

STANDARD WORK INSTRUCTION DOCUMENT

SELCO

Description: H-100 Autobagger S.W.I.D.# 7595-03

Originator: G. Mayfield - Process Technician DATE: 02/25/02

Q.C. Approval: \_\_\_\_\_ REVISION: D

Mfg. Approval: \_\_\_\_\_

Scope:

Safety Considerations

Operating Procedures

Maintenance

1. Safety Considerations:

- 1.1 Do not use equipment without supervision until training is complete and documented.
- 1.2 Remove all jewelry and bind or secure all loose clothing and long hair prior to operating equipment.
- 1.3 Do not use any chemicals before reading M.S.D.S. and properly documenting.
- 1.4 Safety glasses required.

2. Operating Procedures: Start Up

- 2.1 Connect air hose to an air source.
- 2.2 Plug bagger power cord to a 110-volt power supply.
- 2.3 Plug SN-100 sensor into 110-volt power supply.
- 2.4 Switch main power & sensor switch to ON position.
- 2.5 Press COUNT button to display count settings.
- 2.6 Check Total Count, it must display 504 to begin, if not press arrow button up or down until Total Count is highlighted.
- 2.7 Type in 504 using key pad on face of display then press the F4 button to reset count at 504.

- 2.8 Press down arrow once to highlight Set Lot Size, then press the Count button.
- 2.9 Check program settings.
  - Seal Time - 0.05 - 0.20
  - Seal Temp. - 400 Deg. Fer.
  - Seal Point - 0.40
  - Count - 504
  - Pace Rate - 70
  - Air Pulse - 0.05 - 0.15
  - Job - 1 Excel

### 3. Operating Procedures: Loading Bags

- 3.1 Loosen set screw, and remove collar holding empty bag reel.
- 3.2 Remove empty reel from shaft.
- 3.3 Place new reel of bags onto shaft, and lock into place with collar.  
**Note:** Bags must unroll from top of reel.
- 3.4 Thread bags through tension rollers according to diagram on left side of machine.
- 3.5 Press and hold bag feed switch, carefully place end of bag into back of bagger and let feed through until first bag appears on other side of bagger release feed switch.
- 3.6 Feed bag until perforated edge is approximately 1 in. below part feed tube.

### 4. Operating Procedures: Bagging

- 4.1 Press F2 to turn on air.  
**Note:** This will hold bag open.
- 4.2 Place empty shipper under bagger, and align with part feed tube.
- 4.3 Drop one wrist strap through sensor shute of bagger. Bagger will auto cycle.  
**Note:** If bagger faults have problem fixed by mait. if needed, then press reset, and -1 bag.
- 4.4 Repeat step 4.3 until count reaches (0) and display say's COUNT.
- 4.5 Remove filled shipper from under bagger and replace with empty shipper.
- 4.6 Press RESET button to reset count.

4.7 Repeat steps 4.3 thru 4.6.

5. Operating Procedure: End of Shift

5.1 Switch main power to OFF position.

5.2 Switch sensor power to OFF position.

6. Maintenance:

**NOTE:** For any machine malfunction, shut down equipment and notify Maintenance Technician. Do not attempt to repair machine yourself.

7. SWID History:

<u>Date</u>	<u>Rev</u>	<u>Author</u>	<u>Reason For Change</u>
09/18/00	New	G. Mayfield	New
12/11/00	A	"	Updated steps 2.6, 2.7, 3.2, 3.4
01/23/01	B	"	Updated step 2.9
08/07/01	C	"	Updated step 2.9
02/25/02	D	"	Changed Count on steps 2.6, 2.7, 2.9