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Title: Commissioning Procedure Screw conveyor					

1. Commissioning

1.1 General.


- The purpose of this Commissioning Procedure is to ensure that the functionality and control of the equipment is in accordance with design specifications.
- This commissioning procedure covers Vågen Screw Conveyors
- For installation, operation and maintenance of Vågen Screw Conveyors, refer to Vågen Technical Documentation.

1.2 Supplier assistance information.

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1.3 Check list.

There will be a separate check list per Vågen Screw Conveyor.
Ref. check lists attached.

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Screw Serial No.	
Drawing No.	
Project No.	
Tag No.	

No	Description	Comments
1	Check correct installation configuration vs. equipment installation layout drawing	
2	Verify installation levelling to be in straight line and within +/- 2,5mm, both in longitudinal and transverse direction and on all support points	
3	Verify that all screw conveyor support points have adequate foundation	
4	Verify that all bolts have been installed and are securely tightened	
5	Look for damage which might have occurred during transport or installation	
6	Verify that all necessary safety protections are installed, adapted to on site conditions and in accordance with Machinery Directive and local safety requirements	
7	Verify that gear is filled to correct oil level based on mounting position. Remove seal ring from the gear breather plug.	
8	Check all grease nipples and lubrication piping to be correctly installed, connected and filled up.	
9	Check for any oil leakage	
10	Inspect the interior of the screw conveyor and remove any debris or foreign object to secure smooth and proper rotation of the rotor inside the trough or pipe	
11	Close and secure all grids and hatches	

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No	Description	Comments
12	Check proper functioning of all gates, valves and chutes	
13	Verify that all electrical equipment and connections have been installed and tested in accordance with relevant procedures	
14	Dry run screw conveyor for 30 minutes	
15	Measure motor amps during dry-run and check verses motor rating	
16	Verify rotation and thus correct transport direction	
17	Check rotation speed verses motor and gear ratings	
18	Listen for any excessive bearing or gear noise	
19	Verify that rotor runs smoothly inside the trough or pipe without bumping against the inside of the conveyor	
20	Re-measure motor amps after 30 minutes test run and compare with previous reading	
21	Check motor and gear movements during running to verify proper installation and drive shaft straightness	
22	Check bearings, gear and motor for excessive heat after test-run	
23	Optional if full load testing: Run with material and normal load for 30 minutes	
24	Optional if full load testing: Check for any leakages during loaded test run. Tighten packing box if applicable	

All check points verified: Date: _____ **Signature:** _____