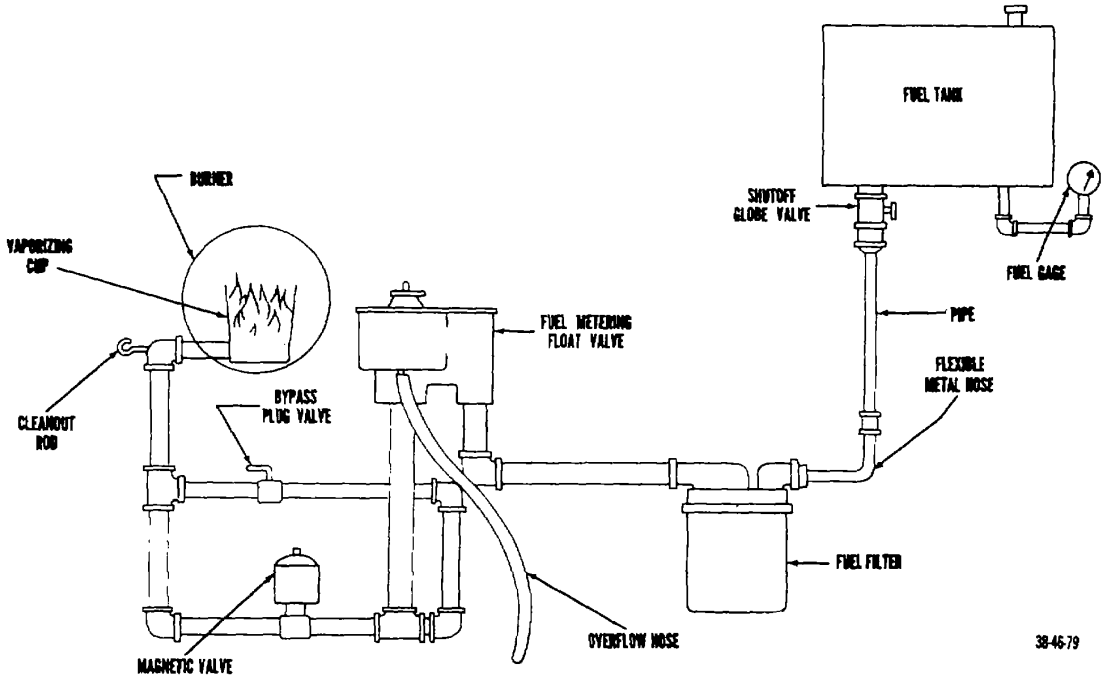


Figure 55. Burner fuel system.

159. Flexible Conduit and Connectors

a. Inspect condition of magnetic valve conduit (2, fig. 51); install new conduit as necessary.

b. Check connectors on conduit to be sure they are making good electrical connections to starter switch, light, and magnetic valve; install new connectors as necessary.

160. Fuel Gage

a. Inspection.

(1) Check fuel gage for proper operation.

(2) Inspect gage and cover for damage.

b. Replacement. To replace gage, drain fuel from tank, unscrew gage from nipple, and reverse procedure using serviceable gage.

Section XI. PROOFING CABINET

161. Indicator Light Assembly

a. Removal.

(1) Disconnect power input cable from power source and unscrew knurled knob on front of light assembly (fig. 56).

(2) Remove cover from junction box.

(3) Pull light and receptacle forward.

(4) Unscrew hexagon nut and lockwasher from base of junction box.

(5) Pull base and lamp forward, unsolder wires, and remove light assembly.

b. Inspection.

(1) Inspect lamp for proper operation.

(2) Inspect light assembly for cracks, breaks, evidence of short circuits, and other damage.

(3) Check wires for bare places and fraying.

c. Lamp Replacement. If lamp is defective, twist and remove it from light assembly and insert serviceable lamp.

d. *Installation*. Reverse procedures in a above.

162. Thermostatic Switch

a. Inspect thermostatic switch (fig. 56) for damage.

b. Check temperature in cabinet with a thermometer to see if it agrees with setting of thermostatic switch dial.

163. Power Input Cable

a. Removal. Remove knob, dial shield, and cover of thermostatic switch and disconnect and tag input cable terminals.

b. Inspection and Repair.

(1) Inspect power input cable for wear, breaks, or fraying and install new cable if necessary.

(2) Check condition of cable connections at plug and switchbox. If wires are broken at terminals, make new connections.

(3) Inspect plug and install new plug if necessary.

c. Installation. Reverse procedure in a above.

164. Wiring Harness

a. Removal.

(1) Disconnect power source and remove knob, dial shield, and cover of thermostatic switch.

(2) Disconnect harness from two middle output terminals at top of thermostatic switch.

(3) Remove connectors holding cable where harness enters cabinet (fig. 57).

(4) Remove clamps holding harness to cabinet.

(5) Remove wires from each contact on heater strips and tag wires for identification.

(6) Pull harness through opening to inside of cabinet and remove harness.

b. Inspection.

(1) Inspect harness for worn places or other damage.
(2) Inspect wire terminals for corrosion.
(3) Check insulation for cracks caused by heat.

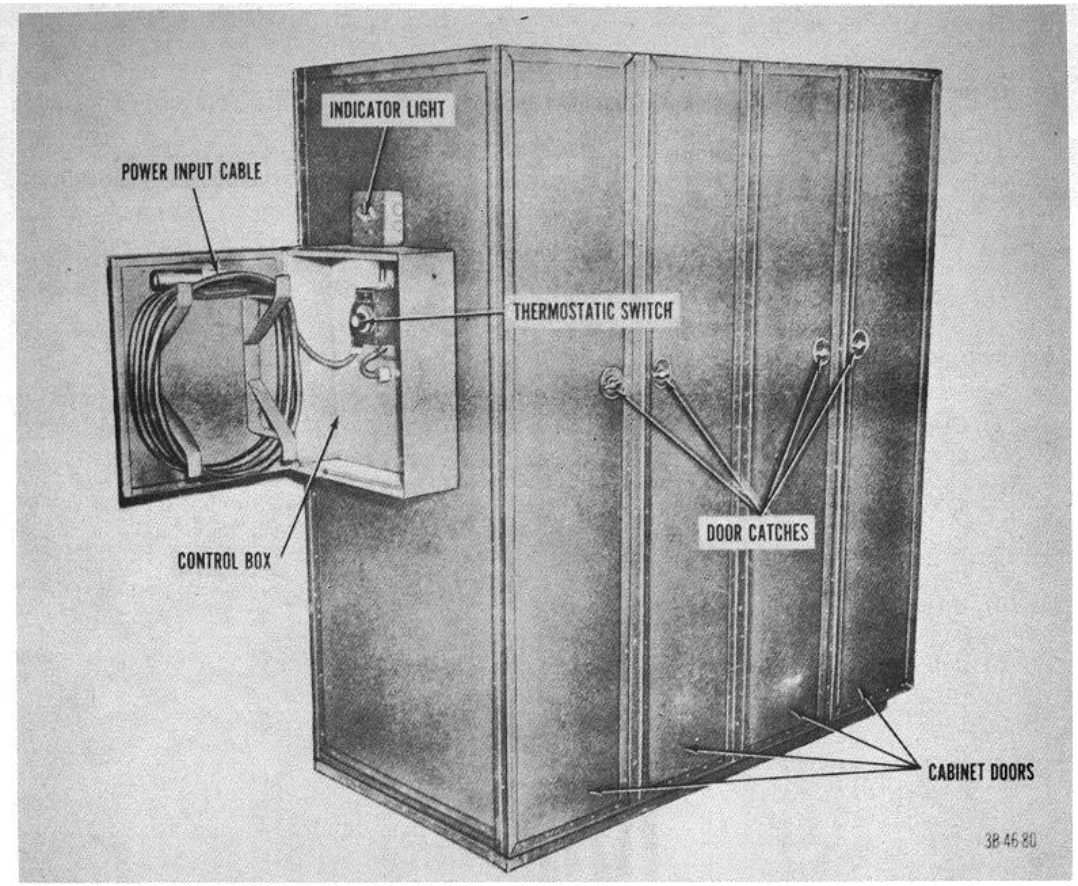


Figure 56. Proofing cabinet with control box door open.

c. Repair. Clean all corrosion from harness contacts and heater strips.

d. Installation. Reverse procedures in a above.

165. Cam and Catch Assemblies

a. Removal,

(1) Remove nut and lockwasher from cam (fig. 57).

(2) Remove two screws from catch on outside of door.

(3) Remove cam and catch.

(4) Repeat procedures for other cam and catch assemblies,

b. Inspection. Inspect cam and catch for damage and be sure they hold door tightly shut.

c. Installation. Reverse procedures in a above.

166. Door Gaskets

a. Inspection. Inspect gaskets for wear and damage and be sure they are tightly joined.

b. Removal. Remove drive screw nails holding gasket to door and remove gasket.

c. Installation. Reverse procedure in b above.

167. Heater Assemblies

a. Inspection.

(1) Check surface of heaters (fig. 57) for rough places and inspect heaters and terminals for corrosion.

Figure 57. Proofing cabinet with front doors open.

(2) Inspect terminals for secure connections.

b. Removal.

(1) Disconnect and tag wires leading to heater.

(2) Remove two nuts, screws, and washers from heater and remove heater from frame.

(3) Repeat procedures for other heaters.

c. Installation. Reverse procedures in b above.

168. Water Pans

a. Inspection.

(1) Inspect water pans (fig. 57) for leaks and corrosion.
(2) Test clamps to be sure they hold water pans securely.

b. Repair. Straighten dents or bent clamps if possible.

169. Control Box Thumbscrews

Check condition of thumbscrews in control box door and replace them if necessary.

Section XII. FLOUR SIFTER

170. Electric Motor

a. Inspection.

(1) Inspect motor (12, fig. 58) during operation for signs of overheating and listen for unusual noises.

(2) Be sure motor is mounted securely and check electrical connections.

b. Removal.

(1) Disconnect power source (6) and remove cable at junction box (11) on motor. Tag wires for identification.

(2) Remove four nuts, bolts, and lockwashers that mount motor to frame and remove motor.

c. Installation. Reverse procedures in b above.

171. Motor Manual Starter

a. Removal.

(1) Disconnect power source.

(2) Remove starter cover plate (5, fig. 58) and disconnect wires from terminals.

(3) Remove screws securing starter to box and remove starter.

b. Inspection.

(1) Inspect starter assembly for proper operation.

(2) Check for damage and be sure wire terminals and contacts are in good condition.

c. Repair.

(1) Clean contacts with fine sandpaper.

(2) If starter is defective, replace it with a serviceable item.

d. Installation. Reverse procedures in a above.

172. Sack Spurs

a. Inspection. Inspect spurs (7, fig. 58) to be sure they are not bent or broken.

b. Replacement. To replace spur, remove screw, lockwasher, and spur and install serviceable spur with lockwasher and screw.

173. Counterbalance Sheave Assembly

Inspect sheave assembly (14, fig. 58) for cracks, breaks, and other damage.

174. Drive V-Belt

a. Inspection. Inspect V-belt (13, fig. 58) for wear, frays, cuts, and other damage.

b. Removal.

(1) Remove sieve frames (par. 175a).

(2) Remove three bolts from each of lower hanger rod supports and lift out sieve frame bed with rods attached.

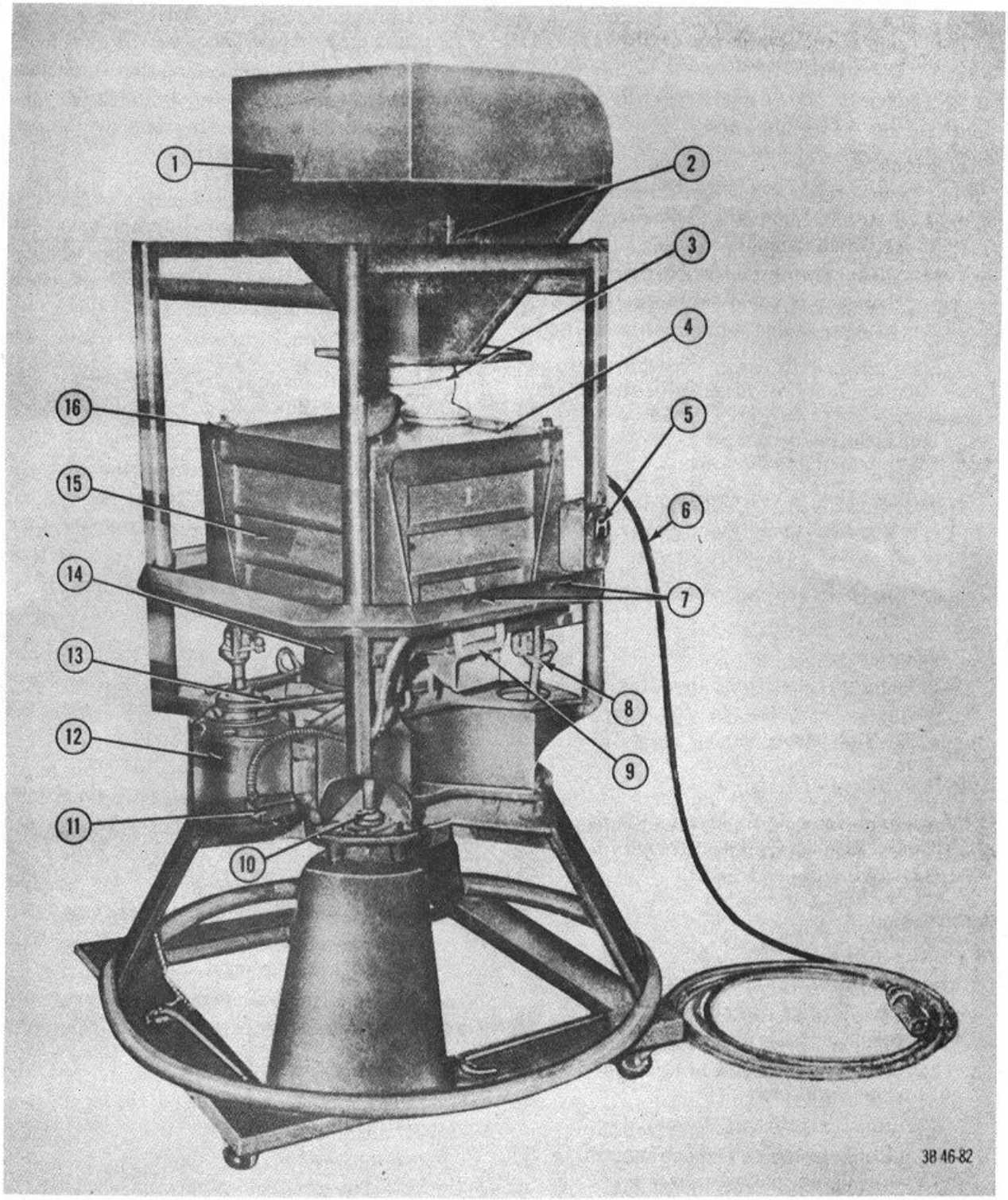
(3) Move motor adjusting bracket to release tension on V-belt and remove V-belt.

c. Installation. Reverse procedures in b above.

175. Lower and Upper Frame Assemblies

a. Removal.

(1) Loosen lower tube clamp (4, fig. 58), release feed hopper barrel bolts (2),



1 Hopper, feed
2 Bolt, barrel
3 Tube, cloth
4 Clamp, cloth tube
5 Starter, manual
6 Cable, power
7 Spurs, sack
8 Rod, hanger, sieve frame
9 Door, discharge
10 Shims
11 Box, junction
12 Motor
13 V-belt, drive
14 Sheave assembly, counterbalance
15 Frames and holddown box, sieve
16 Rod, holddown box

Figure 58. Flour sifter, overall view.

and remove feed hopper assembly (1) from machine bed post.

(2) Remove four nuts from top of holddown box (15) and lift top from box.

(3) Remove sieve frames.

b. Inspection, Cleaning, and Repair.

(1) Inspect frames for dents, bends, tears, or other damage.

(2) Clean frames with a brush or compressed air (not over 30 psi).

(3) If frames are defective, install serviceable items.

c. Installation. Reverse procedures in a above.

176. Sieve Frame Bed Gaskets

a. Removal.

(1) Remove sieve frames (par. 175a).

(2) Remove gaskets from frame bed.

b. Inspection. Inspect gaskets for damage and deterioration.

c. Installation.

(1) Glue gaskets into position in frame bed.

(2) Install sieve frames (par. 175c).

177. Sieve Frame Hanger Rods

Inspect four sieve frame hanger rods (8, fig. 58) for breaks, bends, and other damage. Be sure they are securely attached.

178. Rubber Shims

a. Removal.

(1) Remove three capscrews and lockwashers at top of hanger rod (8, fig. 58).

(2) Remove three nuts, lockwashers, and bolts at bottom of rod.

(3) Remove rod with shims.

(4) Remove capscrew and retaining cap at top of rod and remove shim.

(5) Remove two nuts and retainers from bottom of rod and remove shims (10).

b. Inspection. Inspect shims to be sure they are serviceable; check for dry rot.

c. Installation. Reverse procedures in a above.

179. Discharge Hopper Door Springs

a. Inspection. Inspect springs in discharge door (9, fig. 58) for damage and check tension.

b. Replacement. If spring is defective, unhook it and install a serviceable item.

180. Holdown Box Assembly

a. Removal. Follow procedures in paragraph 174b (1) and (2).

b. Inspection. Inspect holddown box assembly (15, fig. 58) for damage.

c. Installation. Reverse procedures in paragraph 174b (1) and (2).

181. Holddown Box Rods

a. Removal.

(1) Remove nut from each corner of holddown box top and remove top.

(2) Unscrew rods (16) and remove them.

b. Inspection. Inspect rods for stripped threads, bends, and other damage.

c. Installation. Reverse procedures in a above.

182. Sieve Frame Insert Assemblies and Rubber Balls

a. Removal.

(1) Remove frames (par. 175a).

(2) Remove insert panel, wire cloth, hardware cloth, and rubber balls from each frame.

b. Inspection.

(1) Inspect insert assemblies. for damage.

(2) Check rubber balls for lost elasticity, cuts, and other damage.

c. Installation. Reverse procedures in a above.

183. Cloth Tube and Clamps

a. Inspection. Inspect tube (3, fig. 58) and clamps (4) for damage.

b. Removal.

(1) Squeeze bottom clamp together, unhook ends, and remove clamp.
(2) Remove nut and bolt securing each of two upper clamps and remove clamps.
(3) Remove cloth tube.

c.Installation. Reverse procedures in b above.

CHAPTER 4

SHIPMENT, LIMITED STORAGE, AND DEMOLITION

Section I. SHIPMENT AND LIMITED STORAGE

184. General

These instructions apply to the bakery plant that is to be ready for immediate use upon arrival from shipment,-or the bakery plant which will be out of service for a period not to exceed 6 months. Instructions pertaining to oversea shipment are contained in MIL-STD-162A.

185. Preliminary Services

a. Inspection. Thoroughly inspect the equipment of the mobile bakery plant to be sure all items are in serviceable condition.

b. Operation Test. Test the equipment to be sure it operates satisfactorily by performing a run-in test (par. 10).

c. Correcting Deficiencies. Correct all deficiencies if facilities are available for such service. If repairs are beyond the scope of organizational maintenance, refer them to a higher echelon for correction.

186. Preparation of Equipment

a. Draining.

(1) Drain all water from the water-transfer system and water-tempering tank.

(2) Drain divider oil from pump and reservoir.

(3) Empty flour from the three flour dusters and from the sifter assembly.

(4) Drain and dry the proofing cabinet water pans.

(5) Drain fuel from the oven fuel tank, filter, float valve, and fuel lines.

b. Cleaning and Painting.

(1) Clean all parts of the bakery plant equipment thoroughly. Be very careful in cleaning flour and dough-contacting surfaces; do not use any cleaning solution that would contaminate the dough.

(2) Remove all rust and corrosion from the equipment and repaint as necessary.

c. Lubrication. Lubricate the equipment according to instructions on the lubrication orders (figs. 1, 3, 5, 7, and 9).

d. Packing.

(1) Remove all accessories such as handcranks, dough troughs and carriers, water pans, overhead lights, extension cords, power cables, oven blower motor and V-belt, oven burner, stovepipe sections, etc. Wrap these items and place them in the proper storage compartments or in boxes and crates lined with barrier paper. Seal with tape.

(2) Place covers or barrier paper and tape over all openings and exposed mechanical parts.

(3) Use nonhygroscopic tape to secure and seal gages, indicators, exposed electrical connections, and loose doors, lids, and boxes.

(4) Secure canvas covers over the mixing and makeup machinery and on the end of the oven trailer.

(5) Remove the sifter feed hopper and base. Invert hopper on the holddown box and invert the base and secure it to the sifter machine bed. Place the collapsed sifter on a specially designed crate base and completely wrap it in barrier paper.

Section II. DEMOLITION

187. Authority

The mobile bakery plant will be destroyed only if it is in danger of being captured and used by the enemy, and only upon the order of the unit commander.

188. Methods

Destroy the same parts on all similar equipment to prevent enemy use through cannibalization. Be sure to obliterate all serial numbers, nameplates, and unit markings.

a. Destruction by Hand.

(1) Use sledge hammers, axes, crowbars, or any other heavy tools to smash the components of the bakery plant.

(2) Slash tires, electrical cables, cords, hoses, and fuel lines.

(3) Punch holes in water pans, water and fuel tanks, and insulated panels.

(4) Destroy controls, instruments, lights, and other accessories.

(5) If a stream is nearby, throw loose parts into the water. Bury or scatter all other parts.

b. Destruction by Explosives. If demolition explosives are available, charges should be placed in the following areas:

(1) In back of the mixer bowl.

(2) Beneath the divider.

(3) Inside the divider dough box.

(4) In the molder sheeting rolls.

(5) In the oven combustion tunnel.

(6) In the proofing cabinet, just above the thermostatic switch bulb.

(7) In the sifter machine bed.

APPENDIX I

REFERENCES

AR 320-5	Dictionary of United States Army Terms
AR 320-50	Authorized Abbreviations and Brevity Codes
AR 385-40	Accident Reporting and Records
AR 700-38	Unsatisfactory Equipment Report
AR 700-58	Report of Damaged or Improper Shipment
AR 750-1	Concept of Maintenance
AR 754-9130-1	Utilization of Automotive Gasoline
DA Pam 108-1	Index of Army Motion Pictures, Filmstrips, Slides, and Phono-Recordings
DA Pam 310-1	Military Publications: Index of Administrative Publications
DA Pam 310-2	Military Publications: Index of Blank Forms
DA Pam 310-3	Military Publications: Index of Training Publications
DA Pam 310-4	Index of Technical Manuals, Technical Bulletins, Supply Bulletins, Lubrication Orders, and Modification Work Orders
FM21-5	Military Training
FM21-6	Techniques of Military Instruction
FM21-30	Military Symbols
TM9-1870-1	Maintenance and Care of Pneumatic Tires
TM10-1400	Special Purpose Vehicles and Equipment; Inspections and Organizational Preventive Maintenance Services.
TM10-7360-201-10	Operator's Manual: Bakery Plant, Mobile
TM10-7360-201-20P	Organizational Maintenance Repair Parts and Special Tools Lists: Bakery Plant, Mobile
TM 11-661	Electrical Fundamentals
TM 38-230	Preservation, Packaging, and Packing of Military Supplies and Equipment
SB 38-5-3	List of Standard Lubricants, Hydraulic Fluids, Liquid Fuels, and Preservative Material Used by the Army

APPENDIX II

MAINTENANCE ALLOCATION CHART

1. This appendix was prepared 24 March 1958 and lists all maintenance operations to be performed by the applicable echelons. These allocations are based on skills, tools, test equipment, and time required and/or available in the average TOE organizations.

2. The sequence of entries coincides with the sequence followed in the functional parts list in TM 10-7360-201-20P.

3. This appendix is a guide in performing maintenance operations; for authorization for specific repair parts refer to TM 10-7360-20120P.

4. The explanations listed below define the terms used in the Maintenance Allocation Chart:

a. Clean. Major cleaning internally or with disassembly.

b. Adjust. To regulate periodically to prevent malfunctioning.

c. Inspect. To verify serviceability and to detect electrical or mechanical failure by scrutiny.

d. Test. To verify serviceability and to detect electrical or mechanical failure by use of special equipment such as gages, meters, etc.

e. Replace. To remove and install or substitute serviceable assemblies, subassemblies, and parts for unserviceable like items.

f. Repair. To restore to a serviceable condition by replacing unserviceable parts or by any other action required utilizing tools, equipment, and skills available and authorized, to include welding, grinding, riveting, straightening, adjusting, etc.

g. Aline. To adjust two or more parts and/ or assemblies of an electrical, precision, mechanical, or steering system so that their functions are properly synchronized.

h. Rebuild. To restore to a condition comparable, to new by disassembling the item as necessary to determine the condition of each assembly or part; rebuilding or repairing of parts; and reassembling, using serviceable, rebuilt, or new assemblies, subassemblies, and parts.

Maintenance Allocation Chart

MIXING AND MAKEUP OUTFIT TRAILER GROUP 06-ELECTRICAL	Echelon				
	1	2	3	4	5
Wiring, trailer and intervehicular cable Inspect, Replace	-------	x			
Lamps, incandescent Inspect, Replace	--------	x			
Lights, service and blackout Inspect, Repair, Replace	--------	x			
Switch, blackout Inspect, Replace	-------	x			
Battery, emergency brake Inspect..... Replace	x -------	x			

	Echelon				
	1	2	3	4	5
GROUP 12 BRAKES					
Brakes, Controls, and Fittings					
Inspect, Adjust, Repair, Replace	-------	X			
Kit, brake lining					
Replace	--------	------	X		
GROUP 13 WHEELS, BEARINGS, HUBS, DRUMS					
Wheel Assemblies, disk, trailer					
Inspect, Replace	---------	X			
Bearings and Grease Seals, wheel					
Inspect, Replace	------	X			
Brakedrum, Backing Plate, and Hub, trailer					
Inspect	------	X			
Inspect, Replace					
Wheel Assembly, caster	-------	------	X		
Inspect, Repair, Replace	------	X			
TIRES, TUBES					
Tires and Tubes, pneumatic					
Inspect, Repair, Replace	------	X			
GROUP 15 FRAME, ALE, TOWING ATTACHMENTS					
Lunette and Chain Assembly, safety					
Inspect	X				
Replace	------	X			
Ale, trailer					
Inspect	--------	X			
Replace	--------	X			
Bumper, rubber, trailer ale					
Inspect, Replace	--------	X			
GROUP 16 SPRINGS, SHACKLES					
Spring Assemblies and Hangers					
Inspect, Repair, Replace	--------	X			
GROUP 22 MISCELLANEOUS					
Jack Assemblies, leveling support					
Inspect, Repair, Replace	------	X			
GROUP 30 ELECTRIC MOTORS					
Motor Assemblies, electric, divider; molder; mixer					
Inspect, Replace	------	X			
Repair	------	------	X		
Test, Rebuild	-------	-------	-------	X	
Breaker Units, lighting and power panel					
Inspect, Replace	-------	X			
Fixtures, trailer lighting					
Inspect, Replace	--------	X			
Cord, extension, lighting, w/5 socket outlet					
Inspect, Repair, Replace	------	X			
Lamps, incandescent					
Inspect, Replace	-------	X			
Globes, fixture, trailer lighting					
Inspect, Replace	--------	X			
Plugs, power and lighting panel					
Inspect, Replace	-------	X			
Receptacles, trailer lighting fixture					
Inspect, Replace	---------	X			
Receptacles, w/spring cover, power and lighting panel					
Inspect, Repair, Replace	-------	X			
Reflectors, multiple light, extension cord					
Inspect, Replace	------	X			

GROUP 48 BAKERY MACHINERY	Echelon				
	1	2	3	4	5
Chains, roller, divider; molder; mixer					
Inspect, Repair, Replace	------	X			
Chains, silent, divider; molder; mixer					
Inspect, Repair, Replace	------	X			
Divider Assembly, dough, wv/l4£ hp electric motor and gear reduction unit					
Inspect, Adjust	------	X			
Repair, Replace	------	------	X		
Catch, divider rear door transom latch					
Inspect, Replace	------	X			
Cushions, divider dough checking scale mounting					
Inspect, Replace	------	X			
Hinges, divider door					
Inspect, Replace	------	X			
Scale, divider dough piece checking					
Inspect, Adjust, Replace	------	X			
Repair	------	-------	X		
DIVIDER CONVEYOR, DUSTER					
Bar Assemblies, divider conveyor duster					
Inspect, Replace, Repair	-------	X			
Belt, divider conveyor idler pulley and shaft					
Inspect, Replace	-------	X			
Bushings, conveyor belt duster studs; conveyor drive; idler; pinion					
Inspect	------	X			
Replace	-------	-------	X		
Gear, w/Pulley, Pinion, Shafts, and Collars, conveyor					
Inspect	------	X			
Replace	-------	--------	X		
Screens, divider duster					
Inspect, Replace	------	X			
Crankshaft, Lever, Pillow Block, and Sprocket, divider					
Inspect	------	X			
Repair, Replace	------	------	X		
DIVIDER CYLINDER					
Cylinder Assembly, divider					
Inspect, Adjust	------	X			
Repair, Replace	------	------	X		
Knife, Plunger, Links, and Piston, dough					
Clean, Inspect	X				
Replace	------	X			
Box Assembly, dough					
Clean, Inspect	------	X			
Repair, Replace	-------	------	X		
Reduction Unit, gear, divider					
Inspect	------	X			
Repair, Replace	------	------	X		
Pump Assembly, oil, divider					
Clean, Inspect, Repair, Replace	------	X			
CONTROLS, INSTRUMENTS, PANELS, SWITCHES					
Pushbutton Units					
Inspect, Replace	------	X			
Starter Assembly, magnetic, divider motor					
Inspect, Repair, Replace	------	X			

MIXER ASSEMBLY	Echelon				
	1	2	3	4	5
Mixer Assembly, dough, w/7% hp electric motor and gear reduction unit					
Clean	X				
Inspect, Adjust	------	X			
Repair, Replace	------	------	X		
Rebuild	------	------	------	X	
Cushions, leather, mixer front door					
Inspect, Replace	-------	X			
Bowl Assembly, mixer					
Clean	X				
Inspect	------	X			
Replace	------	------	X		
Bushings, mixer bowl agitator eccentric and small roller					
Inspect, Replace	------	X			
Bushings, mixer bowl agitator right and left					
Inspect	------	X			
Replace	------	------	X		
Glands, packing, mixer bowl agitator shaft					
Inspect	------	X			
Replace	------	------	X		
Packing, flax, mixer bowl agitator shaft					
Inspect	-----	X			
Replace	------	------	X		
Roller, eccentric, mixer bowl agitator					
Clean	X				
Inspect, Replace	------	X			
Roller, small, mixer bowl agitator					
Clean	X				
Inspect, Replace	------	X			
Shaft Assemblies W/Sleeves, mixer bowl agitator left and right					
Inspect	------	X			
Replace	------	------	X		
Spacer, mixer agitator					
Inspect, Replace	------	------	X		
Wheel, sprocket, mixer bowl agitator					
Inspect, Replace	------	X			
Studs W/Washers mixer bowl agitator shaft					
Inspect, Adjust, Replace	-------	X			
Dump Assembly, mixer bowl					
Inspect	------	X			
Repair	------	------	X		
Reduction Unit, gear, mixer					
Inspect	------	X			
Repair, Replace	------	------	X		
Gage, oil level, mixer gear reduction unit housing					
Inspect	------	X			
Replace	------	------	X		
Blocks, mixer pillow					
Inspect	-------	X			
Replace	------	------	X		
Controls, Instruments, Gages, and Switches, electrical					
Inspect, Repair, Replace	-------	X			
WATER TEMPERING TANK, WATER TRANSFER SYSTEM					
Pump Assembly, mixer water transfer					
Inspect, Repair, Replace	------	X			

	Echelon				
	1	2	3	4	5
Valves, check; gate; plug; three way					
Inspect, Replace	------	X			
MOLDER ASSEMBLY					
Molder Assembly					
Inspect	------	X			
Repair, Replace	------	------	X		
Rebuild	------	------	------	X	
Belt Assemblies, molder dough curler and conveyor					
Inspect, Replace	------	X			
Hub W/Sprocket, molder conveyor belt drive shaft	------				
Inspect, Replace		X			
Board Assembly, pressure					
Clean	X				
Inspect, Replace	------	X			
Pulleys, molder conveyor belt drive and idler					
Inspect, Adjust, Replace	------	X			
Molder Sheeting Rolls, Drive Shaft, Duster Bearings and Bushings					
Inspect	------	X			
Replace	------	------	X		
Eccentric, molder sheeting roll shaft					
Inspect	------	X			
Replace	------	------	X		
Gear, drive, molder sheeting rolls and conveyor					
Inspect, Replace	------	X			
Handle and Engaging Screw, duster adjusting stud					
Inspect, Replace	------	X			
Hubs W/Sprockets, front and rear sheeting roll shaft					
Inspect, Replace	------	X			
Lever, regulating, duster agitator					
Inspect, Adjust, Replace	------	X			
Pinions, lower and upper front sheeting roll adjusting shaft					
Inspect	------	X			
]Replace	------	------	X		
Pinion, molder motor shaft					
Inspect, Replace	------	X			
Rod, drive, molder sheeting roll duster					
Inspect, Replace	------	X			
Screen, molder sheeting roll duster					
Inspect, Replace	------	X			
Shaft Assemblies, sheeting roll					
Inspect	------	X			
Replace	------	------	X		
Shaft, drive, molder sheeting rolls and conveyor					
Inspect	------	X			
Replace	------	-------	X		
Springs, front sheeting roll adjusting shaft handwheel					
Inspect, Replace	------	X			
Springs, tension, chain idler sprocket					
Inspect, Replace	------	X			
Sprockets, sheeting roll shaft					
Inspect, Replace	------	X			
Stud, adjusting, duster agitator lever					
Inspect, Replace	------	X			
Controls, Instruments, and Switches					
Inspect, Repair, Replace	------	X			
Carrier, dough trough					
Inspect, Replace, Repair	------	X			

	Echelon				
	1	2	3	4	5
Springs, monorail latch					
Inspect, Replace	.....	X			
Wheel Assemblies, monorail					
Inspect	.....	X			
Replace	.....	.....	X		
OVEN TRAILER					
GROUP 06-ELECTRICAL					
Wiring, trailer and intervehicular cable					
Inspect, Replace	.....	X			
Lamps, incandescent					
Inspect, Replace	.....	X			
Lights, service and blackout					
Inspect, Repair, Replace	.....	X			
Switch, blackout					
Inspect, Replace	.....	X			
Battery, emergency brake					
Inspect	X				
Replace	.....	X			
GROUP 12-BRAKES					
Brakes, Controls, Fittings, and Lining					
Inspect, Adjust, Repair, Replace	.....	X			
GROUP 13-WHEELS, BEARINGS, HUBS, DRUMS					
Wheel Assemblies, disk, trailer					
Inspect, Replace	.....	X			
Bearings and Grease Seals, wheel					
Inspect, Replace	.....	X			
Brakedrum and Hub, trailer					
Inspect	.....	X			
Repair, Replace	.....	.....	X		
Wheel Assembly, caster					
Inspect, Repair, Replace	.....	X			
TIRES, TUBES					
Tires and Tubes, pneumatic					
Inspect, Repair, Replace	.....	X			
GROUP 15 FRAME, AXLE, TOWING ATTACHMENTS					
Lunette and Chain Assembly, safety					
Inspect	X				
Replace	.....	X			
Axle, trailer					
Inspect	.....	X			
Replace	.....	.....	X		
Bumper, rubber, trailer axle					
Inspect, Replace	.....	X			
GROUP 16-SPRINGS, SHACKLES					
Spring Assemblies and Hangers					
Inspect, Repair, Replace	.....	X			
GROUP 22-MISCELLANEOUS					
Jack Assemblies, leveling-support					
Inspect, Repair, Replace	.....	X			
GROUP 30-ELECTRIC MOTORS					
Motor Assembly, electric, oven blower					
Inspect, Replace	.....	X			
Repair	.....	.....	X		
Rebuild	.....	.....	.....	X	
GROUP 48-BAKERY MACHINERY					
Bearings, oven conveyor drive shaft and oven door					
Inspect, Replace	.....	X			

	Echelon				
	1	2	3	4	5
Belt, oven blower					
Inspect, Replace	.....	x			
Bushings, bronze, and Collars, conveyor and thrust					
Inspect, Replace	.....	x			
Cap W/Chain, oven fuel tank					
Inspect, Replace	.....	x			
Chains, roller, oven conveyor					
Inspect, Adjust, Repair, Replace	.....	x			
Cranks, oven conveyor drive shaft					
Inspect, Replace	x				
Gaskets					
Inspect, Replace	.....	x			
Block, pillow					
Inspect, Repair, Replace	.....	x			
Pulleys					
Inspect, Aline, Replace	.....	x			
Light, oven indicator					
Inspect, Repair, Replace	.....	x			
Blower, oven					
Inspect, Repair, Replace	.....	x			
Sheets, pressure relief					
Inspect	x				
Replace	.....	x			
Springs, adjusting; compression; tension					
Inspect, Adjust, Replace	.....	x			
CONTROLS, INSTRUMENTS, PANELS, SWITCHES					
Cable Assemblies and Cord, extension					
Inspect, Repair, Replace	.....	x			
Plugs, Receptacles, and Sockets					
Inspect, Replace	.....	x			
Lamps, Globes, and Holders, oven					
Inspect, Replace	.....	x			
Control, temperature					
Inspect	.....	x			
Repair, Replace	.....	.....	x		
Starter Assembly, manual, oven motor					
Inspect, Repair, Replace	.....	x			
Switch, oven light					
Inspect, Replace	.....	x			
Thermometer, oven					
Inspect, Replace	.....	x			
GROUP 56-FUEL OIL BURNER, FILTER, LINES, FITTINGS					
Burner Assembly					
Inspect, Clean, Repair, Replace	.....	x			
Tunnel, combustion					
Inspect, Clean	.....	x			
Replace	.....	.....	x		
Filter Assembly, fuel					
Inspect, Clean, Replace	.....	x			
Element, Gaskets, and Nuts, filter					
Inspect, Replace	.....	x			
Valve, float, fuel metering					
Inspect, Adjust, Repair, Replace	.....	x			
Hose and Line Assemblies					
Inspect, Replace	.....	x			
Nipples, Pipe, Tubing, Tee, Elbow, and Unions					
Inspect, Replace	.....	x			

	Echelon				
	1	2	3	4	5
Valves, globe and plug					
Inspect, Replace	.....	x			
CONTROLS, INSTRUMENTS, GAGES, SWITCHES					
Conduit, flexible, and Connectors					
Inspect, Replace	.....	x			
Gage, oven fuel tank					
Inspect, Replace	.....	x			
Plugs, twistlock and sealtite					
Inspect, Replace	.....	x			
Switch and Terminals					
Inspect, Replace	.....	x			
Valve Assembly, magnetic					
Inspect, Replace	.....	x			
PROOFING CABINET					
GROUP 32-CONTROLS, SWITCHES					
Lamp, indicator light					
Inspect, Replace	.....	x			
Light Assembly, indicator					
Inspect, Replace	.....	x			
Switch, thermostatic					
Inspect	.....	x			
Adjust, Replace	.....	.....	x		
GROUP 36-ELECTRIC FITTINGS					
Cable Assembly and Harness, internal wiring					
Inspect, Repair, Replace	.....	x			
GROUP 48-BAKERY MACHINERY					
Cam and Catch Assemblies					
Inspect, Replace	.....	x			
Gaskets, door					
Inspect, Replace	.....	x			
Heater Assemblies					
Inspect, Replace	.....	x			
Pans W/Clamps, water					
Inspect, Repair, Replace	.....	x			
Thumbscrews, door, control box					
Inspect, Replace	.....	x			
FLOUR SIFTER					
GROUP 30-ELECTRIC MOTORS					
Motor Assembly, electric, sifter					
Inspect, Replace	.....	x			
Repair	.....	.....	x		
Test, Rebuild	.....	.....	.....	x	
GROUP 32-CONTROLS, SWITCHES					
Starter Assembly, manual					
Inspect, Repair, Replace	.....	x			
GROUP 36-ELECTRIC FITTINGS					
Cable Assemblies					
Inspect, Repair, Replace	.....	x			
GROUP 48-BAKERY MACHINERY					
Spurs, sack, sifter					
Inspect, Replace	.....	x			
Sheave Assembly, counterbalance, sifter					
Inspect	.....	x			
Repair, Replace	.....	.....	x		
V-Belt, sifter drive					
Inspect, Replace	.....	x			

	Echelon				
	1	2	3	4	5
SIFTER SIEVE FRAME ASSEMBLY					
Frame Assembly, lower and upper					
Clean, Inspect, Repair, Replace	.....	X			
Gaskets, rubber, sieve frame bed					
Inspect, Replace	.....	X			
Rod., sieve frame hanger					
Inspect	.....	X			
Repair, Replace	.....	.....	X		
Shim, rubber, sieve frame and holddown box					
Inspect, Replace	.....	X			
Springs, discharge hopper door					
Inspect, Replace	.....	X			
Box Assembly, holddown, sifter					
Inspect, Replace	.....	X			
Rods, holddown box					
Inspect, Replace	.....	X			
SIFTER SIEVE INSERT ASSEMBLY					
Insert Assemblies, sieve frame					
Inspect, Replace	.....	X			
Balls, rubber, wire cleaner					
Inspect, Replace	.....	X			
Clamps, cloth tube					
Inspect, Replace	.....	X			
Sieves, wire cloth					
Inspect, Replace	.....	X			
Tube, cloth					
Inspect, Replace	.....	X			

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