

GENERAL BATCH PLANT MAINTENANCE PROCEDURE

REXCON
An Astec Industries Company


REXCON.
MOBILE 5CM


REXCON.


REXCON.





RexCon Contacts

Parts.....(262) 539-4482
Dan Sertich (Inside)

Technical Support ..... (262) 539-4549
Jake Nitka

Electrical Support ..... (414) 973-9566
Timm Hintz



WE ACCEPT:

Any and all prices are subject to change without notice. For the most current price contact our Parts Department.

All prices F.C.A. Point of Manufacture
*Some items ship direct from other manufactures

$25.00 Charge on wire transfers under $500.00
$50.00 minumum charge for all export items.

2841 Whiting Rd, Burlington, WI 53105



RexCon has partnered with Intraflo Automatic Lubrication Systems to bring you an AutoLube system that will help prevent premature wear of your equipment.

Our system uses a proximity sensor to detect the flow of grease. This allows us to set the pump to distribute the proper amount of grease needed for the wear parts over an extended period of time.

The RexCon AutoLube System will recognize when a wear part is not receiving the grease needed. If a grease line breaks or the system is low on grease, the pump will send an error signal warning you that something has compromised the grease system.

We can retrofit any existing grease system or create a custom system for your concrete plant. Reduce unnecessary grease waste and costly equipment breakdowns. Contact our Parts Department for a custom quote today!

Standard Kit

Our standard grease system is designed for the RexCon Tilt Mixer, but can be adapted to any mixer, concrete plant grease system or batch controls.

- Digital grease pump
- Power cable
- Proximity sensor with cable
- Grease blocks
- Grease lines and fittings for all grease points
- Warning light system
- Wiring diagram
- Operator's manual

New to the RexCon parts catalog is a service kit for the Auto-grease system. It includes all the fittings to repair the Intra-flo Automatic Lube System and 40' of pre-filled grease line.

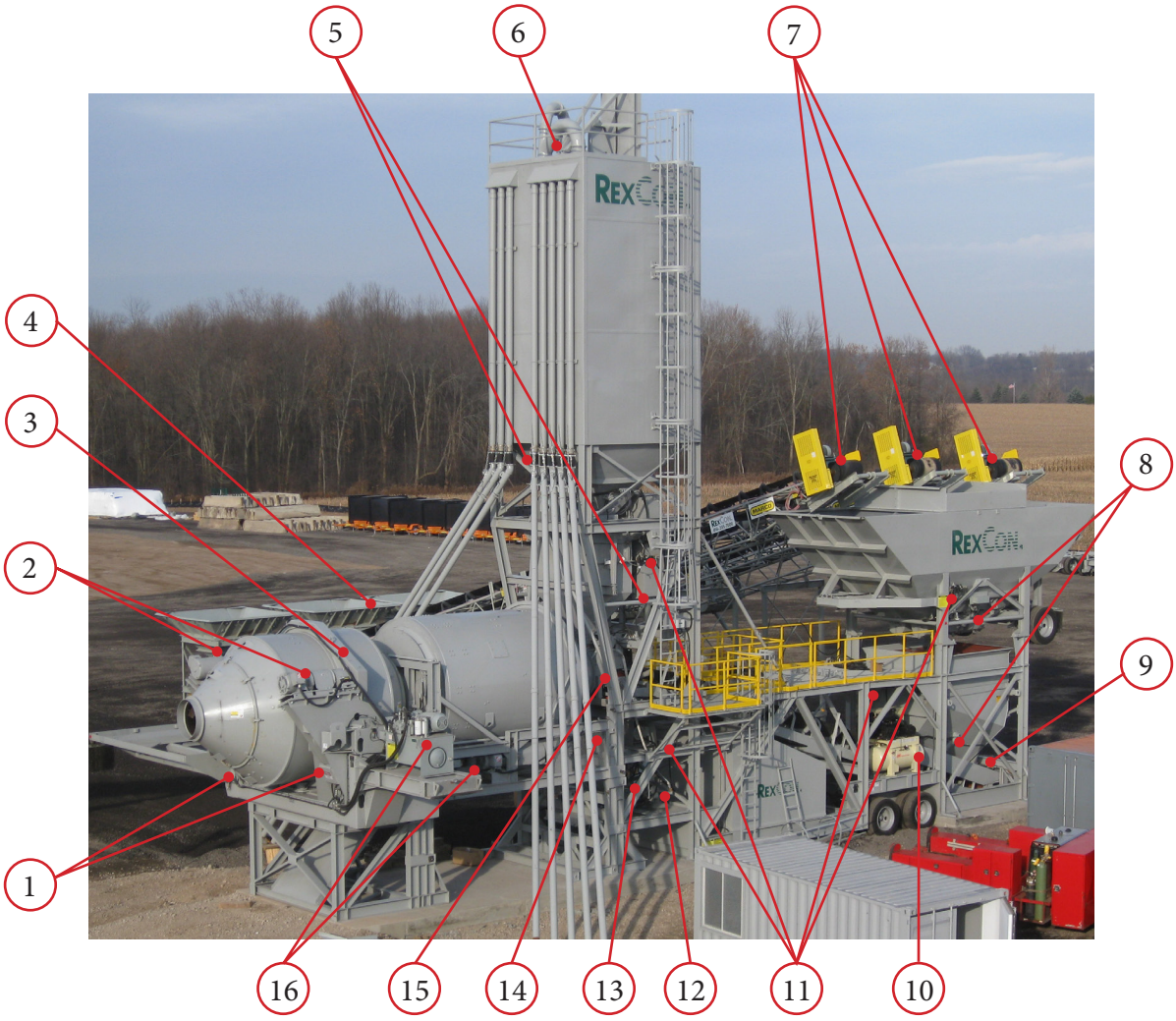
(Grease blocks sold separatly)



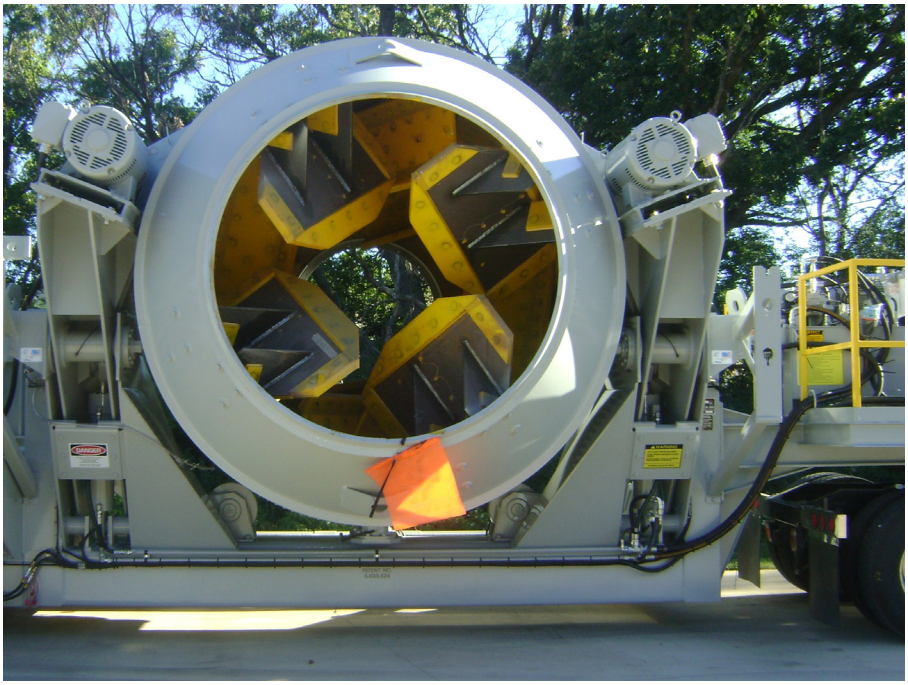


new

• LOOK FOR MORE NEW ITEMS THROUGH THE CATALOG •



1	Edge & Main Rollers, Tilt Pins, Cylinders, Bushings	9	Tail Pulley
2	Gear Boxes & Motors	10	Air System Drain
3	Pinions & Ring Gear	11	Oilers
4	Tail Pulleys	12	Water Pump
5	Bin-flo Pads	13	Water Meters
6	Ducting	14	Gear Box
7	Head Pulleys	15	Head Pulley
8	Bin Gates & Pins	16	Hydraulic Pac



DAILY MIXER MAINTENANCE

- Ensure gear drives are properly aligned & lubricated
- Grease cylinders pins, (4) pins, (4) zerks, (2) pumps
- Grease Tilt pins RBC bushings, (4)zerks, (2) pumps
- Grease cylinder bearings, (4) zerks, (2) pumps
- Grease drum rollers, (8) rollers, (8) zerks, (2) pumps
  - Use Mobilith SHC 100 Synthetic
- Ring gear (2) doors on shroud
  - Use Mobiltac 375 NC
- Check hydraulic fluid level with sight glass on tank
  - Use Mobile DTE 26
- Fill Automatic oil reservoir
  - Use IOW 30
- Fill auto-lube system. Use the grese zerk on the body of the auto-lube pump
- Fill ring gear greaser
  - Use Mobiltac 375

WEEKLY MIXER MAINTENANCE

- Check gear box oil level and fill in necessary

MONTHLY MIXER MAINTENANCE

- Run emergency tilt on hydraulic pac
- Gearboxes should get oil changed annually or every 2500 hours
- All motors should get a half shot of grease every 6 months
- Tighten blade bolts every (6) months



DAILY BASE TRAILER MAINTENANCE

- Grease agg scale gate pins, (4) zerks front & back
- Grease tail pulley, (2) zerks
- Grease head pulley, (2) zerks
  - Use Mobilith SHC 100 Synthetic
- Drain water traps and compressor
- Fill (2) air line oilers at water system and agg scale
  - Marvel Mystery Oil or Air Line Oil
- Check for air leaks at solenoids

WEEKLY BASE TRAILER MAINTENANCE

- Check batcher belt gear box oil level
  - Use SHC 629
- Check aeration blower level
  - Use Royal Purple SynFilm GT 220
- Check water pump oil level
  - Use 4oz of 90w gear oil
- Check compressor oil level
  - Use Ingersoll Rand Season Select Oil



DAILY AGGREGATE BIN MAINTENANCE

- Grease gate pins, (24) zerks
  - Use Mobilith SHC 100 Synthetic
- Fill air line oiler
  - Use Marvel Mystery Oil or Air Line Oil
- Drain water trap
- Check solenoids and cylinders for air leaks



DAILY CEMENT SILO MAINTENANCE

- Drain water trap
- Check air line oiler
  - Use Marvel Mystery Oil or Air Line Oil
- Clean cement chute, USE A SCRAPER...NOT A HAMMER!
- Check 6" vent -a-hood for cleanliness
- Check cement boots for build-up or cracking
- Check ducting
- Check man hole cover



DAILY DUST COLLECTOR MAINTENANCE

- Grease blower bearings
- Drain water trap
- Check return pot for cleanliness
- Check magnehelic gauge. It shouldn't be over 6-8" of static pressure.
- Check electric motors, 1/2 pump of grease every 6 months
- Inspect solenoids for proper operation and adjustment



DAILY CONVEYOR MAINTENANCE

- Check idlers and trailing idlers for alignment
- Drain water trap
- Check oiler
  - Use Marvel Mystery Oil or Air Line Oil
- Grease head pulley, (2) zerks
- Grease tail pulley, (2) zerks

WEEKLY CONVEYOR MAINTENANCE

- Check head pulley bearings
- Check tail pulley bearings
- Clean breather

MONTHLY CONVEYOR MAINTENANCE

- Check gear box oil level
  - Use SHC 629 Synthetic
- Check motor belt tension
- Conveyor belt tension should have 1" of play between return idlers
- Lubricate internal bearings and fill oil levels

BATCH PLANT DAILY START UP PROCEDURE

- Make sure the silo and water tank are full
- If using a generator, check oil level and start it up
- Turn on disconnect to plant
- Turn on main power panel
- Turn on key switch for 110 power
- Turn on conveyor power and fill bins
- Flip Aux. Breaker on RC3 wall mount
- Check for closed, empty lights and scale limit
- Make sure both scale meters are zero
- Put RC3 in auto and auto load on
- Turn on Mixer, Hydraulic Pac, Air Compressor, Batch Belt, Aeration Blower, Water, Pumps and Conveyors
- Rinse drum then tilt and return drum
- Enter mix design or job, then start batch

BATCH PLANT DAILY SHUT DOWN PROCEDURE

- Clean out cement chute
- Make sure the aggregate and cement scale are free and not bound up
- Blow off plant with air. DO NOT USE WATER AROUND MOTORS!!!
- Run water through drum, 200 gal. at a time, until water is clear. Use stone if there is build up. Chip any existing build-up
- Fill cement silos and water tank
- Perform plant maintenance
- Print out any report that might be needed, then reset inventory and production total
- Do a backup to a flash drive
- Turn off computer, auxiliary breakers, key switches, and the main disconnect
- Drain Y-strainer

BATCH PLANT WINTERIZATION PROCEDURE

- Completely fill all gear boxes and cover all components
- Drain all water meters, piping/pumps, and fill with anti-freeze
- Clear out all admix lines
- Drain water traps and air compressor
- Leave all gates open
- Grease all bearings
- Drain cement silos
- Clean out all aggregate bins and conveyor hoppers
- Clean out dust collector(s)
- Remove batch computers and store in a controlled enviroment
- Remove PLC and put it in something to keep dust out of it and store in a controlled enviroment

Equipment	Part	Method	Lubricant	Frequency
Tilt Mixer	Edge Roller	Grease Gun	Mobilith SHC 100	Daily
	Main Roller	Grease Gun	Mobilith 375	Daily
	Ring Gear	Grease Gun	Mobiltac 375	Daily
	Tilt Pins	Grease Gun	Mobilith SHC 100	Daily
	Cylinder Pins	Grease Gun	Mobilith SHC 100	Daily
	Drive Motor	Grease Gun	Mobilith SHC 100	6 Months
	Gear Box	Reservoir	Mobil SHC 629	Annually/Every 2500 Hrs
	Hydraulic Pac	Reservoir	Mobil DTE 26	Annually/Every 2500 Hrs
	Auto Greaser	Reservoir	Mobilith SCH 100	As Needed
	Hydraulic Breather	N/A	N/A	As Needed
	Hydraulic Filter	N/A	N/A	6 Months/As Needed
	Drip Oiler	Reservoir	10w-30	Daily
	Tilt Cylinder Bushing	Grease Gun	Mobilith SHC 100	Daily
	Emergency Tilt Pump	12v Power Supply	N/A	Monthly
Horizontal Mixer	Main Roller	Grease Gun	Mobilith SHC 100	Daily
	Edge Roller	Grease Gun	Mobilith SHC 100	Daily
	Ring Gear	Grease Gun	Mobiltac 375	Daily
	Drive Motor	Grease Gun	Mobilith SHC 100	6 Months
	Gear Box	Reservoir	Mobil SHC 629	Annually/2500 Hrs
	Hydraulic Pac	Reservoir	Mobil DTE 26	Annually/2500 Hrs
	Hydraulic Filter	N/A	N/A	6 Months/As Needed
	Transfer Gate	Reservoir	Mobilith SHC 100	Daily
	Auto Greaser	Reservoir	Mobilith SHC 100	As Needed
	Drip Oiler	Reservoir	10w-30	Daily
Silo	Airline Oiler	Reservoir	Marvel Mystery Oil	Daily
	Batch Gates	Grease Gun	Mobilith SHC 100	Daily
	Discharge Gates	Grease Gun	Mobilith SHC 100	Daily
	Aeration Blower	Reservoir	Royal Purple SHC-200	Annually/2500 Hrs
	Blower Motor	Grease Gun	Mobilith SHC 100	6 Months
	Blower Filter	N/A	N/A	6 Months/ As Needed
	Water Trap	Drain valve	N/A	Daily
Batch Conveyor	Head Pulley	Grease Gun	Mobilith SHC 100	Daily
	Tail Pulley	Grease Gun	Mobilith SHC 100	Daily
	Hold Down Roller	Grease Gun	Mobilith SHC 100	Daily
	Drive Motor	Grease Gun	Mobilith SHC 100	6 Months
	Gearbox	Reservoir	Mobil SHC 629	Annually/2500 Hrs

Equipment	Part	Method	Lubricant	Frequency
Material Conveyor	Head Pulley	Grease Gun	Mobilith SHC 100	Daily
	Tail Pulley	Grease Gun	Mobilith SHC 100	Daily
	Drive Motor	Grease Gun	Mobilith SHC 100	Daily
	Gear Box	Reservoir	Mobi SHC 629	Daily
	Hopper Gate	Grease Gun	Mobilith SHC 100	Daily
	Airline Oiler	Reservoir	Marvel Mystery Oil	Daily
	Water Trap	Drain Valve	N/A	Daily
Agg Bin	Airline Oiler	Reservoir	Marvel Mystery Oil	Daily
	Gate	Grease Gun	Mobilith SHC 100	Daily
	Water trap	Drain Valve	N/A	Daily
Agg Batcher	Airline Oiler	Reservoir	Marvel Mystery Oil	Daily
	Gate	Grease Gun	Mobilith SHC 100	Daily
	Water Trap	Drain Valve	N/A	Daily
Air Compressor	Gear Box	Grease Gun	IR All Season Select / SAE 30 (Synthetic)	Annually/2500Hrs
	Filter	N/A	N/A	6 Months/As Needed
	Motor	Grease Gun	Mobilith SHC 100	6 Months
	Water Trap	Drain Valve	N/A	Daily
Water Pump	Motor	Grease Gun	Mobilith SHC 100	6 Months
	Airline Oiler	Reservoir	Marvel Mystery Oil	Daily
	Strainer	Drain Valve & Screen	N/A	Daily
	Water Trap	Drain Valve	N/A	Daily
Screw Conveyor	Motor	Grease Gun	Mobilith SHC 100	Daily
	Gear Box	Reservoir	Mobil SHC 629	Annually/2500 Hrs
	Section Bearings	Grease Gun	Mobilith SHC 100	Refer To Manufacturer Suggested Maintenance

2841 WHITING ROAD BURLINGTON WI 53105
Tel (262) 539-4050 Fax (262) 539-4487

www.REXCON.com