WEIGHPACK™

SWIFTY BAGGER® JUNIOR

OPERATOR'S MANUAL

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Preface

Thank you for purchasing from WeighPack Systems Inc.

It is strongly recommended that this manual be read before use of the Swifty Jr machine. This manual contains detailed descriptions of the structure, function, operation and maintenance of the Swifty Jr. Also, please note that due to continuous improvements, the contents of this manual may differ slightly from the machine received. In the event this document cannot provide the answers to problems arising from machine operation or other circumstances, please contact the WeighPack service department immediately.

Contact Us

Head Office Phone Number	1-888-WEIGHPACK
WeighPack Website	WWW.WEIGHPACK.COM

LIABILITY DISCLAIMER

All statements, technical information and recommendations contained in this manual or any other information supplied by WeighPack in connection with the use, features and qualifications of the WeighPack machine are based on tests believed to be reliable, but the accuracy or completeness thereof is not guaranteed. Before using the WeighPack machine, the owner should determine the machine's suitability for its intended use based on the owner's knowledge and the characteristics of materials intended to be used with the machine. The Buyer bears all risk in connection with the use of the WeighPack machine.

Since the use of this manual and the conditions or methods of installation, operation, use and maintenance of the WeighPack machine is beyond the control of WeighPack, WeighPack does not assume responsibility and expressly disclaims liability for loss, damage or expense, whether direct, indirect, consequential or incidental, arising out of or anyway connected with such installation, operation, use, or maintenance. Damage caused by neglect, misuse or failure to comply with this manual will invalidate the warranty of the WeighPack equipment.

1. SAFETY

IMPORTANT SAFETY INFORMATION

READ ALL INSTRUCTIONS BEFORE OPERATING

Do not operate the machine when tired, ill, or under the influence of alcohol, drugs or medication.

The instructions and data in this manual are vital to the proper installation and operation of the machine. In order to avoid accidents due to faulty installation or operation of the machine, please ensure that these instructions are read by the individuals who will install, operate or maintain the machine. The instructions issued in this manual are not meant to cover all possible conditions and situations that may occur.

1.1 Injury prevention

Limbs, hair, loose clothing and accessories should remain clear of moving or heated parts of the machine, as it may get caught and pull the operator into the machine.

Do not power on the machine if any of the machine's components have been removed or modified.

Do not to leave any objects near any of the machine's moving components, or on top of the machine.

Do not perform maintenance or cleaning on machinery while it is in operation or energized.

Always lock out / tag out the machine before performing any maintenance work.

1.2 Fire Prevention

Keep a fire extinguisher near the machine.

All electrical components must be kept dry, clean and in good condition.

Lockout / Tagout the machine before maintenance.

Electrical fires can occur if any wires are scratched, corroded, color-faded, uninsulated, or have damaged ends. Wires should be changed immediately if presenting any of the above conditions. Any exposed electrical components should never come into contact with the ground-connector or any other electrically conductive objects; such as tools.

1.3 Electrical Precautions

Only trained professionals should install, examine and maintain the electronics of the machine.

Do not store liquids near the machine or near the machine's electrical components. Exposing electrical components to excess moisture or direct contact with liquids risks a short-circuit.

Should a liquid spill onto the machine, turn off the power immediately and once having cleaned the liquid, test all the electrical components to ensure they are functioning properly.

To avoid short-circuiting, keep all wires and connections clean. Keep limbs, hand-held tools, and any other electrically conductive objects away from exposed electrical components.

Ensure the electrical cabinet is always closed, unless needed for maintenance.

The machine must be grounded. Ensure that the ground wire is firmly connected with the ground before starting the machine.

After installation check all electrical connections and test all electrical circuits before powering on.

Improper connection of the machine's grounding conductor can result in a risk of electrical shock. Check with a qualified electrician or serviceman if there is doubt as to whether or not the machine's outlets are properly grounded.

1.4 Labels

Warning labels serve to advise the operator of potential danger. Warning labels should be kept clearly visible at all times, and are not to be ignored or removed from the machine. Removal of warning labels from the machine could result in an increase in machine related accidents. Should the machine require a replacement label please contact the company immediately.

Symbol	Description
	**PHYSICAL HARM** Take caution when in the presence of moving parts as they may cut, crush, dismember or otherwise injure body parts in close proximity. Loose clothing or accessories around moving components may get caught and pull the operator into the machine.
	**BURN HAZARD** Many surfaces of the machine will become extremely hot during the course of its operation. Please avoid contacting the indicated hot surfaces to avoid burns. Surfaces will remain hot for an extended period of time after powering down the machine. Ensure the machine is completely cool before contact.
	**HIGH VOLTAGE** While powered, the machine's electrical systems possess sufficient voltage to electrocute any who misuse it. Do not attempt to tamper with the electrical systems of the machine. If damaged wiring or damaged circuits are discovered, please power the machine down and contact the company immediately.

2. SPECIFICATIONS

	Swifty Jr			
Power Supply	230	Vac		
	60	Hz		
	8	Amps		
	1	Phase		
Air Pressure (dry air)*	80	PSI	5.5	Bar
Air Consumption (dry air)*	7	CFM	3.3	LPS
Weight	260	lbs	118	kg
Dimensions	**Length:**	163 (64)	cm (in)	
	Width:	51 (20)	cm (in)	
	Height:	145 (57)	cm (in)	

***If the machine is not to be connected to the facilities pneumatics system, it is advised the use of a screw compressor with an air dryer. The machine accepts hoses with an ID ½ inch.**

2.1 Bag Sizes

Speed*	Up to 15 bags per minute
Bag Width	130MM (5.5IN) to 280MM (11IN)
Bag Length	130MM (5.5IN) to 300MM (12IN)

***Speed may vary depending on bag material and length.**

This machine supports the following bag types:

1. 3 Sided sealed pouch
2. Stand up pouch
3. Pillow bag
4. Bags with zipper (must be pre-opened before inserting into the machine's bag magazine)

3. INSTALLATIONS

3.1 Electrical

Static electricity can cause problems with electrical equipment and operation, ensure that the equipment is properly grounded during installation. Ground the machine and test its ground resistance, if resistance is less than 5Ω then it is acceptable. Any auxiliary equipment should be grounded as well. If static is present in the facility, the installation of static eliminators may be required.

3.2 Pneumatic

The Magazine/Blowers Filter Regulator is located on the back of the JuanaRoll. The JuanaRoll operates at 90psi and has an air consumption of 15 cfm . It is important to ensure that the air supply of the owner's facility be dry and can meet these specifications.

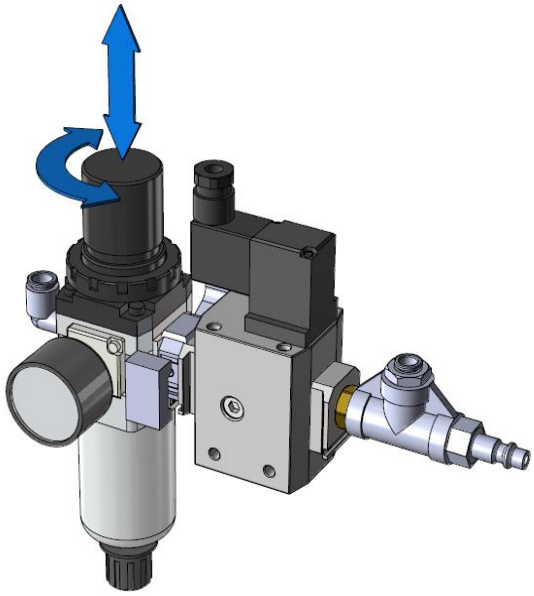


Figure 3-1 Pneumatics Intake

To Adjust Air Pressure

1. Pull the knob to release it and adjust the pressure.

2. If the knob is rotated clockwise, the inlet pressure will increase, if rotated counter clockwise it will decrease.

3. Press down on the knob to lock it in place again once the pressure changes have been completed.

NOTE: THE FILTER REGULATOR IS ALREADY LUBRICATED.
PLEASE DO NOT ADD ANY LUBRICATION TO THE FILTER REGULATOR AS IT MAY CAUSE CONTAMINATION.

4. MACHINE OVERVIEW

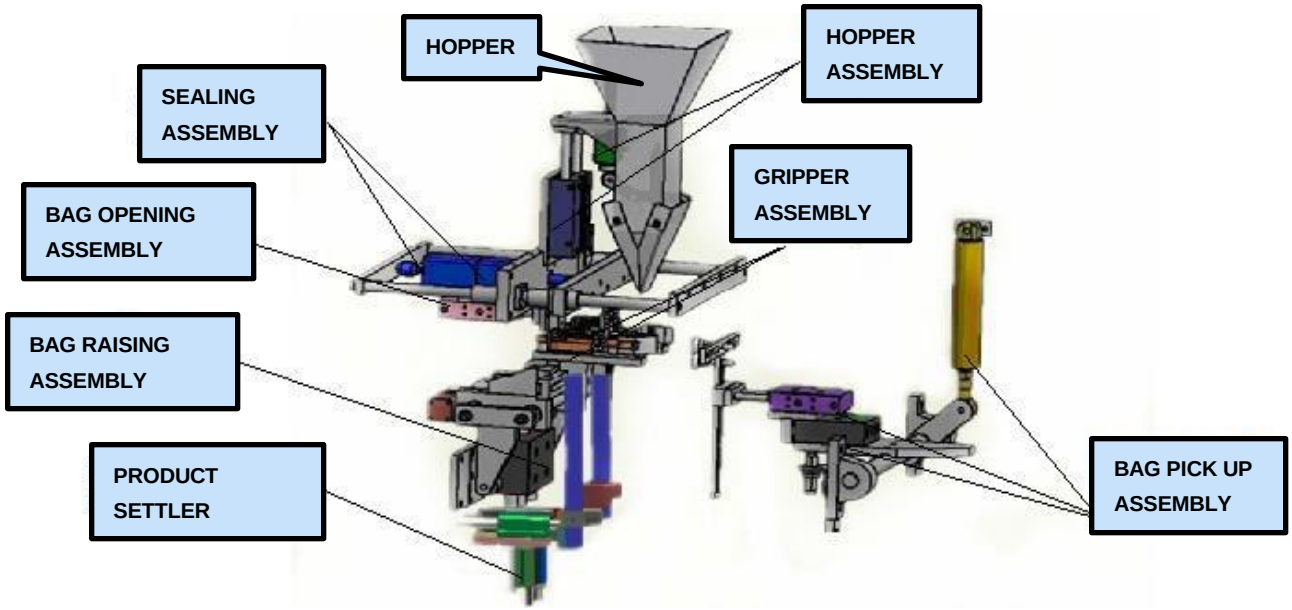


Figure 4-1 Machine Overview

5. MECHANICAL ASSEMBLIES

WE RECOMMEND HAVING THE FOLLOWING TOOLS AVAILABLE WHEN MAKING ADJUSTMENTS TO THE MACHINE: METRIC ALLEN KEYS, METRIC SOCKET SET, METRIC WRENCHES, VOLT METER, SCREW DRIVERS, TAPE MEASURE, RULER, CALIPER, ADJUSTABLE WRENCHES AND A GREASE GUN.

5.1 Bag Magazine

The Bag Magazine can accept varying sizes of bags. To adjust the width of the Bag Magazine to a new bag size, follow these steps:

1. Begin by loosening the 4 knobs securing the Bag Magazine in place (labelled 1 to 4 in the image below.)
2. Loosen the knobs of the Bag Holders (labelled 5 and 6 in the images below.)
3. Slide open the two sheet metal plates of the Bag Magazine.
4. Slide open the black Bag Holders of the Bag Magazine.
5. Once there is sufficient room, place the new Bag on the Bag Magazine and center it as seen in the images below.
6. Slide the sheet metal plates closed until they are up against the Bag, leaving a 1/16” gap between the Bag and the plates.
7. Slide the black Bag Holders closed, leaving a 1/16” gap between the Bag and the holders.
8. Tighten all knobs labelled 1 through 6.

Figure 5-1 Bag Magazine

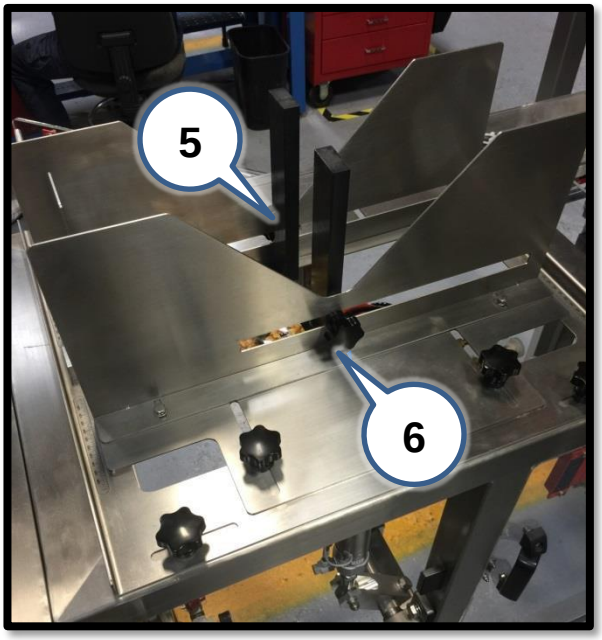


Figure 5-2 Bag Magazine - Plates

5.2 Bag Pick Up Assembly

The images below display the typical placements of the suction cups of the bagger. The suction cups seen on the right are part of an arm used to grab empty Bags from the Bag Magazine, pull them down and bring them into the machine. The suction cups apply a vacuum only when transporting an empty Bag.

In the images below, both the black and orange air hoses apply vacuum when picking up and carrying a bag. After the bag has been moved under the Hopper, the black air hoses cease their vacuum and only the orange air hoses continue to apply a vacuum in order to open the bag.

The suction cups seen on the left image are used to hold the empty bag delivered from the arm and serve to hold the empty bag as it is spread open, filled and then sealed. These suction cups continuously apply a vacuum to keep the empty Bag in place as it is being filled and sealed, these suction cups will deactivate to release the Bag after sealing.

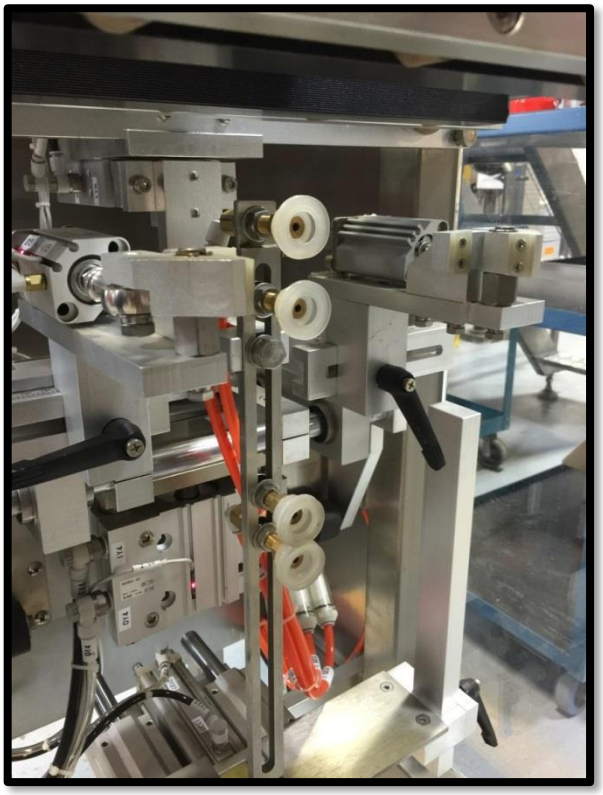


Figure 5-3 Bag Open Suction Cups

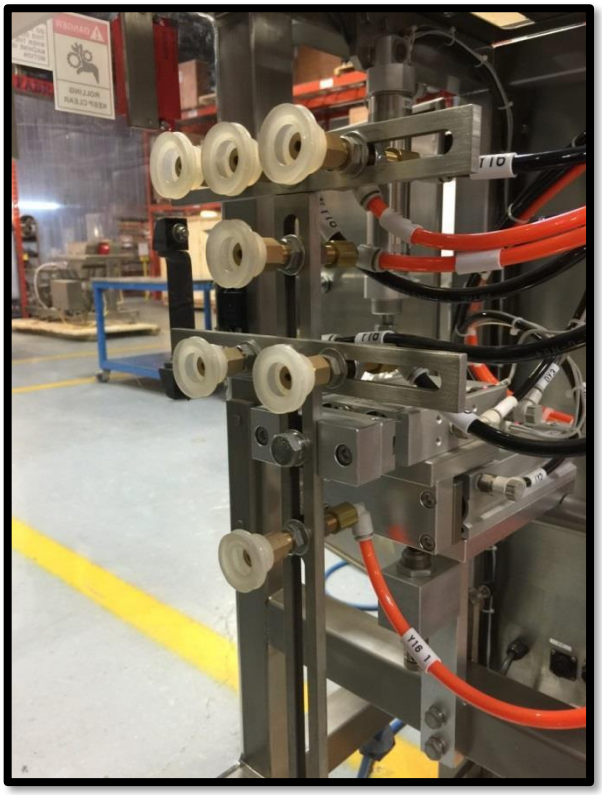


Figure 5-4 Bag Pick Up Suction Cups

Seen in the image below are the various groups of suction cups, divided by function into “Group A” shown in red and “Group B” shown in blue. The suction cups from “Group A” including those labeled as “a” and “b” are used when picking up a bag from the Bag Magazine, suction cups “c” and “d” are used for holding onto larger bags when necessary.

The suction cups from “Team B” including those labeled as “O”, “P”, “R” and “S” will be used to draw open the bag being held under the hopper. Suction cups “Q” and “T” are used for opening larger bags when necessary.

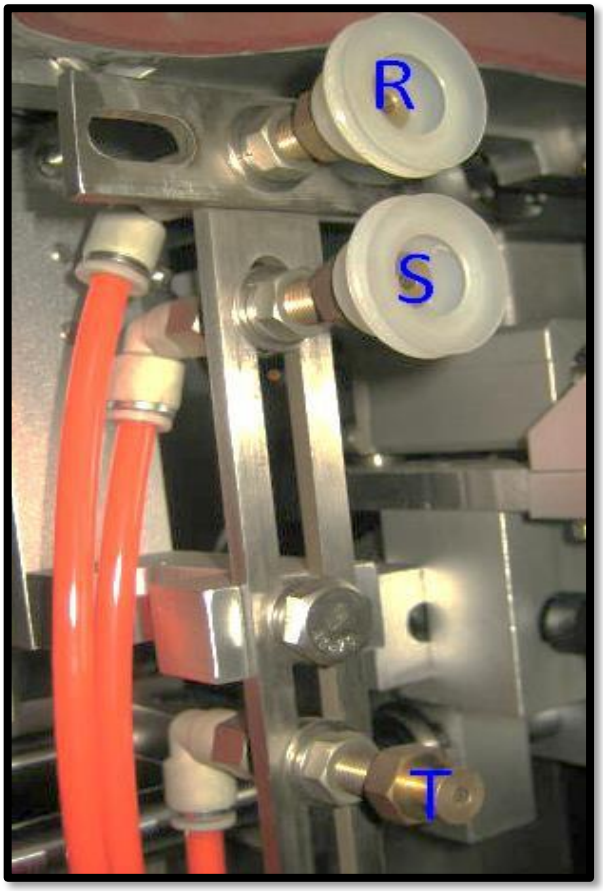


Figure 5-5 Suction Cups

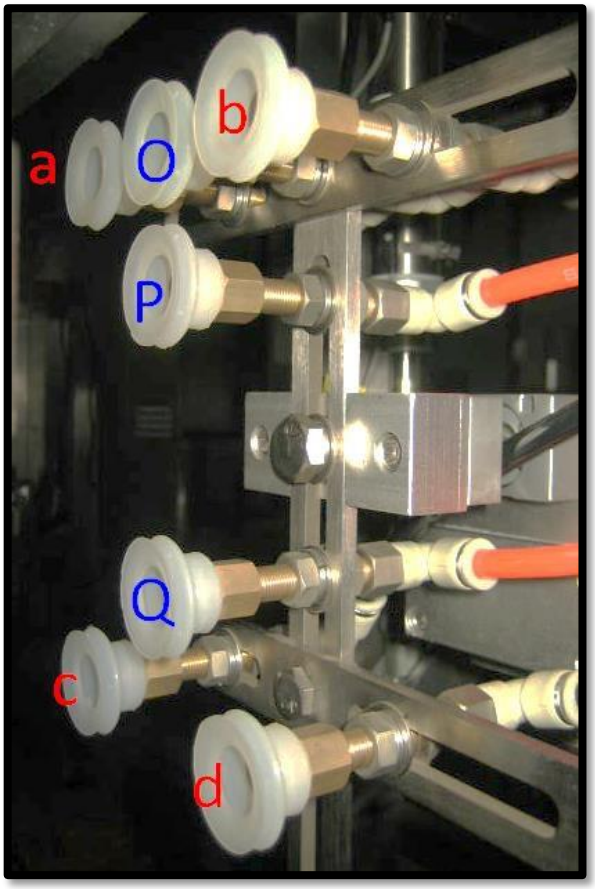


Figure 5-6 Suction Cups

5.3 Gripper Assembly

The Bag Gripper's fingers can be adjusted to accommodate a variety of bags ranging from 5.5 inches (130 millimeters) up to 11 inches (280 millimeters) in width.

In order to adjust the distance between the Bag Gripper's fingers, loosen the knobs below the fingers (as seen in the images below) which will allow the fingers to slide further apart or closer together.

Once the required width between fingers has been achieved, tighten the knobs once again to secure the fingers in place.

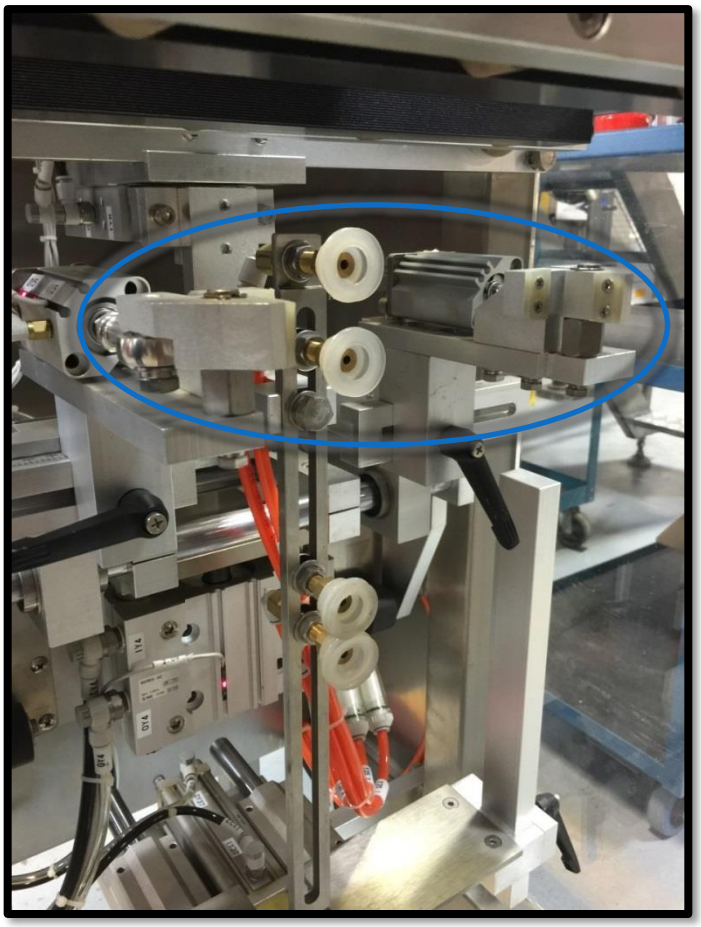


Figure 5-7 Movement of Suction Cups

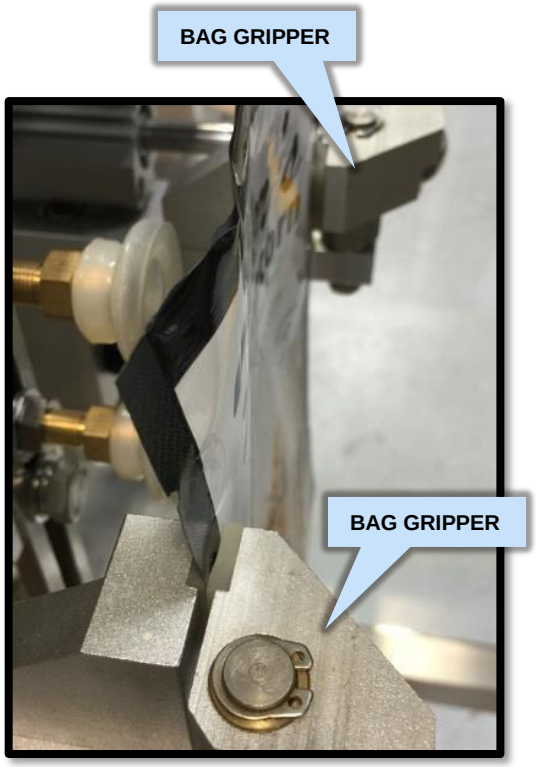


Figure 5-8 Bag Gripper

Figure 5-9 Ratchet Handle Adjustment

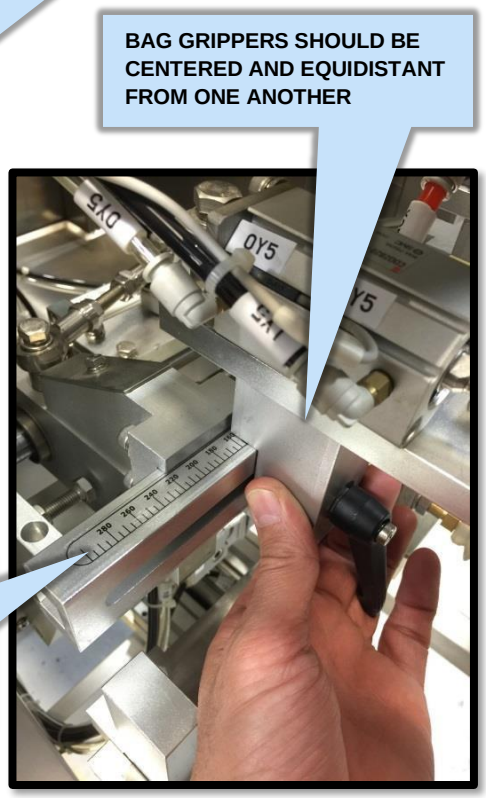


Figure 5-10 Gripper Adjustment

5.4 Printer Assembly

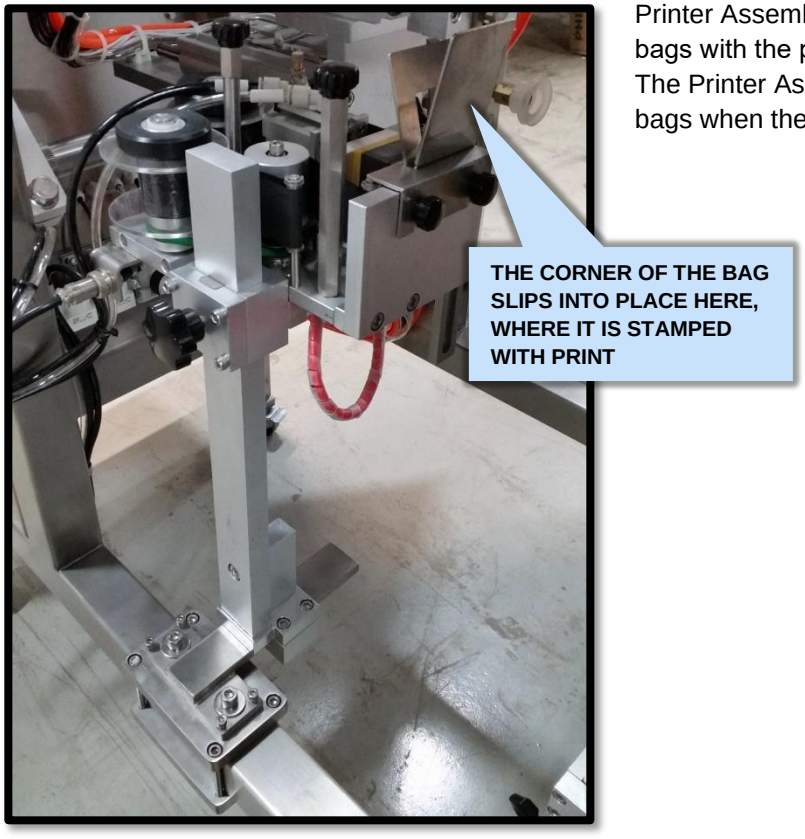


Figure 5-11 Bag Enters Printer

Printer Assembly is an optional component which is used to mark bags with the product's expiration date or other useful information. The Printer Assembly stamps print characters onto the corner of bags when they are loaded into the bagger.

The Printer's ribbon needs to be changed periodically when it runs out. To thread a new film ribbon through the printer following the steps indicated below:

1. Unscrew the cap of both ribbon spools. Locate the flat head screws inside of the caps and unscrew them until the caps can be slid off.

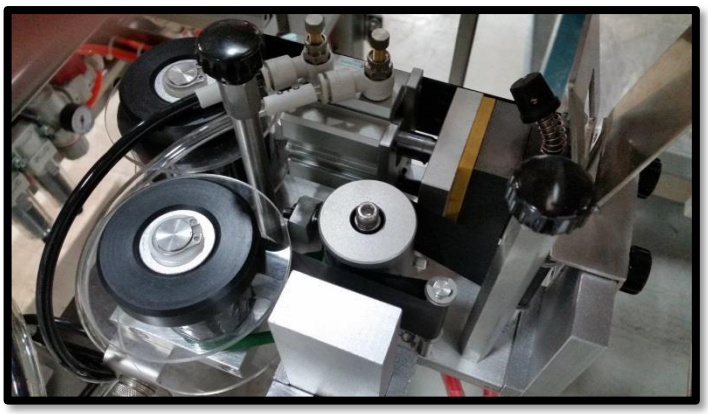


Figure 5-12 Ribbon Spools

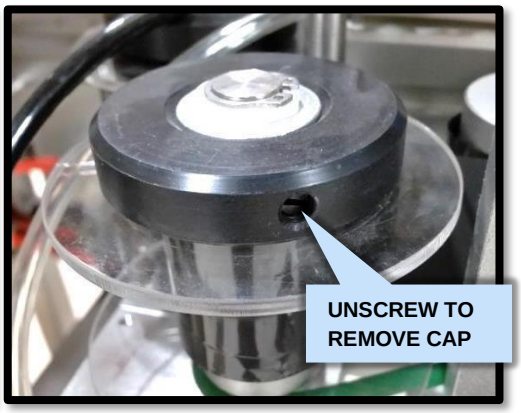


Figure 5-13 Ribbon Spool Cap

2. Finish running the ribbon out of the Printer.

3. Slip the caps of the spools up and off, then slip the top of the spool off.

4. Remove the roll of used up film from “spool 2.”

   The new ribbon will come with 2 rolls, one which is full and 1 which is a carbord tube with the ribbon attached to it.

Figure 5-13 Ribbon Spool 1 and 2

5. Place the new roll of ribbon onto “spool 1.” The new roll of ribbon will be attached to an empty carboard roll, this empty cardboard tube will be held onto while ribbon is passed through the Printer. While holding the empty cardboard tube, pass the ribbon through the Printer and finally place the tube on to “spool 2.”

Use the diagram below to run ribbon through the Printer.

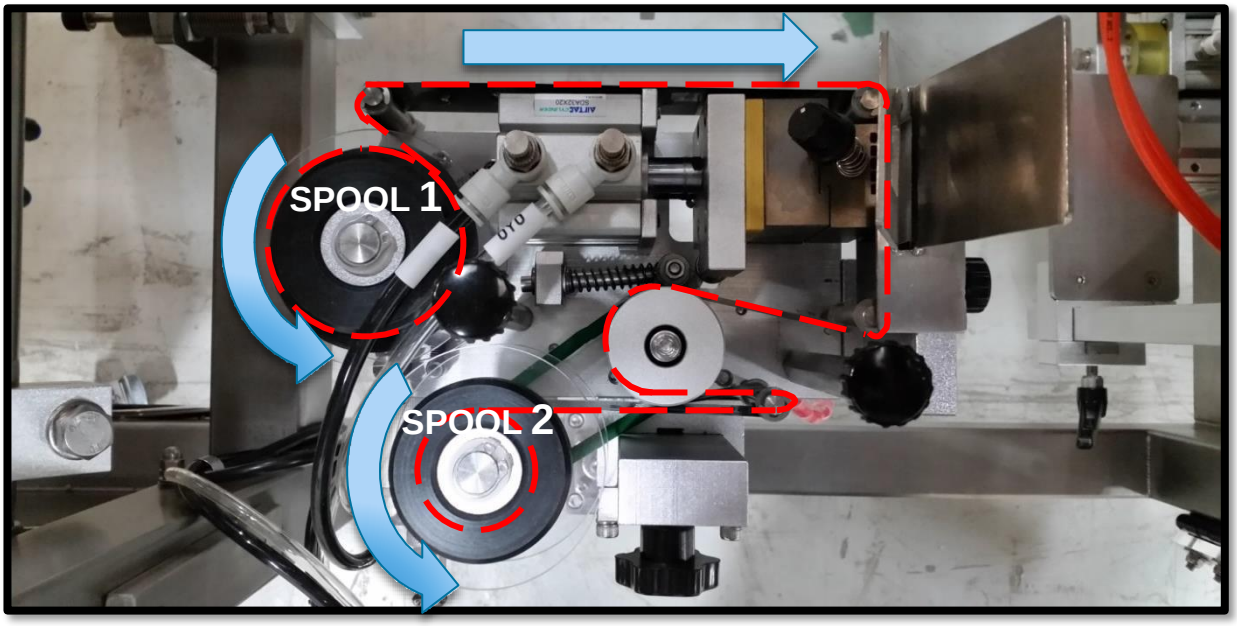


Figure 5-14 Ribbon Threading Diagram

6. Replace the caps of both spools and screw them into place to secure them

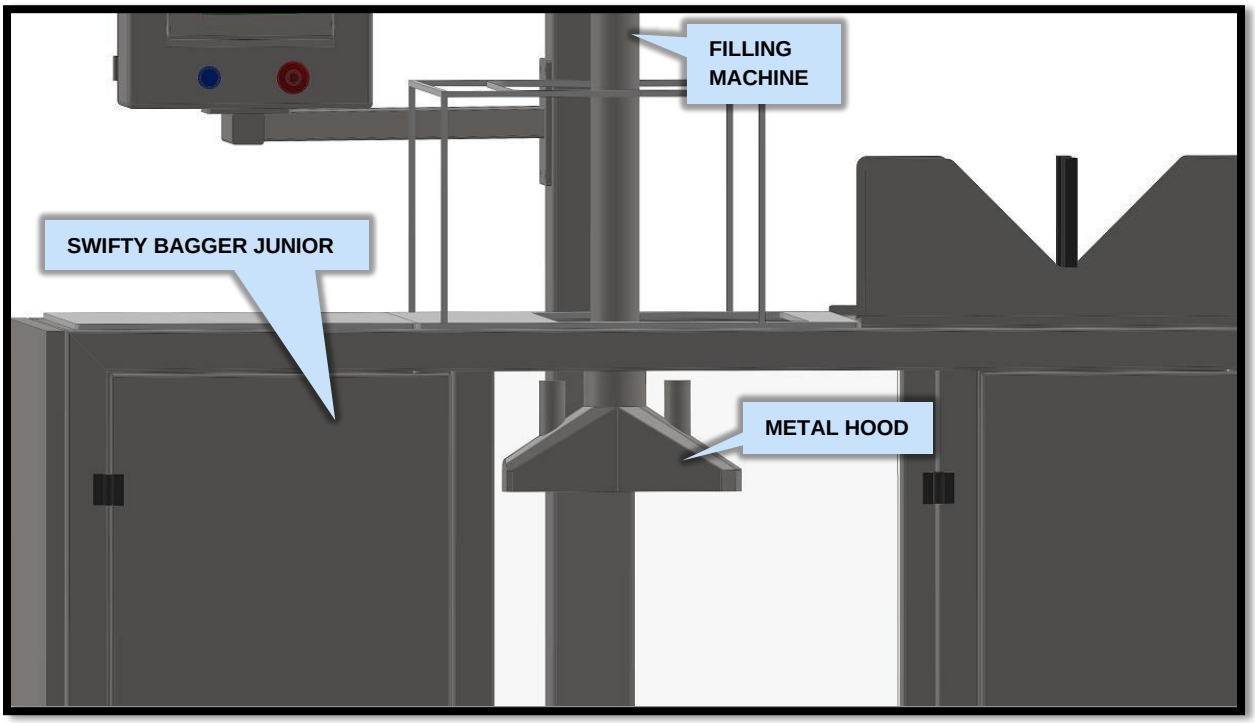
5.5 Dust Protection Kit (OPTIONAL)

For powder products, the Swifty Junior can come with a dust protection kit. This is an optional kit that is often used when the Swifty Junior is used with a Star Auger machine, especially for dry powder products.

NOTE: when the dust protection kit is equipped, the Swifty Junior may not have pneumatic filters as their function is already being done by the dust protection kit.

The principal operation of the dust protection kit is simple:

1. The bag is opened and positioned below the metal hood and sealing jaws.
2. The bag is then raised their proper position in-between the sealing jaws.
3. The product is dumped into the opened empty bag.
    a. The amount of product dumped into the bag is defined in the settings of the Swifty Junior, see the recipe menu of the HMI.
    b. This is where the dust protection will start working, to make sure there is no dust or powder released into the outside area when the product is dumped into the bag.
4. The jaws are closed in as to seal the bag.
5. The bags are lowered and removed from the Swifty Junior.



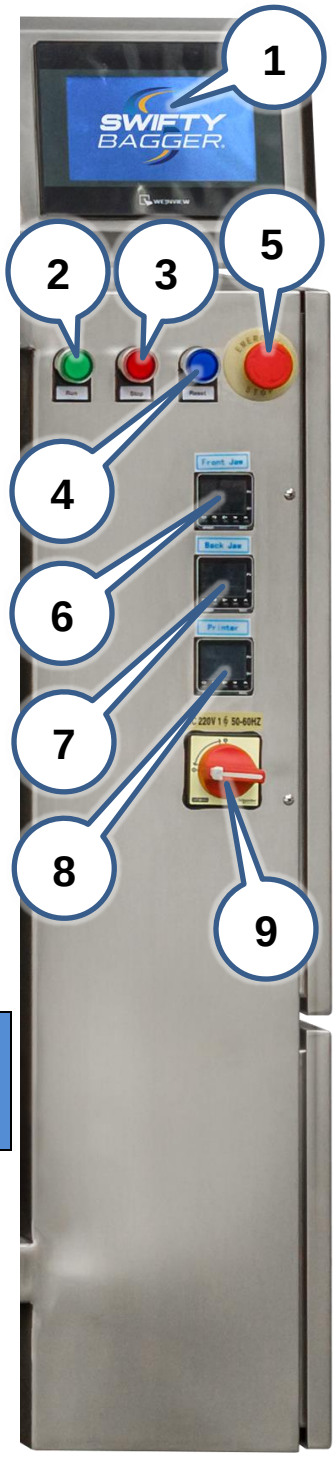
6. CONTROL PANEL

6.1 Controls

For details concerning the H.M.I. Software and Machine Operation, please see their respective sections.

CONTROL PANEL		
Item		**Description**
1	**H.M.I. Touch Screen**	The Swifty Jr is equipped with a 7" TFT LCD color touchscreen industrial PC that is used to input variable data and to control the machine.
2	**Start**	The Start button is used to restore the MCR (Master Control Relay) immediately after an Emergency Stop.
3	**Stop Button**	Stops the machine's filling process, the bags leftover inside the machine will stop being filled but continue to exit out.
4	**Reset Button**	The Reset button is used to restore the HMI functions immediately after an Alarm has been serviced.
5	**Emergency Stop Button**	The Emergency Stop button is used to bring the machine to a total stop in case a dangerous situation arises.
6	**Temperature Controller (Front Jaws)**	Displays the temperature of the Front Jaws of the machine, which can be modified using the buttons below the display.
7	**Temperature Controller (Back Jaws)**	Displays the temperature of the Back Jaws of the machine, which can be modified using the buttons below the display.
8	**Temperature Controller (Printer)**	Displays the temperature of the Printer of the machine, which can be modified using the buttons below the display.
9	**Power Switch**	Use this switch to turn the machine **ON/OFF**.

Table 6-1 Swifty Jr Control Panel

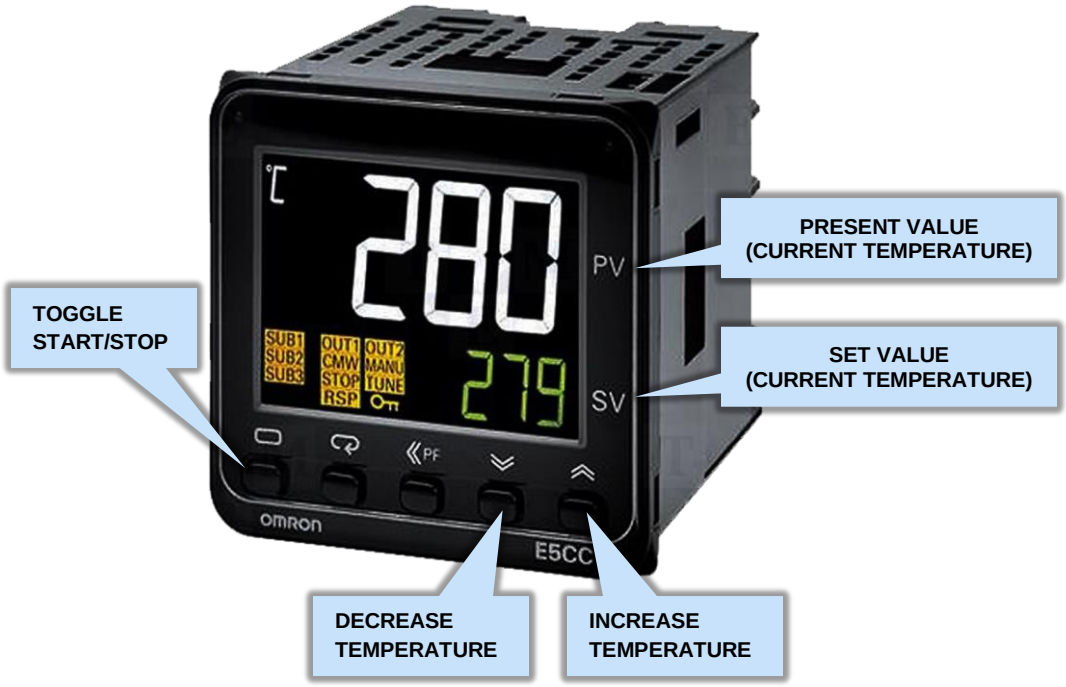


Alarms

In the event of a machine malfunction, such as a jam, an alarm warning will display on the H.M.I. Touch Screen. After an alarm has been triggered, the machine should be inspected, and the alarm must be reset. Alarms may be reset on the H.M.I. Touch Screen. Refer to ***SECTION 7.3.*** for a more detailed description.

Temperature Controls

The Temperature Controls are located below the H.M.I. Touch Screen, on the Control Box.



1. Turn On Heater - Press the toggle button and then press the arrow down button which will display RUN and the heater will now be activated, press the toggle button a second time to return to the run screen. “Out” will flash confirming the heater is now on, and heater temperature will begin to rise.

2. Turn Off Heater – Press the toggle button and the press the arrow up button. The display will now read STOP, press the toggle button a second time to return to the run screen “stop” will flash confirming the heater is now off and the temperature will begin to decrease.

Use the up and down arrow keys to raise or lower the set temperature

Emergency

In the event of an emergency, pressing the Emergency Stop button will cut power to the machine and halt its moving parts. While the Emergency Stop remains depressed, servo motors will stop, and air will be cut off from pneumatics.

Immediately following the use of the Emergency Stop button, the operator may also need to halt the functions of any auxiliary machinery feeding the bagger.

After having been pressed, the Emergency Stop button must be reset before the machine can be operated. Pull out the Emergency Stop button, it should snap back into its original position. If Emergency Stop button has been pulled out, press the “Start” button to reactivate the machine. The machine should now be ready to run.

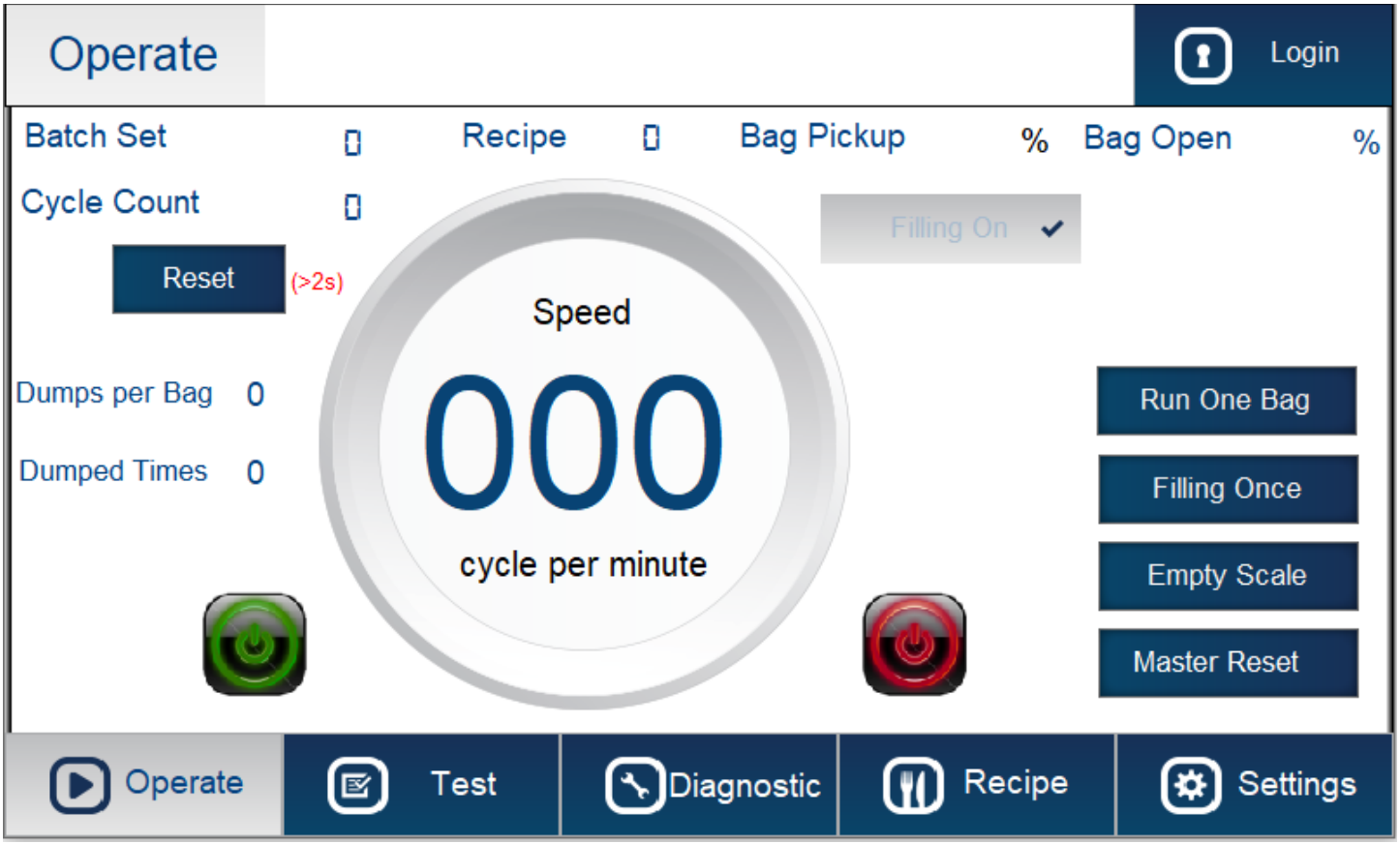
6.2 Electrical Schematics

For detailed Electrical Schematics, please see attached Appendix A.

7. HUMAN MACHINE INTERFACE (H.M.I)

7.1 Operate Screen

This screen allows the operator to start and stop the automatic bag making process, observe the speed at which bags are being produced, how many bags have been produced, monitor alarms and to switch between Recipes.



START: Starts the machine in automatic mode with the present Recipe and at the speed specified by the Speed Setting. The machine will continue to produce bags until the Stop button is pressed.

STOP: Stops the machine's filling process, the bags leftover inside the machine will stop being filled but continue to exit out of the machine until no bags remain.

SPEED: Displays the average number of bags being produced per minute by the bagger.

Reset ***RESET:*** Resets the Cycle Count to 0.

BATCH SET: Displays the amount of finished bags which the machine will complete before finishing its automated bag making cycle. [Press the number field to enter a value]

CYCLE COUNT: Displays the number of cycles (bags made) during the current bag making cycle. A cycle is defined as the entire process of opening, filling and sealing a single bag. Pressing the reset button will reset the Cycle Count to 0

RECIPE: Displays the number of the Recipe that is presently loaded. [Press the number field to enter a value]

BAG PICKUP %: Displays the percentage of bags successfully picked up by the bagger since the automated bag making cycle has begun.

BAG OPEN %: Displays the percentage of bags successfully opened and filled by the bagger since the automated bag making cycle has begun.

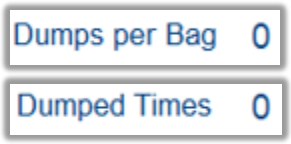
FILLING ON: Displays the status of the Filling Device feeding the bagger; "Filling On" indicates the Filling Device is ready to deliver product to the bagger.

RUN ONE BAG: Press to have the bagger seal and release a single bag. This function can only be performed when the bagger is not running continuously.

FILLING ONCE: Press to have the Filling Device discharge product to the bagger. This function can only be performed when the bagger is not running continuously.

EMPTY SCALE: Press to have the Filling Device empty out into the bagger until no product remains in the Filling Device. This function can only be performed when the bagger is not running continuously.

MASTER RESET: This button resets all machine sequences. The same as turning the machine off, then on again**.**



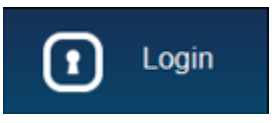
DUMPS PER BAG: This counter shows the amount of product dumps per bag that the Swifty Jr is set to.

DUMPED TIMES: This counter shows the number of times that the product has been dumped.

7.1.1 NAVIGATION BAR

The bottom of the screen displays the **Navigation Bar**: The Home, Automatic, Testing, Manual, Recipe and System buttons that can be accessed at any time in any screen. These buttons will always be displayed, unless entering a submenu.

7.1.2 LOGIN



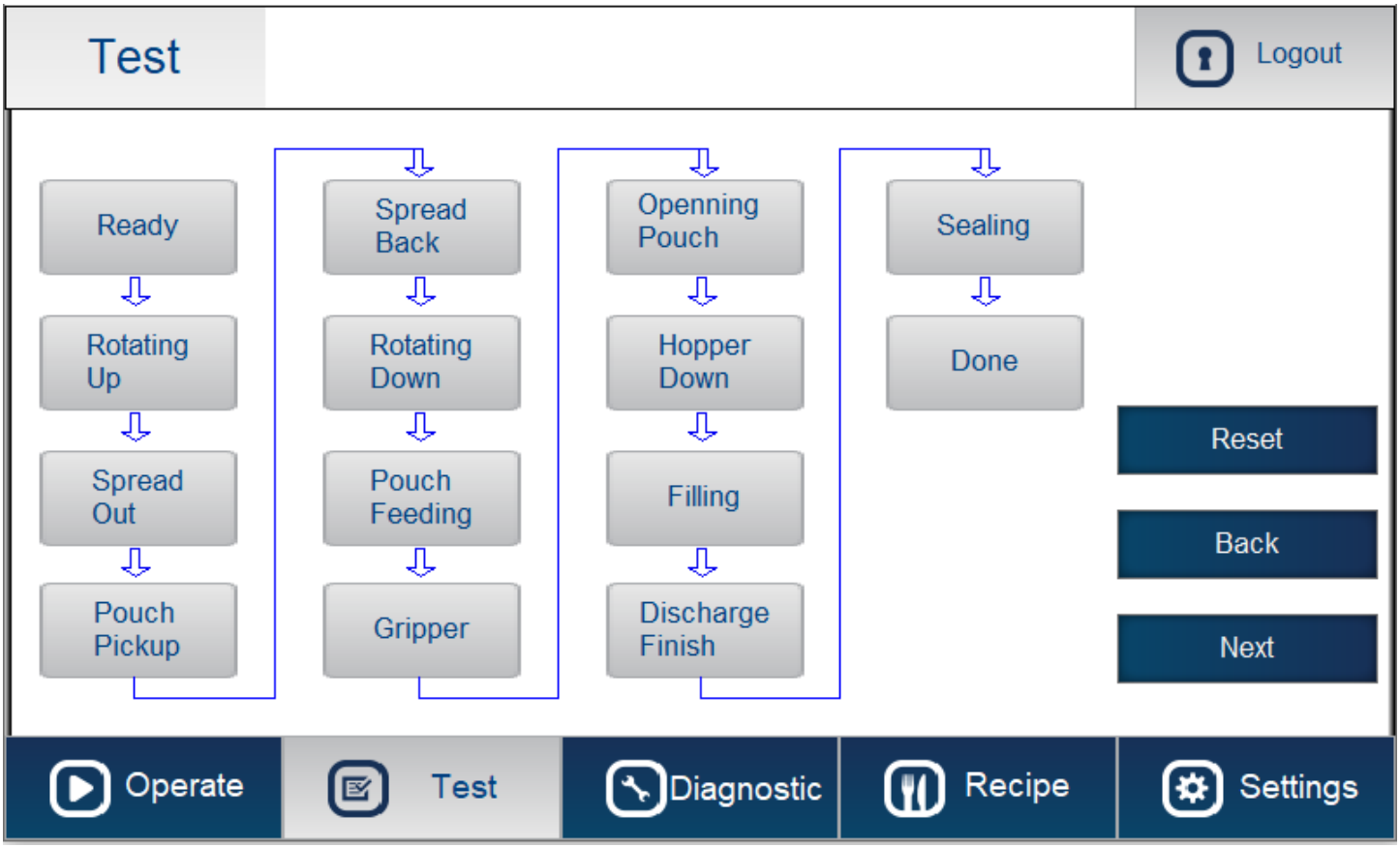
The Home screen contains the Login button. Some system settings are restricted, and require that a technician log in to alter them. An operator does not need to log in to use the machine normally, but the Recipe Screen can only be accessed by a Supervisor or Technician.

Press the Login button to enter login credentials, the login button will change into the Logout button afterwards.

SUPERVISOR LEVEL ACCESS	
USERNAME: 2	PASSWORD: 2222

7.2 Test Screen

The Test screen allows the operator to run the Bagger through each step of the form, fill and sealing process. Each step of the bag making cycle can be tested, to check the functionality of the machine.



In the Test Screen, each mechanical function of the machine is shown in the order the machine performs them in. These functions will be highlighted as they are performed, allowing an operator to track the machine's mechanical processes from beginning to end. The "Ready" step will be highlighted when the Bagger is ready to be tested.

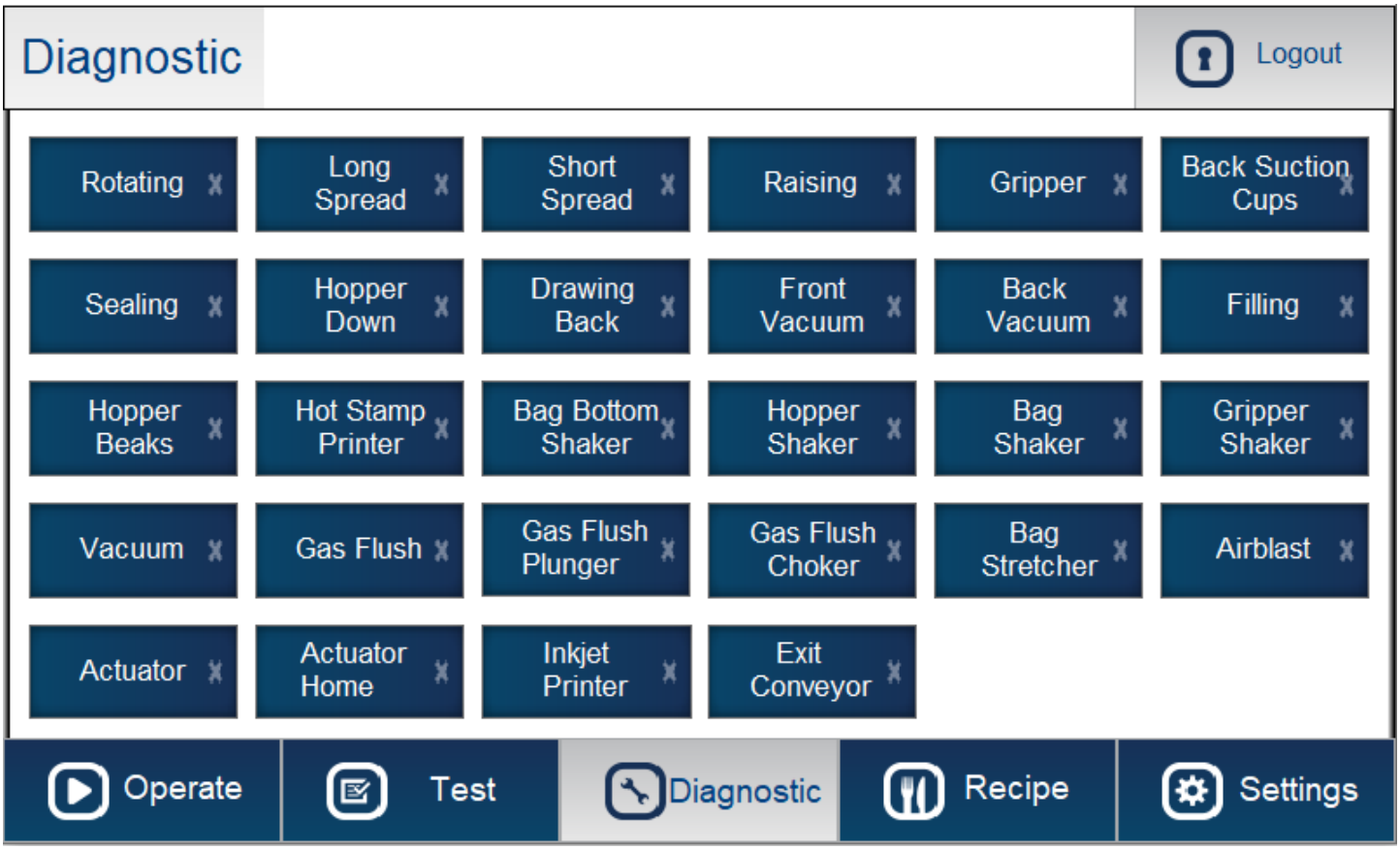
NEXT: Pressing this button will activate the next step in the bag making process.

BACK: Pressing this button will activate the previous step in the bag making process.

RESET: Pressing this button will return the bagger to the "Ready" step

7.3 Diagnostic Screen

ONLY QUALIFIED TECHNICAL PERSONNEL SHOULD USE THE DIAGNOSTIC SCREEN. PHYSICAL INJURY CAN ARISE WHEN TESTING FEATURES ON THIS SCREEN, DUE TO MOVING PARTS.



Each button is named for the function that is activates. Pressing the button once will activate that function and it will remain activated and highlighted, when the button is pressed again it will deactivate and no longer be highlighted.

ROTATING: Pressing this button will rotate the Pick Up Bag Assembly.

LONG SPREAD: Pressing this button will cause the suction cups to spread the bag open lengthwise.

SHORT SPREAD: Pressing this button will cause the suction cups to spread the bag open widthwise.

RAISING: Pressing this button will cause the Bag Assembly to move up.

GRIPPER: Pressing this button will cause the Gripper under the Sealing Assembly to close.

BACK SUCTION CUPS: Pressing this button will cause the suction cups of the Pick Up Bag Assembly to advance forward.

SEALING: Pressing this button will cause the Sealing Assembly to close.

HOPPER DOWN: Pressing this button will cause the Hopper to descend.

DRAWING BACK: Pressing this button will cause Gripper Assembly to draw the bag closed.

FRONT VACUUM: Pressing this button will activate the suction cups of the Pick Up Assembly.

BACK VACUUM: Pressing this button will activate the suction cups of the Raising Bag Assembly.

FILLING: Pressing this button will cause the interfaced Scale to deposit product into the Swifty Jr's funnel.

HOPPER BEAKS: Pressing this button will cause the Hopper to open.

HOT STAMP PRINTER: Pressing this button will activate the Printer, stamping the film.

BAG BOTTOM SHAKER: Pressing this button will activate the shaker under the bag, settling product within the bag.

HOPPER SHAKER: Pressing this button will activate the Hopper Shaker, agitating the Hopper.

BAG SHAKER: Pressing this button will activate the Bag Shaker, agitating the Bag.

GRIPPER SHAKER: Pressing this button will activate the shaker for the gripper holding the bag.

VACUUM: Pressing this button will activate the Vacuum.

GAS FLUSH: Pressing this button will activate the Gas Flush feature of the Swifty Jr. (Gas Flush feature may be optional)

GAS FLUSH PLUNGER: Pressing this button will move the Gas Flush assembly up and down.

GAS FLUSH CHOKER: Pressing this button will activate the Gas Flush Choker; the choker is essentially a false jaw that will close to ensure bag is proper during gas flush operation.

BAG STRETCHER: Pressing this button will activate the Trimmer, cutting the bag.

AIRBLAST: With this function enabled, air is blown through the Funnel after product is deposited into the bag.

ACTUATOR: Pressing this button will activate the actuator for the printer attached to the Swifty Jr, causing the printer to extend towards the film or to retract. (Printer may be optional)

ACTUATOR HOME: Pressing this button will send the printer back to its initial position.

INKJET PRINTER: Pressing this button will send a signal to the printer attached to the Swifty Jr. (Printer may be optional)

EXIT CONVEYOR: Pressing this button will cause any interfaced Exit Conveyor to turn on when the Swifty Jr is running. When the Swifty Jr stops running, the Exit Conveyor will stop as well.

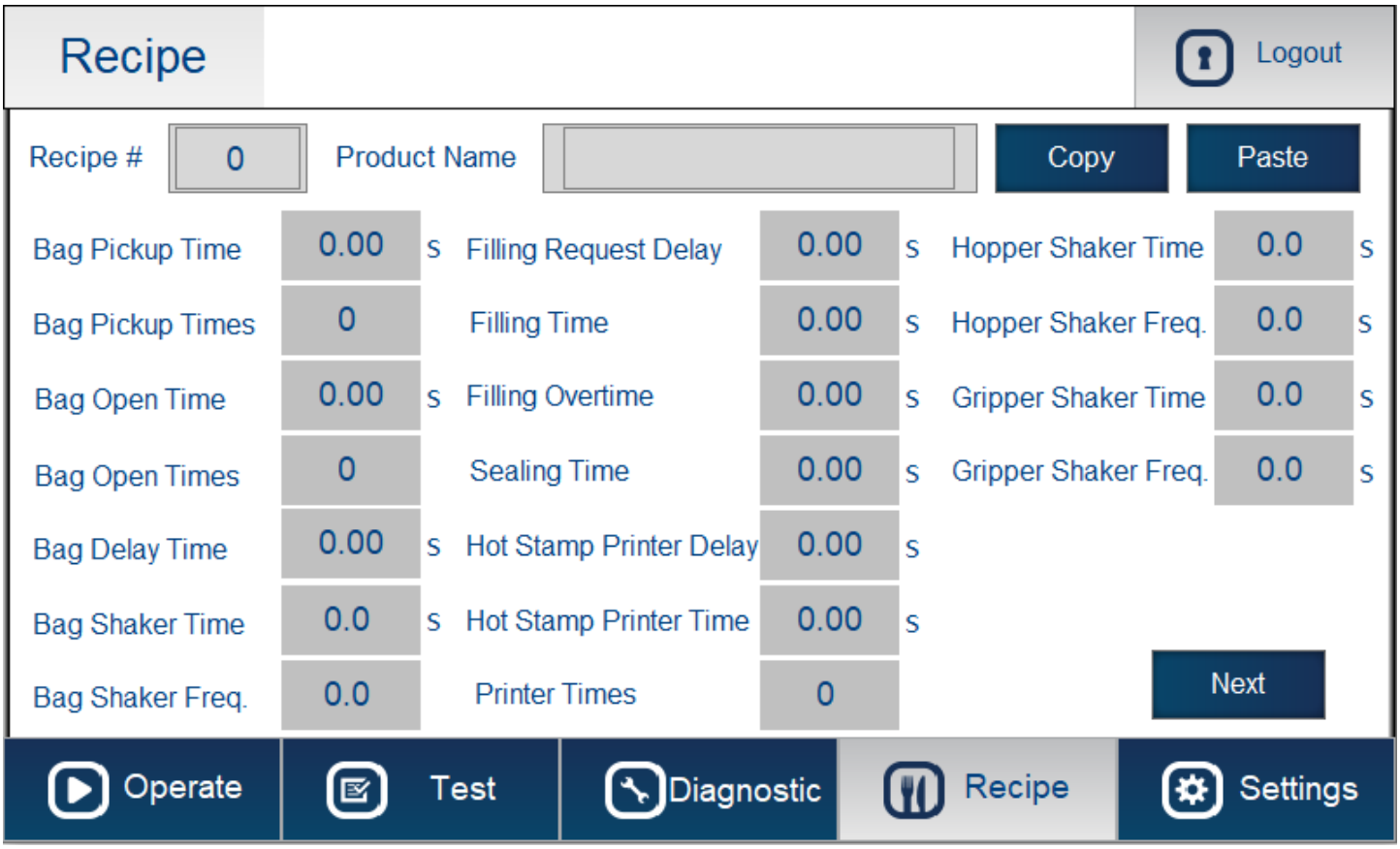
7.4 Diagnostic Screen

The Recipe screen is used to save or load a recipe.

A recipe is the program of the bagger's Parameters for a particular bag. Many Parameters are available to configure the machine's recipe and up to 20 recipes can be stored in the P.L.C. memory, from 0-19. Parameters will be saved immediately upon entering a new numerical value.

ONLY QUALIFIED TECHNICAL PERSONNEL SHOULD USE THE RECIPE SCREEN, PARAMETERS CHANGED HERE WILL ALTER THE PERFORMANCE OF THE MACHINE.

The Parameters listed on this screen represent timing controls for the various assemblies of the machine. Parameters are named after their function.



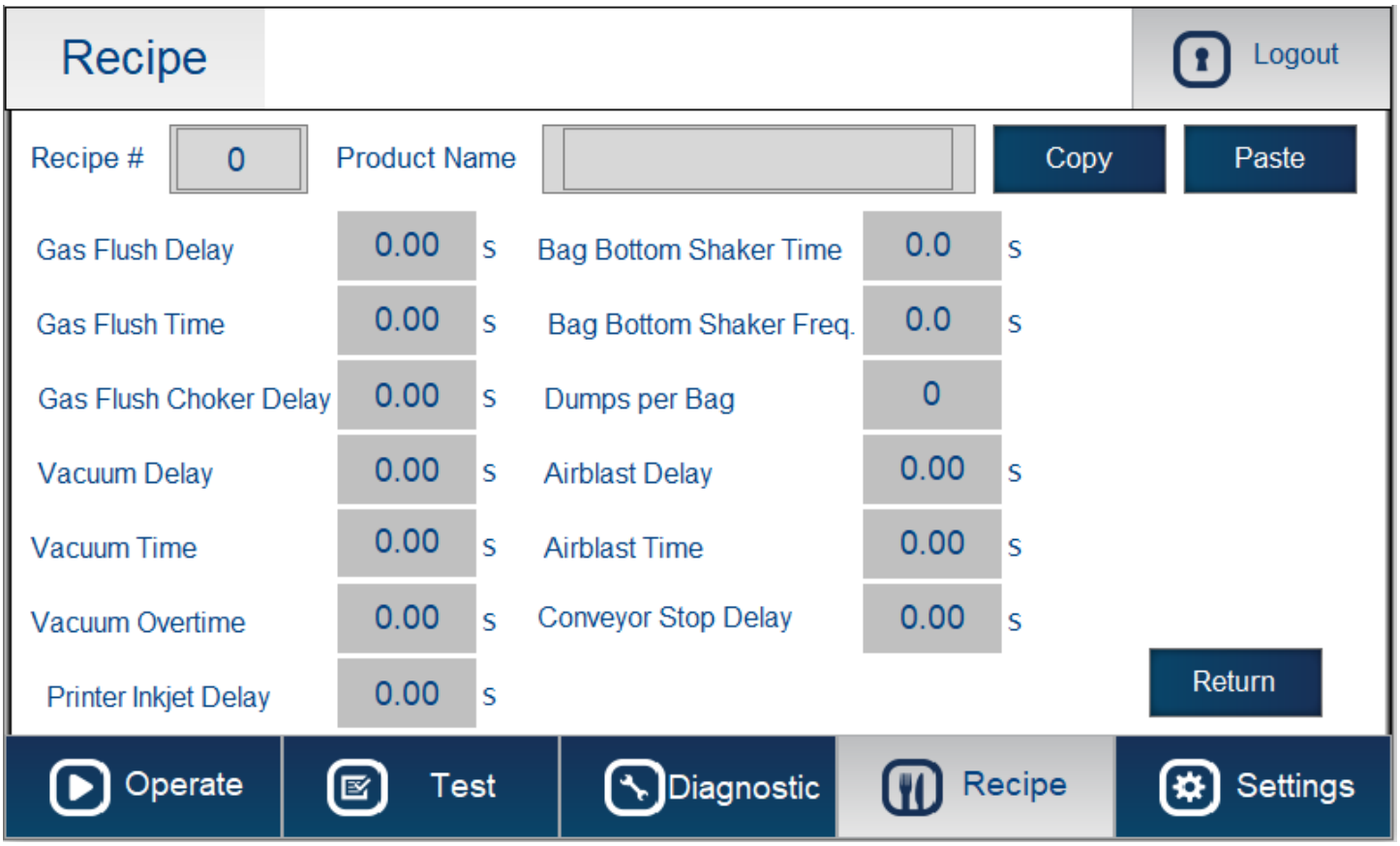
NEXT: Pressing this button will open the second page of the Recipe menus.

RECIPE #: Displays the number of the recipe. The Parameters on the screen will reflect the Recipe Number inputted in this field. 20 Recipes can be stored, from 0 to 19. Changes made to a Recipe Number are automatically saved. [Press the number field to enter a value]

PRODUCT NAME: Displays the name given to the Recipe Number, which may be changed. [Press the field to enter a value]

COPY: Pressing this button will copy the current Recipe's Parameters.

PASTE: Pressing this button will paste the copied Recipe Parameters unto a new Recipe Number. Enter the Recipe number to be overwritten before pressing the Paste button.



RETURN: Pressing this button will return to the first page of the Recipe menus.

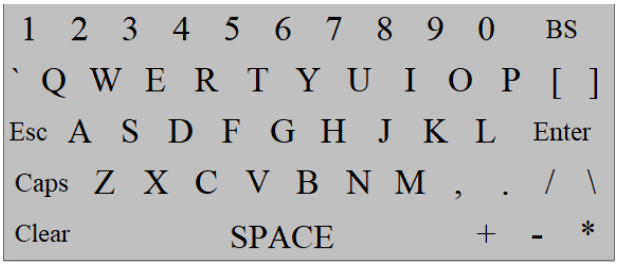


Figure 7-1 Alphabetical Keyboard

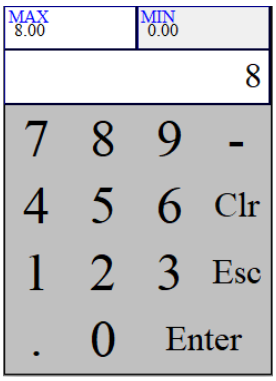
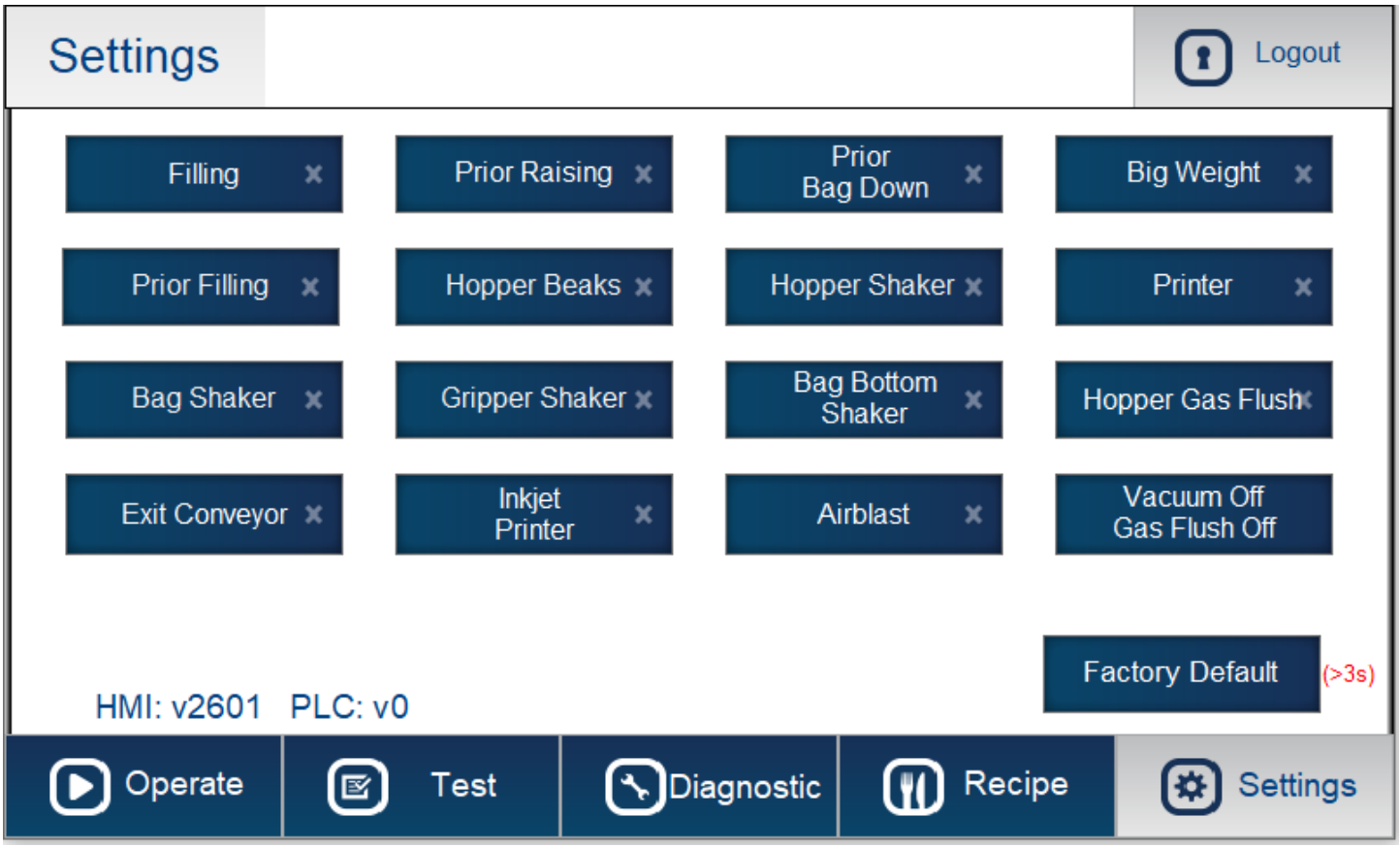


Figure 7-2 Numerical Keys

7.5 System Settings Screen

The System screen allows features of the machine to be enabled or disabled. The current HMI and PLC versions are displayed at the bottom of the screen.

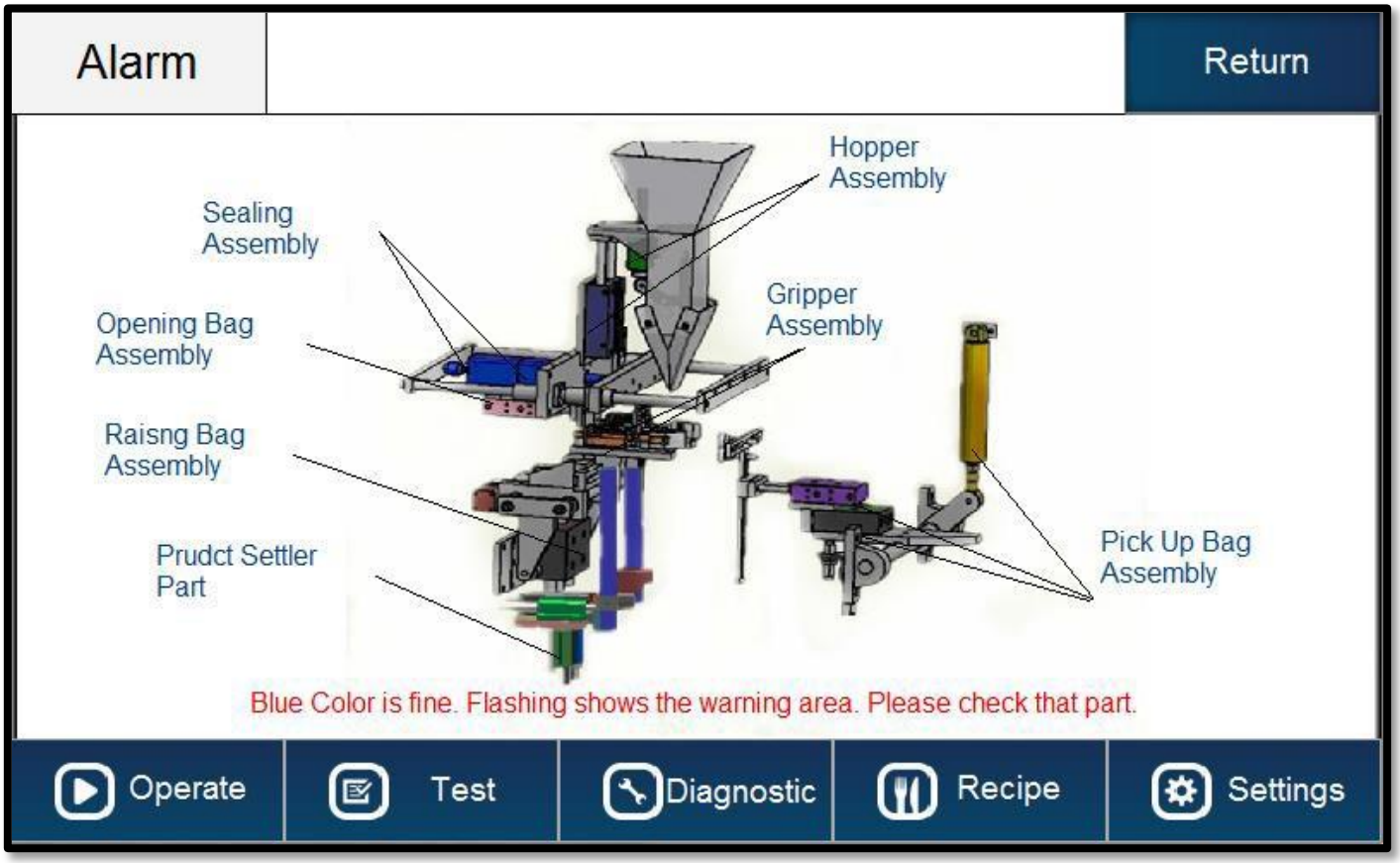
ONLY QUALIFIED TECHNICAL PERSONNEL SHOULD ALTER SYSTEMS SETTINGS.

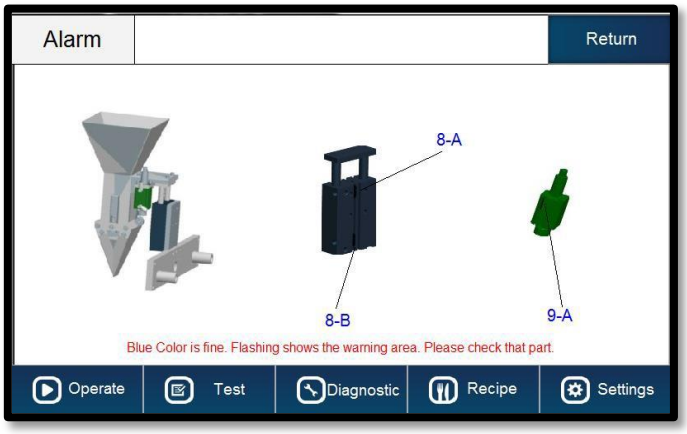


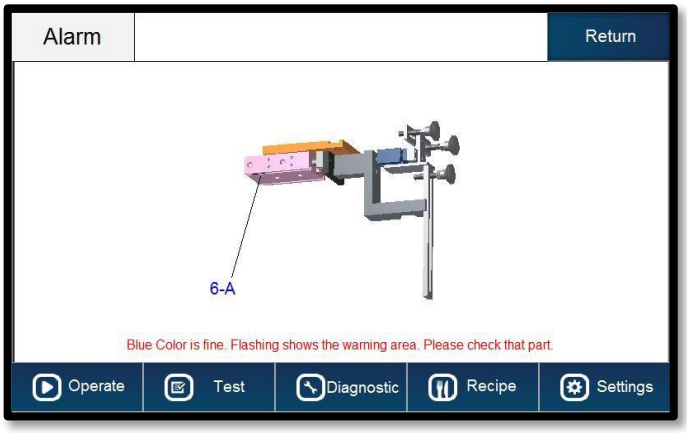
Each button on the Settings screen is named after a function and enables that function when it is pressed. Active functions are highlighted white and display a checkmark next to their button. The highlighted button may be pressed again to deactivate that function.

FACTORY DEFAULT: Pressing this button will restore the machine to its factory default settings.

7.6 Alarm Screen



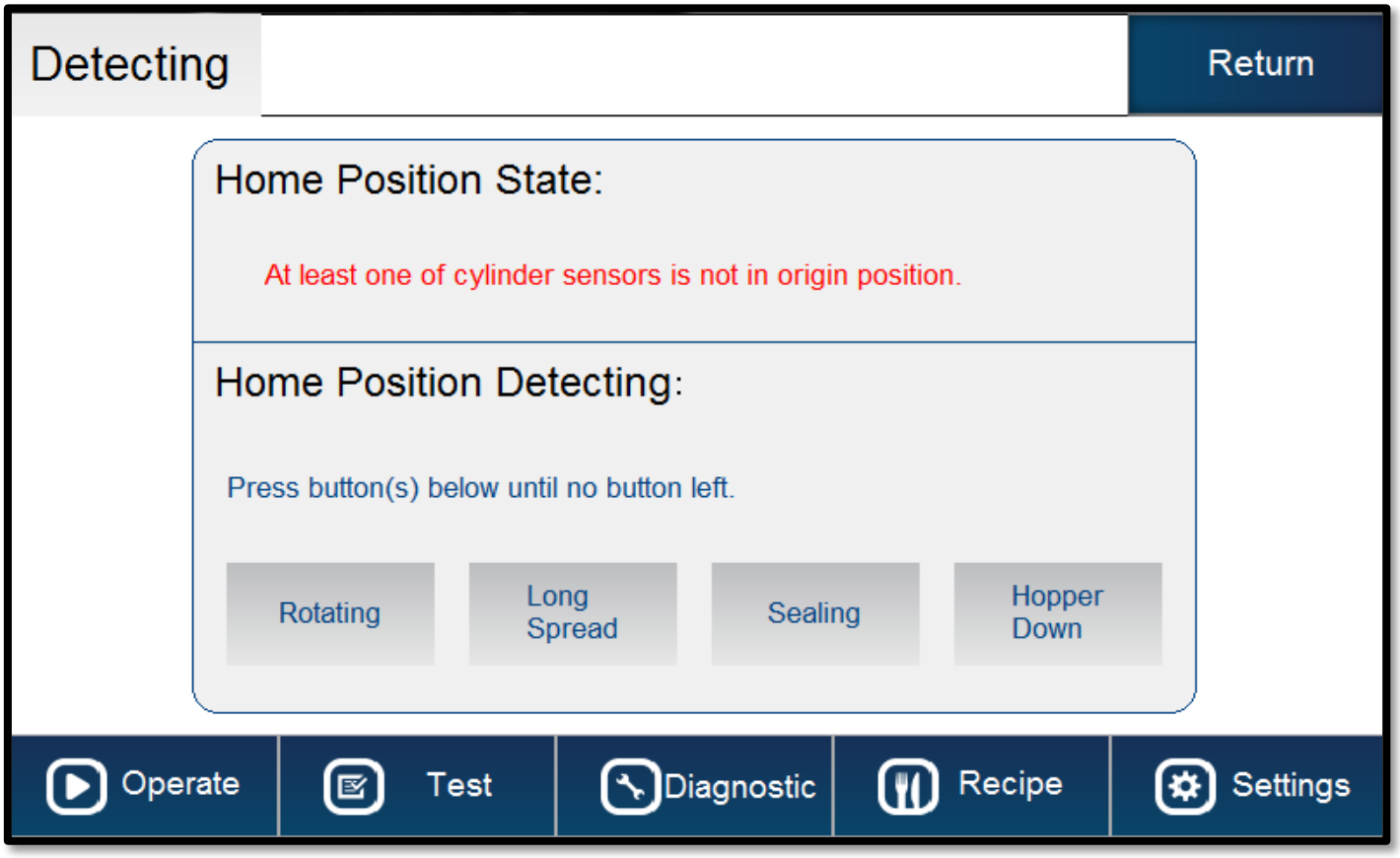




In the event of a machine malfunction, such as a jam, an alarm warning will display on the H.M.I. Touch Screen. A message will appear on screen to describe the cause of the alarm. Once the problem has been resolved, press the Reset button on the front of the control panel to allow the machine to be run again.

7.6.1 DETECTING

In the event one of the sensors of the machine becomes misaligned, this alarm will be triggered. Follow the instructions onscreen to home the machine's sensors. Once the problem has been resolved, press the Reset button on the front of the control panel to allow the machine to be run again.



8. MACHINE OPERATION

8.1 Starting the Machine

ENSURE ALL COVERS ARE CLOSED AND THE EMERGENCY STOP BUTTON IS NOT ENGAGED.

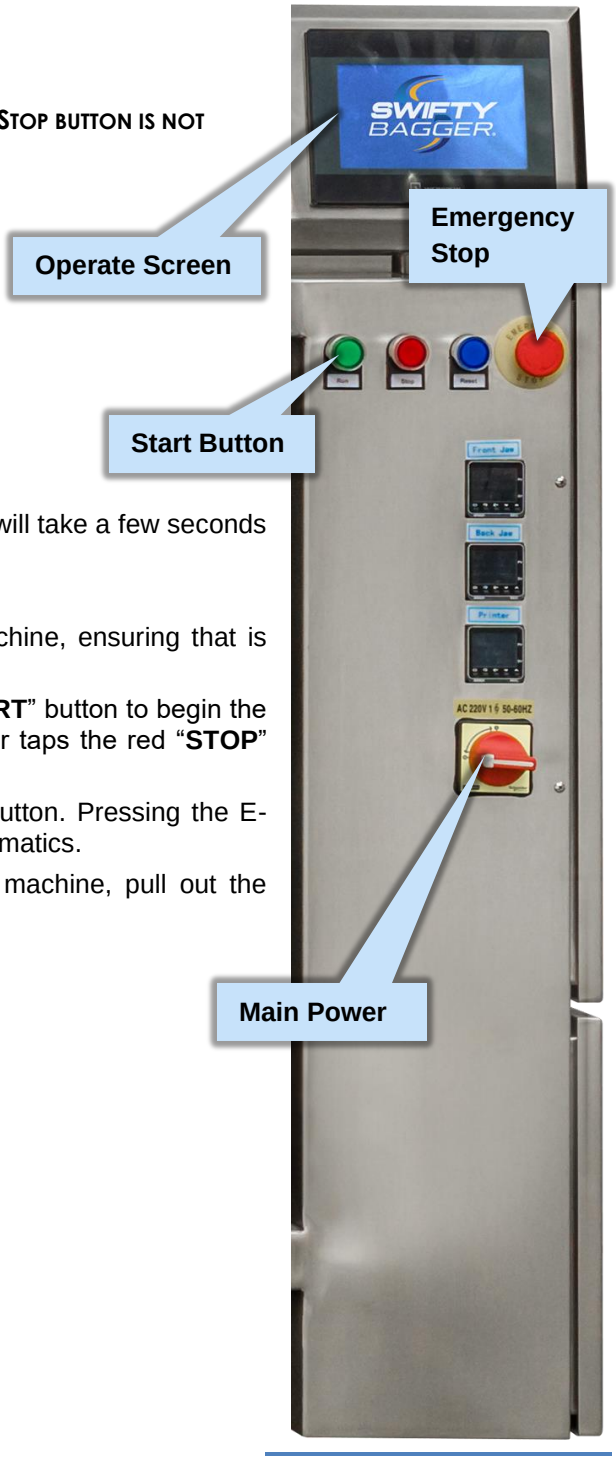


Figure 8-1 Control Panel

Follow the steps bellow:

1. Locate the **MAIN POWER** switch and turn **ON** the machine. It will take a few seconds for the H.M.I. Touch Screen to power up.
2. Press the **START** button.
3. Navigate to the H.M.I.'s **OPERATE SCREEN**. Setup the machine, ensuring that is loaded with the correct Recipe.
4. On the **OPERATE SCREEN** of the H.M.I., tap the green "**START**" button to begin the filling process. The filling process will repeat until the operator taps the red "**STOP**" button on the H.M.I.
5. For emergency machine shut off, use the Emergency Stop button. Pressing the E-Stop will cut power to the machine. Air will be cut off from pneumatics.
6. To resume using the machine: resolve any issues with the machine, pull out the E-Stop and press the **START** button.

9. MAINTENANCE & CLEANING INFORMATION

We recommend having the following tools available when performing maintenance on the machine: metric Allen keys, metric socket set, metric wrenches, voltmeter, screw drivers, tape measure, ruler, caliper, adjustable wrenches and a grease gun.

Maintenance depends on the machine's operating conditions. The machine may require more frequent maintenance, depending on the environment in which it operates. All damaged components must be replaced; failure to do so will affect the machine's performance and result in further damage

9.1 lubrication

Use 3 in 1 Professional White Lithium Grease for lubricating gears & shafts mentioned in the checklist.

9.2 Storage

When storing the machine for a long period of time, disconnect the air, power off and clean the machine thoroughly. After periods of inactivity, it is recommended the machine is tested and adjusted. All the electrical components and connections should be thoroughly checked before powering the machine on.

Do not store the machine in a corrosive environment.

9.3 Cleaning

WHAT IS MEANT BY "STAINLESS" STEEL?

STAINLESS STEEL & RUST

Stainless steel does not rust… **false!**

All metals rust, stainless steel is simply highly rust resistant. The only exceptions to this rule are gold and platinum. Stainless Steel is a term derived from the concept that it "stains less" than other steels, it is not immune to the rusting process or any chemical reaction.

WHAT CAUSES RUST?

RUST CAUSED BY ENVIRONMENT

- Areas with high humidity or excessive cold (where condensation can occur).
- Areas where there are trace amounts of salt in the air or other chemical products.

RUST CAUSED BY PRACTICES

- Cross contamination caused by materials which were used to clean another rusty surface.
- Rusted metal components coming into contact with stainless steel components.
- Damage to the stainless steel surface caused by cleaning tools that are **not designed** for the specific purpose of cleaning stainless steel. Examples include: scouring pads/mesh cloths (for non-stainless steel surfaces) and metal tools such as scrapers or steel wool.

RUST CAUSED BY CLEANING PRODUCTS

- Using cleaning solutions which contain **Sodium Hypochlorite**.
- Not diluting cleaners before using them, dilute solutions as per supplier instructions.
- Not rinsing the machine soon enough, rinse off cleaning product as per supplier instructions.

CLEANING RECOMMENDATIONS

Failure to follow any of our Cleaning Recommendations or misuse of a cleaning product will result in <u>voiding your warranty</u>.

See Page 9.4 for a list of all cleaning and rust removal products

1. Follow Section 9.4 in order to clean the machine.
2. ***Do not*** use high pressure jets of water to clean machinery, water may get into the electrical enclosure.
3. ***Do not*** spray the sealing assemblies with water or cleaners. Make sure they have cooled down and then proceed to wipe them clean.
4. Always use clean cloths when wiping the machine in order to avoid cross contamination.
5. If rinsing a surface, use clean non-contaminated water.
6. Dry all surfaces thoroughly to avoid water spots.
7. ***Do not*** use metal scouring pads/mesh cloths or metal tools such as scrapers or steel wool when.
8. If using ammonia to clean transparent viewing surfaces, take care not to allow any ammonia to touch the stainless steel. Clean viewing surfaces with different cloths than stainless steel surfaces.
9. **Before cleaning, please wear protective safety equipment, including rubber gloves and eye protection.**

FOOD GRADE SANITATION

A sanitizer must reduce the presence of bacteria by 99.9% when used during cleaning. Not to be confused with the legally distinct term “disinfecting” which must eliminate between 99.9999% and 100% of all bacteria and microorganisms on a given surface.

CLEANING A MACHINE BEFORE OR AFTER A PRODUCT RUN

1. Consult our list of pre-selected cleaning products meant to be used to decontaminate stainless steel surfaces without damaging them. See Page 9-4 for the full list.
2. Look up information on the Cleaning Product you have chosen, finding and fully understanding the instructions for the proper use of the Cleaning Product. See the links on Page 9-4 for details, contact information should be available on the supplier’s website.
3. Mix the correct concentration of the Cleaning Product, if applicable and as directed by the information obtained from the supplier.
4. Follow Section 9.4 in order to clean the food contact parts of the machine. Do not apply corrosive cleaning products to the internal workings of the machine.
5. Scrub and remove any and all contaminants from the machine’s food contact surfaces, use non-metallic hand pads to do so. Examples of such scrubbing pads include the “Blendex™” hand pad mentioned on Rust Removal section.
6. Thoroughly rinse off all of the cleaning product from the machine, do not miss any spots as any lingering cleaning product is corrosive and will cause permanent rusting which will spread to the other metallic components of your machine.
7. Dry the machine thoroughly and make sure that no moisture is left behind at the end of the cleaning process, any wet spots are not only form water spots but are unhygienic and may facilitate the growth of bacteria on a surface.

RUST REMOVAL

FOR RUST REMOVAL ON STAINLESS STEEL SURFACE

The following is intended for small amounts of surface level rust on stainless steel surfaces such as rust spots. Surfaces excessively covered in rust cannot be recovered using this process.

1. Spray the clean stainless steel surfaces with “E-Nox Clean™”.
2. Spread the “E-Nox Clean™” cleaning product over the surface of the stainless steel part using a clean cloth.
3. Wait 10 minutes.
4. Scrub the surfaces of the stainless steel part with a clean white “Blendex™” hand pad or similar non-metallic scrubbing pad.
5. Rinse the surface with non-contaminated water at approx. 22°C (room temperature.)
6. Examine the surface of the stainless steel part, paying close attention to weld seams. If the rust persists, then repeat steps 1 through 5 again until all rust has been eliminated.
7. Once the surface of the stainless steel part is free from all signs of rust, spray the parts with the neutralizing agent “Surfox-N™.”
8. Wait 5 minutes.
9. Rinse the surface with clean non-contaminated water at approx. 22°C.
10. Dry the surfaces of the part thoroughly with a clean dry cloth.

CLEANING PRODUCT INFORMATION

Please seek out and carefully read any instructions related to the use of your selected cleaning product, information is available on the cleaning product supplier's website.

METALLURGY COMPANY – CONTACT FOR MATERIAL & METALLURGICAL CONSULTATION

https://cep-experts.ca/service/materials-and-metallurgical/

SUPPLIER: WALTER CLEANING TECHNOLOGIES (NORTH AMERICA)

RUST TREATMENT ***"E-Nox Clean™"*** stainless steel cleaner

https://www.walter.com/products/environmental-solutions/industrial-cleaning-degreasing/e-nox-clean

RUST TREATMENT ***"Surfox-N™"*** neutralizing formula

https://www.walter.com/products/-/producttradename/welding/surfox-liquids/surfox-n

RUST TREATMENT ***"Blendex™"*** hand pads

https://www.walter.com/en_US/products/abrasives/sanding/blendex-hand-pads

SUPPLIER: MICRO GREEN CLEAN (NORTH AMERICA & EUROPE)

LIQUID SANITIZER ***"Micro Green Clean"***

https://www.coleparmer.com/p/micro-green-clean-biodegradable-cleaner/72372

SUPPLIER: PURE BIOSCIENCE (NORTH AMERICA)

LIQUID SANITIZER ***"Pure Hard Surface"***

https://www.purebio.com/products/pure-hard-surface.htm

FOAM SANITIZER ***"Pure Hi-Foam Cleaner"***

https://www.purebio.com/products/pure-hi-foam-cleaner.htm

SUPPLIER: SAN ECO TEC (NORTH AMERICA)

LIQUID SANITIZER ***"Clean 20"***

https://sanecotec.com/sanitizers/

SUPPLIER: BIO GUARD HYGIENE (EUROPE)

FOAM SANITIZER ***"Hi & Lo Foam Food Processing Cleaner"***

https://www.bioguardhygiene.co.uk/products/hi-lo-foam-food-processing-cleaner/

CLEANING PRODUCTS

The customer is responsible for any damages resulting from the use of a product not reviewed by Paxiom Group. If the customer seeks out their own sanitizer product, they must keep in mind to not use solutions which contain **Sodium Hypochlorite**.

9.4 Cleaning Steps

POWER OFF AND UNPLUG:

Begin by turning off the machine. Turn the Main Power Switch located on the Control Box to the off position. Ensure that all components are cool to the touch before continuing.

When unplugging the machine, ensure that the power plug is carefully covered in order to avoid exposure to moisture.

DISLODGE DEBRIS:

Use compressed air to dislodge debris from components and clean the electrical panel.

REMOVE AND CLEAN FOOD CONTACT COMPONENTS:

Remove food contact components including chutes and funnel so they may be cleaned individually and away from the body of the machine. Do not apply excessive force on components attached to the load cell as this may cause damage to the load cell.

BODY OF THE MACHINE:

Clean the machine with a damp cloth; this machine has not been designed to be washed down with a low- or high-pressure water hose. Do not expose the machine to large quantities water such as pouring water on the machine. Clean all metal surfaces thoroughly to remove any contaminants. Use non-corrosive cleaning products.

DRY COMPONENTS:

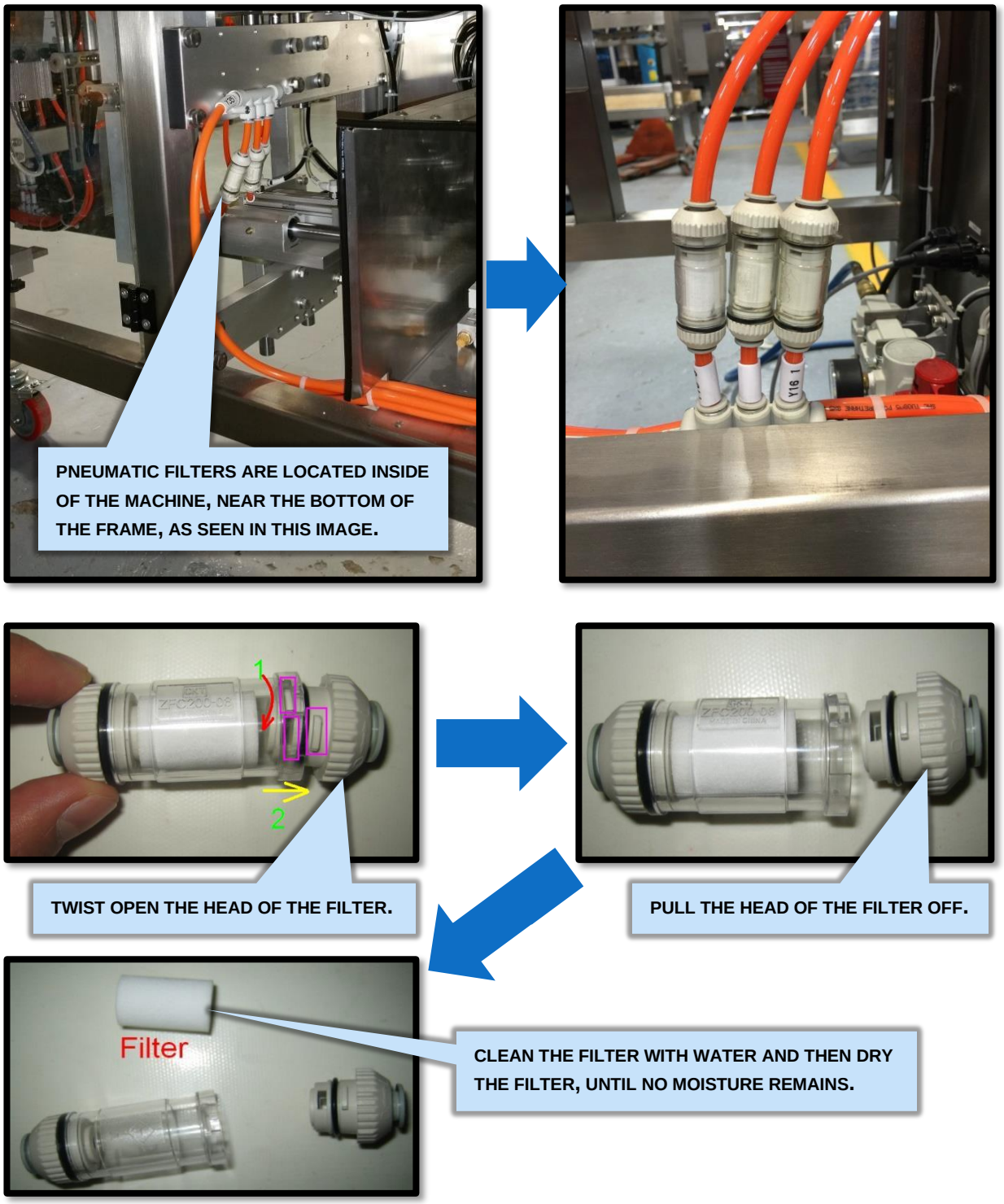
Dry all components with a clean, dry cloth. No water spots should remain on the machine. Leftover cleaning solution can cause damage to stainless steel surfaces.

REINSTALL COMPONENTS:

Once cleaning is completed, reinstall all components.

9.4.2 CLEANING THE PNEUMATIC FILTERS

There are multiple pneumatic filters located throughout the machine, the following steps detail how to disassemble and clean them. Please reassemble filters in the reverse order in which they were disassembled.



10. MAINTENANCE CHECKLIST

DAILY CHECKLIST

ENSURE THE MACHINE HAS BEEN TURNED OFF, LOCKED OUT / TAGGED OUT AND THAT ALL COMPONENTS ARE COOL TO THE TOUCH BEFORE PERFORMING MAINTENANCE ON PARTS.

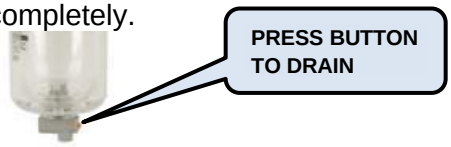
	MON.	TUES.	WEDS.	THURS.	FRI.
SUCTION CUPS					
Check all suction cups for damage and check for proper functionality.	☐	☐	☐	☐	☐
Clear any debris from the suction cups and carefully clean them with a damp cloth.	☐	☐	☐	☐	☐
SEALING JAWS					
Clean the Knife and remove any residue on its surface.	☐	☐	☐	☐	☐
Clean Jaws and inspect for damage, such as chipping.	☐	☐	☐	☐	☐
PNEUMATICS					
Drain the Filter Regulator completely. 	☐	☐	☐	☐	☐
Clean all Pneumatic Filters.	☐	☐	☐	☐	☐
ELECTRONICS					
Machine must be powered ON for this test. Power it OFF and Lock Out when the test is complete.					
Test the safety switches by opening the doors and checking if the machine stops.	☐	☐	☐	☐	☐
Test the Emergency Stop button.	☐	☐	☐	☐	☐

Table 10-1 SWIFTY JR DAILY CHECKLIST

WEEKLY CHECKLIST

(or after 48 hours of continuous operation)

ENSURE THE MACHINE HAS BEEN TURNED OFF LOCKED OUT / TAGGED OUT AND THAT ALL COMPONENTS ARE COOL TO THE TOUCH BEFORE PERFORMING MAINTENANCE ON PARTS.

	1ST WEEK	2ND WEEK	3RD WEEK	4TH WEEK
SEALING JAWS				
Check the Knife for chipping and general damage.	☐	☐	☐	☐
PNEUMATICS				
Check if the air supply to the machine is functioning correctly.	☐	☐	☐	☐
Clean the pneumatic filters as described in the Maintenance Section.	☐	☐	☐	☐
ELECTRONICS				
Check the interior of the Control Box and clean all electrical contacts if there are signs of dust build up or residue.	☐	☐	☐	☐

Table 10-2 SWIFTY JR WEEKLY CHECKLIST

MONTHLY CHECKLIST

ENSURE THE MACHINE HAS BEEN TURNED OFF LOCKED OUT / TAGGED OUT AND THAT ALL COMPONENTS ARE COOL TO THE TOUCH BEFORE PERFORMING MAINTENANCE ON PARTS.

SEALING JAWS

Apply White Lithium grease to the shafts holding the jaws.	☐	☐	☐	☐	☐
Tighten all nuts and bolts on moving parts.	☐	☐	☐	☐	☐

PNEUMATICS

Machine must be powered ON for this test. Power it OFF and Lock Out when the test is complete.

Test if the Filter Regulator is functioning properly and check for air leaks in the machine..	☐	☐	☐	☐	☐
Clean the pneumatic filters as described in the Maintenance Section.	☐	☐	☐	☐	☐

ELECTRONICS

Check for any damaged electrical wiring or damaged power cables.	☐	☐	☐	☐	☐

Table 10-3 SWIFTY JR MONTHLY CHECKLIST