Panel View 1000
Model: 12-16HR
Rev: 11

Ultima ST
Introduction

Thank you for purchasing a HayssenSandiacre packaging machine. HayssenSandiacre strives to deliver the best packaging technology combined with rugged, durable construction to provide a productive and reliable means of packaging your product.

To ensure the packaging machine lives up to all expectations, it is important to read and comply with this instruction manual. Please store this manual near the machine for easy access, as it is an important resource for all personnel involved with the operation and maintenance of the HayssenSandiacre machine.

This manual provides personnel with the information needed to safely operate and maintain the HayssenSandiacre machine. It has been designed and written to be used as an instructional tool, as well as a reference tool, for everyday work. To improve understanding by all levels of users, step-by-step instructions are provided where possible. Important tags mark information about the best ways to operate the machine, and this information can be valuable in maximizing the production and longevity of the machine.

It is important that all personnel read and understand the Safety Chapter BEFORE operating the machine. Also, read all Warning and Caution notices at the beginning of each chapter BEFORE attempting to make any adjustments or changes. Warning and Caution notices are also positioned in strategic areas throughout the manual to point out any hazards that may arise from machine setup and/or adjustment procedures.

If there are further questions about the operation or maintenance of the machine, please contact the HayssenSandiacre Service Department at (864) 486-4111, option 3. For ordering additional manuals or replacement parts, please contact the Parts Department at (864) 486-4111, option 2. Both the Parts Manual and the Instruction Manual also include an ordering guide for assistance when ordering parts. To gain the most from the machine, always use genuine HayssenSandiacre parts. Visit www.HayssenSandiacre.com for more information about equipment and parts.
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CHAPTER 1: MACHINE OVERVIEW

COMPONENT IDENTIFICATION

Unwind Stand
Registration Roller
Pull Belts
Forming Tube
Platen
End Seal

Figure 1: Component Identification

<table>
<thead>
<tr>
<th>Component Overview</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>UNWIND ASSEMBLY</strong></td>
</tr>
<tr>
<td>The unwind stand unwinds film from the spindle and supplies it to the registration</td>
</tr>
<tr>
<td>roller assembly.</td>
</tr>
<tr>
<td><strong>REGISTRATION ROLLER ASSEMBLY</strong></td>
</tr>
<tr>
<td>The registration roller assembly pulls one bag length of film for each bag making</td>
</tr>
<tr>
<td>cycle.</td>
</tr>
<tr>
<td><strong>FORMING ASSEMBLY</strong></td>
</tr>
<tr>
<td>The forming shoulder shapes the film into a tube with a seam in the front as the pull</td>
</tr>
<tr>
<td>belts move the film forward.</td>
</tr>
<tr>
<td><strong>PULL BELT ASSEMBLY</strong></td>
</tr>
<tr>
<td>The pull belts pull film over the forming shoulder and into the end seal jaw area.</td>
</tr>
<tr>
<td><strong>PLATEN ASSEMBLY</strong></td>
</tr>
<tr>
<td>The platen is a heated bar which seals the vertical seam on the bag.</td>
</tr>
<tr>
<td><strong>END SEAL ASSEMBLY</strong></td>
</tr>
<tr>
<td>The jaws form the top and bottom seals and the knife separates the bags.</td>
</tr>
</tbody>
</table>
The bagger forms plain or printed film into a tube, adds product then seals and ejects the filled bag.

Component Overview

| DRIP PAN (NOT VISIBLE IN DRAWING) | The drip pan can be bolted to the top frame of the machine to catch any overhead falling items, preventing them from reaching the bagger. |

OPERATION OVERVIEW

Figure 2: Film Measure, Form and Pull

The bagger forms plain or printed film into a tube, adds product then seals and ejects the filled bag.
Pre-programmed bag length pulled by registration rollers and pull belt.

Various seals are fused in the jaw area:
1. Platen fuses the back seal.
2. End seal jaw seals the top of the filled bag and the bottom of the next bag.

Knife cuts between the bottom seal and top seal of the bags.

Finished bag drops from end seal.

Registration rollers pull the film from the unwind stand as the pull belts roll the film over the forming tube assembly to maintain tension.

The platen is heated to a programmed temperature. The jaws consist of two hot metal dies.

If installed, bag ejector ejects the bag. The next bag making cycle begins.
CHAPTER 2: SAFETY

SAFETY OVERVIEW

Safety depends on everyone who operates, maintains, services, or works nearby operating equipment. Any person involved with the operation of this equipment should be familiar with the following danger, warning, and caution notices.

Personnel should NOT operate this machine until trained on its function and purpose.

Safety Signals

The following signal words are used to inform about potential hazards and proper machine usage.

- **WARNING:** Alerts to a potential hazard that results in serious personal injury or possible death unless avoided.
- **CAUTION:** Alerts to a potential hazard that may result in personal injury, or an unsafe practice that causes damage to the equipment or property if not avoided.
- **IMPORTANT:** Identifies specific information that will assist with machine operation, prevent damage to the machine, or extend the life of machine parts.

BASIC DANGER AND WARNING NOTICES

Installation

Only trained machinery movers, using appropriate and well-maintained equipment, should handle, move, and install the machine. Please refer to the installation chapter in this manual for complete instruction and safety information.

Guards

Guards are supplied with the machine and must be in place before operation begins. NEVER bypass or disconnect safety switches. Doing so could greatly increase the chance for personal injury.
Guards are installed to protect personnel working on or around the machine. Guards **MUST** be closed when the machine is operating.

Figure 1: Guards Warning Notice

![Guards Warning Notice](image)

Safety switches are located on each guard. If a guard is opened while the machine is running, the machine stops and the operator interface indicates which door is open.

Guard design is based on level machine footings that are even with the work area. Raising the machine or using platforms, staircases, stools, or ladders near the machine creates hazardous operating conditions.

Guards shield personnel from moving parts. Reaching over, under, or through a guard, blocking it open, or tampering with a guard interlock is **EXTREMELY** hazardous and must **NEVER** be attempted. Guards should **NEVER** be altered from factory setup.

Work with special care when guards are removed for lubrication, adjustment, and part replacement. All guards should be reinstalled correctly immediately following maintenance or repair.

Opening a guard **DOES NOT** disconnect electrical power in the control cabinet. To disconnect control power, padlock the main disconnect in the **OFF** position.

**Machine Location**

- Machine location must provide sound footing, adequate lighting, and accessibility from all sides.
• **DO NOT** install the machine in a combustible environment or near combustible or explosive material.

• Keep the area around the machine clean and free of obstacles to avoid injuries due to falls.

**Burn, Nip, and Pinch Points**

NEVER touch or repair components while they are hot. If heat components must be handled, use insulated gloves and mechanical devices where practical.

---

**Figure 3: Safety Symbols**

Be **EXTREMELY** careful when working near nip points and pinch points. Keep body parts, hair, neckties, clothing, and tools away from these hazards to prevent serious injury or death. **DO NOT** wear rings, watches, or necklaces near the machine.

All notices, labels, and plates must be in place and legible. Immediately replace damaged or missing labels and notices. Contact Hayssen-Sandiacre Parts for replacement notices, labels, and plates.

**Electrical**

---

**Figure 4: Electrical Warning Notices**
A qualified electrician must install and repair electrical equipment and verify electrical ground. Complete electrical information is provided in the electrical chapter of this manual.

- **ALWAYS** padlock the electrical disconnect in the **OFF** position before adjusting, cleaning, lubricating, or maintaining the machine.
- **DO NOT** make revisions or additions to the programmable controller. This impairs the operation of the machine.
- **NEVER** use jumper wires to bypass electrical circuits. Doing so may activate parts of the machine which could cut, crush, or seriously injure persons in the immediate area.
- Modifications or additions to the electrical system causes machine malfunction and creates safety hazards for personnel.
- The electronic controller on the machine requires an electrically clean environment.
- **DO NOT** break the seal, bypass, or change settings to the air pressure switch.

**IMPORTANT:**
Any changes not authorized by HayssenSandiacre may void the machine warranty. If there are any question or a need for modification, contact HayssenSandiacre.

**Replacement Parts**
Parts should be replaced by maintenance personnel familiar with the machine. Please contact HayssenSandiacre for assistance.

- High voltage electrical shocks cause serious injury or death if repairs are made with power applied.
- **DO NOT** replace parts while the machine is in operation.
- **DO NOT** operate the machine while parts are removed.
- Removing parts with power applied stalls processors and causes problems in other areas of operation due to stray voltage.

**IMPORTANT:**
**NEVER** remove or replace any part with power applied

**Lubrication**
**ALWAYS** padlock the electrical disconnect in the **OFF** position before lubricating the machine. Specific lubrication instructions are located in the Preventive Maintenance chapter of this manual.

- Lubricate manual fittings **BEFORE** operation.
- Verify lubrication system is operational.
CHAPTER 3: INSTALLATION

MACHINE DELIVERY

When the machine arrives, inspect the entire shipment for damage. If there is damage, photograph for verification and immediately file a claim with the carrier.

- Provide competent machinery movers when the machine arrives.
- Note the gross weight of the machine shown on machine order acknowledgement and on the bill of lading.
- Study the mass and weight distribution of the machine.
- Refer to the illustration showing recommended lifting points.

PREPARE SITE AND UTILITIES FOR MACHINE

Select the machine site carefully. The structure must support the machine and production activities. The area should be well lit for operator efficiency and accessible from all sides for service, maintenance and operation.

WARNING:
DO NOT install the machine in a combustible environment or near explosives.

INSTALLING AIR DEVICES

- Supply clean dry air with a minimum of 65 PSI
- Use pipe that is at least the size of the inlet (minimum 1/2"). A smaller pipe can be used only if a surge tank is in place.
- The following chart may be used as a guide for installing air devices.

IMPORTANT:
The exact consumption may vary slightly. Consumption depends on model, speed, and auxiliary equipment. Call HayssenSandiacre for exact specifications.
INSTALLING ELECTRICAL DEVICES

A fused disconnect must be provided for the machine. The microprocessor in the machine requires an isolated, clean voltage power source. Follow voltage requirements as specified in the Order Acknowledgement.

<table>
<thead>
<tr>
<th>Model</th>
<th>Bags/Minute</th>
<th>scfm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Single Tube w/ Resistance Seal</td>
<td>10</td>
<td>2.5 scfm</td>
</tr>
<tr>
<td>Single Tube w/ Quali-Seal</td>
<td>10</td>
<td>3.5</td>
</tr>
<tr>
<td>Twin Tube w/ Combination Seal</td>
<td>10/side</td>
<td>7.0</td>
</tr>
<tr>
<td>Twin Tube w/ Resistance Seal</td>
<td>20 (10/side)</td>
<td>5.0</td>
</tr>
<tr>
<td>Twin Tube w/ Quali-Seal</td>
<td>20 (10/side)</td>
<td>7.0</td>
</tr>
<tr>
<td>Twin Tube w/ Combination Seal</td>
<td>20 (10/side)</td>
<td>7.0</td>
</tr>
</tbody>
</table>

WARNING:
External power MUST be wired through the bottom rear side of the electrical enclosure. This eliminates the possibility of metal chips coming in contact with the boards or components, possibly causing sparks, shock or machine damage.

The proper location for wiring external power without a voltage transformer has been designated with the customer power decal. If a voltage transformer is required, the external power should:

- Enter the transformer on the primary side terminals inside the transformer.
- The secondary side terminals go to the location designated with the customer power decal.

Machines are prewired to the Order Acknowledgement. Check the name plate on the electrical cabinet for the exact power requirements. A labeled terminal is provided in the electrical enclosure for this connection. If further assistance is needed, contact the HayssenSandiacre Service Department.

WARNING:
Ground the machine using an earth permanent device. Failure to ground the machine could result in electric shock and damage to the machine.
Ground Fault Circuit Interrupter (GFCI)

Current can flow through a person if electrically hot lines are touched while an individual is also touching the machine. The GFCI acts as an overload device that senses ground currents which can be caused by wet wiring in equipment or contact with hot lines.

Proper installation and monthly circuit breaker testing are important for the protection of personnel and proper maintenance. Record each circuit breaker test in the machine maintenance records.

The GFCI is intended to protect all personnel who are associated with machine operation.

**WARNING:**

- **DO NOT** disable the GFCI. It protects against overloads, short circuits, and potential ground fault conditions that cause serious injury or death.
- The **GFCI DOES NOT** eliminate shock but only reduces the amount of shock a victim feels. Persons with heart problems or poor health could be seriously injured.
- Machine power must be **OFF** before service or maintenance.

Power Source for External Devices

External devices need a power source separate from the bagger. Some external devices (metal detector, coupon inserter, etc.) can cause random, strange behavior in the bagger control system when they are powered off the bagger’s power supply.

TO LIFT MACHINE FROM SKID

The machine should remain on the platform or skid until it has been moved to the installation site.

**WARNING:**

When lifting or moving the machine adhere to the following guidelines to prevent harm to personnel or machinery:

- Use the recommended lift points. Damage resulting from incorrect lifting may require the machine be returned to the manufacturer for repair at the customer’s expense.
- Handling, moving, and installation should be done only by trained machinery movers using appropriate equipment.
- Use equipment with adequate capacity.
- Prevent anyone from walking, crawling, or reaching under the machine while it is solely supported by a forklift or other device.
**To Lift Machine from Skid**

- Keep hands and feet clear of the machine, platform, or skid and the wheels of the lifting equipment.
- Watch for overhead utility lines, low clearances, and other obstructions.
- Remain alert and careful.
- Before lifting the machine, remove all unsecure items, blocks, and fasteners from the skid.

**Figure 1: Lift Points**

To lift the machine, a fork lift or other suitable lifting device and four hoist straps are required.

1. Loop a hoist strap under each corner of the frame (1 and 2).
2. Position the fork lift at the front of the machine with forks raised.
3. Slide the loose end of each hoist strap over the adjacent fork, front straps first.

**IMPORTANT:**

When lifting the machine, carefully secure slings to the four top outside corners of the machine frame.
4. Slowly lift the machine.
5. Remove platform or skid.
6. Install leveling feet.
7. Lower and position machine onto floor pads.
8. Remove hoist straps.
9. Adjust feet to level the machine.

PRODUCT FEED INTERFACE INSTALLATION AND OPERATION

**Feed System**

Use the interface schematic provided to connect the bagger to the feed system. The schematic is included in the panel set of drawings shipped with the machine and in the parts manual.

**Electrical**

Use the interface schematic provided to connect the bagger to the feed system. The schematic is included in the panel set of drawings shipped with the machine and in the parts manual.

**IMPORTANT:**

Follow electrical requirements outlined in the feed system instruction manual. The feed system should have its own protected line supply. In most cases, an earth ground is required. If it is required, the feed system earth ground should be terminated on the same grounding bus as the machine.

**Timing**

The control unit contains a time delay signal with a maximum delay equal to the cycle time. It cannot delay a dump signal into the next cycle. This delay is used to approximate the time the product takes to fall from the feed system to the jaw area.

Frequently time delay may not be sufficient to account for the total drop time. Additional transfer time delays must be provided by the feed system. Provide a maximum of 1000 milliseconds delay between the actual dump signal and the signal given to the machine.

**Product Spacing**

There must be sufficient space between dumps to allow the jaws to close without catching the product. The amount of space depends on bag width, product volume, speed, funnel slope and product drop characteristics. One or more of these might require modification if product stringout does not allow enough space.

Inadequate space between dumps may:

- cause product to be caught in the end seal resulting in waste and cleanup problems.
- cause product intended for one bag to transfer to another with corresponding under/over weight results.
**Mechanical Interface**

The usual mechanical interface is a transition chute between the end of the feed system discharge and the entrance to the forming tube assembly funnel.

<table>
<thead>
<tr>
<th>1. Poker</th>
<th>2. Product Shield</th>
</tr>
</thead>
<tbody>
<tr>
<td>A. Width of Poker Access Hole</td>
<td>B. Height of Poker Access Hole</td>
</tr>
<tr>
<td>C. Diameter of Transition Chute</td>
<td></td>
</tr>
</tbody>
</table>

![Figure 2: Transition Chute](image)

**Double Dumping**

Double dumping to achieve larger weights is not recommended in most cases. However, machines with a volumetric feed system can have double dumps. The feed system should give a signal on each dump.
MEZZANINE INSTALLATION

**WARNING:**
To prevent injury to personnel and equipment damage, use proper lifting, and equipment moving techniques. Restrict personnel from walking, crawling, or reaching under equipment while it is supported.

---

**Figure 3: Typical Scale Mezzanine Components**

1. Measure the length of the tie bar assemblies and set the legs upright this distance apart.
2. Attach the tie bars to the legs.
3. Secure all mounting bolts and attach the mezzanine to the floor to eliminate rocking.
4. Ensure the mezzanine is level by placing shims under as needed.
5. Attach the hoist hooks to the eye bolts on the scale and lift it with the hoist. Use a sling, as needed, to distribute the weight. Lift the scale and place it onto the mezzanine on mounting pads.
6. Level the scale on the mezzanine by shimming between the pads and scale frame. Level to 1/32" (0.8mm) per foot.
7. If the scale does not rest on all four pads, shim the corners to support the scale before tightening the mounting bolts.

8. If the mezzanine has a stairway and platform instead of a ladder:
   a. Install the railing which is adjacent to the stairway.
   b. Bolt the platform in place.
   c. Bolt the platform rail in place.
   d. Lift the stairway into place and bolt onto the platform.


10. Secure the ladder in the appropriate place.

**IMPORTANT:**
The ladder, or stairway and platform may be moved to the opposite side of the mezzanine by reversing railings. This places the ladder or stairs at the right hand front.
CHAPTER 4: PREVENTATIVE MAINTENANCE

HayssenSandiacre packaging machines are designed for minimum maintenance. There are a few areas that must be serviced regularly.

**WARNING:**
Turn all power to the machine **OFF** before doing any lubrication, cleaning, adjustments or maintenance.

LUBRICATION

Use HayssenSandiacre Lubri-Can™ food grade lubricants to properly maintain the machine. A full line of H1 approved oil and grease is available.

![Figure 1: HayssenSandiacre Lubri-Can Food Lubricants](image)

<table>
<thead>
<tr>
<th>Type of Lubricant</th>
<th>Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pneumatic System</td>
<td>1 gallon</td>
</tr>
<tr>
<td></td>
<td>5 gallon</td>
</tr>
<tr>
<td></td>
<td>55 gallon</td>
</tr>
<tr>
<td>Volumetric and Auger Gear Oil</td>
<td>1 gallon</td>
</tr>
<tr>
<td>Grease</td>
<td>14.5 ounces</td>
</tr>
</tbody>
</table>
### Lubrication Chart

<table>
<thead>
<tr>
<th>Item</th>
<th>Area of Machine</th>
<th>Lubricant</th>
<th>Change</th>
<th>Clean</th>
<th>Frequency</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Clevis Pin On End Seal Jaw</td>
<td>grease</td>
<td></td>
<td></td>
<td>every 8 hours</td>
</tr>
<tr>
<td>2.</td>
<td>Trunion Mounts</td>
<td>grease</td>
<td></td>
<td></td>
<td>every 160 hours</td>
</tr>
<tr>
<td>3.</td>
<td>Universal Joints On Drive Shafts Of Pull Belts</td>
<td>grease</td>
<td></td>
<td></td>
<td>every 6 months</td>
</tr>
<tr>
<td>4.</td>
<td>Air Line Lubricator</td>
<td>Pneumatic system oil</td>
<td></td>
<td></td>
<td>every 8 hours or as needed</td>
</tr>
<tr>
<td>5.</td>
<td>Air Filter</td>
<td>none</td>
<td>X</td>
<td></td>
<td>drain as needed</td>
</tr>
<tr>
<td>6.</td>
<td>Oil Recovery Filter</td>
<td>none</td>
<td>X</td>
<td></td>
<td>drain as needed</td>
</tr>
<tr>
<td>7.</td>
<td>Spur Gears On End Of Registration Roller Assembly</td>
<td>multi-purpose grease</td>
<td></td>
<td></td>
<td>every 40 hours</td>
</tr>
<tr>
<td>8.</td>
<td>Stub Shaft On Unwind Motor</td>
<td>multi-purpose grease</td>
<td></td>
<td></td>
<td>every 40 hours</td>
</tr>
<tr>
<td>9.</td>
<td>Support Shafts Of Unwind Stand</td>
<td>light weight oil</td>
<td></td>
<td></td>
<td>every 40 hours</td>
</tr>
<tr>
<td>10.</td>
<td>Registration Eye Threaded Shaft</td>
<td>light weight oil</td>
<td></td>
<td></td>
<td>every 40 hours</td>
</tr>
<tr>
<td>11.</td>
<td>Jaw Guide Shafts</td>
<td>none</td>
<td>X</td>
<td></td>
<td>every 40 hours</td>
</tr>
<tr>
<td>12.</td>
<td>Pull Belt Support Shafts</td>
<td>light weight oil</td>
<td>X</td>
<td></td>
<td>every 40 hours</td>
</tr>
<tr>
<td>13.</td>
<td>Pull Belts</td>
<td>X</td>
<td></td>
<td></td>
<td>as needed</td>
</tr>
<tr>
<td>14.</td>
<td>Jaw Motor Drive Belts (applies to SU only)</td>
<td>X</td>
<td>yearly</td>
<td></td>
<td></td>
</tr>
<tr>
<td>15.</td>
<td>Jaw Cylinders</td>
<td>X</td>
<td></td>
<td>every 5 million cycles</td>
<td></td>
</tr>
<tr>
<td>16.</td>
<td>Platen Actuator Shafts (front and rear) Quad Seal Only</td>
<td>light oil</td>
<td></td>
<td>every 40 hours</td>
<td></td>
</tr>
<tr>
<td>17.</td>
<td>Pull Belt Auxiliary Drive Belt (Quad Seal Only)</td>
<td>light oil</td>
<td></td>
<td>every 40 hours</td>
<td></td>
</tr>
<tr>
<td>18.</td>
<td>Platen Air Cylinder Shaft</td>
<td>light oil</td>
<td></td>
<td>every 3 months or as required</td>
<td></td>
</tr>
<tr>
<td>19.</td>
<td>Bearings w/grease fittings</td>
<td>HayssenSandiacre Lubri-Can Food Grade grease</td>
<td></td>
<td>every 80 - 100 hours</td>
<td></td>
</tr>
</tbody>
</table>
GENERAL MAINTENANCE

Rollers

Periodically inspect all rollers in the feed system. Remove any rollers that do not turn freely and replace the bearings.

Bearing lubrication is not recommended as they operate under very light loads. Lubricant attracts dust and dirt from the atmosphere and accelerates contamination.

Belts

Check the registration roller drive belt for excessive wear and slack every 160 hours of operation. Inspect screws, bolts and setscrews. Retighten where necessary.

APPLYING LOCTITE®

The recommended amount of LocTite® to use is usually 1/3 of the engaged area.

Primers are not required with threadlocker adhesives, but do speed the cure and act as a cleaner.

Standard LocTite® is not designed for temperatures higher than 300°F (149°C). In areas above 300°F, use LocTite® Product 620, which is specifically designed for temperatures between 300°F and 450°F (232°C).

IMPORTANT:
• HayssenSandiacre uses only USDA approved LocTite®.
• When using LocTite®, DO NOT use lock washers.
• DO NOT use LocTite® on any adjustment screws.
GUIDELINES FOR WASHDOWN ENVIRONMENTS

These recommendations should be followed to help prevent problems from occurring in environments where machinery is exposed to water during clean-up.

**CAUTION:**
- **DO NOT** use this procedure on painted machines; it will cause rust.
- Use this procedure on **STAINLESS STEEL MACHINES ONLY!**

**Bagger**

**IMPORTANT:**
- The preferred cleaning method is to wipe the unit down or to blow the unit off with compressed air.
- If components such as clutches, brakes, or rollers get “wet” some erratic operations, such as bag length variation due to slip, can be expected until the components dry.

**CAUTION:**
- To avoid injury, **ALL POWER TO THE INFEED MUST BE OFF** before completing this procedure.
- **DO NOT** apply the water stream directly on electrical components.
- Water pressure used to rinse the machine should be regulated to 5 psi maximum.
- A nozzle should **NOT** be used to increase force applied. **Use open ended hose only.**
- Use neutral cleaning solution (pH 6-8).

1. Turn all power to the Infeed System **Off**.
   Use appropriate lockout/tagout procedures.
2. Insure all openings to the electrical panels are sealed.
3. Cover all electrical enclosures, user interface and all motors with plastic or suitable material prior to applying any water to the machine.
4. Apply cleaning solution.
5. Use a soft brush or a plastic scraper to remove heavy deposits.
6. Rinse with clean water.
7. Remove excess water.
8. Allow machine to dry.
9. Remove plastic covers from machine components.
10. Restore power to the machine.
Scale

**IMPORTANT:**
- Refer to your scale operation manual for the manufacturer’s recommended cleaning procedure.
- It is strongly recommended that all buckets and vibratory feed pans be removed prior to cleaning the main scale body. The removed components should be cleaned and/or sterilized while removed.

**CAUTION:**
- These units are **NOT** made to be pressure washed. Exceeding the water pressure specified can cause seals to leak which may result in damage to electrical components.
- Water pressure used to clean the machine should be regulated to 5 psi maximum.
- A nozzle should **NOT** be used to increase force applied. **Use open ended hose only.**
- Use neutral cleaning solution (pH 6-8).

1. Insure all openings to the electrical panels are sealed.
2. Remove weigh buckets to prevent possible load cell damage.
3. Cover the MDT, SCC or RCU.
CHAPTER 5: OPERATOR INTERFACE

ALLEN BRADLEY PANELVIEW 1000

The bagger uses a touchscreen interface to enable or disable machine functions and set operating parameters. Below is a visual aid for navigation from screen to screen.

IMPORTANT:
• Applying too much pressure to the touchscreen may cause damage to the display.
• Screens on the machine may differ slightly from those shown in this manual. Screens are shown with all possible touchpads. Some touchpads only appear when a specific action occurs. Other touchpads are available one if certain are installed.
• Any touchpad not described with a screen is listed in the Common Functions table.
**Common Functions**

<table>
<thead>
<tr>
<th><strong>MESSAGES/ERRORS</strong></th>
<th>Operation messages, errors, and warnings display in the rectangular box near the bottom of the screen.</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>ACCU-TRACK</strong></td>
<td>The Accu-Track system monitors the film edge, and automatically adjusts the unwind stand left or right to maintain correct film position at the forming shoulder.</td>
</tr>
<tr>
<td><strong>UNWIND MANUAL</strong></td>
<td>When Accu-Track is disabled, Unwind Manual Left or Right touchpads at the bottom of the screen are used to move the unwind in the desired direction.</td>
</tr>
<tr>
<td><strong>START/STOP</strong></td>
<td>Start and stop the machine using the corresponding touchpad. The pad illuminates after being touched.</td>
</tr>
<tr>
<td><strong>RETURN</strong></td>
<td>The previously viewed screen displays when the Return pad is touched.</td>
</tr>
<tr>
<td><strong>PLAIN FILM</strong></td>
<td>Also known as unregistered film. Plain Film is selected when using film without an eyespot (no registration mark).</td>
</tr>
</tbody>
</table>

*Auger screen not available via the Empty Bag screen.*
<table>
<thead>
<tr>
<th>Common Functions</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>PRINTED FILM</strong></td>
</tr>
<tr>
<td>Also known as registered film. Printed Film is selected when using film with an eyespot (registration mark).</td>
</tr>
<tr>
<td><strong>FILM SETUP</strong></td>
</tr>
<tr>
<td>Advances the registration position where the film stops to ensure the first bag is made in registration.</td>
</tr>
<tr>
<td><strong>SINGLE CYCLE</strong></td>
</tr>
<tr>
<td>When the machine is in single cycle mode, a single bag is produced each time the <strong>Start</strong> pad is touched.</td>
</tr>
<tr>
<td><strong>CONTINUOUS CYCLE</strong></td>
</tr>
<tr>
<td>When the machine is in continuous cycle mode, empty bags are produced continuously when the <strong>Start</strong> pad is touched until the <strong>Stop</strong> pad is touched.</td>
</tr>
<tr>
<td><strong>NEXT PANEL</strong></td>
</tr>
<tr>
<td>When there are multiple screens under one heading (machine setup), touching <strong>Next Panel</strong> will display the next screen.</td>
</tr>
<tr>
<td><strong>CURRENT RECIPE</strong></td>
</tr>
<tr>
<td>Displays the active recipe.</td>
</tr>
<tr>
<td><strong>FROM DEG</strong></td>
</tr>
<tr>
<td>The start time (in machine degrees) for each machine function.</td>
</tr>
<tr>
<td><strong>TO DEGREE</strong></td>
</tr>
<tr>
<td>The stop time (in machine degrees) for each machine function.</td>
</tr>
<tr>
<td><strong>O/I</strong></td>
</tr>
<tr>
<td>Touchpads directly beneath the O/I label are touched to enable or disable a function. Enabled functions are illuminated.</td>
</tr>
<tr>
<td><strong>INDICATOR CIRCLE</strong></td>
</tr>
<tr>
<td>Touchpads located next to a function label are touched to enable or disable a function or access another screen. Enabled functions are illuminated.</td>
</tr>
</tbody>
</table>
PANELVIEW 1000 SCREENS

IMPORTANT:
- The Typical Values shown are representative of a recipe producing 8" bags at 60 bags per minute.
- These screens include information/typical values for optional equipment that may not be on every machine.

POWER UP

This screen is the first to appear when the power is cycled. This screen indicates a successful system initialization.

A Barry-Wehmiller Company
225 SPARTANGREEN BLVD.
DUNCAN, SC. 29334
PHONE: 864-486-4000
FAX: 864-486-4383
<table>
<thead>
<tr>
<th>Mode</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Manual</td>
<td>Provides access to the Manual Functions screen to operate machine features without producing bags or energizing the feed system.</td>
</tr>
<tr>
<td>Empty Bags</td>
<td>Provides access to the Empty Bags screen to set machine parameters and run sample bags without energizing the feed system.</td>
</tr>
<tr>
<td>Filled Bags</td>
<td>Provides access to the Filled Bags screen to set machine parameters and produce bags filled with product.</td>
</tr>
<tr>
<td>Program Setup</td>
<td>Provides access to the Program Setup screen to setup up feed system.</td>
</tr>
<tr>
<td>Program Select</td>
<td>Provides access to the Program Selection screen to load and save new recipes. This screen is also used to enter the password for Engineering level access to the System Installation screen to setup machine functions.</td>
</tr>
<tr>
<td>Diagnostic</td>
<td>Provides access to the Diagnostic screen to monitor machine states, the status of the discrete logic controller inputs and outputs, and Hayssen-Sandiacre part numbers for installed software.</td>
</tr>
</tbody>
</table>