

AMS FILLING SYSTEMS, INC.

OPERATING INSTRUCTIONS FOR MODEL A-100 FILLER

CUSTOMER

NAME: CERTIS, USA

ATTN: Alex Georgian

PURCHASE ORDER NO: 8111

MOTOR VOLTAGE: 440V/3PH/60HZ

CONTROL VOLTAGE: 110V/1PH/60HZ

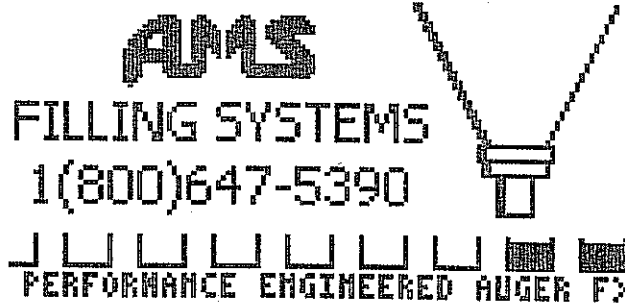
AMS FILLING SYSTEMS

JOB NUMBER: A-100894

DATE: November 2001

WIRING DIAGRAM: DW-2062.000

AMS FILLING SYSTEMS
2500 Chestnut Tree Road
Honey Brook, PA 19344 USA
TEL: (610) 942-4200
www.amsfilling.com



“START UP SCREEN” This is the screen that will appear when the machine is powered on, or power is cycled.

AMS FILLING SYSTEMS INC. 1H:MM PM MM/DD/YY	
RUN (F1) COUNTS	RUN (F2) REVOLUTIONS
PRODUCT SELECT (F3)	SETUP (F4)

“MAIN SCREEN” From the main screen you can select your mode of viewing auger turns, select a product from memory, or setup a new product.

- F1 - Displays auger turns in “Counts” (200 counts = one auger turn).
- F2 - Displays auger turns in “Revolution’s” (1 revolution = one auger turn.)
- F3 - Go to the Product Select screen.
- F4 - Go to the Setup screen. Here is where you will adjust the machine’s functions such as conveyor “on, off”; or vibration “on, off” etc...(If options are available)

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#	#	#	#	#	#
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PRODUCTION COUNT:##### CPM:###

COUNT (F1)	AGITATION (ON)	AUTO OFF	MAIN
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“RUN SCREEN” (counts / revolutions) This screen will give you the name of your product (up to 16 alpha numeric), the number of counts/revolutions, your production count, and containers per minute (CPM).

- F1 - Changes your counts / revolutions.
- F2 - Changes your Agitation mode. (on, off, w/Fill) *
- F3 - Changes your mode of operation. (auto/manual) **
- F4 - Returns to the main screen.

—* Agitation “on” continually turns the agitator blade located inside the hopper. Agitation “w/fill” (with fill) allows the agitator blade to turn only when the auger is turning. Agitation “off”; the agitator blade will not turn.

NOTE: Agitation is used to help consistently feed the product into the flight of the auger.

NOTE: When agitation “on” is selected the agitation will only run for ten seconds after the last fill. It will however start back up after the next fill initiation. This is an added safety feature to prevent over packing of the auger.

** Auto mode means the machine will cycle with predetermined time in-between repeated fills. This time is referred to as recycle time.

7	1. AAAAAAAAAAAAAAAAAAAAAA				
	2. AAAAAAAAAAAAAAAAAAAAAA				
	3. AAAAAAAAAAAAAAAAAAAAAA				
	4. AAAAAAAAAAAAAAAAAAAAAA				
	5. AAAAAAAAAAAAAAAAAAAAAA				
	6. AAAAAAAAAAAAAAAAAAAAAA				
	7. AAAAAAAAAAAAAAAAAAAAAA				
<table><tr><td>LOAD (F1)</td><td>DEL (F2)</td><td>SAVE (F3)</td><td>MAIN (F4)</td></tr></table>		LOAD (F1)	DEL (F2)	SAVE (F3)	MAIN (F4)
LOAD (F1)	DEL (F2)	SAVE (F3)	MAIN (F4)		

“PRODUCT SELECT SCREEN” This screen gives you a list of your products stored in memory. Use ↑, ↓ arrows to highlight different products.

- F1 - Load a product recipe from memory
- F2 - Delete a product recipe from memory
- F3 - Save a product recipe into memory
- F4 - Returns to the main screen

AMS FILLING SYSTEMS INC.
11:11 PM 11/11/11

MAINTENANCE (F1)	CONTROL (F2)
PRODUCT SETUP (F3)	MAIN (F4)

“SET UP SCREEN” From this screen you will be able to access the maintenance screen, control screen, product setup, or return to the main screen.

- F1 - Maintenance screen: Here you will be able to control such things as production count reset, agitation jog, fill jog, etc...
- F2 - Control screen: Here you will be able to adjust the amount of recycle time, (recycle time is the amount of time in between each fill) when machine is in auto mode, and vibration mode (on, off, w/Fill).
- F3 - Product setup screen: This guides you through a series of screens allowing you to adjust all aspects of the machine, and save them as a recipe.
- F4 - Returns to the main screen.

AMS FILLING SYSTEMS INC.
1H:MM PM MM/DD/YY

FILL JOG (F1)	AGITATION JOG (F2)
MAIN (F3)	NEXT (F4)

“MAINTENANCE SCREEN” (pg.1) This screen allows you to manually control the auger and agitation.

- F1 - Fill jog (turns the auger) *
- F2 - Agitation jog (turns the agitation)*
- F3 – Returns to the main screen.
- F4 - Advances to the next maintenance screen.

*Both auger and agitation will continue to run as long as their designated buttons are held.

AMS FILLING SYSTEMS INC.
1H:MM PM MM/DD/YY

PRODUCTION COUNT RESET (F1)	ALARM PAGE (F2)
BACK (F3)	CONFIGURE SCREEN (F4)

MAINTENANCE SCREEN” (pg.2) This screen allows you to reset your production count, view the alarm page, and access the panel view configuration settings.

- F1 - Resets the production counter. By pressing, production count resets to zero.
- F2 - Advance to the alarm page.
- F3 - Return to the first maintenance page.
- F4 - Advance to the panel view configuration screen.

NOTE: Panel view settings are factory preset, by adjusting settings the possibility for communication failure can occur.

AMS FILLING SYSTEMS INC.
1H:MM PM MM/DD/YY

RECYCLE TIME MM.MM (F1)	VIBRATION OFF (F2)
BACK (F3)	MAIN (F4)

CONTROL SCREEN The control screen gives you the ability to control the amount of recycle time and vibration mode.

- F1 - Recycle time adjustment. (.10-10 sec)*
- F2 - Vibration mode (on, off, w/fill)
- F3 - Returns to the previous screen.
- F4 - Advance to the main screen

NOTE: Recycle time is the amount of time between cycle initiation.

AMS FILLING SYSTEMS INC.
1H:MM PM MM/DD/YY

1H:MM PM AUGER RUN AWAY (CHECK CLUTCH BRAKE)			
ACK (F1)	CLEAR (F2)	BACK (F3)	MAIN (F4)

“ALARM PAGE” This page will maintain a record of any alarms triggered by the machine, such as an emergency stop.

- F1 - Acknowledges the alarm.
- F2 - Clears the alarm
- F3 - Return to the previous Screen
- F4 - Return to the main screen

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INPUT TYPE:		COUNTS	
AGITATION:		ON	
NAME (F1)	INPUT (F2)	AGITATE (F3)	NEXT (F4)

“PRODUCT SET UP” (pg.1) This is the first of six screens that will guide you through a complete set up of your product.

F1 - Name: Here you will enter a description for your product up to 16 characters (alpha numeric) long.

F2 - Input: Select your auger turn preference (counts/ revolutions).

F3 - Agitate: Select a mode of agitation (on/ off/ with fill).

F4 - Next: Advance to the next product setup screen.

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#####			
COUNTS (F1)	MAIN (F2)	BACK (F3)	NEXT (F4)

“PRODUCT SET UP” (pg.2)

F1 - Counts/Revs: Enter the number of counts/revolutions

F2 - Main: Return to the main screen

F3 - Back: Return to the previous product setup screen

F4 - Next: Advance to the next product set up screen

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VIBRATION: ON

VIBRATE (F1)	MAIN (F2)	BACK (F3)	NEXT (F4)
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“PRODUCT SET UP” (pg.3)

- F1 - Vibrate: Select your mode of vibration (on/ off/ with fill).
- F2 - Main: Return to the main screen
- F3 - Back: Return to the previous product setup screen
- F4 - Next: Advance to the next product set up screen

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AUGER SIZE Ø# (F1)	AUGER TYPE FF (F2)	AUGER LENGTH Ø#, ### (F3)
BACK (←)		NEXT (F4)

“PRODUCT SET UP” (pg.4) Here you have the ability to save the exact Tooling size you are using for a particular product.

- F1 - Enter the size of your auger
- F2 - Enter the type of auger (self-feeding, or free flow)
- F3 - Enter the length of the auger
- F4 - Next: Advance to the next product set up screen
- ← - Back: Advance to the previous product setup screen


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FUNNEL SIZE Ø# (F1)	FUNNEL TYPE LIP (F2)	FUNNEL LENGTH Ø#.### (F3)
BACK (←)		NEXT (F4)

“PRODUCT SET UP” (pg.5)

- F1 - Enter the size of your funnel
- F2 - Enter the type of funnel (Lip or Straight)
- F3 - Enter the length of the funnel
- F4 - Next: Advance to the next product set up screen
- ← - Back: Advance to the previous product setup screen

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COUNTS:#####

AGITATION: W/FILL

VIBRATION: ON

AUGER: MM SF MM.MMM

FUNNEL: MM LIP MM.MMM

BACK(F1)	MAIN(F4)
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“PRODUCT SET UP” (pg.6) The last product set up screen gives you a review of your selections.

- F1 – Back: Return to the previous product setup screen
- F2 – Main: Return to the main screen

Bill of Material

Codes: A - Assembly S - Sub-Assembly D - Detail E - Electrical P - Purch

Customer: CERTIS USA

Number: A-100894

Item	Code	Drw'g / Part No.	QUAN	Description
1	A	D-1010-A	1	HEAD ASSEMBLY: Type: Painted
2	S	B-1019	1	HOPPER COVER: Type: Dust Proof
3	S	B-1020	1	LEVEL CONTROL ASSEMBLY:
4	D	C-1036-Gr#1	1	HOPPER: Type: 22" Straight Sided w/ 3.25" Opening
5	S	B-1011-GR#2	1	HOPPER COUPLING: Type: Large
6	D	A-1027	1	COLUMN: Length: 84"
7	S	B-1260-GR#1	1	BASE: Type: Floor: wo/ Casters
8	-	-	-	-
9	S	B-1695-13A	1	CONTROL ENCLOSURE: Type: Painted
10	S	B-1024-8	1	MOUNTING: CONTROL ENCLOSURE loc: Column
11	D	B-1009-9	REF	MOTOR STARTER MOUNTING: loc: Column
12	D	-	0	TRANSFORMER MOUNTING: loc: _____
13	E	ELC2062.000	1	ELECTRICAL COMPONENT LIST:
14	E	A100.B001	1	MOTOR COMPONENT LIST: Wire for 440 VAC
15	E	DW-2062.000	1	WIRING DIAGRAM: MACHINE
16	E	BW-1008	1	WIRING DIAGRAM: LEVEL CONTROL
17	-	B-1715	-	DIVING NOZZLE ASSEMBLY
18	-	-	-	-
19	S	A-1158.000	1	AIR CONTROL PACKAGE:
20	S	A-1158	1	AIR PACKAGE ASSEM:
21	S	A-1054	1	AIR SCHEMATIC:
22	-	-	-	-
23	S	-	1	INSTRUCTION MANUAL:

NOTES:

Wire Length:

Motor Input: 12'

115 VAC: 12' w/ Plug

Free Flow Tooling w/Diving Nozzle

Platinum 2000 Controls

A M S Filling Systems. Inc.**Bill of Material**

Date: _____ Page 2 of 17

Codes: A - Assembly S - Sub-Assembly D - Detail E - Electrical P - Purch

Customer: CERTIS USA

Number: A-100894

Item	Code	Drw'g / Part No.	QUAN	Description
1	D	B-1023-M-GR#10	1	AUGER SHAFT: Length: 10 5/8"
2	-	_____	-	_____
3	D	C-1008	1	SLOW SPEED BLADE: Cut for: 2 1/4" Diameter Flight
4	D	_____	-	SLOW SPEED BLADE: Cut for: _____
5	-	_____	-	_____
6A	-	D-1082-1-Gr#2	1	AUGER: #36 Free Flow x 13 1/8" Lg.
6B	D	A-1087-#13	1	SPINNER PLATE: 4 1/2" Diameter
6C	P		2	NUT: 3/8-16 LH
7	-	_____	-	AUGER:
8	-	_____	-	AUGER:
9	-	D-1055-3-Gr#1	1	FUNNEL: #36 Str x 5 9/16" Lg.
10	-	_____	-	FUNNEL:
11	-	_____	-	FUNNEL:
12	D	B-1090	0	FUNNEL ADAPTER:
13	D	B-1030	1	ALIGNMENT TOOL:
14	P		0	LOCKING COLLAR: 5/8" I.D.
15	-	_____	-	_____
16	S	B-1215-8	1	COLLECTOR FUNNEL ASSEMBLY: 8" Diameter

Title: HEAD ASSEMBLY w/ AGITATION

Draw'g or Part Number: D-1010-A

Item	Code	Drw'g / Part No.	QUAN	Description
1	D	D-1000-B-GR#1	1	HEAD FRAME:
2	D	C-1015	1	SUPPORT BASE: 8" Dia.
3	D	C-1002-5-GR#1	1	MOTOR SUPPORT PLATE:
4	D	A-1000	4	ROD: For item #3, motor support plate
5	D	C-1079-GR#1	1	FRONT COVER:
6	D	C-1080-GR#1	2	SIDE COVERS:
7	D	C-1082-IT#1-GR#1	1	BELT GUARD:
8	D	C-1082-IT#2-GR#1	1	MOTOR PULLEY COVER:
9	D	C-1081-GR#1	1	TOP COVER:
10	D	C-1006-B	1	CLUTCH BRAKE ASSEMBLY: w/ ENCODER
11	P	MAS53x7/8	1	PULLEY: Driver, three step (3,4,5" DIA) 7/8" Bore
12	P	ABCDEFGF	1	PULLEY: Driven, (8" DIA) 7/8" Bore
	P	#4L760	1	BELT: Type "4L" 76" Lg.
14	S	B-1158	1	BEARING HOUSING: Slow Speed Agitation
15	S	B-1008	1	SPRING LOADED CHAIN TAKEUP:
16	P		1	CHAIN: #40 ROLLER x 25.00" Lg.
17	P		1	CONNECTING LINK: For #40 Chain
18	P		1	CONNECTING HALF LINK: For #40 Chain
19	E	See Motor Comp.	0	MOTOR: Fill
20	E	See Motor Comp.	0	MOTOR: Agitation

Bill of Material

Codes: A - Assembly S - Sub-Assembly D - Detail E - Electrical P - Purch

Title: CLUTCH BRAKE ASSEMBLY w/ ENCODER**Drw'g or Part Number: C-1006-B**

Item	Code	Drw'g / Part No.	QUAN	Description
1	P	#EM180-30	1	CLUTCH MODULE: "Warner"
2	P	#EM180-20	1	BRAKE MODULE "Warner"
3	D	B-1000	2	MOUNTING BRACKET:
4	D	B-1005-2-IT#1	1	DRIVE SHAFT:
5	D	B-1005-2-IT#2	1	WASHER:
6	P		1	BOLT: Hex Head (5/16-18 x 1" Lg)
7	D	A-1005-IT#2	2	SPACER: Encoder Mounting
8	D	A-1005-IT#1	1	PLATE: Encoder Mounting
9	D	A-1014-1	1	GEAR: Driver
10	D	A-1007-IT#2	1	GEAR: Driven
11	P		1	KEY: 3/16" Square x 1 3/4" Lg.
12	E	See Electrical	0	ENCODER:

Title: BEARING HOUSING; FOR SLOW SPEED AGITATION**Drw'g or Part Number: B-1158**

Item	Code	Drw'g / Part No.	QUAN	Description
1	D	B-1003	1	BEARING HOUSE:
2	D	B-1004	1	SLOW SPEED SPINDLE: Single Slot
3	D	A-1004	1	SLEEVE:
4	D	A-1003	1	SPROCKET: Ref 20 Teeth
5	P		1	KEY: 1/4" Square x 3/4" Lg
6	P	#209KPP	2	BEARING: "NTR" or equal
7	P	#YA100RR	1	BEARING: "NTR" or equal
8	P	#25007	1	SEAL: "Chicago Rawhide" or equal
9	P	#AC1450-EO	1	SEAL: "NOK"

Title: SPRING LOADED TAKEUP; For Agitation Drive
Drw'g or Part Number: B-1008

Item	Code	Drw'g / Part No.	QUAN	Description
1	D	A-1017-IT#1	1	LONG BRACKET:
2	D	A-1017-IT#2	1	SHORT BRACKET:
3	D	A-1017-IT#4	1	SPACER:
4	D	A-1017-IT#5	1	WASHER:
5	S	A-1018		IDLER SPROCKET SUB ASSEMBLY
	P	A-1018-IT#1	1	SPROCKET: #40A11 "Browning" or equal
	P	A-1018-IT#2	1	BEARING: #S3PP "Fafnir" or equal
6	D	A-1019-GR#2	1	SPACER:
7	P		1	SHOULDER BOLT: 3/8" Dia x 1" Lg
8	P		1	HEX NUT: 5/16-18 Thread
9	P	#E0420-045-3000	1	ENSA NUT: 3/8-16 Thread

Bill of Material

Codes: A - Assembly S - Sub-Assembly D - Detail E - Electrical P - Purch

Title: HOPPER COVER ASSEM: DUST PROOF w/ 7" DIAMETER INFEEED DUCT
Draw'g or Part Number: B-1019

Item	Code	Drw'g / Part No.	QUAN	Description
1	D	D-1003	1	COVER FABRICATION:
2	P		1	GASKET: Neoprene Sponge 1/4" x 1" x 72" Lg
3	D	A-1021	1	GASKET: For Bearing House Mounting
4	D	A-1009	1	INSPECTION DOOR:
5	D	A-1023-Gr1	2	KNOB: For Inspection Door
6	S	A-1030		COVER CLAMP ASSEMBLY:
	D	A-1030-It#1	8	CLAMP CASTING:
	D	A-1030-It#2	8	BOLT: "J"
	P	A-1030-It#3	8	WING NUT: 1/4-20 Thread
7	P		8	SCREW: Pan Head #10-32 x 3/8" Lg

Additional Parts Required without Level control

—	D	A-1036	0	COVER PLATE: For Level Control Mounting Hole
	D	B-1018-IT#3	0	GASKET: For Cover Plate

Bill of Material

Codes: A - Assembly S - Sub-Assembly D - Detail E - Electrical P - Purch

Title: HOPPER SUPPORT ASSEMBLY (LARGE OPENING)**Fig or Part Number: B-1011-GR#2**

Item	Code	Drw'g / Part No.	QUAN	Description
1	D	D-1002	1	SUPPORT CASTING: (PART #1) COLUMN MOUNTED
2	D	C-1004	1	SUPPORT CASTING: (PART #2) "L" BRACKET
3	D	A-1002	2	ALIGNMENT PIN:
4	D	A-1001	2	ALIGNMENT BUSHING:
5	P		4	BOLT: 3/8-16 (Socket Head Cap) x 2 3/8" LG.
6	D	C-1003-4	1	SUPPORT CASTING: (Large Coupling w/ provision for proximity switch)
7	D	A-1022-GR#1	3	KNOB: (Short) For Hopper Mount
8	D	A-1022-GR#3	3	KNOB: (Long) For Tooling Mount
9	P		1	BOLT: 1/2-13 (Hex) x 2 1/4" lg.
10	P		1	WASHER: 1/2" Flat
11	P		2	BOLT: 3/8-16 (Hex) x 1 3/4" LG.
12	P		2	WASHER: 3/8" Flat x .075" Thick
13	P		6	HELI-COIL: 5/16-18 Thread x 1/2" LG.
14		See Electric List	1	Proximity Switch

Bill of Material

Codes: A - Assembly S - Sub-Assembly D - Detail E - Electrical P - Purch

Title: FLOOR BASE ASSEMBLY w/o CASTERS**w'g or Part Number: B-1260-GR#1**

Item	Code	Drw'g / Part No.	QUAN	Description
1	D	D-1004-1-Gr#1	1	FLOOR BASE FABRICATION: Type: Painted
2	D	C-1001	1	ROUND BASE: Type: Painted

Bill of Material

Codes: A - Assembly S - Sub-Assembly D - Detail E - Electrical P - Purch

Title: LEVEL CONTROL ASSEMBLY**'g or Part Number: B-1020**

Item	Code	Drw'g / Part No.	QUAN	Description
1	P	#318-B-1	1	LEVEL CONTROL UNIT: "Robertshaw"
2	P	#740-B1-A012	1	PROBE: "Robertshaw"
3	D	A-1654	1	MOUNTING DISC: For Level Control Unit
4	D	B-1018-IT#3	1	GASKET: For Mounting disc
5	D	B-1018-IT#4	1	SUPPORT: For Probe End
6	P		1	BOLT: Hex Head 1/4-20 x 1/2" Lg
7	P		4	WASHER: 1/4" Flat
8	P	#PB-2521	1	STRAIN RELIEF: For Electrical Wire

Bill of Material

Codes: A - Assembly S - Sub-Assembly D - Detail E - Electrical P - Purch

Title: CONTROL ENCLOSURE ASSEMBLY: MODEL A-100 w/ RECYCLE
Drw'g or Part Number: B-1695-13A

Item	Code	Drw'g / Part No.	QUAN	Description
1	D	B-1694-13A	1	ENCLOSURE:
1A	P	A-12108DL	1	ENCLOSURE: "Hoffman"
1B	P	A-12P10	1	PANEL: "Hoffman"
2	D	A-1011-12	1	NAME PLATE:
3	E	SEE ELECTRICAL	REF	PANEL VIEW 300 MICRO

Bill of Material

Codes: A - Assembly S - Sub-Assembly D - Detail E - Electrical P - Purch

Title: ASSEM: COLUMN MOUNTING FOR ENCLOSURE - (Rotated 90°)
Draw'g or Part Number: B-1024-8

Item	Code	Drw'g / Part No.	QUAN	Description
1	D	B-1002	2	COLUMN CLAMP:
2	D	A-1020-6-GR#3	2	MOUNTING BAR:
3	D	A-1816-2	4	SPACER:
4	D	B-1695-13A	REF	CONTROL ENCLOSURE:

Bill of Material

Codes: A - Assembly S - Sub-Assembly D - Detail E - Electrical P - Purch

Title: ELECTRICAL COMPONENT LIST**Dr'g or Part Number: ECL 2062.000**

Item	Code	Drw'g / Part No.	QUAN	Description
1	—	—	—	—
2	P	#6042-448-003	1	CONTROL MODULE: (Clutch Brake) "Warner" Model #CBC-700-90VDC
3	P	#90-0001	2	SWITCH: (Power) S.P.S.T. "ON - OFF" "RUN ON - OFF"
4	P	#679-5105	1	INDICATOR LIGHT: "Red"
5	P	#740-0141	2	FUSE: 3 Amp @ 120VAC
6	P	#354	2	FUSE HOLDER: "Little Fuse"
7	P	#S14K130	4	SUPPRESSOR: (MOV)
8	P	#31-0200-300-1	1	ENCODER: 200PPR / 5-24VDC "Dynapar"
9	P	#1762-L24 BxB	1	PLC: Micro Logix 1200
10	—	#2711 M3A-18LI01	1	PANELVIEW 300 MICRO
11	P	#25777-03	1	BOOT: "Red" For Toggle Switch
12	P	#25777-01	1	BOOT: "Black" For Toggle Switch
13	P	#632-S	1	INITIATION SWITCH: (Foot) "Linemaster"
14	P	#7485V	1	PLUG: (Initiation Switch) "Hubbell" Twist-Lock"
15	P	#7596V-BLK	1	RECEPTACLE: (Initiation Switch) "Hubbell" Twist-Lock"
16	P	# SCP 305248-DN	1	POWER SUPPLY: "Sola"
17	D	A1810		OPERATOR INTERFACE CABLE
17A	P	283-1174	1	8 PIN MINI DIN CONNECTOR 6' CABLE
17B	P	742-1556	1	8 PIN MINI DIN CONNECTOR
24				
25				
26				
27	P	#7596V-BLK	1	RECEPTACLE: (Initiation Switch) "HUBBELL" Twist-Lock"
28	P	#E10801PPOF-1	1	PROXIMITY SWITCH: "Carlos Gavazzi"
29	P	CONH10-S5	1	CABLE FOR PROX

Bill of Material

Codes: A - Assembly S - Sub-Assembly D - Detail E - Electrical P - Purch

Title: MOTOR COMPONENT LIST – Standard Three Phase / 60 Hertz Applications
’g or Part Number: A100.B001 w/ TD Agitation

Item	Code	Drw’g / Part No.	QUAN	Description
1	P	#120183	1	MOTOR: (Fill) 1.5 HP (3 ph) 1140 RPM – TEFC Frame Size: #J145T “LEESON”
2	P	#100601	1	MOTOR: (Agitation) .50 HP (3 ph) 1725 RPM – ODP Frame Size: #LS56C w/ FOOT “LEESON”
3	P	#F721-30STP-B5-J	1	REDUCER: (Agitation) 30:1 RATIO “BOSTON”
4A	D	B-1007-12-It#1	1	MOUNTING BRACKET: Agitation Reducer Right Side
4B	D	B-1007-12-It#2	1	MOUNTING BRACKET: Agitation Reducer Left Side
5	D	B-1007-5A	2	MOUNTING BRACKET: Agitation Motor
6	P	#40B14 – 1”B.	1	SPROCKET: Agitation Reducer
7A	P	#A9DSP-84JM/AF-2	1	DUAL MOTOR STARTER PACKAGE: w/ PLASTIC ENCL. USE w/ 230 VAC – 3 PHASE – 60 HERTZ
7B	P	#TA25DU1,4	1	OVERLOAD TO CONVERT ITEM 7A TO 460 VAC
—	D	B-1009-9	1	MOTOR STARTER MOUNTING: Loc: COLUMN
8B	D	B-1002	1	COLUMN CLAMP: For Motor Starter Mounting Plate
9	P	#T-2-53008-S	0	TRANSFORMER: 0.5 KVA – SINGLE PHASE

Note: Transformer supplied only when specified under Optional Equipment at time of order.

Bill of Material

Codes: A - Assembly S - Sub-Assembly D - Detail E - Electrical P - Purch

Title: AIR CONTROL PACKAGE (Ref: FOUR WAY)**W'g or Part Number: A-1158.000**

Item	Code	Drw'g / Part No.	QUAN	Description
1	P	#611B-11-111CA	1	SOLENOID VALVE: (4 way) "MAC Valve"
2	P	#R384-02C-1/4"	1	REGULATOR: "Norgren"
3	P	#18-013-225	1	GAUGE: "Norgren"
4	P		1	PULLING ELL: Electrical 1/2"
5	P	#2521	1	STRAIN RELIEF: Electrical "T&B"
6	P		1	CLOSE NIPPLE: 1/2"
7	P		1	RUBBER CORD: Three Wire w/ Ground 48" Lg.
8	P	#215PNL-2-15	1	NIPPLE: "Parker"
9	P	#209P-4-2	1	REDUCING BUSHING: "Parker"
10	P	#168P-4-2	2	FITTING: (Straight) 1/8P to 1/4T "Parker"
11	P		2	TUBING: (Poly-Flow) 1/4" OD x 48" Lg.
12	P	#FCP2	0	FLOW CONTROL VALVE: "Bimba"

Bill of Material

Codes: A - Assembly S - Sub-Assembly D - Detail E - Electrical P - Purch

Title: ASSEMBLY DIVING NOZZLE**Drw'g or Part Number: B-1715**

Item	Code	Drw'g / Part No.	QUAN	Description
1	D	B-1717	1	DIVING NOZZLE:
2	D	B-1716	1	BRACKET:
3	D	B-1002	1	COLUMN SUPPORT CLAMP:
4	P	CM-175-D	1	AIR CYLINDER: "BIMBA"
4	P	MRS-.087-BLQCX-17	2	SENSING SWITCH: "BIMBA"

Bill of Material

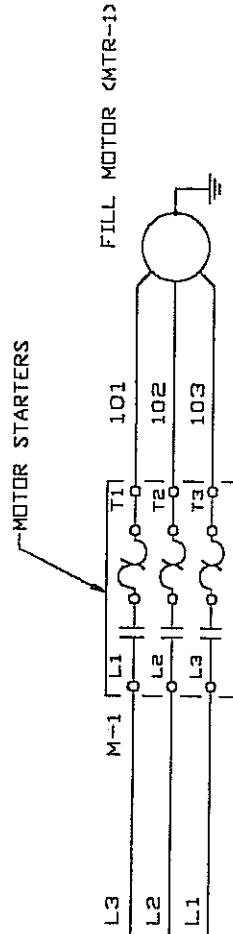
Codes: A - Assembly S - Sub-Assembly D - Detail E - Electrical P - Purch

Title: ASSEMBLY 8" COLLECTOR FUNNEL**Dr'g or Part Number: B-1215-8**

Item	Code	Drw'g / Part No.	QUAN	Description
1*	D	100894-02	1	8" COLLECTOR FUNNEL: Dust Shroud: No Nozzel Size: 2 1/2" OD X .065 W Nozzel Length: 6 1/4" Overall Length: 14 3/8"
2	D	B-1083-Gr#1	1	COVER
3	D	B-1085-GR#5	1	FUNNEL CLAMP
4	D	A-1047	4	MOUNTING CLIP
5	P	ST. STL.	4	WING NUT #10-32 THREADS
6	P	ST. STL.	4	SCREW: (Round Head) #10-32 x 1 1/2" LG.
7	P	ST. STL.	4	ESNA NUT #10-32
8	P	ST. STL.	1	SET SCREW: 1/4-20 X 1 1/2" LG.

MOTOR INPUT VOLTAGE
(THREE PHASE)

L3
L2
L1
GROUND

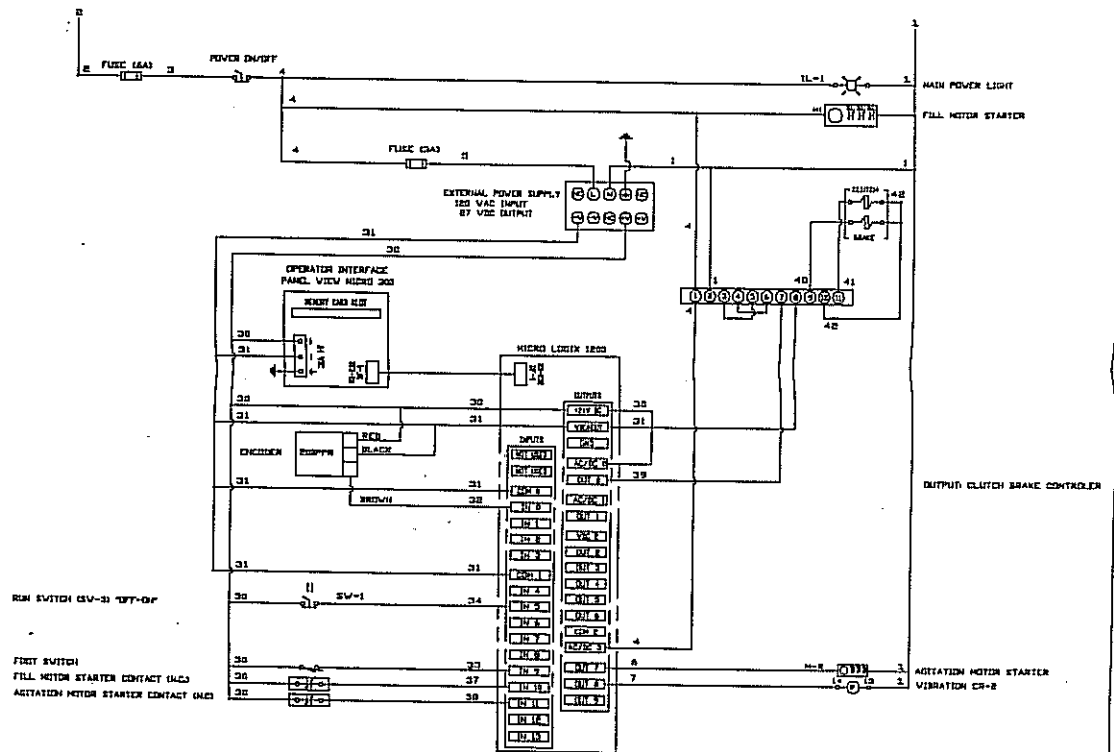
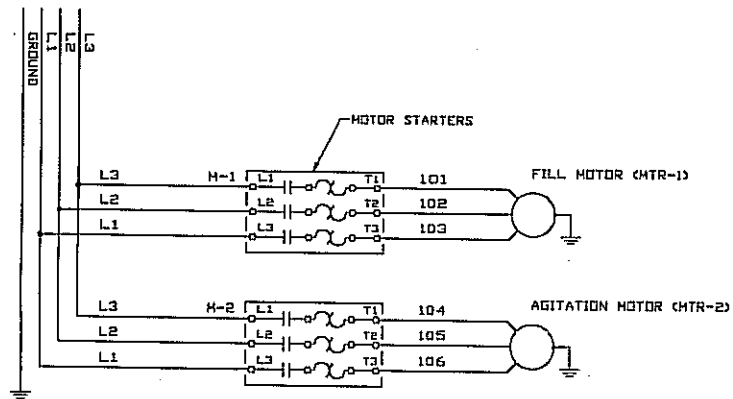


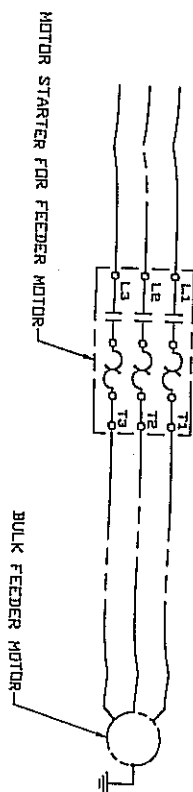
AGITATION MOTOR (MTR-2)

AMS A M S FILLING SYSTEMS INC
HONEY BROOK, PA. 19344 U.S.A.

TITLE	
WIRING DIAG: A100 W/AB CONTROLS	
DATE	05.16.01
BY	DW-2062.000
DWG NOT SCALE	FILE NAME DW2062.000

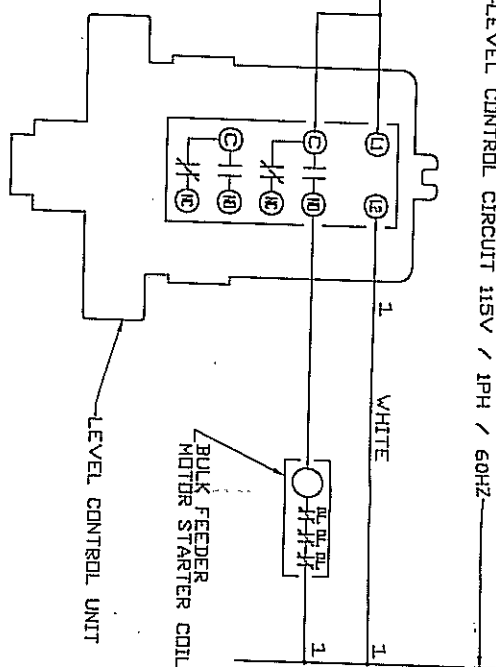
MOTOR INPUT VOLTAGE
(THREE PHASE)





CONNECT TO CONTROL CIRCUIT
AFTER THE POWER SWITCH
WIRE NUMBER _____

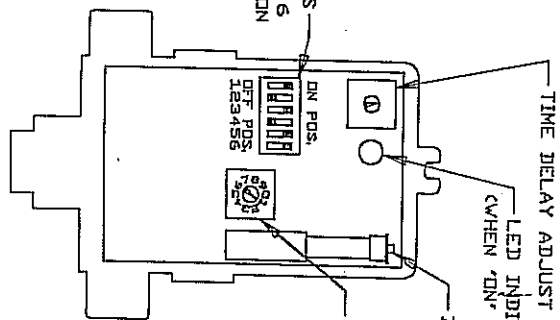
LEVEL CONTROL CIRCUIT 115V / 1PH / 60HZ



BULK FEEDER
MOTOR STARTER COIL

LEVEL CONTROL UNIT

MODE SWITCHES—
1 2 3 4 5 6
ON OFF ON OFF ON ON



CALIBRATING INSTRUCTIONS

- 1- SET MODE SWITCHES FOR HIGH LEVEL FAIL SAFE AS SHOWN
- 2- SET ZERO ADJUST (FINE) TO MINIMUM SETTING (UNIT HAS 30 FULL TURNS, DO NOT FORCE PAST STOPS)
- 3- SET ZERO ADJUST (COARSE) TO #1 POSITION
- 4- OBSERVING LED INDICATOR IS 'OFF', SLOWLY ADJUST THE ZERO ADJUST (FINE) CLOCKWISE UNTIL THE LED JUST TURNS 'ON'. THEN REVERSE 1/2 TO 1 FULL TURN, LED WILL TURN OFF. CALIBRATION IS NOW COMPLETED.
- 6- TO SET TIME DELAY, POSITION MODE SWITCH #6 TO THE OFF POSITION AND ADJUST THE TIME DELAY FOR DESIRED DELAY CLOCKWISE TO INCREASE

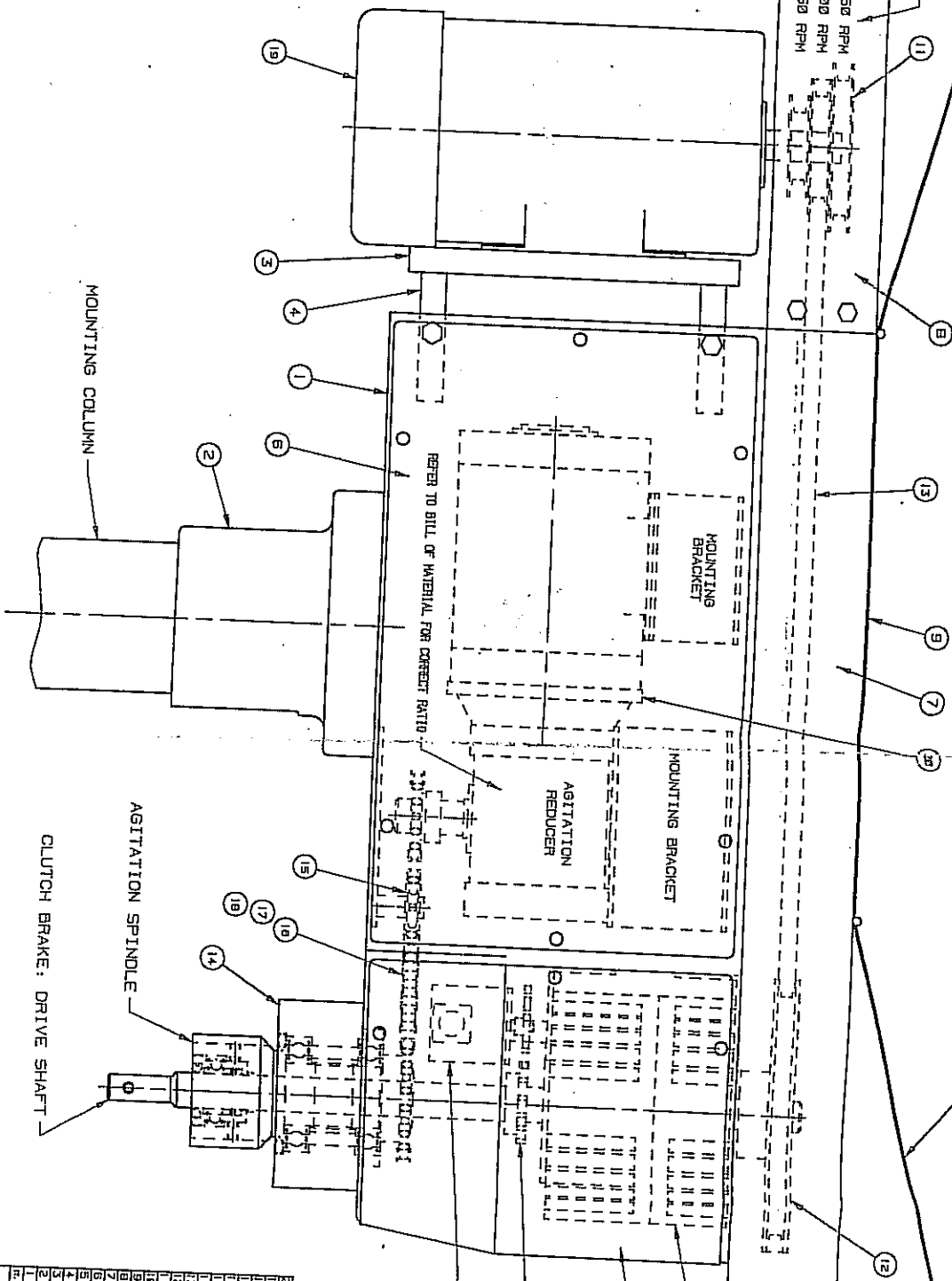
TITLE:		A M S A M S FILLING SYSTEMS INC.	
DRAWING NO.		MALVERN, PA. 19355 U.S.A.	
DATE		DATE	
12/30/88		12/30/88	
BY		BY	
SAH		SAH	
CHECKED		CHECKED	
SCALE		SCALE	
1:1		1:1	
PART USED		PART USED	
WIRING DIAGRAM		WIRING DIAGRAM	
LEVEL CONTROL		LEVEL CONTROL	
1008		1008	

HINGED COVER FOR SPEED CHANGE

HINGED INSPECTION COVER

750 RPM
600 RPM
450 RPM

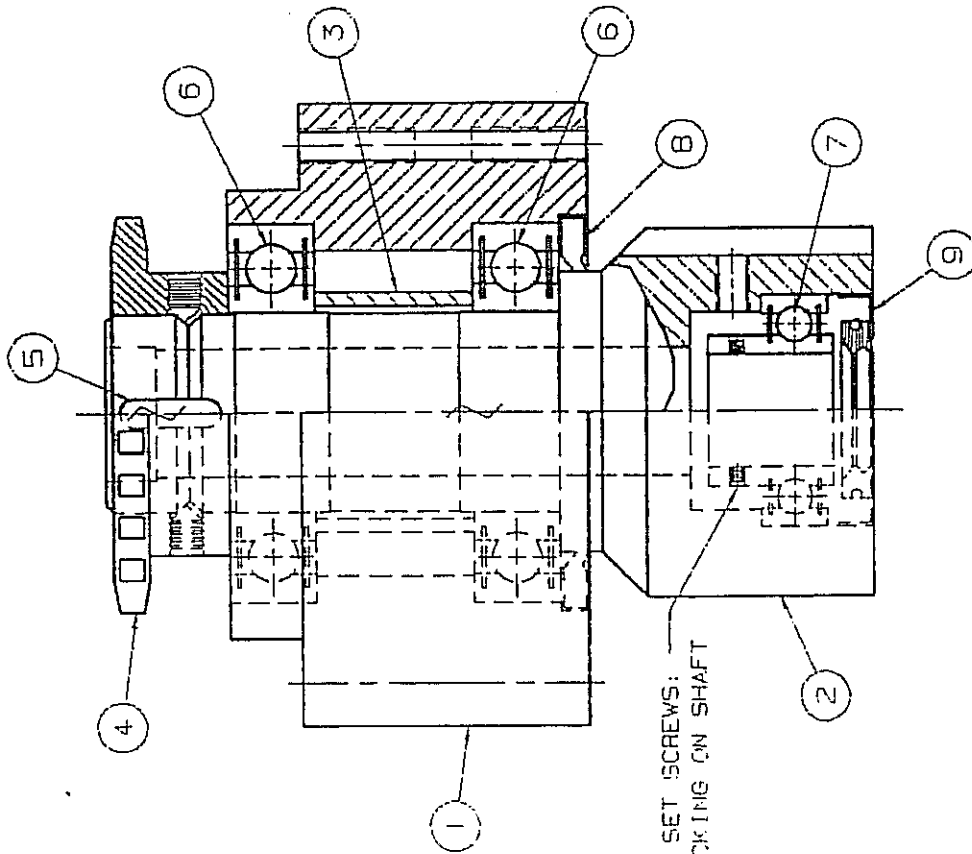
SEE NOTE



NOTE: WITH 60 HERTZ - 1200 RPM MOTOR

REFER TO BILL OF MATERIAL FOR CORRECT PART NO. / DRAWING NO.

GENERAL INFORMATION			
AM S FILLING SYSTEMS INC.			
HAWTHORNE, PA. 19063 U.S.A.			
GENERAL ARRANGEMENT: FILLING HEAD WITH AGITATION			
FIG. NO.	DATE	REV.	BY
01	11/09/90		
D-1010-A			
PART LIST			
1	1	1	AGITATION DRIVE
2	1	1	BEARING HOUSING
3	1	1	BEARING HOUSING
4	1	1	BEARING HOUSING
5	1	1	BEARING HOUSING
6	1	1	BEARING HOUSING
7	1	1	BEARING HOUSING
8	1	1	BEARING HOUSING
9	1	1	BEARING HOUSING
10	1	1	BEARING HOUSING
11	1	1	BEARING HOUSING
12	1	1	BEARING HOUSING
13	1	1	BEARING HOUSING
14	1	1	BEARING HOUSING
15	1	1	BEARING HOUSING
16	1	1	BEARING HOUSING
17	1	1	BEARING HOUSING
18	1	1	BEARING HOUSING
19	1	1	BEARING HOUSING



9	1	AC1450-EO	SEAL "NOK"
8	1	25007	SEAL "CHICAGO RAWHIDE"
7	1	YA100RR	BEARING "NTR"
6	2	209KPP	BEARING "NTR"
5	1	1/4 SQUARE	KEY
4	1	A-1003	SPROCKET
3	1	A-1004	SLEEVE
2	1	B-1004	SPINDLE
1	1	B-1003	BEARING HOUSE
IT.	QUN	MATERIAL	PART NO. / DRNG.
DESCRIPTION			

AMS A M S FILLING SYSTEMS INC
MALVERN, PA. 19355 U.S.A.

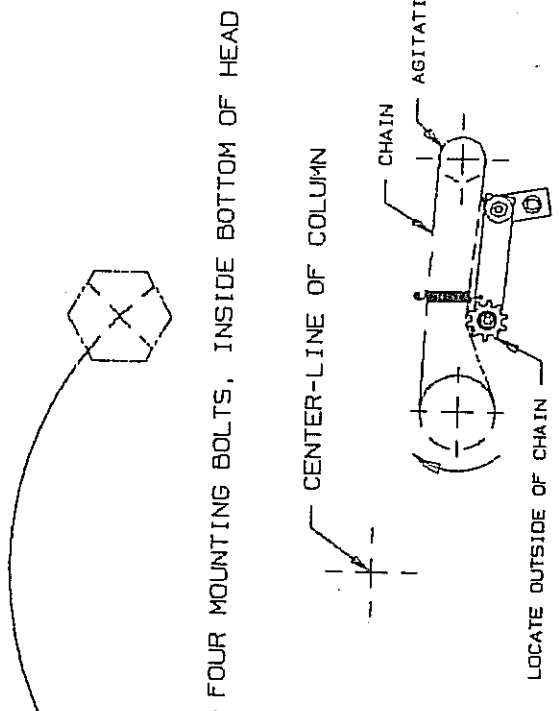
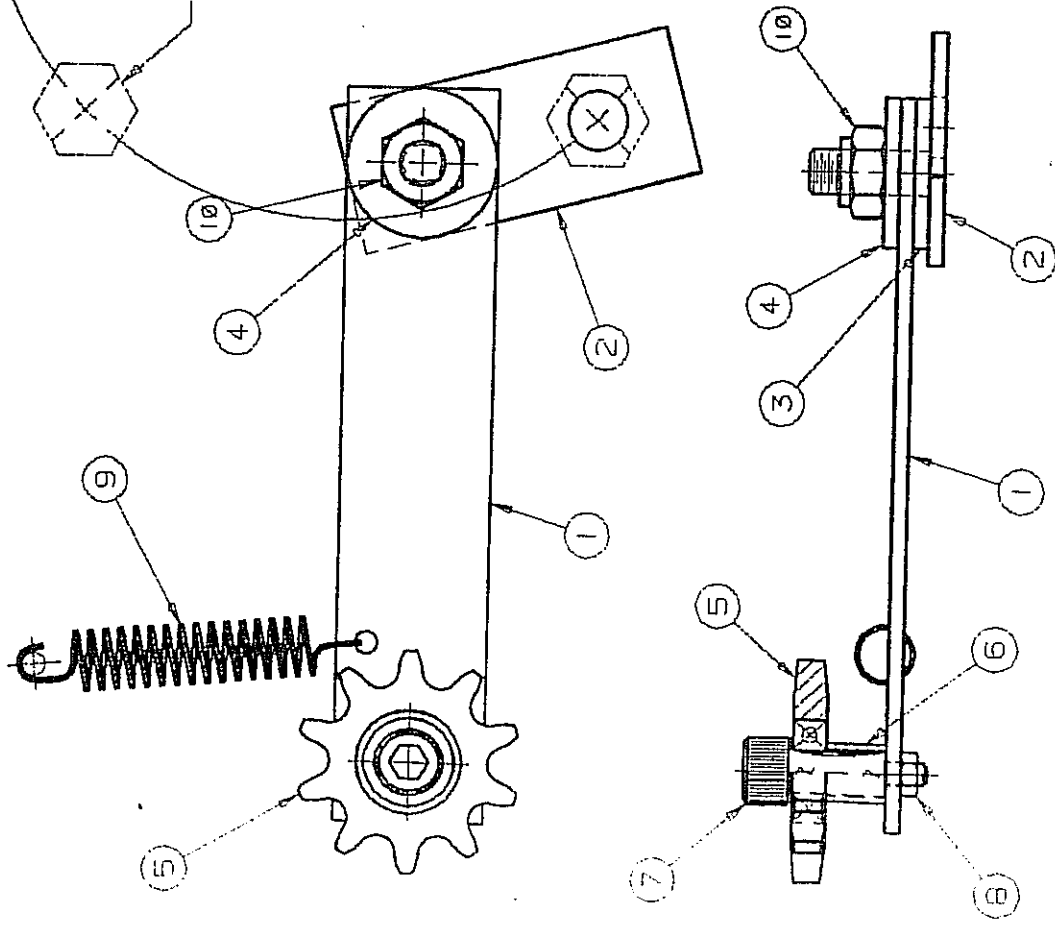
TITLE:

ASSEM: BEARING HOUSING FOR SLOW SPEED AGITATION

FIRST USED	DATE	BY	DATE	BY	DATE
	03/09/89	SAH			
DO NOT SCALE	SCALE	ASSEMBLY NO.	ASSEMBLY NO.	ASSEMBLY NO.	ASSEMBLY NO.

B-1158

MACHINE FRONT



IT.	QTY	PART NO. / DRAW.	DESCRIPTION
10	1		ENSA HEX NUT: 3/8-16 THREAD
9	1	E0420-045-3000	SPRING: "ASSOCIATED SPRING"
8	1		HEX NUT: 5/16-18 THREAD
7	1		SHOULDER BOLT: 3/8" DIA. x 1" LG.
6	1	A-1019-GR#2	SPACER
5	1	A-1018	SPROCKET
4	1	A-1017-3-IT#2	WASHER
3	1	A-1017-3-IT#1	SPACER
2	1	A-1017-1	PIVOT MOUNT
1	1	A-1017-2-GR#1	SWING ARM

AMS A M S FILLING SYSTEMS INC
MALVERN, PA. 19355 U.S.A.

TITLE: ASSEM: SPRING LOADED TAKE-UP FOR AGITATION DRIVE

FIRST USED	DATE	BY	ENGR. NO.
	10/17/86	SAM	

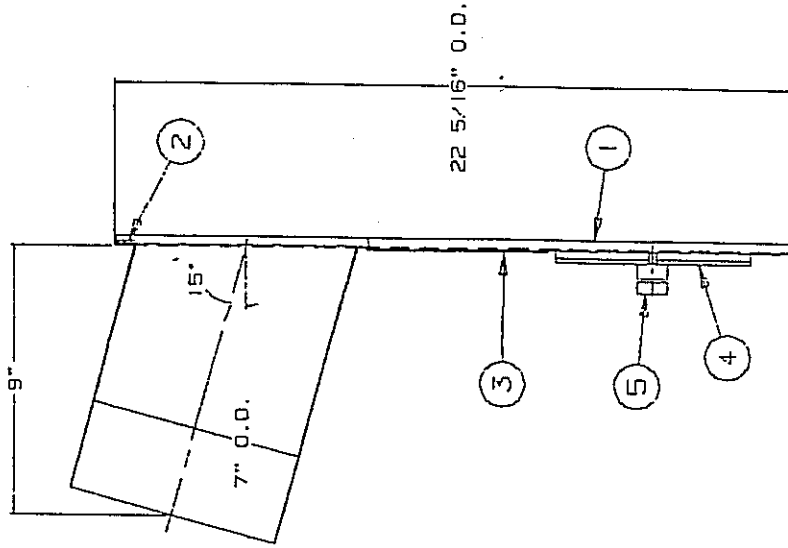
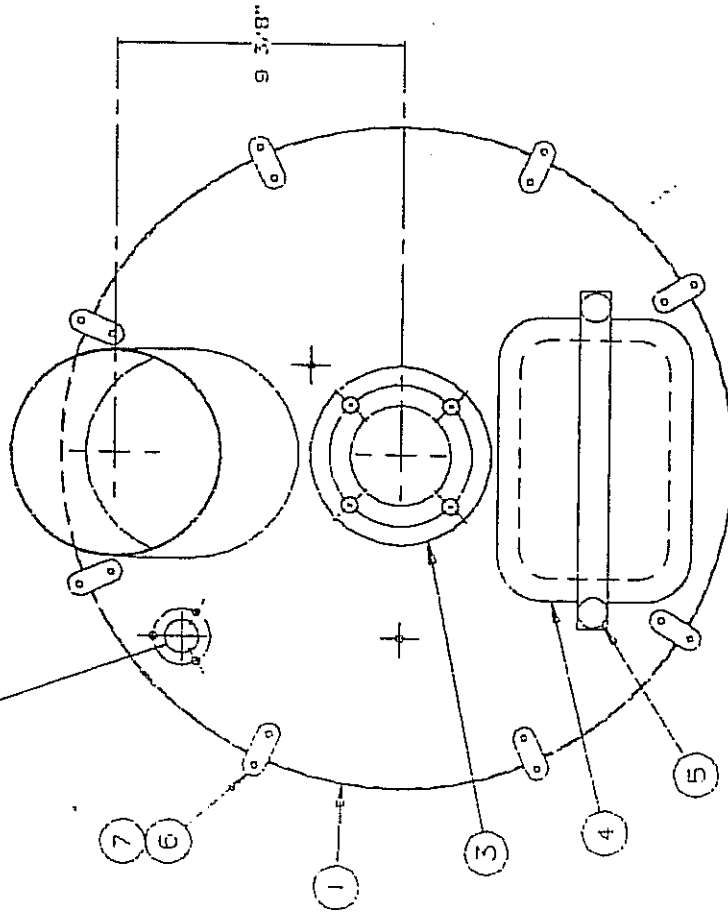
DO NOT SCALE

SCALE

REPRINT DATE

03/27/91

PROVISION FOR LEVEL CONTROL MOUNTING



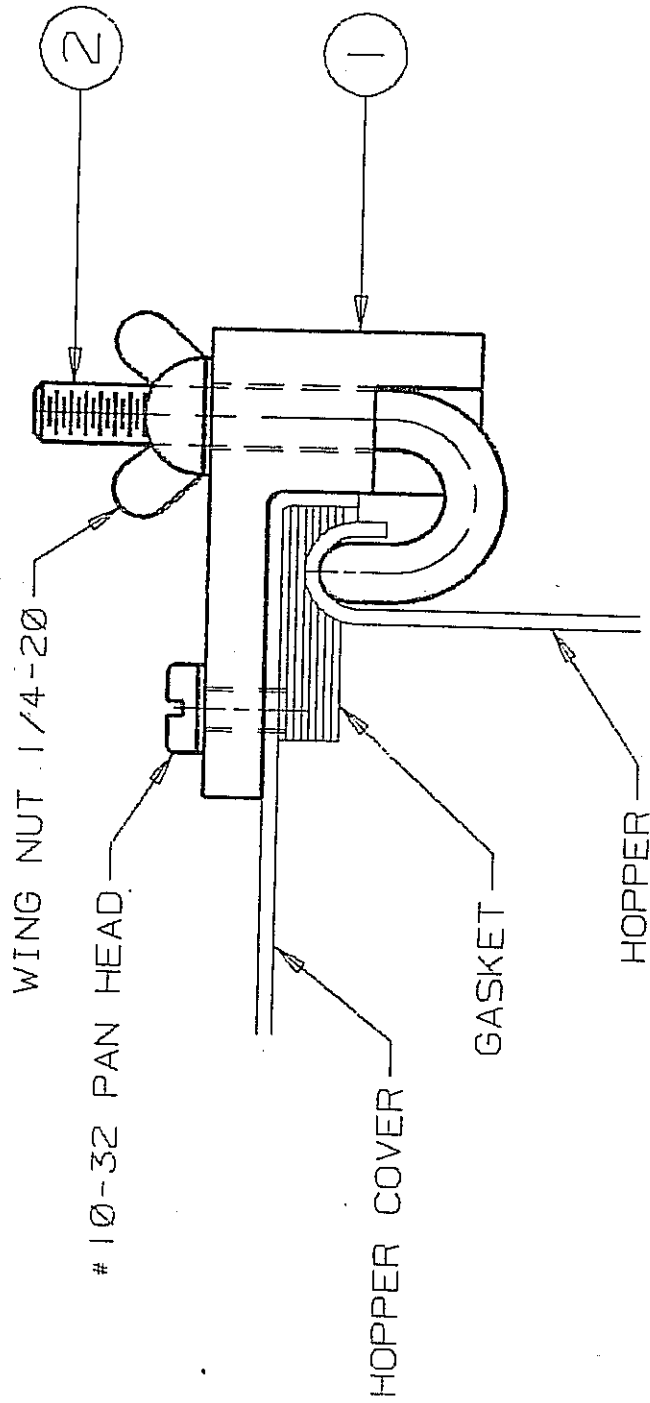
7	B		PAN HEAD SCREW: 10-32 x 3/8"
6	B	A-1030	COVER CLAMP
5	2	A-1023-GR-1	KNOB
4	1	A-1009	INSPECTION DOOR
3	1	A-1021	GASKET (FOR BR'G HOUSE)
2	1	HP 500E	GASKET: 1" x 1/4" x 78" LG
1	1	D-1003	COVER FABRICATION
IT.	QTY	MATERIAL	PART NO. / DWG.
			DESCRIPTION

A M S A M S FILLING SYSTEMS INC
MALVERN, PA. 19355 U.S.A.

TITLE:

ASSEM: STANDARD DUST PROOF COVER W/ INFEED DUCT

DATE 08/14/90
DRAWN BY SAM
CHECKED BY B-1019
DO NOT SCALE
SCALE
ASSEMBLY NO.



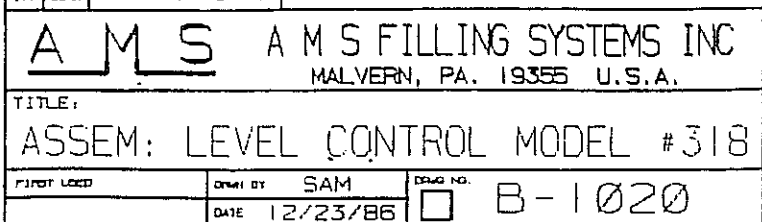
2	1	A-1015	"J" BOLT
1	1	A-1016	COVER CLAMP CASTING
IT.	QTY	MATERIAL	PART NO. / DRWG.
DESCRIPTION			

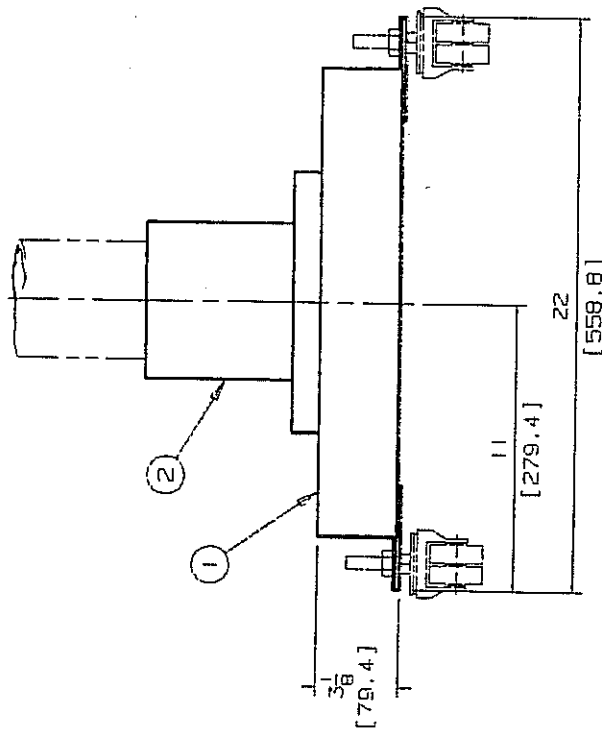
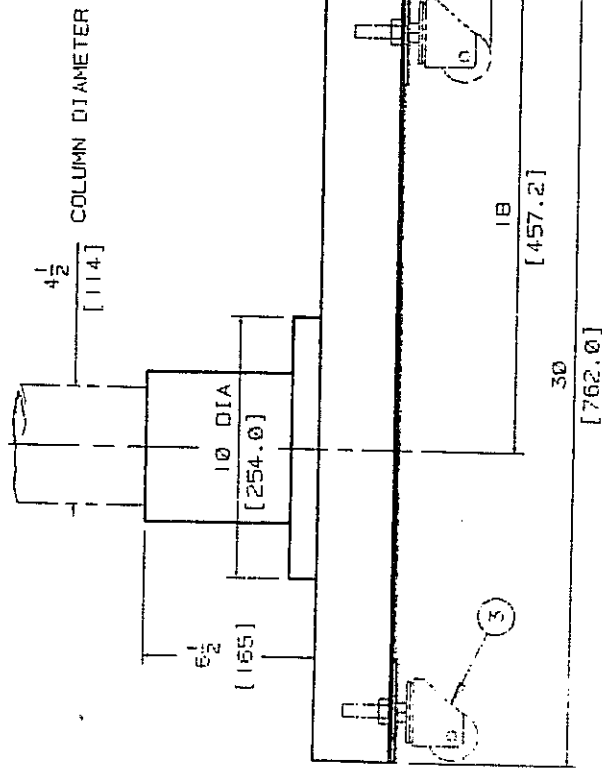
AMS A M S FILLING SYSTEMS INC
MALVERN, PA. 19355 U.S.A.

TITLE:

ASSEM: HOPPER COVER CLAMP

FIRST USED	DRWN BY	SAM	DRWG NO.
	DATE	3/17/89	<input type="checkbox"/> A-1030
DO NOT SCALE	SCALE		ASSEM. DRWG NO.





3	0	4	#3A755	CASTER: SWIVEL WITH LOCK
2	1	1	C-1001	BASE: 10" DIA
1	1	1	D-1004-1	BASE: FLOOR FABRICATION
IT.	DRW	REV	PART NO.	DESCRIPTION

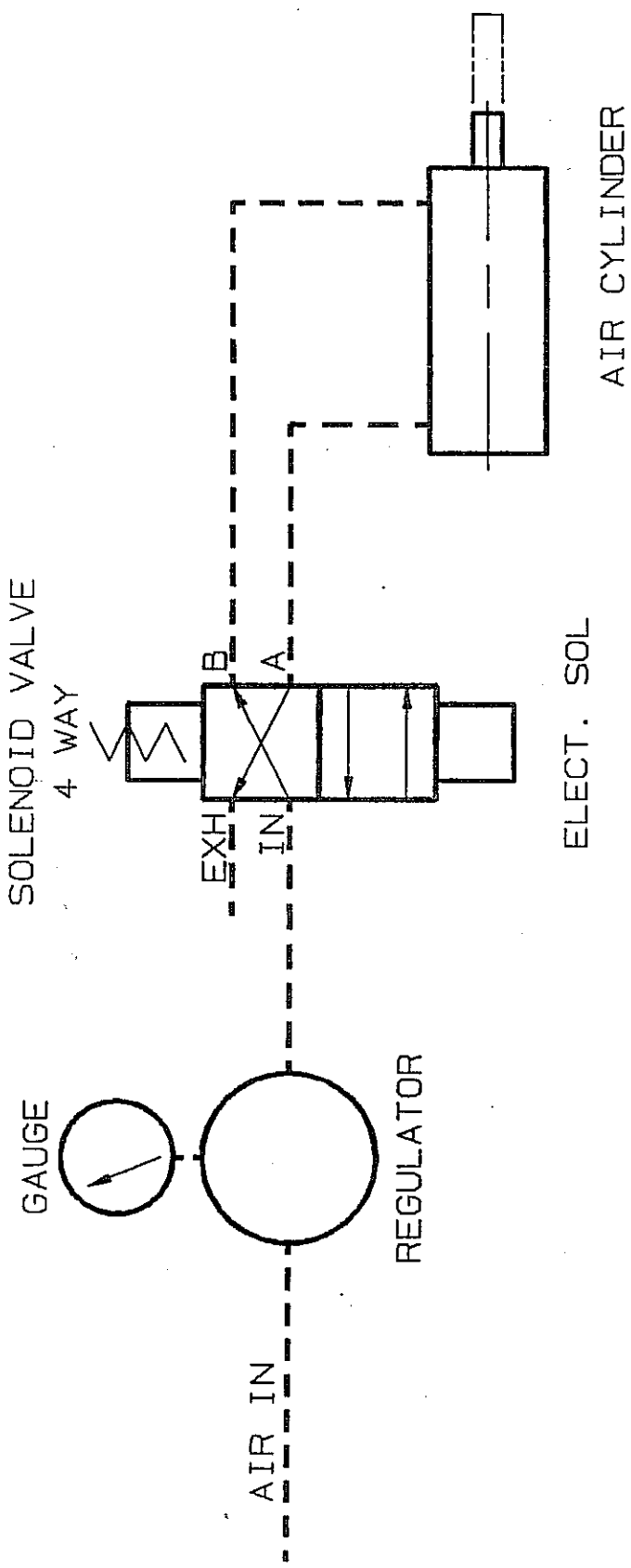
A M S A M S FILLING SYSTEMS INC
MALVERN, PA. 19355 U.S.A.

TITLE:

ASSEMBLY: FLOOR BASE

FIRST USED	DATE	BY	DATE	NO.	ASSEMBLY
	04/10/91	SAM			B-1260
DO NOT SCALE	SCALE				ASSEMBLY

GROUP #1 - NO CASTERS
GROUP #2 - WITH CASTERS

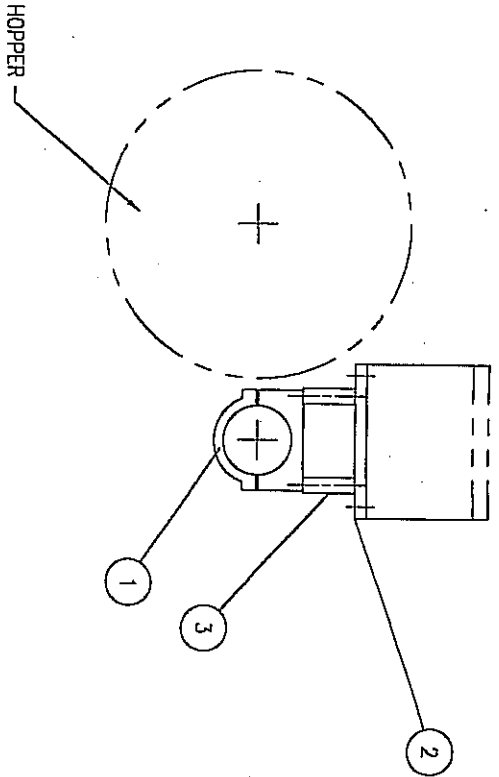


NOTE:
AIR SUPPLY MUST BE CLEAN AND FREE OF MOISTURE.

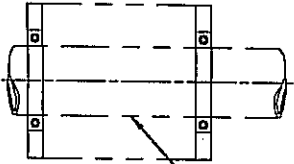
<h1>A M S</h1>				<h2>A M S FILLING SYSTEMS INC</h2>			
				MALVERN, PA. 19355 U.S.A.			
TITLE:							
AIR SCHEMATIC: DOUBLE ACTING CYLINDER							
FIRST USED		DRAWN BY		SAM		DRAWG NO.	
						<input type="checkbox"/> A-1054	
		DATE		03/11/87			
DO NOT SCALE		SCALE				ASSEM. DRAWG NO.	

BILL OF MATERIAL

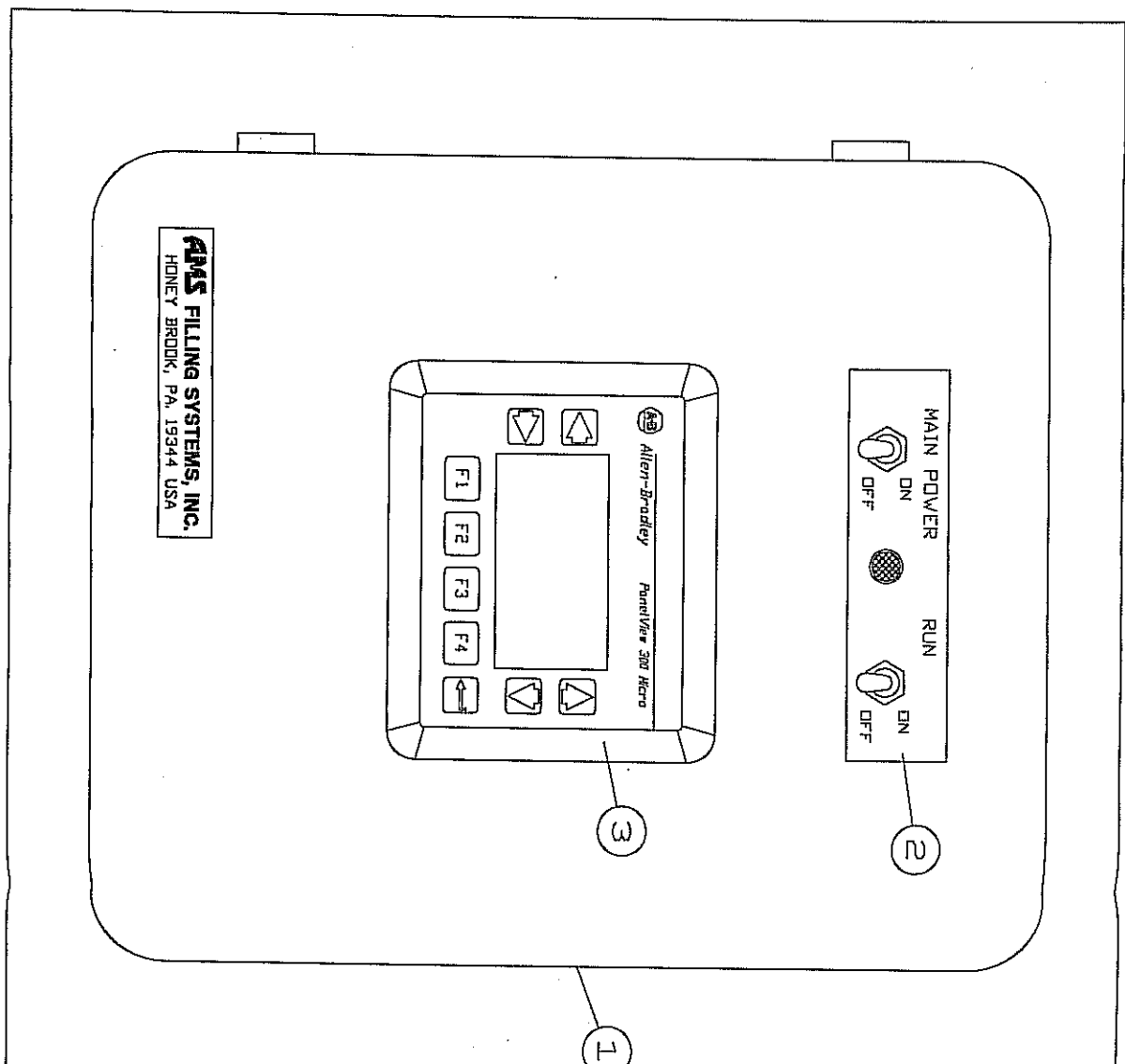
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	B-100Z	COLUMN SUPPORT CLAMP
2	2	A-1020-6 GR/3	MOUNTING BAR
3	4	A-1816-2	SPACER



COLUMN PER BILL OF MATERIAL



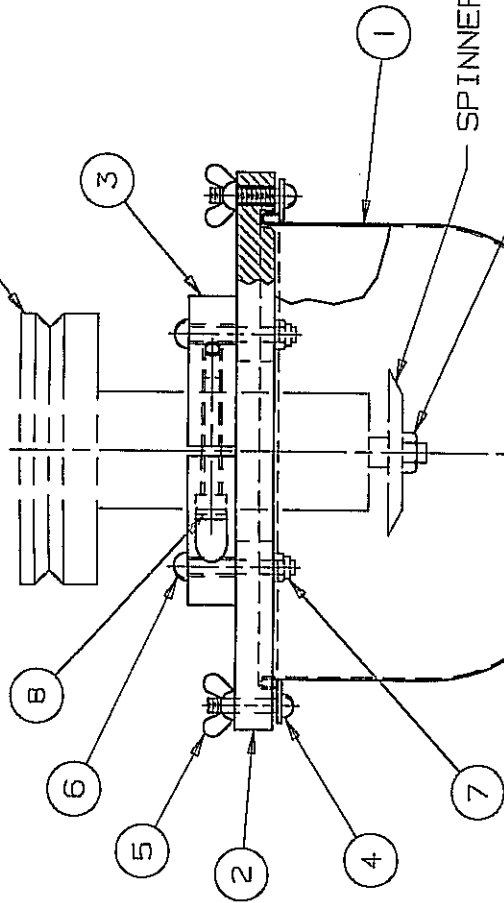
REV	11/14/01	BY	BH
DATE		BY	
<p>THIS DOCUMENT AND ITS CONTENTS ARE THE PROPERTY OF AMS FILING SYSTEMS, INC. AND MUST NOT BE COPIED, REPRODUCED, TRANSMITTED OR DISCLOSED TO ANY THIRD PARTY WITHOUT THE CONSENT OF AMS FILING SYSTEMS, INC. CONVICTION WILL BE PROSECUTED.</p> <p>TOLERANCES UNLESS OTHERWISE SPECIFIED:</p> <p>BREAK ALL SHARP EDGES</p> <p>SURFACE FINISH</p> <p>ANGULAR $\pm 1/2^\circ$</p> <p>FRACTIONAL ($< 8^\circ$) $\pm 1/64$</p> <p>1 PLACE DECIMAL ± 0.13</p> <p>2 PLACE DECIMAL ± 0.08</p> <p>3 PLACE DECIMAL ± 0.05</p> <p>THIRD PLACE DECIMAL ± 0.03</p>			
<p>REVISIONS</p>			
<p>AMS FILING SYSTEMS, INC.</p> <p>DESIGNERS AND MANUFACTURERS OF ARCH FILE MATHS</p> <p>2500 Chelton Hill Road - Heavy Brook, PA 19114 USA</p>			
TITLE		ASSEMBLY: COLUMN MOUNTED ENCLOSURE	
PART SCALE		1"=8"	
SCALE		NTS	
DWG. NO.		B1024-B	
REV.		-	



AMS FILLING SYSTEMS, INC.
HONEY BROOK, PA. 19344 USA

3	0	SEE ELECTRICAL PANNEL VIEW		
2	1	A-1011-12 POWER LABLE		
1	1	B-1694-13A CONTROL ENCLOSURE		
IT.	QUAN	REF/MATL	PART NDL / DRWG.	DESCRIPTION
AMS A M S FILLING SYSTEMS INC HONEY BROOK, PA. 19344 U.S.A.				
TITLE: ASSEM: CONTROL ENCLOSURE (A100) WITH RECYCLE Ref: PAINTED				
1st USED	DRWN BY	BH	DRWG NDL	
	DATE	7/9/01		□ B-1695-13A
DD NOT SCALE	SCALE	11/16	ASSEM DRWG NDL	

FUNNEL



SPINNER PLATE

LOCK NUT (LEFT HAND THREAD)

DUST SHROUD (WHEN REQUIRED)

NOTE:

REFER TO BILL OF MATERIAL FOR CORRECT PART NUMBER

8	1	SCREW: (SOCKET HEAD) 1/4-20 x 1 1/2" Lq.
7	4	ESNA NUT: #10-32 THREAD
6	4	SCREW: (ROUND HEAD) #10-32 x 1 1/2" Lq.
5	4	WING NUT: #10-32 THREAD
4	4	A-1047 MOUNTING CLIP
3	1	B-1085--# FUNNEL CLAMP
2	1	B-1083 COVER
1	1	D-1052--# COLLECTOR FUNNEL
IT.	QTY	PART NO. / DRWG.
DESCRIPTION		

AMS A M S FILLING SYSTEMS INC
MALVERN, PA. 19355 U.S.A.

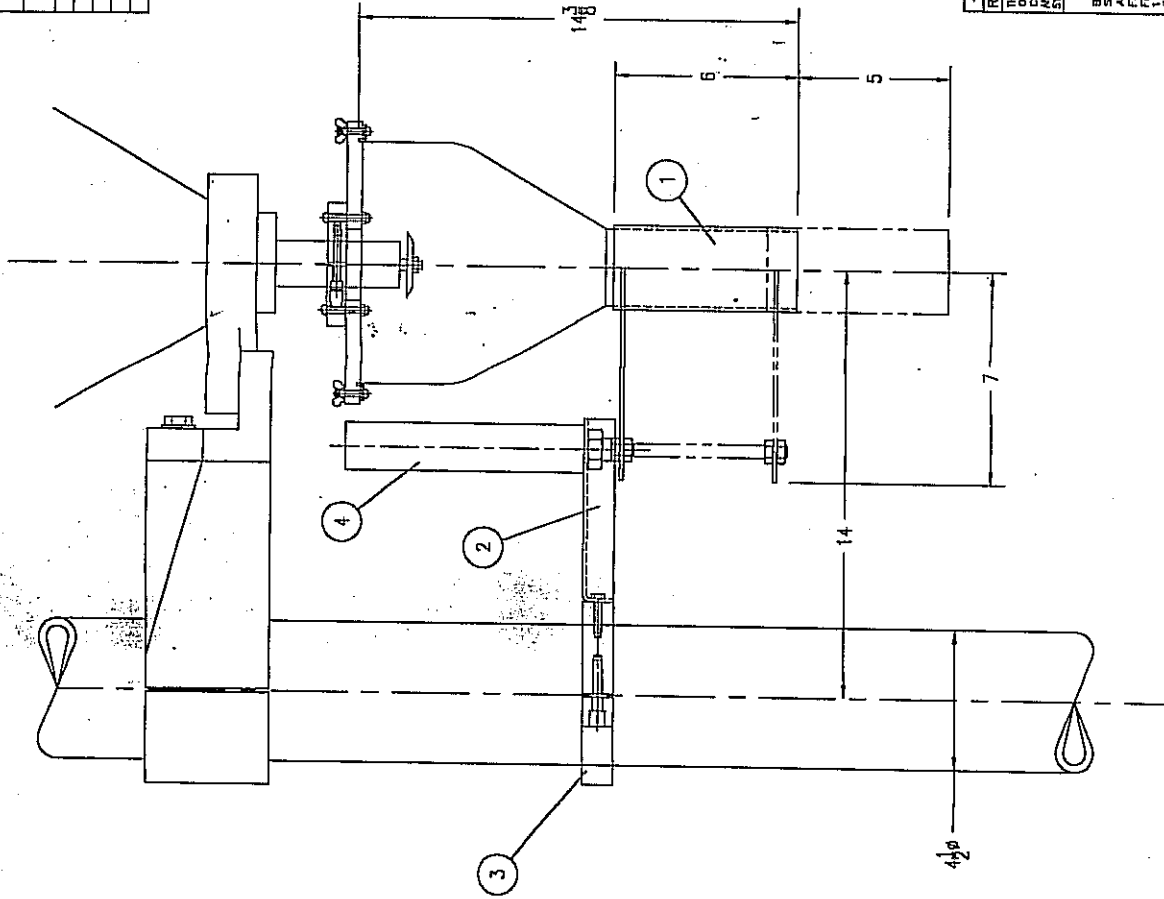
TITLE:

ASSEMBLY: 8" COLLECTOR FUNNEL

FIRST USED	DESIGN BY	DATE	SCALE	ASSEMBLY NO.
	SAM	03/19/90		B-1215-8

BILL OF MATERIAL

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	B-1717	DRIVING NOZZLE
2	1	B-1716	BRACKET
3	1	B-1002	COLLUM SUPPORT CLAMP
4	1	CA-175-D	AIR CYLINDER "BURDA"
5	2	MUS-107-F-BLOCK-17	SEDSING SWITCHES "BURDA"



REV	DATE	BY	REVISIONS
1	11/14/01	BH	THIS DOCUMENT AND ITS CONTENTS ARE THE PROPERTY OF AMS FILLING SYSTEMS, INC. AND ARE NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT THE WRITTEN PERMISSION OF AMS FILLING SYSTEMS, INC. CONTRAVENTION WILL BE PROSECUTED.
			DESIGNERS AND MANUFACTURERS OF AERIAL FILLING MACHINERY 2300 CHESTNUT TREE ROAD - NORTON BRIDGE, TX 75444 USA
			TOLERANCES UNLESS OTHERWISE SPECIFIED: DIMENSIONS IN PARENTHESES SURFACE FINISH BREAK ALL SHARP EDGES ANGULAR ±1/2° ±1/4° FRACTIONAL (DEC) ±1/32 1 PLACE DECIMAL ±.015 2 PLACE DECIMAL ±.010 3 PLACE DECIMAL ±.005 SCALE 1"=4" THIRD ANGLE PROJECTION
			TITLE DRIVING NOZZLE ASSEMBLY FREE FLOW SET UP CWD FILE 1=4 SCALE 1"=4"
			DWG. NO. B-1715
			REV. -

AMS FILLING SYSTEMS, INC.

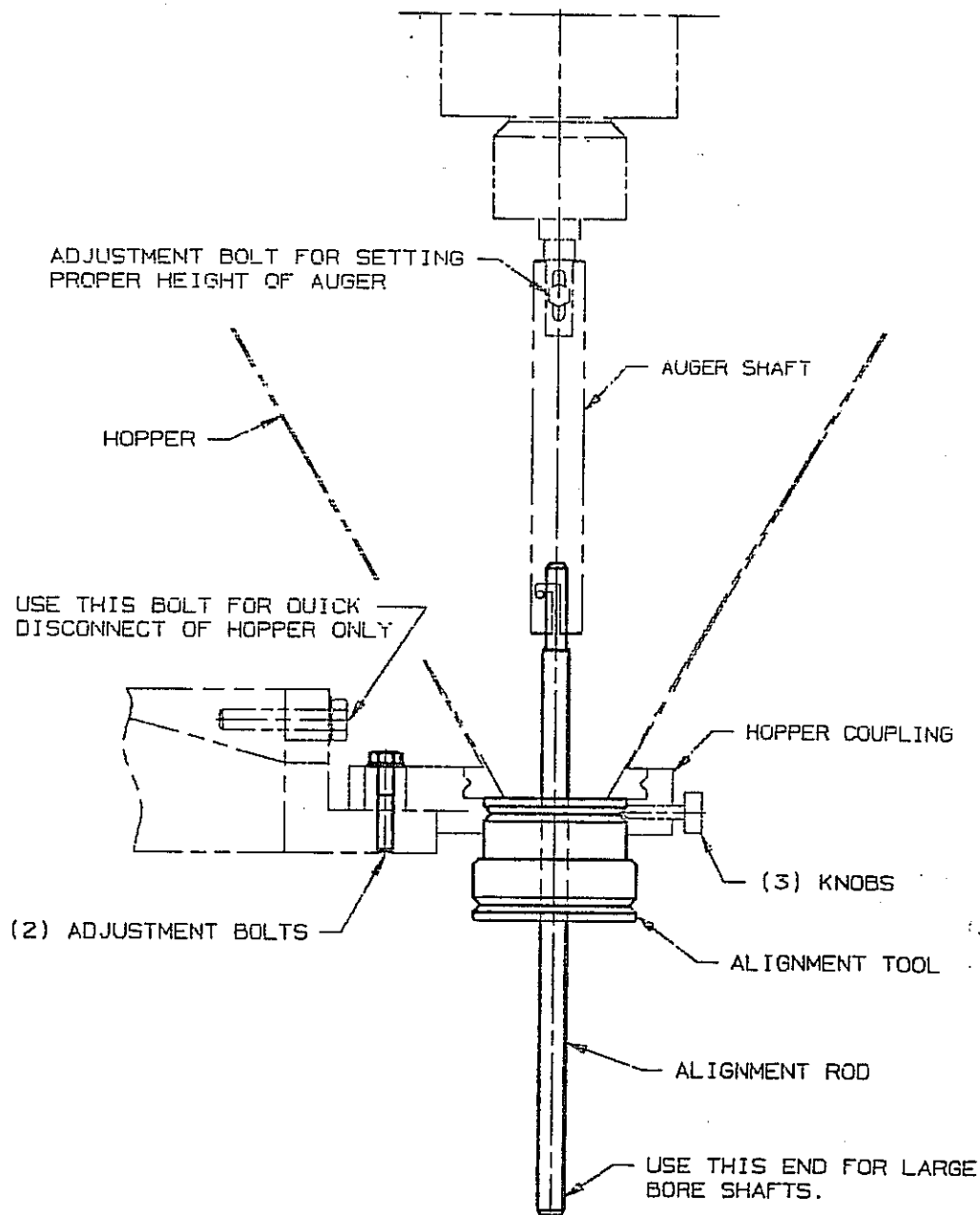
DESIGNERS AND MANUFACTURERS OF AERIAL FILLING MACHINERY
2300 CHESTNUT TREE ROAD - NORTON BRIDGE, TX 75444 USA

TOLERANCES UNLESS OTHERWISE SPECIFIED:
DIMENSIONS IN PARENTHESES
SURFACE FINISH
BREAK ALL SHARP EDGES
ANGULAR ±1/2° ±1/4°
FRACTIONAL (DEC) ±1/32
1 PLACE DECIMAL ±.015
2 PLACE DECIMAL ±.010
3 PLACE DECIMAL ±.005
SCALE 1"=4"
THIRD ANGLE PROJECTION

TITLE
DRIVING NOZZLE ASSEMBLY
FREE FLOW SET UP
CWD FILE
1=4
SCALE
1"=4"

DWG. NO.
B-1715

REV.
-



INSTRUCTIONS FOR ALIGNMENT

- 1- WITH HOPPER IN UPPER PART OF COUPLING, INSERT ALIGNMENT TOOL IN LOWER PART AND TIGHTEN THREE KNOBS.
- 2- INSERT ALIGNMENT ROD THRU ALIGNMENT TOOL INTO AUGER SHAFT. IF ROD DOES NOT SLIDE FREELY INTO AUGER SHAFT, LOOSEN TWO ADJUSTMENT BOLTS ON TOP OF COUPLING AND RE-TIGHTEN WHILE CHECKING SLIP FIT OF ALIGNMENT ROD IN AUGER SHAFT.
- 3- ENSURE TWO BOLTS ARE TIGHT AND RECHECK ALIGNMENT.

A M S

A M S FILLING SYSTEMS INC

MALVERN, PA. 19355 U.S.A.

TITLE:

INSTRUCTIONS FOR HOPPER ALIGNMENT

FIRST USED

DRAWN BY

SAM

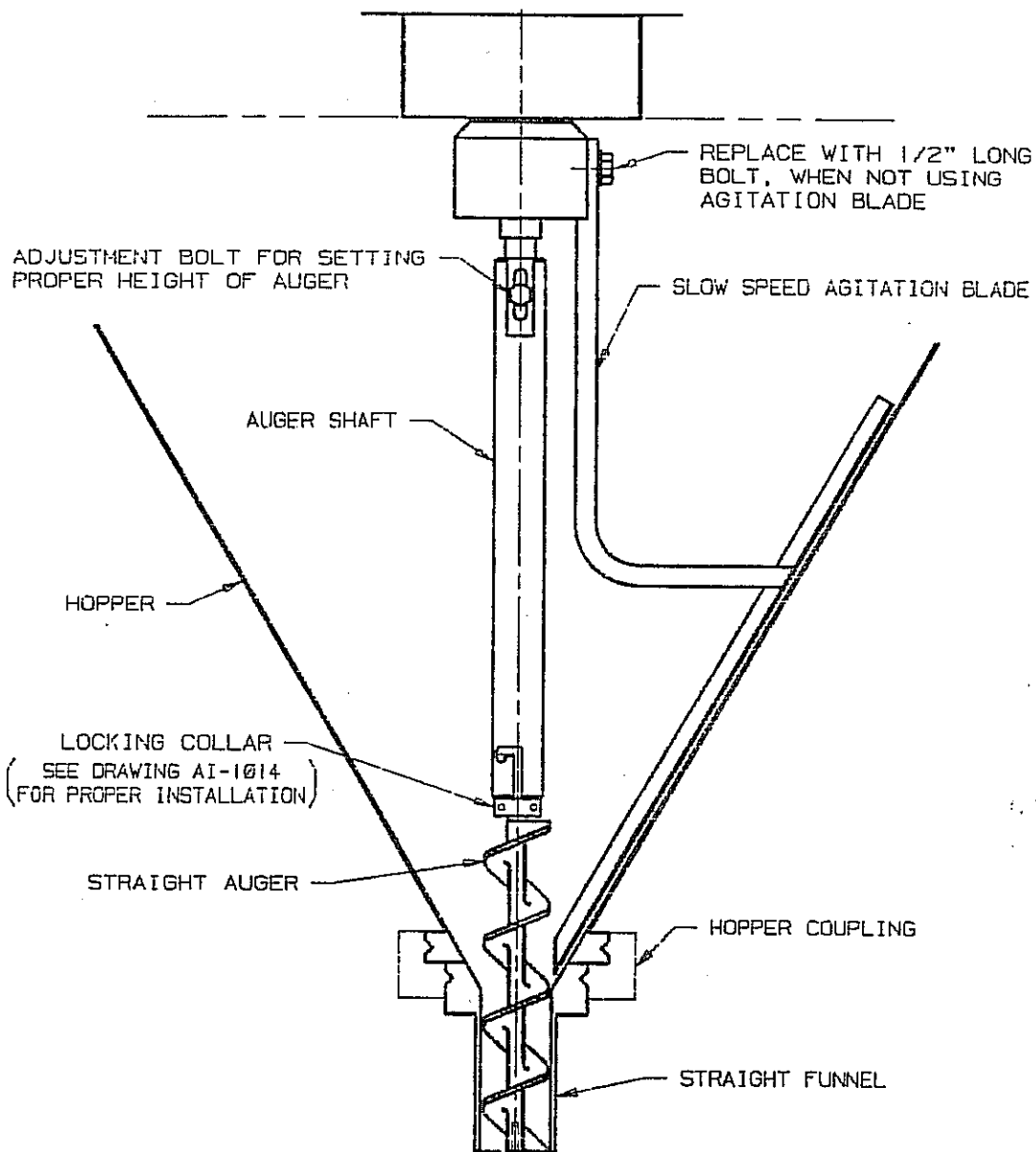
DRAW NO.

DATE

11/24/86

☐

BI-1000



END OF AUGER MUST BE FLUSH WITH BOTTOM OF FUNNEL

NOTE:

HOPPER COUPLING MUST BE IN TRUE ALIGNMENT TO PREVENT UNWANTED WEAR ON TOOLING. SEE DRAWING BI-1000 FOR ALIGNMENT INSTRUCTIONS.

A M S

A M S FILLING SYSTEMS INC
MALVERN, PA. 19355 U.S.A.

TITLE:

STRAIGHT AUGER WITH STRAIGHT FUNNEL

FIRST USED

DRAWN BY

SAM

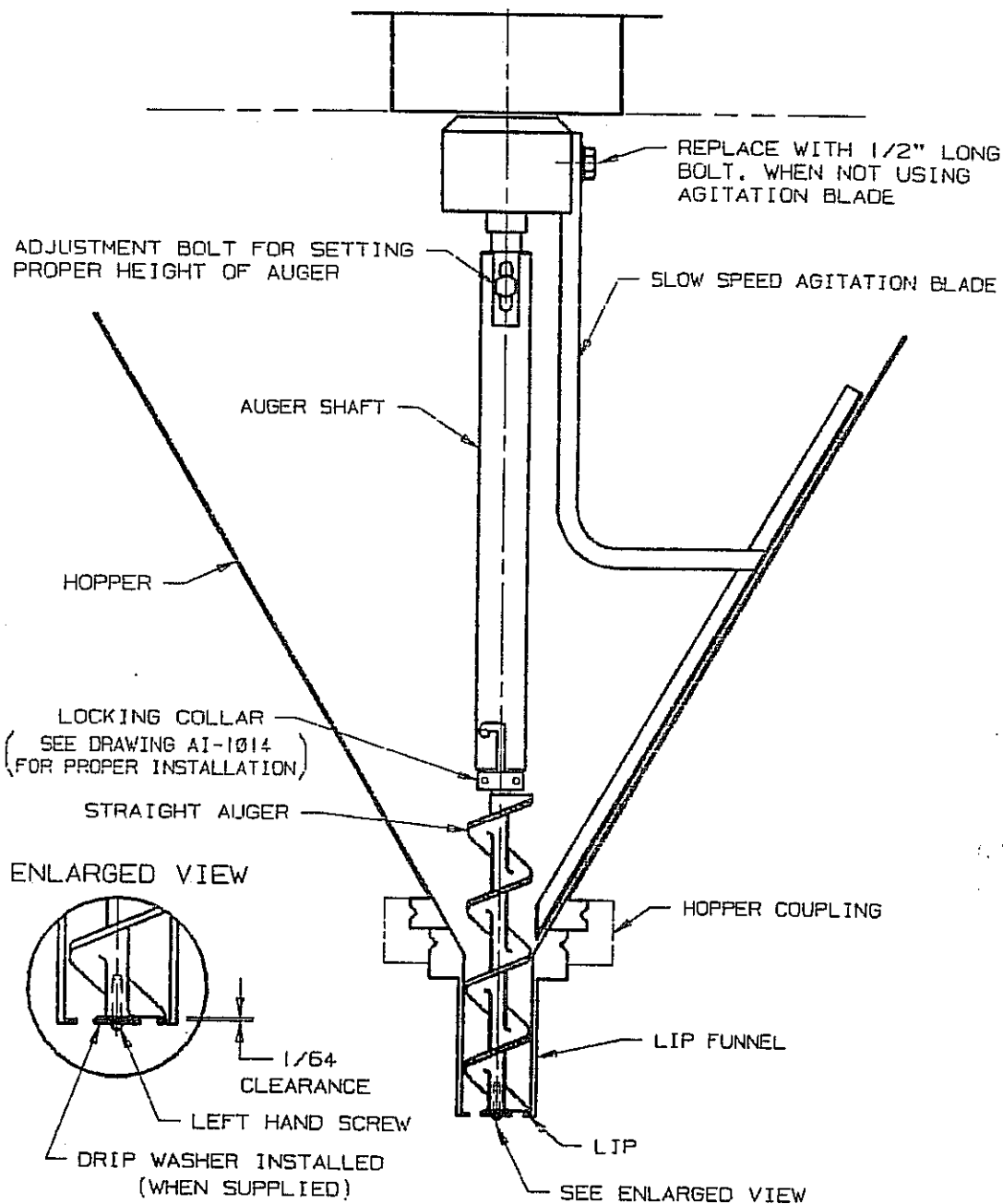
DWG NO.

DATE

06/22/86

☐

AI-1000



ENSURE END OF AUGER FLIGHT IS 1/64" ABOVE LIP OF FUNNEL

NOTE:

HOPPER COUPLING MUST BE IN TRUE ALIGNMENT TO PREVENT UNWANTED WEAR ON TOOLING. SEE DRAWING BI-1000 FOR ALIGNMENT INSTRUCTIONS.

A M S

A M S FILLING SYSTEMS INC

MALVERN, PA. 19355 U.S.A.

TITLE:

STRAIGHT AUGER WITH LIP FUNNEL

FIRST USED

DRAWN BY

SAM

DATE

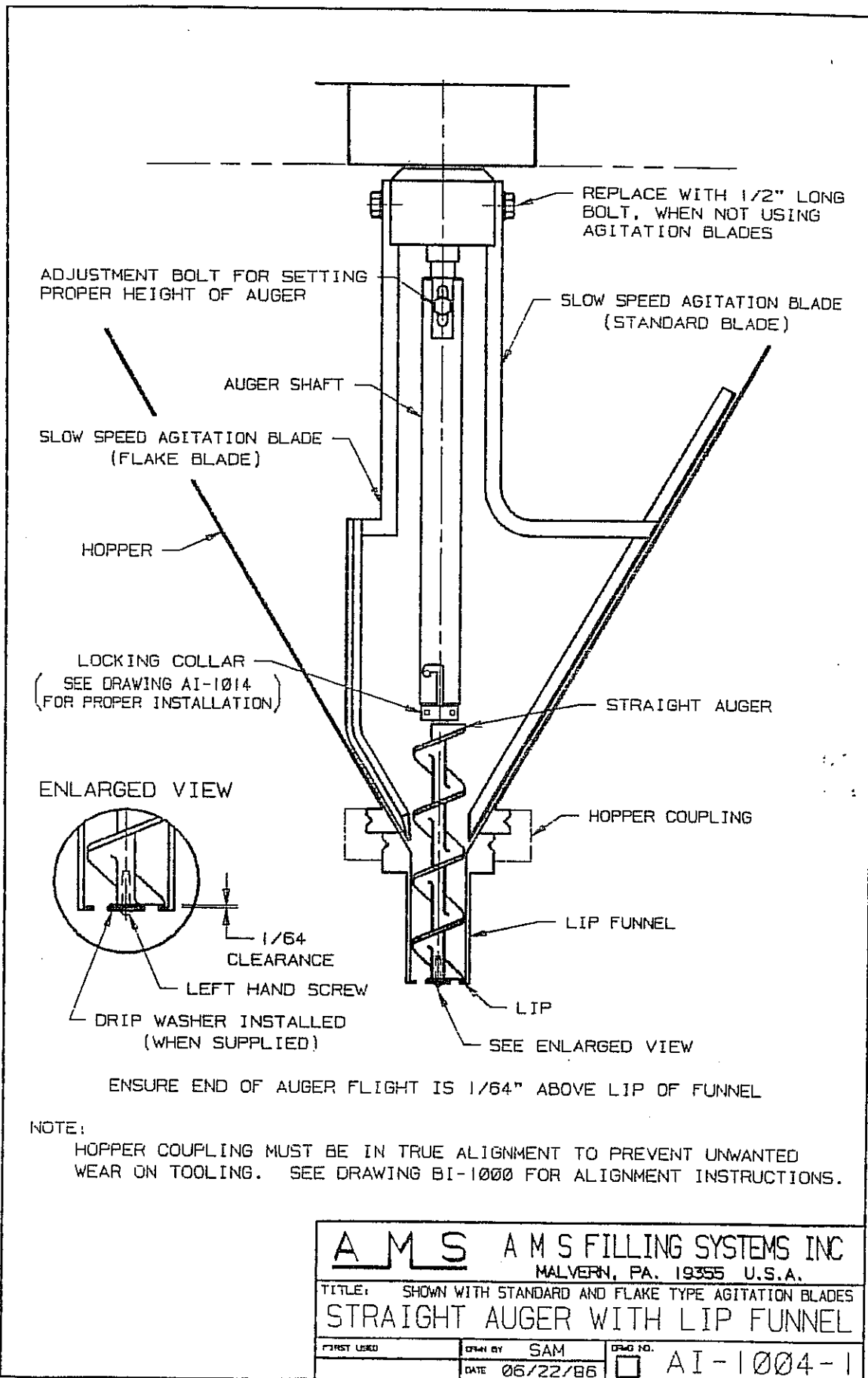
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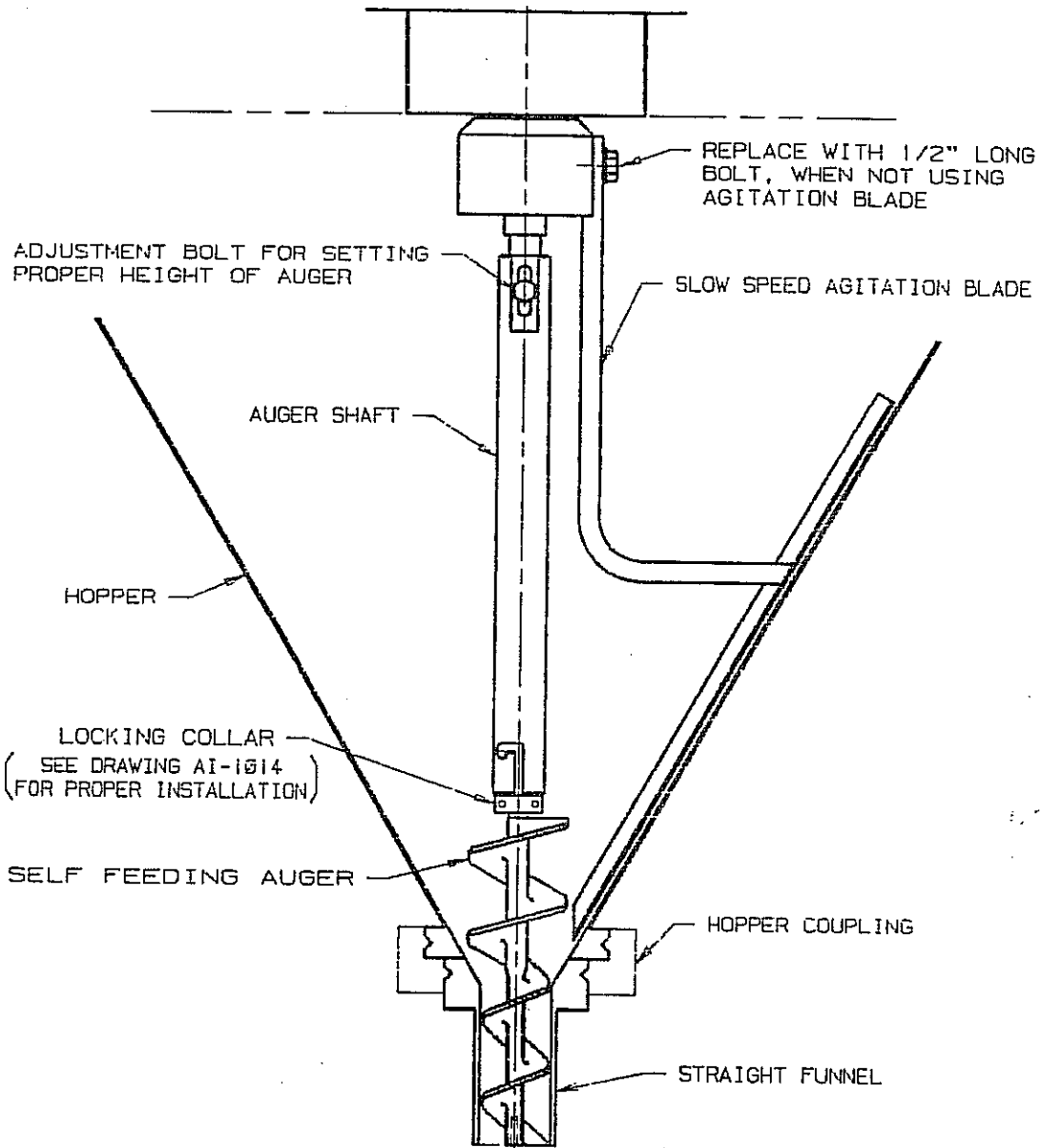
06/22/86

DRAW NO.

☐

AI-1004



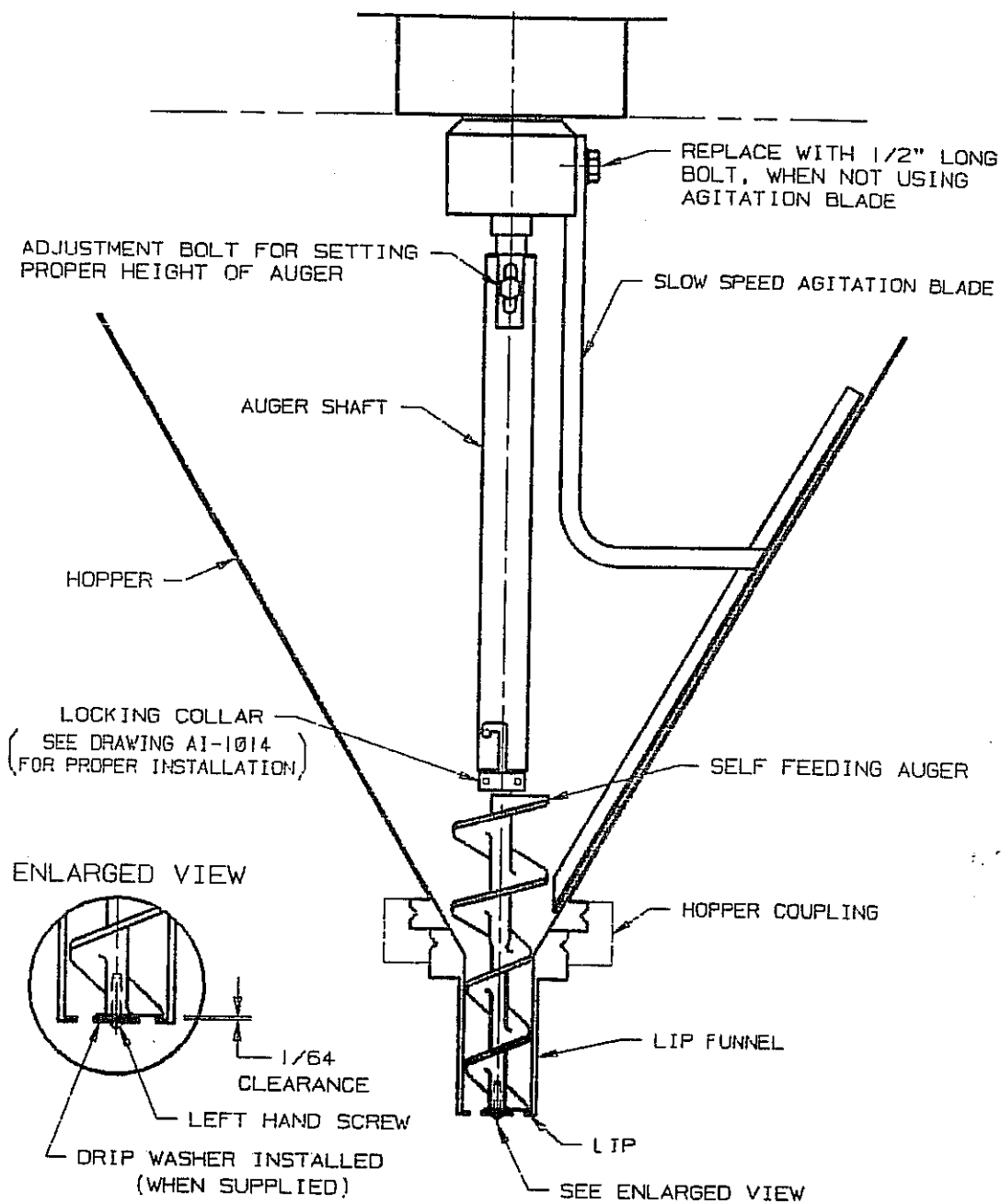


END OF AUGER MUST BE FLUSH WITH BOTTOM OF FUNNEL

NOTE:

HOPPER COUPLING MUST BE IN TRUE ALIGNMENT TO PREVENT UNWANTED WEAR ON TOOLING. SEE DRAWING BI-1000 FOR ALIGNMENT INSTRUCTIONS.

AMS A M S FILLING SYSTEMS INC MALVERN, PA. 19355 U.S.A.		
TITLE: SELF FEEDING AUGER WITH STRAIGHT FUNNEL		
FIRST USED	DRAWN BY SAM	DWG NO.
	DATE 06/22/86	<input type="checkbox"/> AI-1001



ENSURE END OF AUGER FLIGHT IS 1/64" ABOVE LIP OF FUNNEL

NOTE:

HOPPER COUPLING MUST BE IN TRUE ALIGNMENT TO PREVENT UNWANTED WEAR ON TOOLING. SEE DRAWING BI-1000 FOR ALIGNMENT INSTRUCTIONS.

A M S

A M S FILLING SYSTEMS INC

MALVERN, PA. 19355 U.S.A.

TITLE:

SELF FEEDING AUGER WITH LIP FUNNEL

FIRST USED

DRAWN BY

SAM

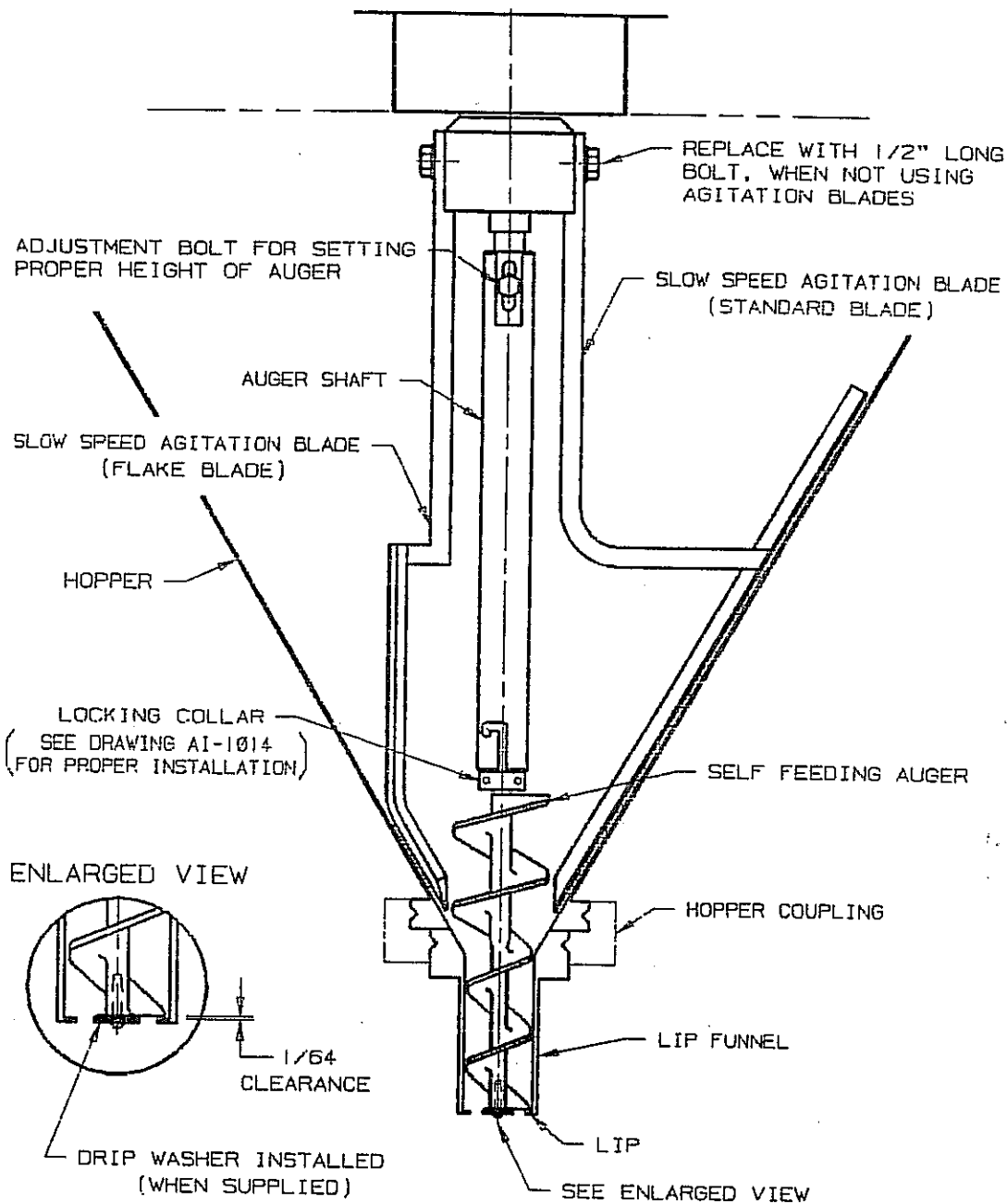
DRWD NO.

DATE

06/22/86

☐

AI-1002

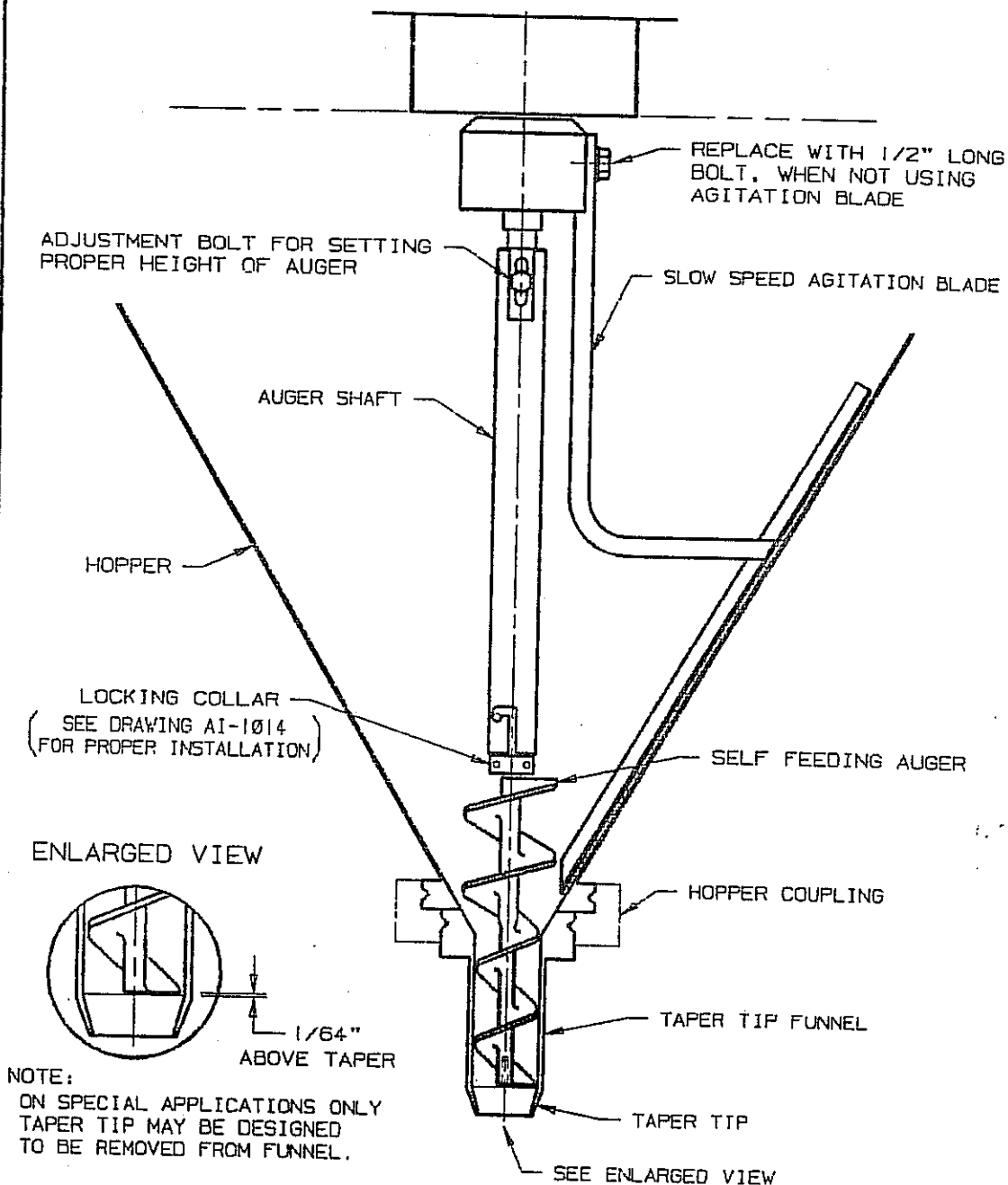


ENSURE END OF AUGER FLIGHT IS 1/64" ABOVE LIP OF FUNNEL

NOTE:

HOPPER COUPLING MUST BE IN TRUE ALIGNMENT TO PREVENT UNWANTED WEAR ON TOOLING. SEE DRAWING BI-1000 FOR ALIGNMENT INSTRUCTIONS.

A M S A M S FILLING SYSTEMS INC MALVERN, PA. 19355 U.S.A.		
TITLE: SHOWN WITH STANDARD AND FLAKE TYPE AGITATION BLADES SELF FEEDING AUGER WITH LIP FUNNEL		
FIRST USED	DRAWN BY SAM	DPMG NO. <input type="checkbox"/> AI-1002-1
DATE 06/22/86		



ENSURE END OF AUGER FLIGHT IS 1/64" ABOVE START OF FUNNEL TAPER

NOTE:
HOPPER COUPLING MUST BE IN TRUE ALIGNMENT TO PREVENT UNWANTED
WEAR ON TOOLING. SEE DRAWING BI-1000 FOR ALIGNMENT INSTRUCTIONS.

A M S A M S FILLING SYSTEMS INC MALVERN, PA. 19355 U.S.A.		
TITLE: SELF FEEDING AUGER WITH TAPER TIP FUNNEL		
FIRST USED	DATE 06/22/86	DRAWN BY SAM DATE 06/22/86
		DRAW NO. AI-1002-2

ADJUSTMENT BOLT FOR SETTING
PROPER HEIGHT OF AUGER

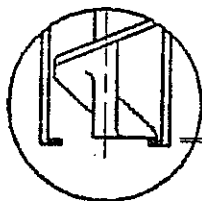
AUGER SHAFT

HOPPER

LOCKING COLLAR
(SEE DRAWING AI-1014
FOR PROPER INSTALLATION)

WING AUGER

ENLARGED VIEW



HOPPER COUPLING

LIP FUNNEL

LIP

SEE ENLARGED VIEW

ENSURE END OF AUGER FLIGHT IS 1/64" ABOVE LIP OF FUNNEL

NOTE:

HOPPER COUPLING MUST BE IN TRUE ALIGNMENT TO PREVENT UNWANTED
WEAR ON TOOLING. SEE DRAWING BI-1000 FOR ALIGNMENT INSTRUCTIONS.

A M S A M S FILLING SYSTEMS INC

MALVERN, PA. 19355 U.S.A.

TITLE: ASSEM. WITHOUT SLOW SPEED AGITATION
WING STYLE AUGER WITH LIP FUNNEL

FIRST USED

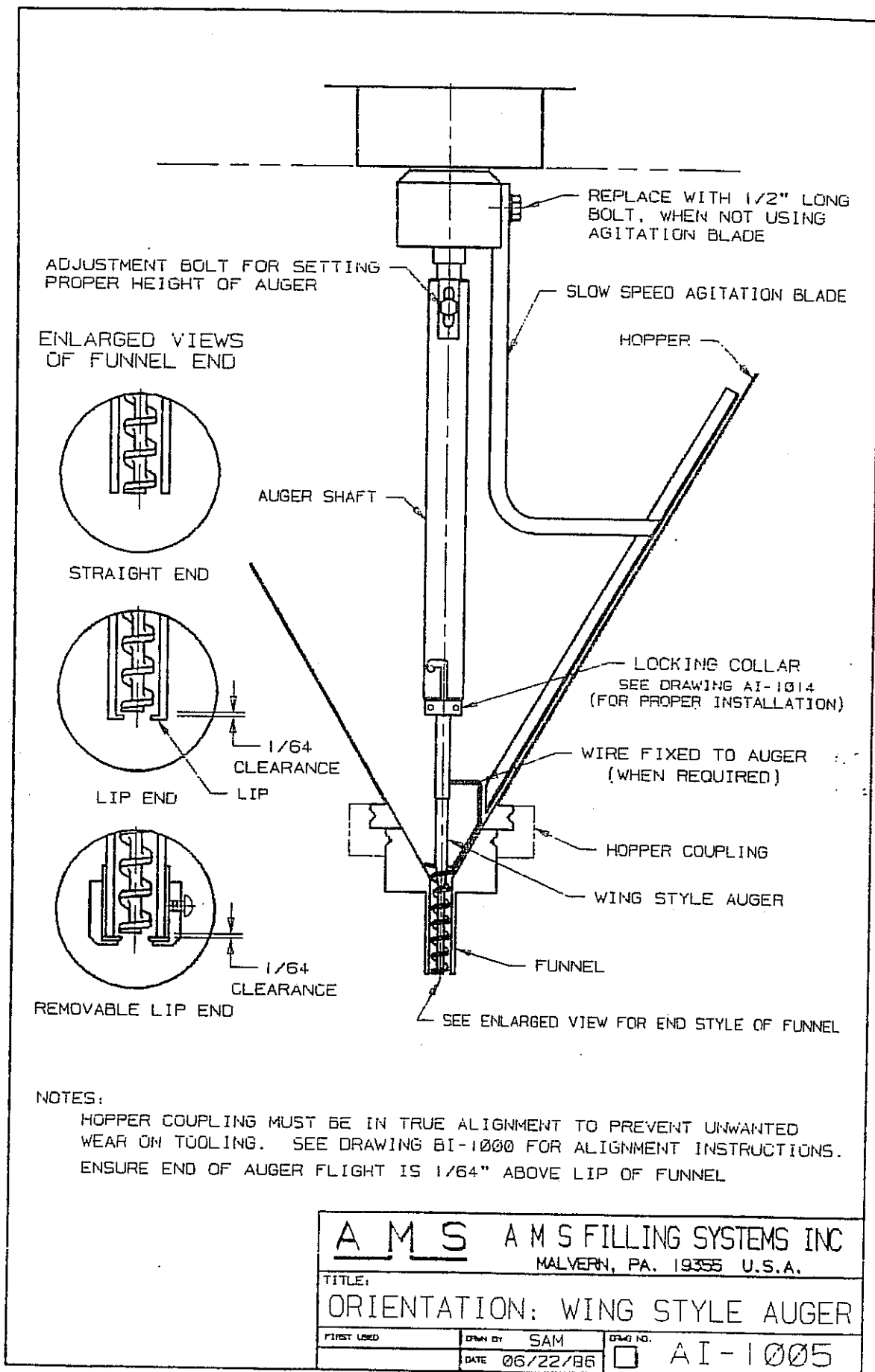
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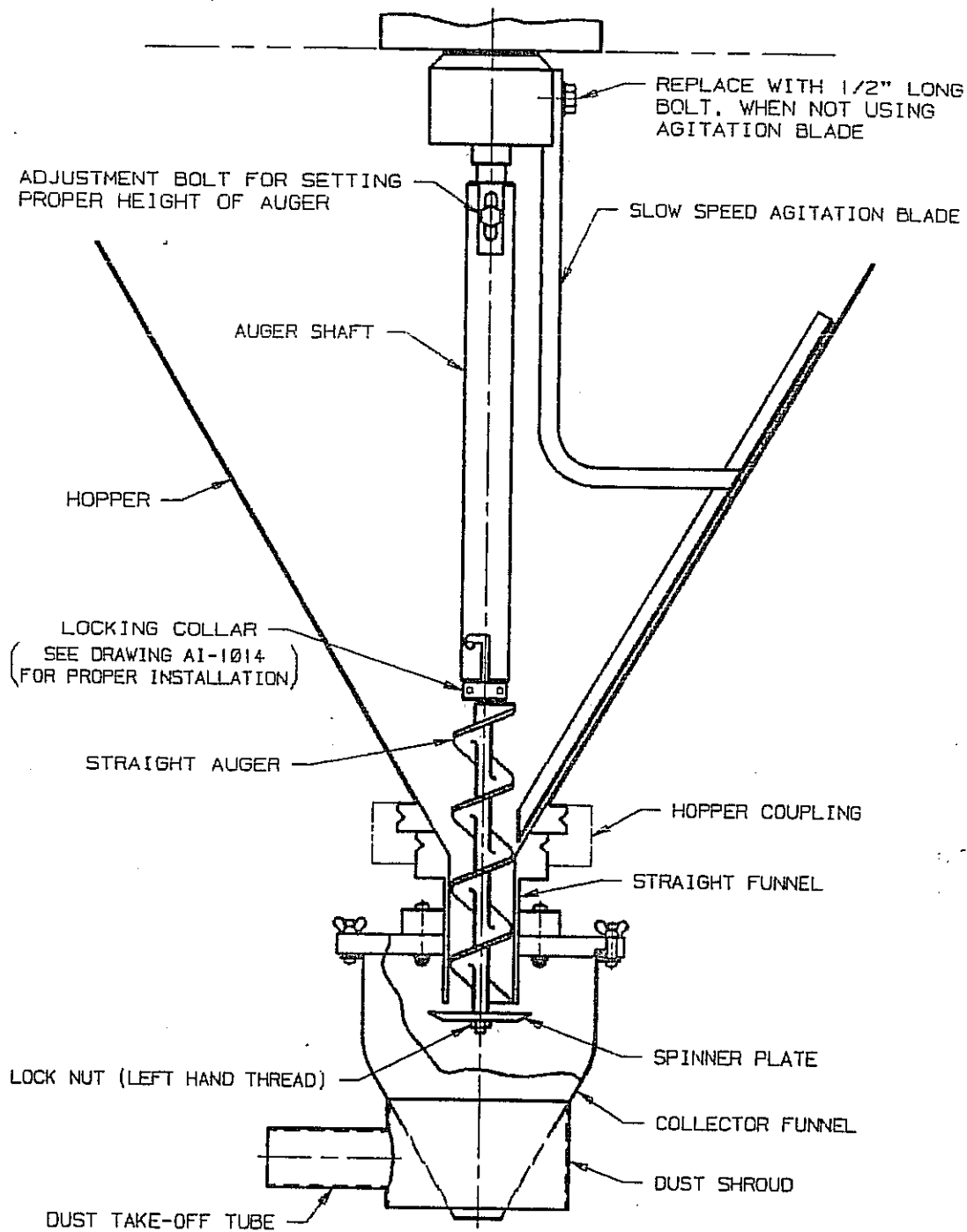
SAM

DRWG NO.

DATE 06/22/86

☐ AI-1005-A

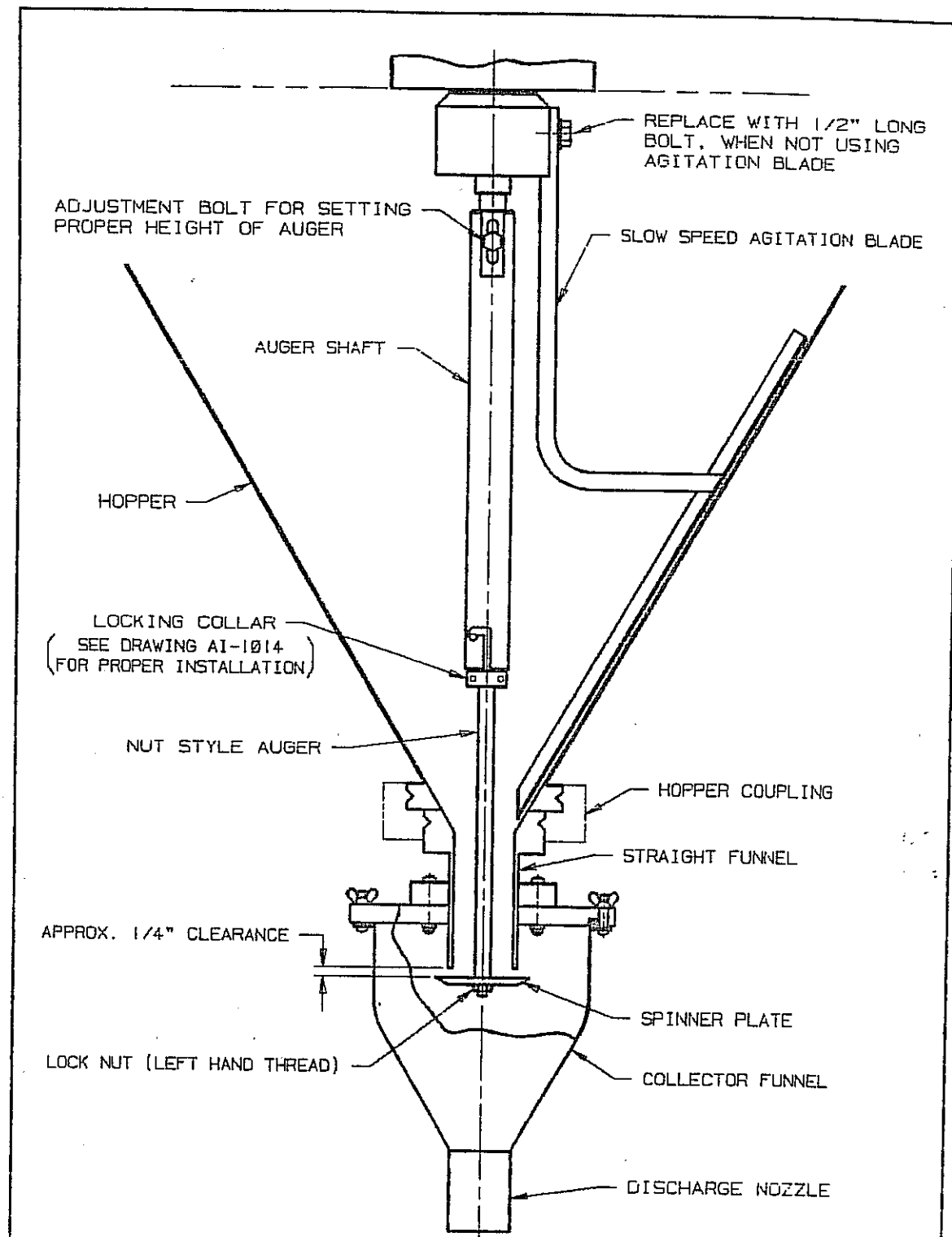




FOR MOST APPLICATIONS END OF AUGER FLIGHT MUST BE FLUSH WITH BOTTOM OF FUNNEL
NOTE:

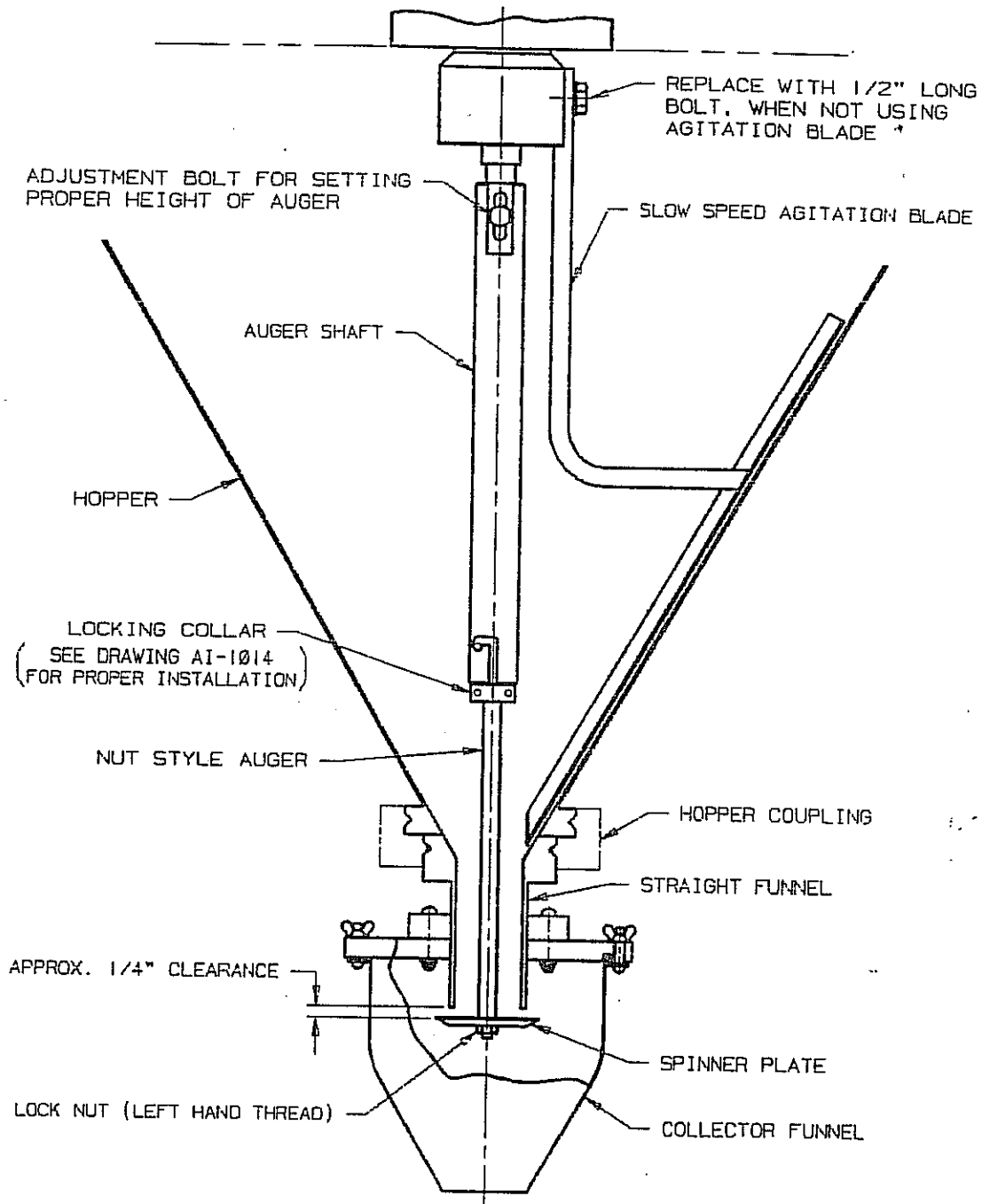
HOPPER COUPLING MUST BE IN TRUE ALIGNMENT TO PREVENT UNWANTED WEAR ON TOOLING. SEE DRAWING BI-1000 FOR ALIGNMENT INSTRUCTIONS.

A M S A M S FILLING SYSTEMS INC MALVERN, PA. 19355 U.S.A.		
TITLE:		
FREE FLOW SET-UP WITH DUST SHROUD - NO NOZZLE		
FIRST USED	DATE	BY
	06/22/86	SAM
<input type="checkbox"/> AI-1008-1		DATE 06/22/86



NOTE: FOR MOST APPLICATIONS ALLOW 1/4" CLEARANCE BETWEEN SPINNER PLATE AND BOTTOM OF FUNNEL
 HOPPER COUPLING MUST BE IN TRUE ALIGNMENT TO PREVENT UNWANTED WEAR ON TOOLING SEE DRAWING BI-1000 FOR INSTRUCTIONS

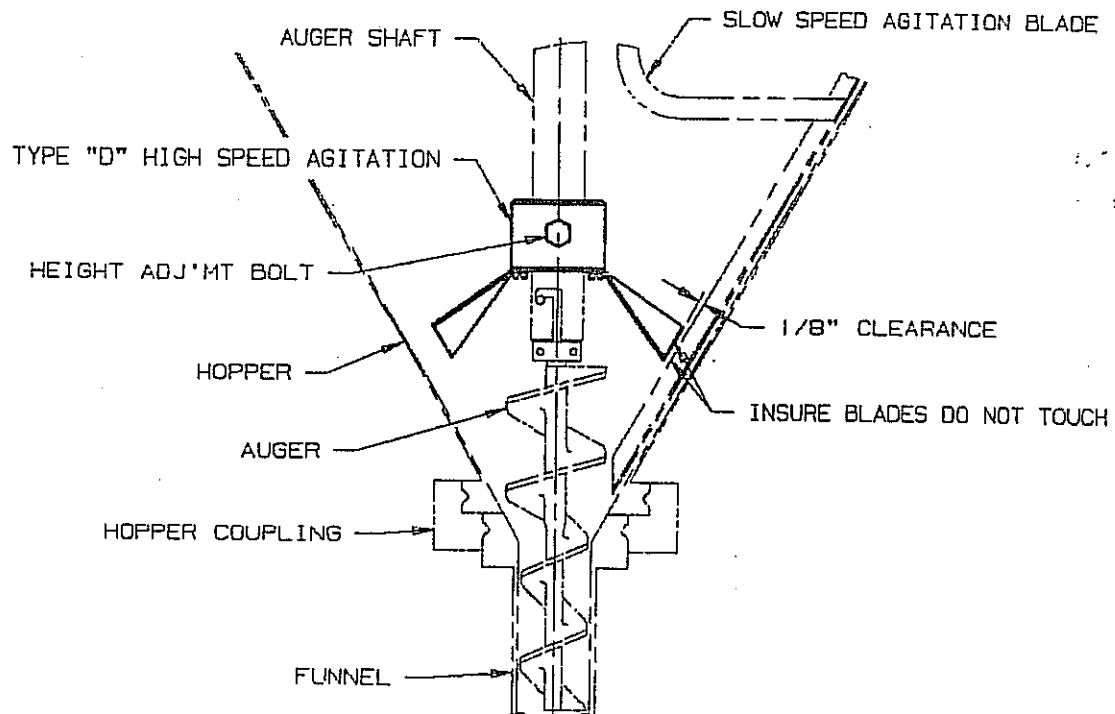
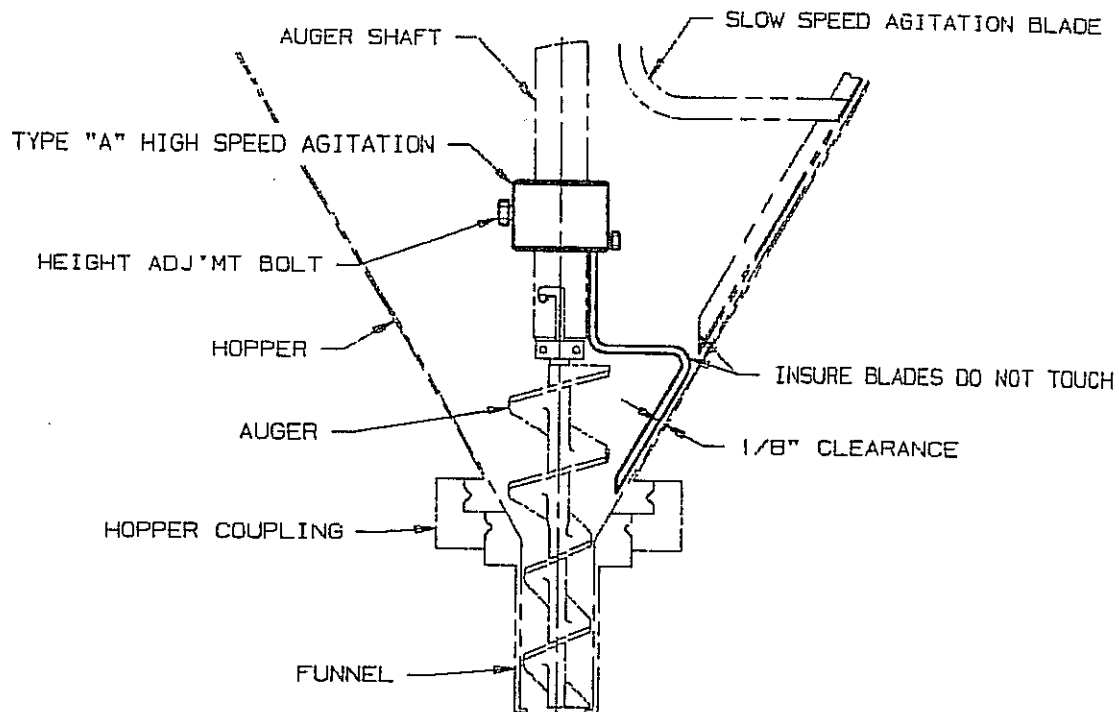
A M S A M S FILLING SYSTEMS INC MALVERN, PA. 19355 U.S.A.		
TITLE:		
FREE FLOW SET-UP WITH NUT STYLE AUGER		
PIST USED	DRW BY	DRG NO.
	SAM	
DATE	06/22/86	<input type="checkbox"/> AI-1010



FOR MOST APPLICATIONS ALLOW 1/4" CLEARANCE BETWEEN SPINNER PLATE AND BOTTOM OF FUNNEL

NOTE:
HOPPER COUPLING MUST BE IN TRUE ALIGNMENT TO PREVENT UNWANTED WEAR ON TOOLING SEE DRAWING DI-1000 FOR INSTRUCTIONS

A M S A M S FILLING SYSTEMS INC MALVERN, PA. 19355 U.S.A.		
TITLE: NO DISCHARGE NOZZLE FREE FLOW SET-UP WITH NUT STYLE AUGER		
FIRST USED	DRAWN BY: SAM	DRAWING NO.
DATE 06/22/86	<input type="checkbox"/>	AI-1010-1



A M S

A M S FILLING SYSTEMS INC

MALVERN, PA. 19355 U.S.A.

TITLE:

GENERAL ORIENTATION OF HIGH SPEED AGITATION BLADES

FIRST USED

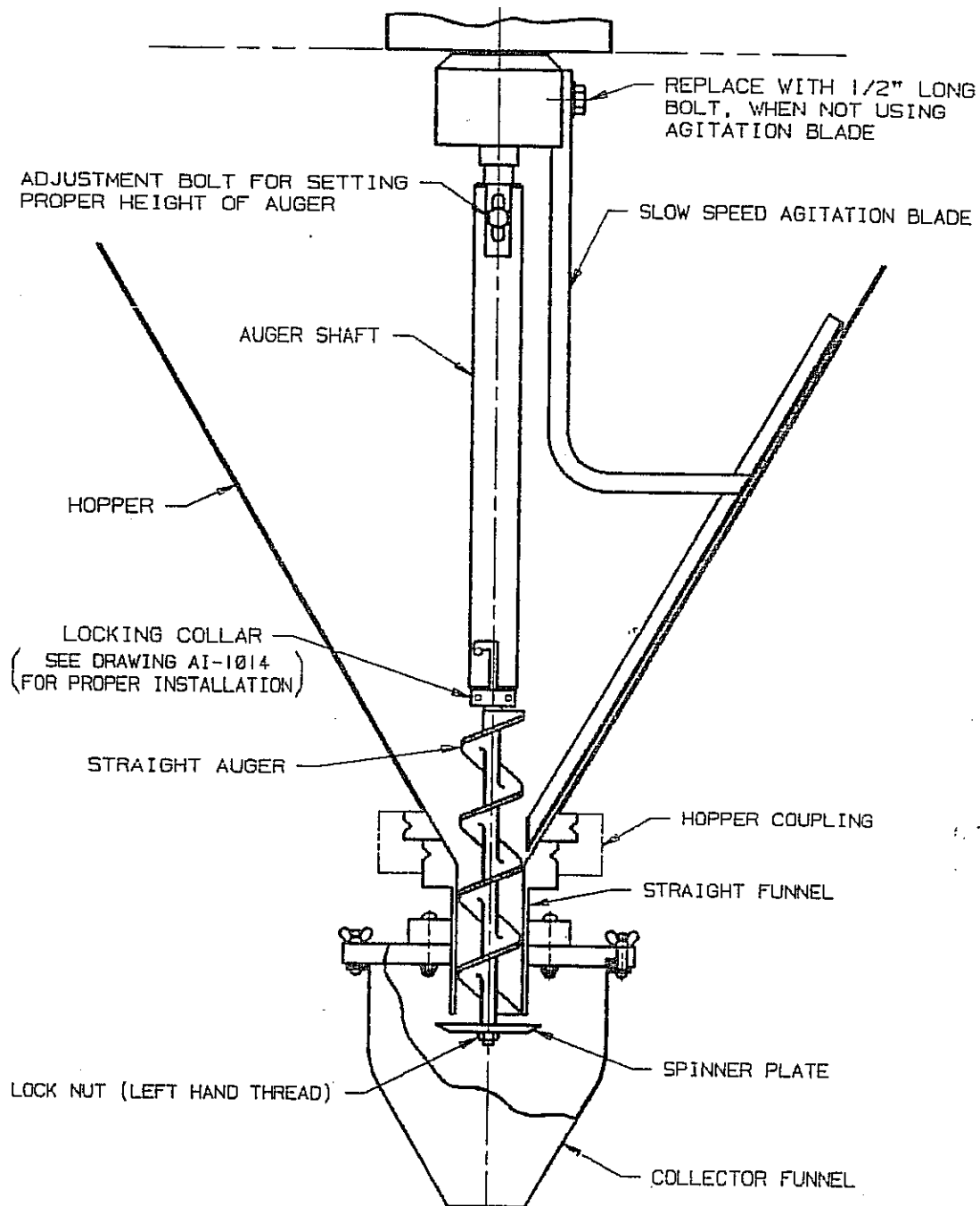
DATE

06/22/86

DRAWN BY SAM

DRAW NO.

AI-1013

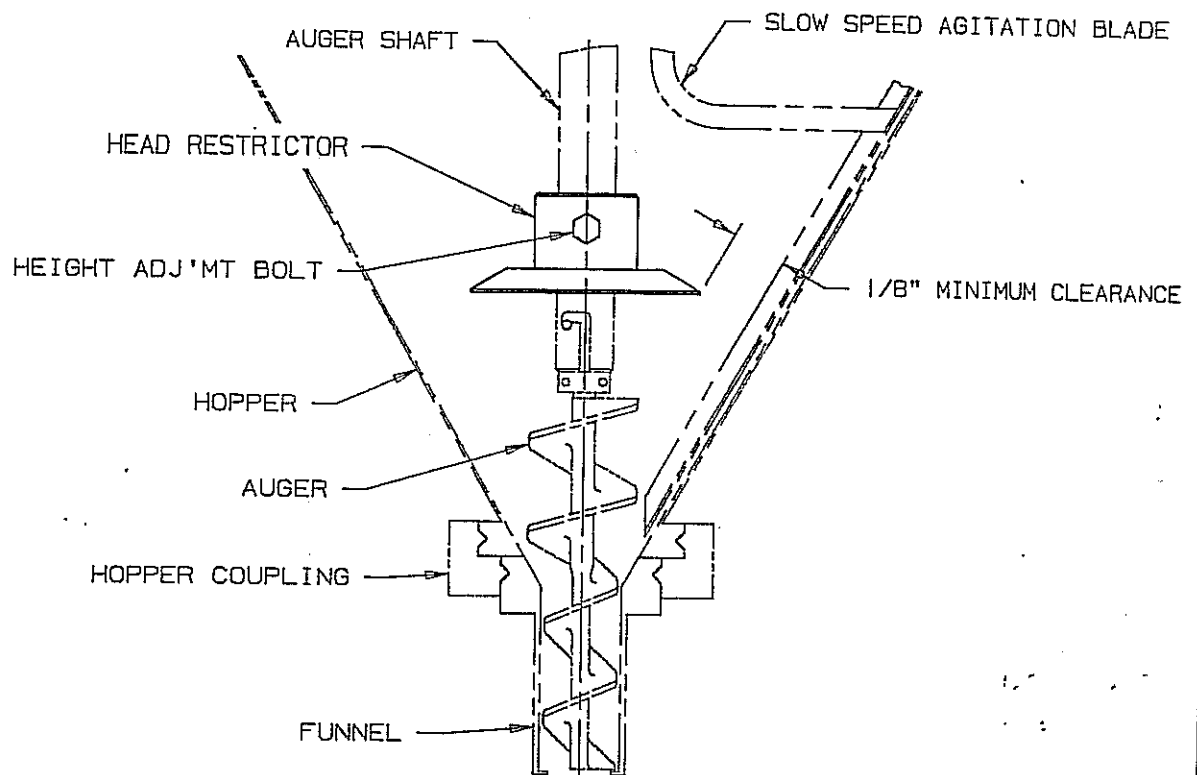


FOR MOST APPLICATIONS END OF AUGER FLIGHT MUST BE FLUSH WITH BOTTOM OF FUNNEL

NOTE:

HOPPER COUPLING MUST BE IN TRUE ALIGNMENT TO PREVENT UNWANTED WEAR ON TOOLING. SEE DRAWING BI-1000 FOR ALIGNMENT INSTRUCTIONS.

A M S A M S FILLING SYSTEMS INC MALVERN, PA. 19355 U.S.A.		
TITLE:		
FREE FLOW SET-UP WITHOUT NOZZLE		
FIRST USED	DRAWN BY	DRWG NO.
	SAM	<input type="checkbox"/> AI-1007-1
	DATE	06/22/86



NOTE:

SET HEAD RESTRICTOR TO BEST MINIMIZE SENSITIVITY TO HEAD PRESSURE, WHILE MAINTAINING ADEQUATE PRODUCT FLOW TO AUGER.

A M S

A M S FILLING SYSTEMS INC
MALVERN, PA. 19355 U.S.A.

TITLE:

ORIENTATION SHOWING HEAD RESTRICTOR SET-UP

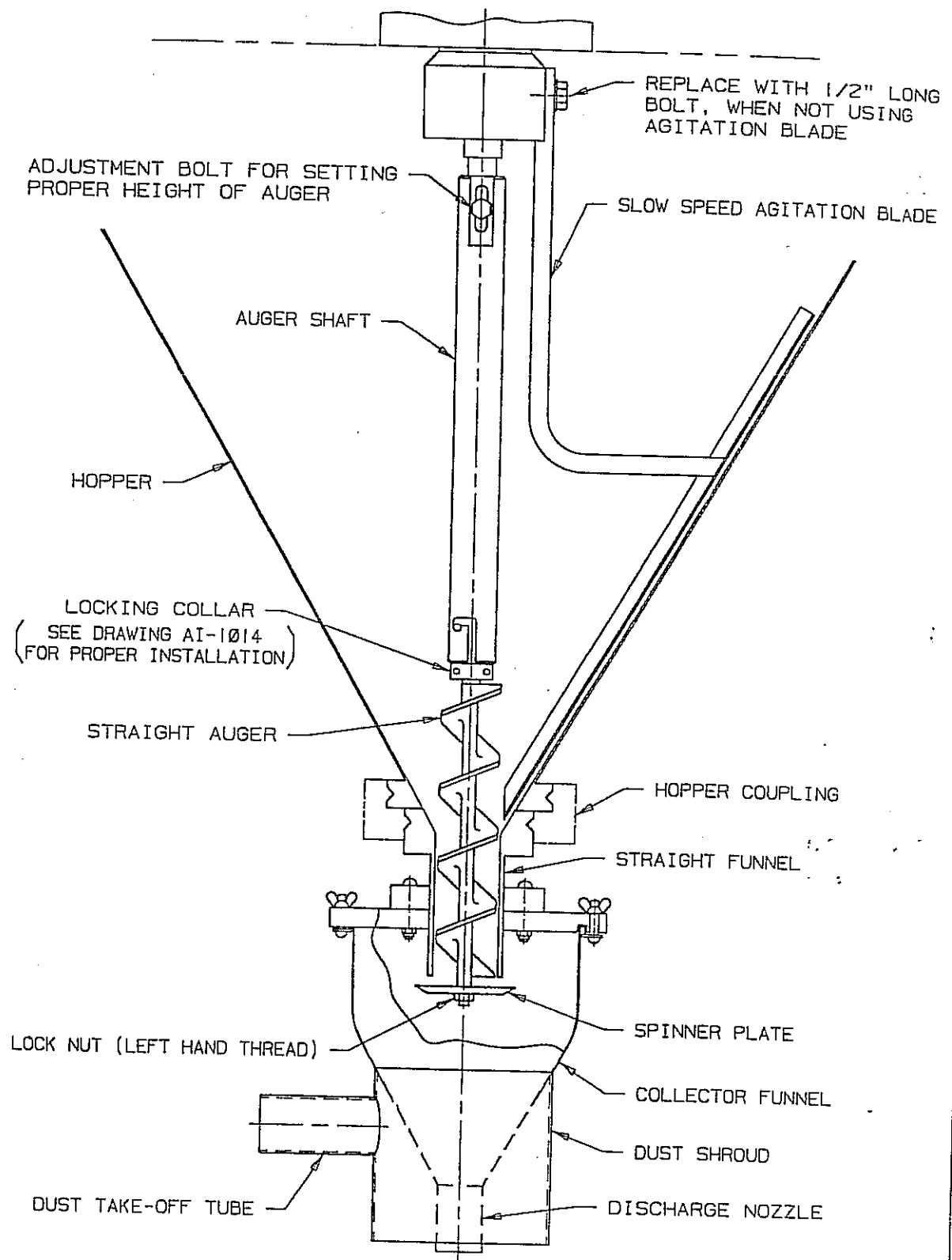
FIRST USED

DRWN BY SAM

DRWG NO.

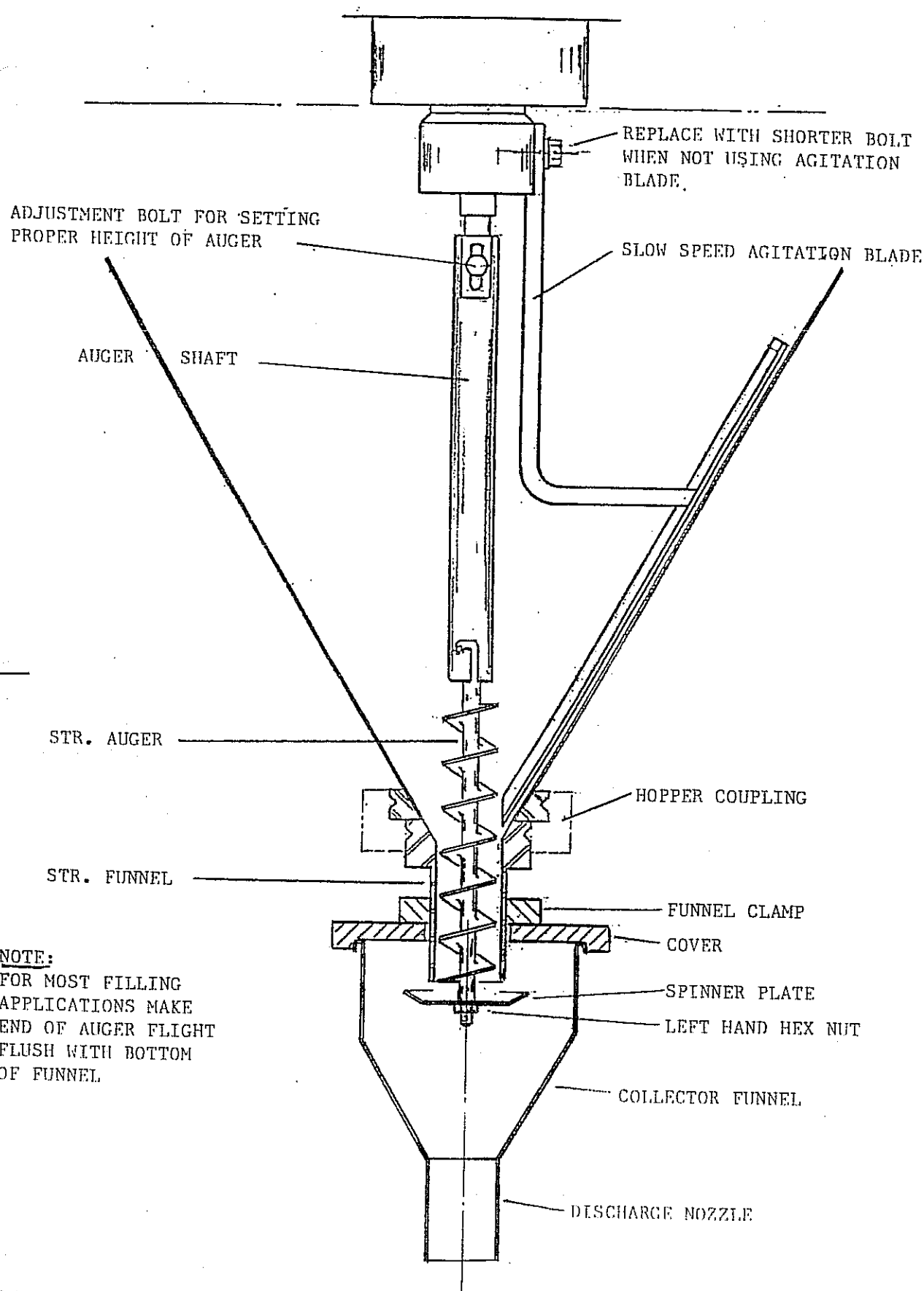
DATE 06/22/86

☐ AI-1013-1



NOTE: FOR MOST APPLICATIONS END OF AUGER FLIGHT MUST BE FLUSH WITH BOTTOM OF FUNNEL
 HOPPER COUPLING MUST BE IN TRUE ALIGNMENT TO PREVENT UNWANTED WEAR ON TOOLING SEE DRAWING BI-1000 FOR INSTRUCTIONS

A M S A M S FILLING SYSTEMS INC MALVERN, PA. 19355 U.S.A.		
TITLE:		
FREE FLOW SET-UP WITH DUST SHROUD		
FIRST USED	DRAWN BY	DRWG NO.
	SAM	
	DATE	
	06/22/86	AI-1008



NOTE:
FOR MOST FILLING
APPLICATIONS MAKE
END OF AUGER FLIGHT
FLUSH WITH BOTTOM
OF FUNNEL

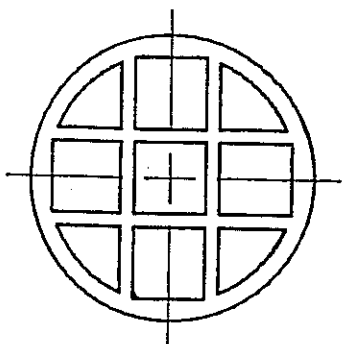
NOTE: HOPPER COUPLING MUST BE IN TRUE ALIGNMENT TO PREVENT UNWANTED WEAR ON TOOLING

DWG. No:

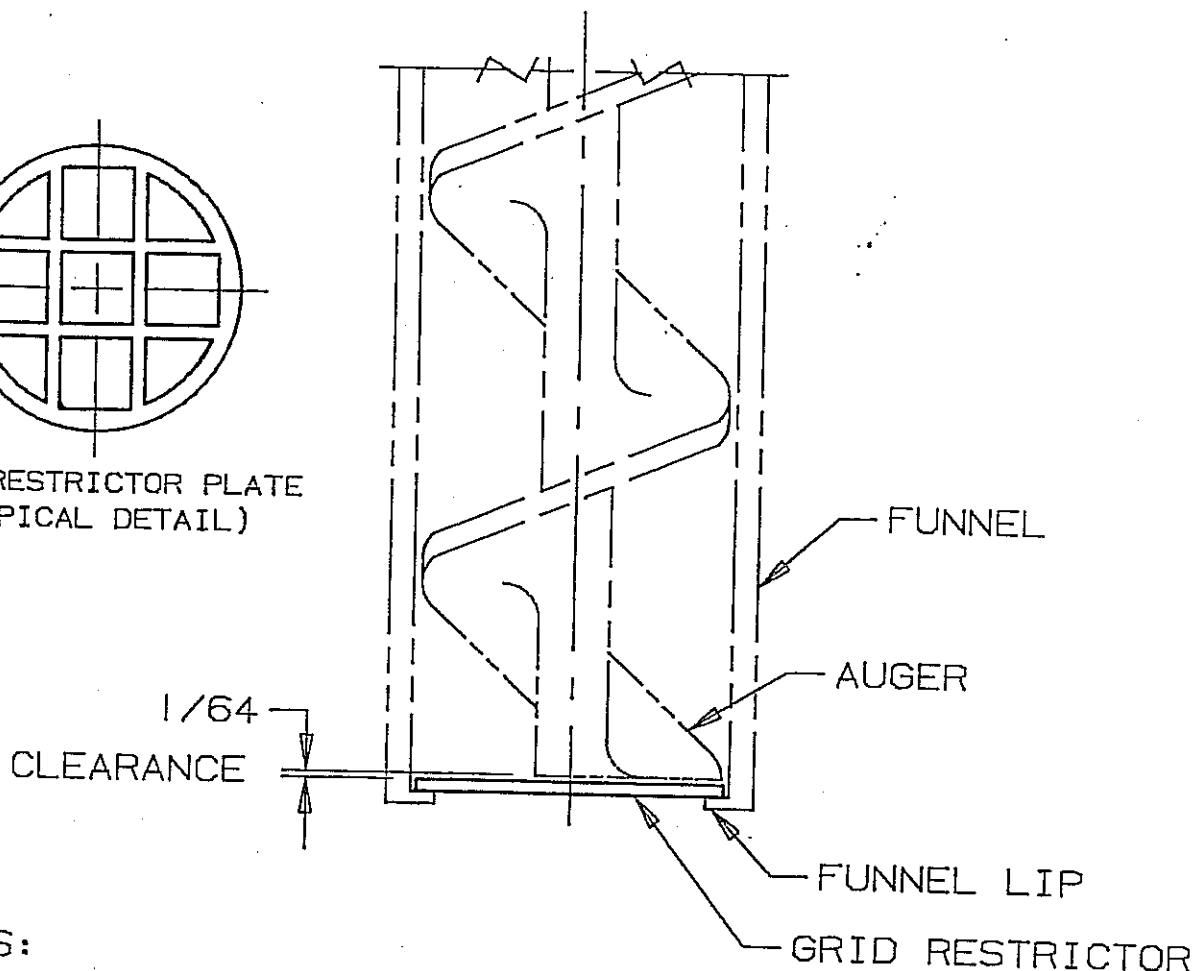
AT-1007

TITLE: FREE FLOWING SET UP

AMS FILLING
SYSTEMS, INC.



GRID RESTRICTOR PLATE
(TYPICAL DETAIL)



NOTES:

- 1 INSERT GRID RESTRICTOR INTO THE FUNNEL, INSURING THAT IT IS FIRMLY SEATED ON TO THE INNER LIP SURFACE.
- 2 ASSEMBLE LOCKING COLLAR, AUGER, AND AUGER SHAFT PER DRAWING AI-1014.
- 3 INSTALL AUGER AND SHAFT ASSEMBLY IN THE FILLING MACHINE.
- 4 ADJUST AUGER ASSEMBLY FOR 1/64" CLEARANCE BETWEEN THE END OF THE AUGER AND THE GRID RESTRICTOR.

CAUTION: FAILURE TO SET PROPER CLEARANCE WILL DAMAGE THE AUGER, GRID RESTRICTOR OR BOTH.

A M S

A M S FILLING SYSTEMS INC
FRAZER, PA. 19355 U.S.A.

TITLE:

ASSEMBLY: GRID RESTRICTOR PLATE INTO FUNNEL

FIRST USED

DRWN BY SAM

DRWG NO.

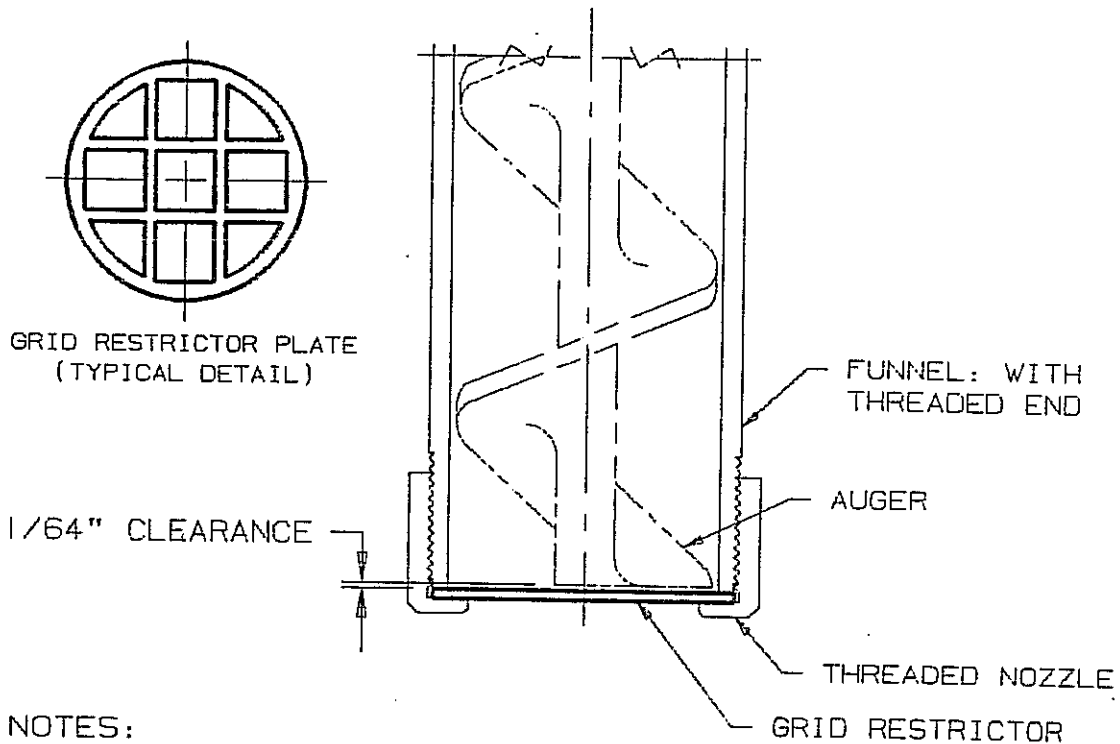
DATE 9/25/89

☐ AI-1015

DO NOT SCALE

SCALE

ASSEM. DRWG NO.



NOTES:

- 1 PLACE GRID RESTRICTOR INSIDE THREADED NOZZLE, INSURING THAT IT IS LAYING FLAT ON THE INNER LIP SURFACE. THREAD NOZZLE ONTO FUNNEL, UNTIL FIRMLY SEATED.
- 2 ASSEMBLE LOCKING COLLAR, AUGER, AND AUGER SHAFT PER DRAWING AI-1014.
- 3 INSTALL AUGER AND SHAFT ASSEMBLY IN THE FILLING MACHINE.
- 4 ADJUST AUGER ASSEMBLY FOR 1/64" CLEARANCE BETWEEN THE END OF THE AUGER AND THE GRID RESTRICTOR.

CAUTION: FAILURE TO SET PROPER CLEARANCE WILL DAMAGE THE AUGER GRID RESTRICTOR OR BOTH.

A M S

A M S FILLING SYSTEMS INC
MALVERN, PA. 19355 U.S.A.

TITLE:

ASSEMBLY: GRID RESTRICTOR PLATE WITH THREADED NOZZLE

FIRST USED

DRWN BY

SAM

DRWG NO.

DATE

10/16/91

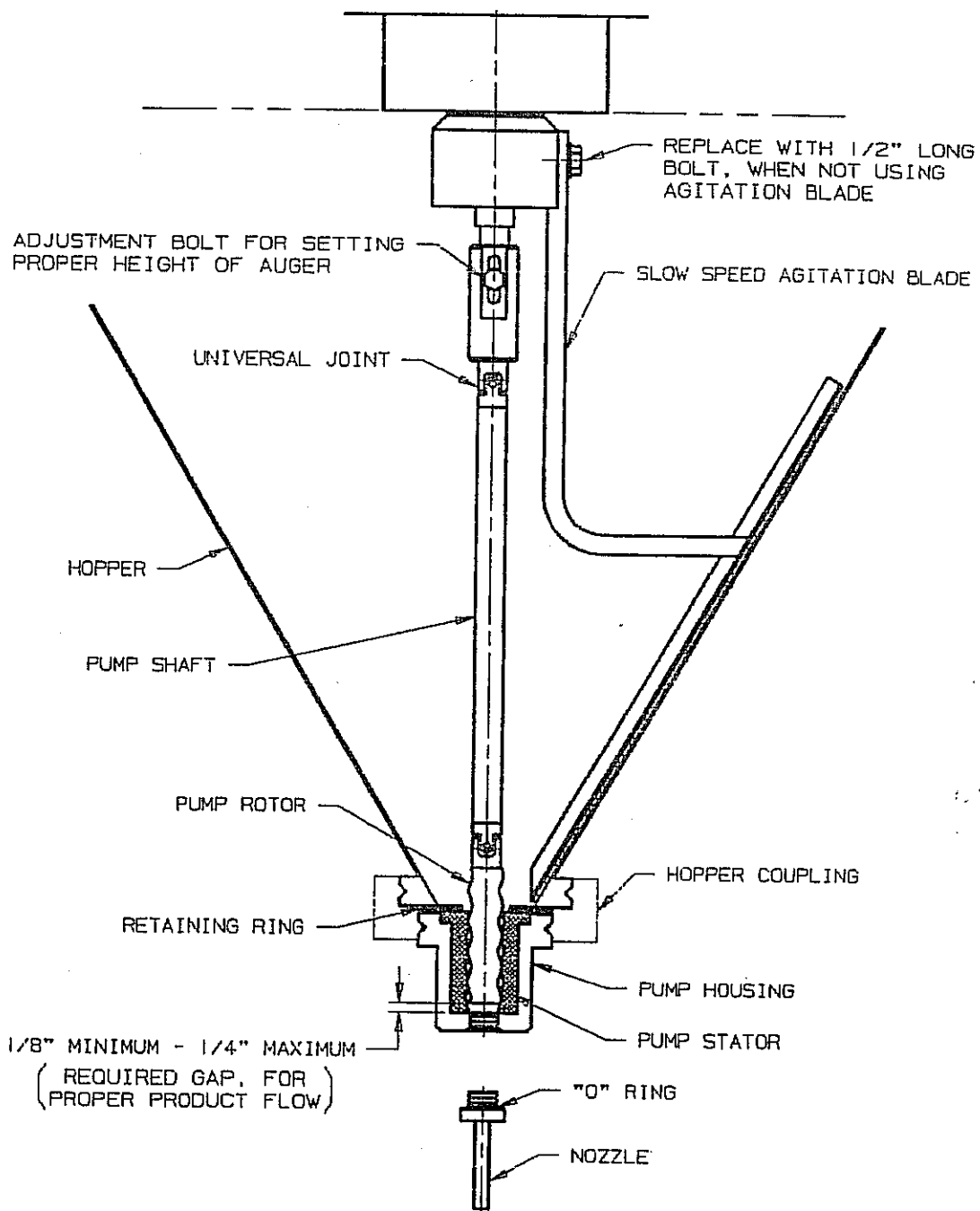


AI-1015-1

DO NOT SCALE

SCALE

ACCH. DRWG NO.

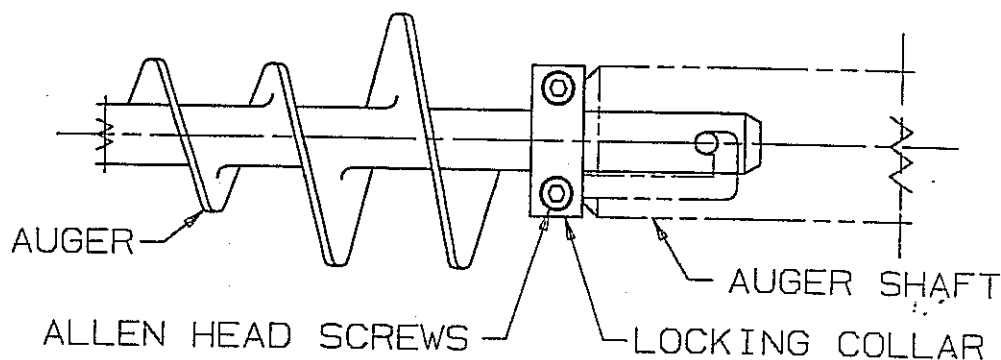
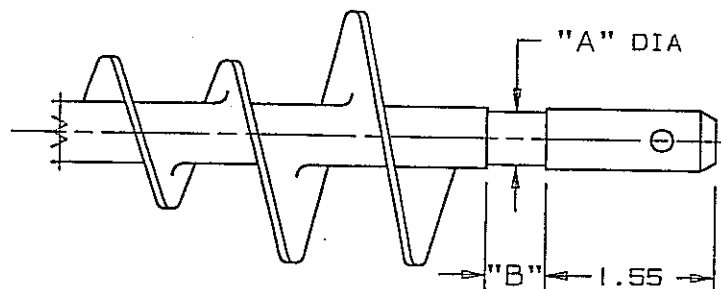


NOTE:
 HOPPER COUPLING MUST BE IN TRUE ALIGNMENT TO PREVENT UNWANTED
 WEAR ON TOOLING. SEE DRAWING BI-1000 FOR ALIGNMENT INSTRUCTIONS.

A M S A M S FILLING SYSTEMS INC MALVERN, PA. 19355 U.S.A.		
TITLE: LIQUID FILL SET-UP - USING SMALL TOOLING		
FIRST USED	DRAWN BY SAM	DWG NO. <input type="checkbox"/> AI-1011
DATE 06/22/86		

AUGER SIZE	"A" +.005 -.000	"B" +.010 -.000
SMALL	.450	.500
LARGE	.575	.531

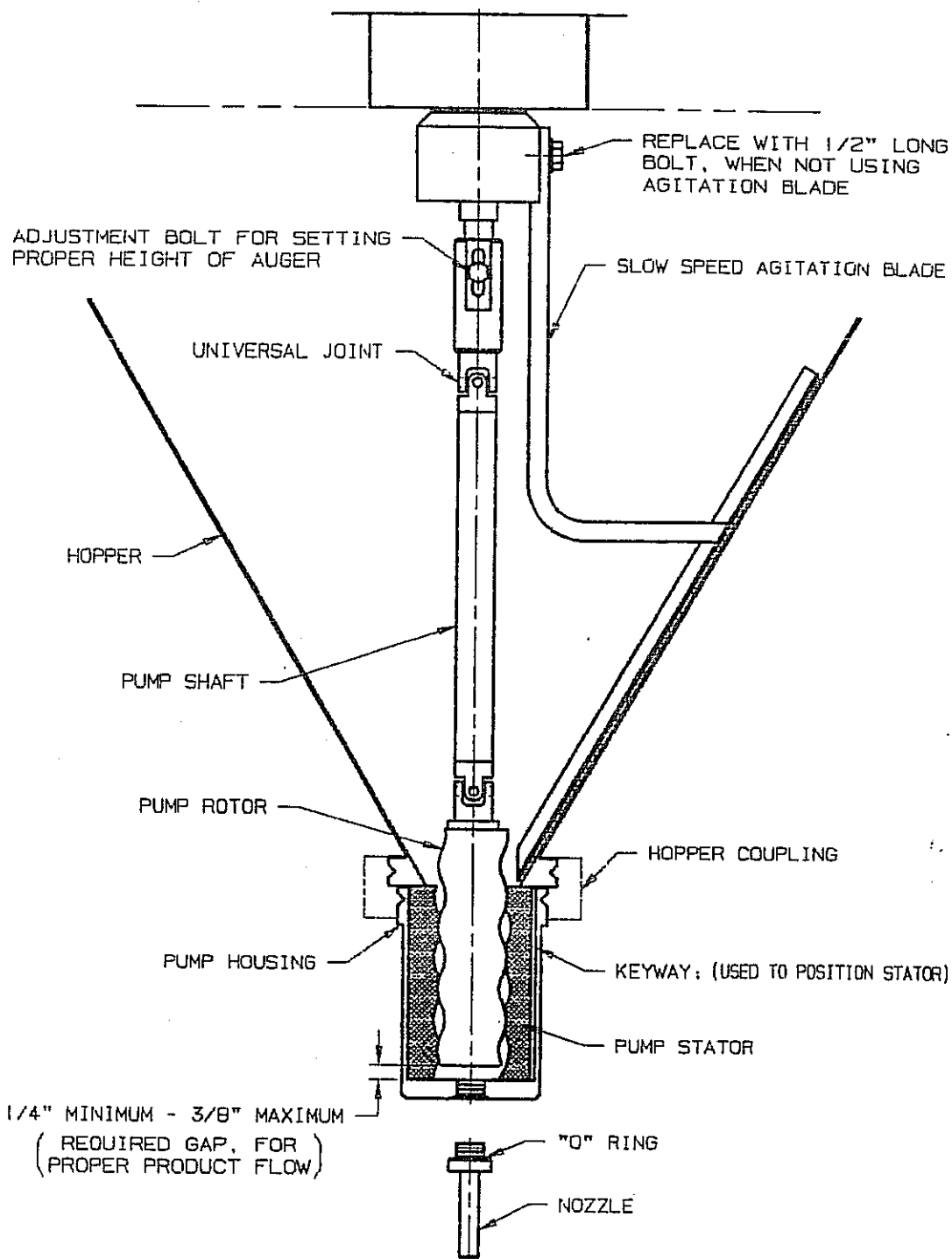
AUGER DETAIL



NOTES:

1. ASSEMBLE LOCKING COLLAR ON AUGER STEM - DO NOT TIGHTEN
2. INSERT AUGER IN AUGER SHAFT
3. SLIDE LOCKING COLLAR UP AGAINST BOTTOM OF AUGER SHAFT AND TIGHTEN TWO ALLEN HEAD SCREWS

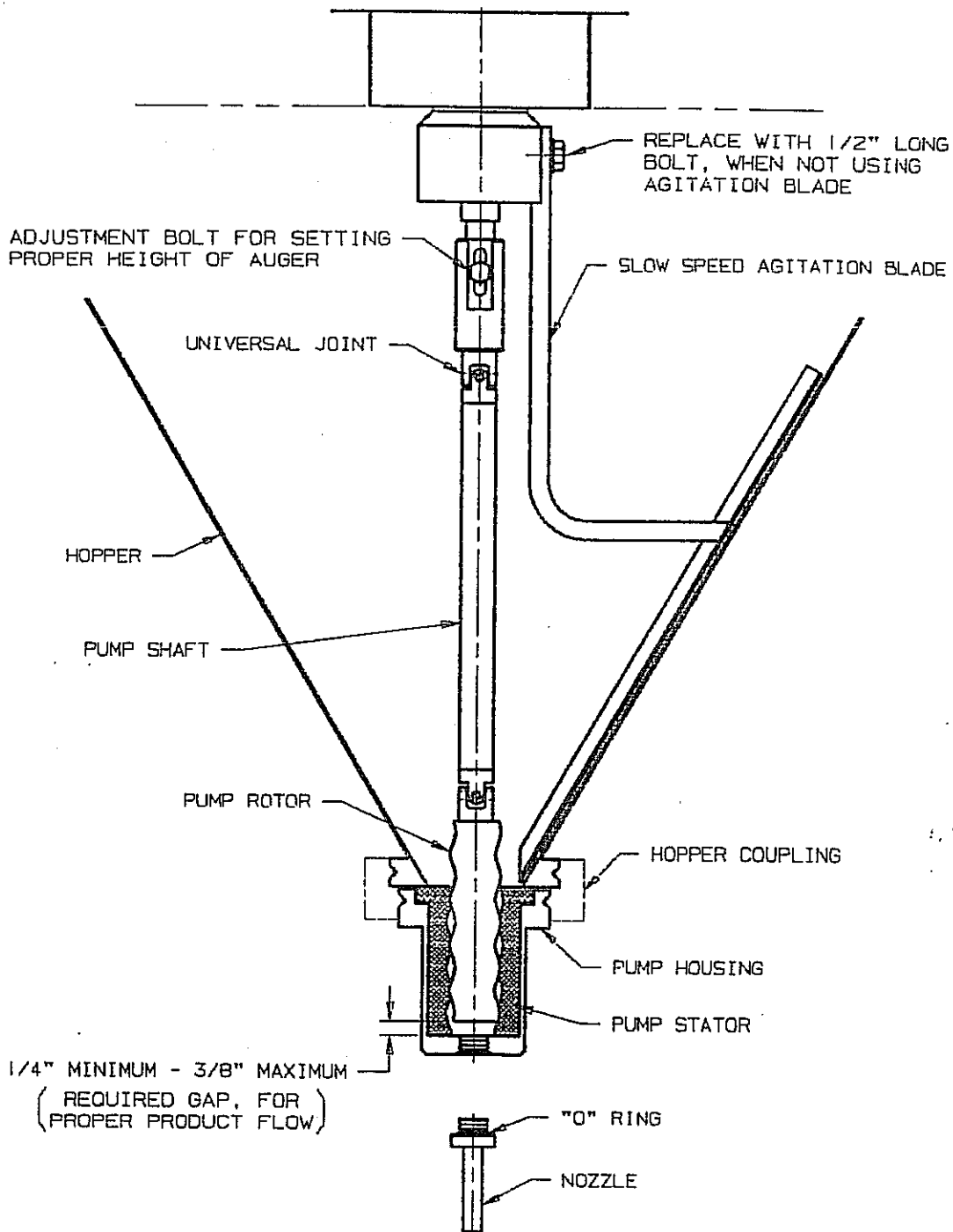
A M S		A M S FILLING SYSTEMS INC	
		MALVERN, PA. 19355 U.S.A.	
TITLE: ASSEMBLY: AUGER LOCKING COLLAR			
FIRST USED	DATE	BY	NO.
	08/23/90	SAM	AI-1014



NOTE:

HOPPER COUPLING MUST BE IN TRUE ALIGNMENT TO PREVENT UNWANTED WEAR ON TOOLING. SEE DRAWING BI-1000 FOR ALIGNMENT INSTRUCTIONS.

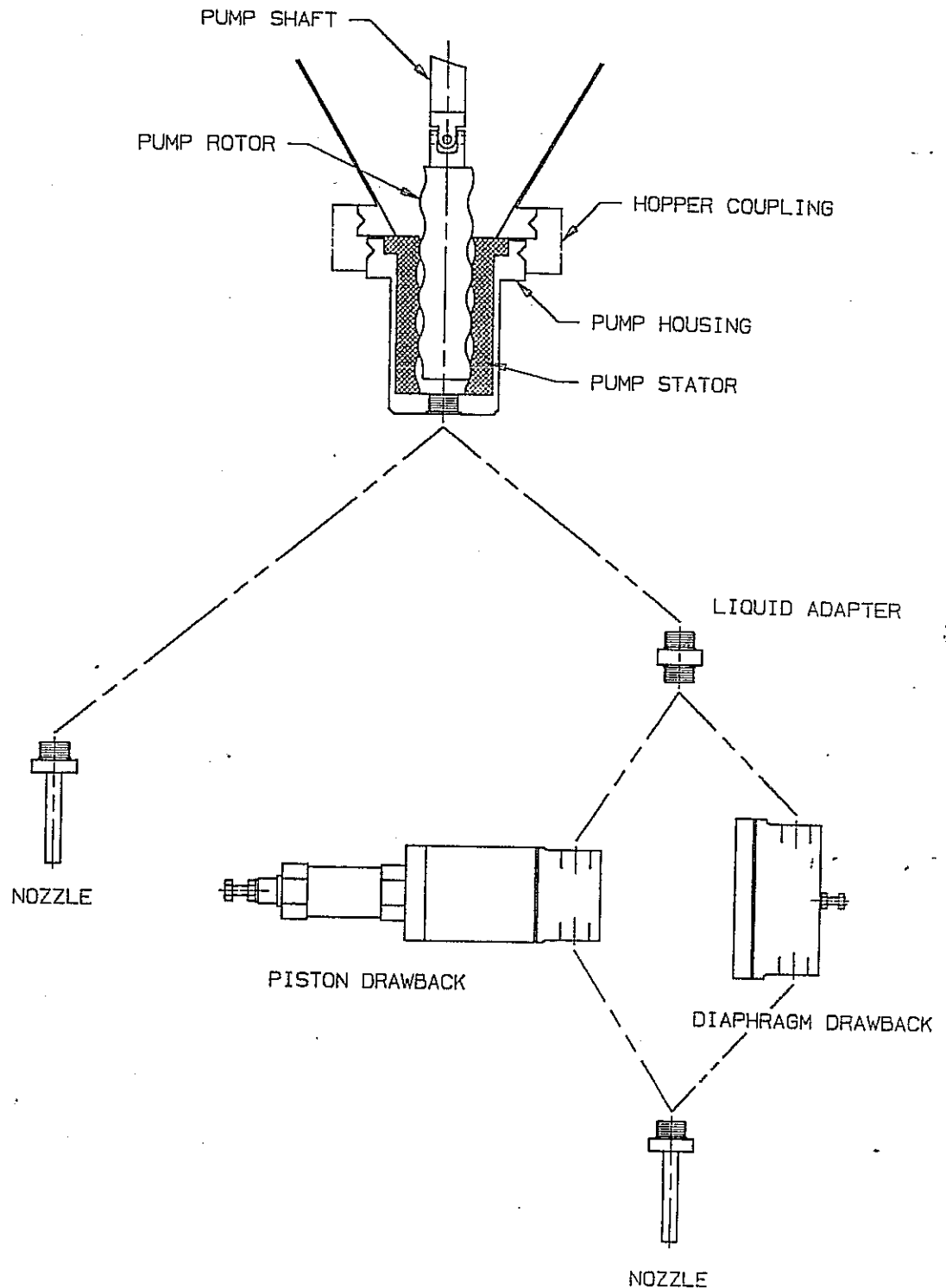
A M S A M S FILLING SYSTEMS INC MALVERN, PA. 19355 U.S.A.		
TITLE: No. 4 PUMP ASSEMBLY LIQUID FILL SET-UP - USING LARGE TOOLING		
FIRST USED	DRAWN BY: SAM	DRAW NO.
DATE 06/22/86	<input type="checkbox"/>	AI-1012-1



NOTE:

HOPPER COUPLING MUST BE IN TRUE ALIGNMENT TO PREVENT UNWANTED WEAR ON TOOLING. SEE DRAWING BI-1000 FOR ALIGNMENT INSTRUCTIONS.

A M S A M S FILLING SYSTEMS INC MALVERN, PA. 19355 U.S.A.		
TITLE: LIQUID FILL SET-UP - USING LARGE TOOLING		
FIRST USED	DRAWN BY SAM	DRAW NO. AI-1012
DATE 06/22/86	<input type="checkbox"/>	



NOTE:
WHEN ASSEMBLING, ALL PARTS MUST USE "O" RING SEAL FOR PROPER CONNECTION

A M S

A M S FILLING SYSTEMS INC
MALVERN, PA. 19355 U.S.A.

TITLE:

GENERAL ORIENTATION OF LIQUID TOOLING

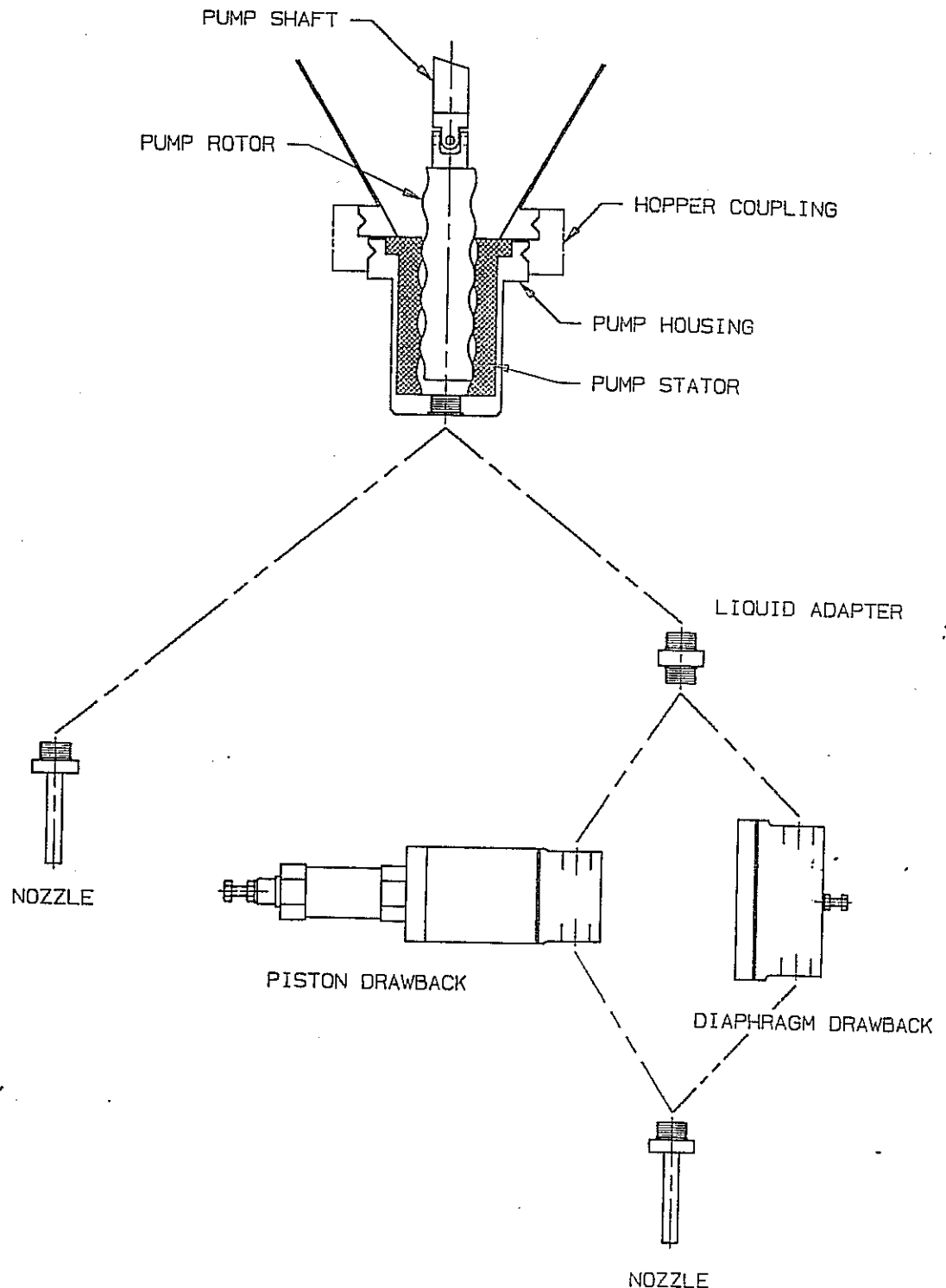
FIRST USED

DRAWN BY SAM

DRWG NO.

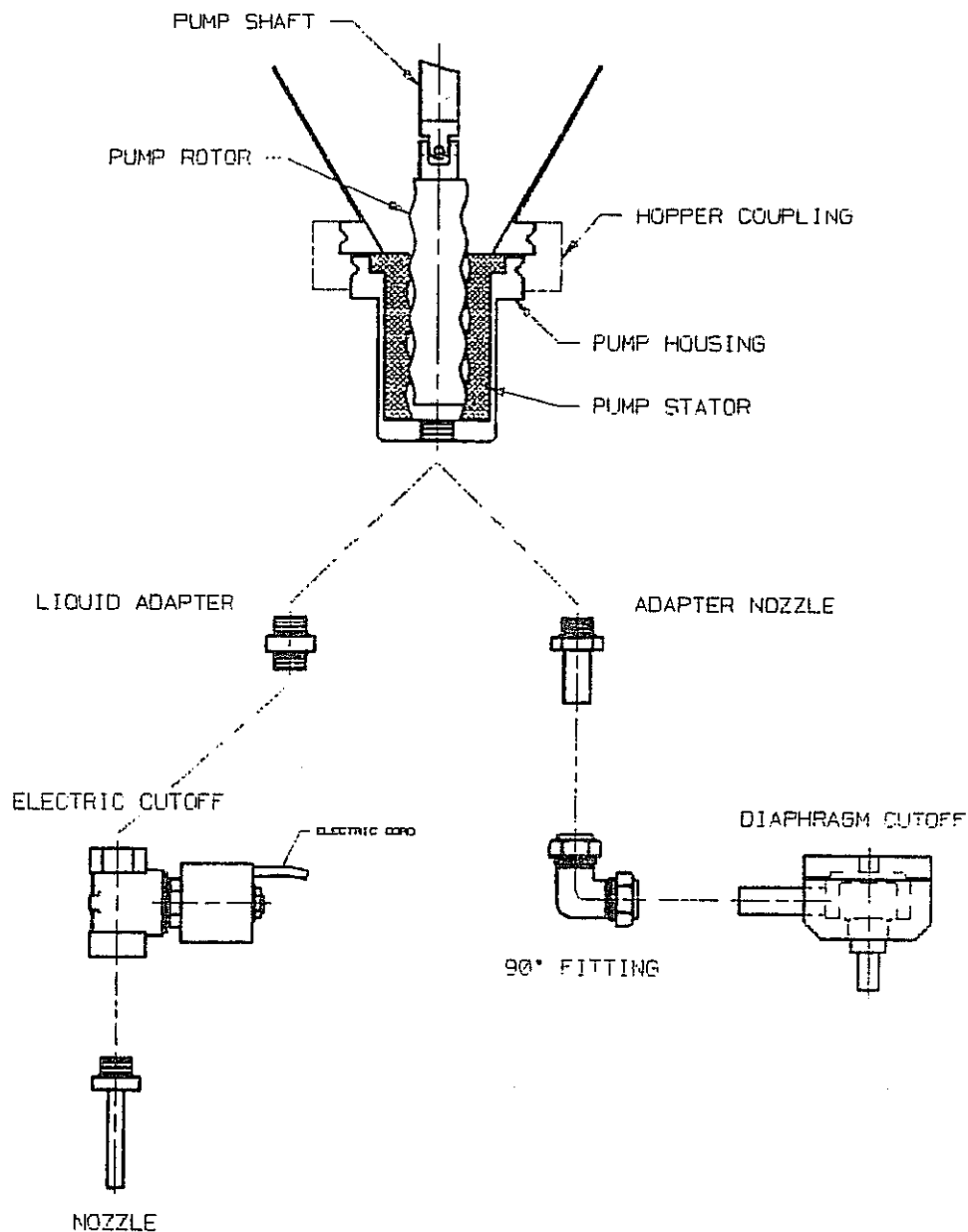
DATE 06/22/86

☐ AI-1016



NOTE:
WHEN ASSEMBLING, ALL PARTS MUST USE "O" RING SEAL FOR PROPER CONNECTION

A M S A M S FILLING SYSTEMS INC MALVERN, PA. 19355 U.S.A.		
TITLE:		
GENERAL ORIENTATION OF LIQUID TOOLING		
FIRST USED	DRAWN BY	DWG NO.
	SAM	<input type="checkbox"/> AI-1016
DATE	06/22/86	



NOTE:

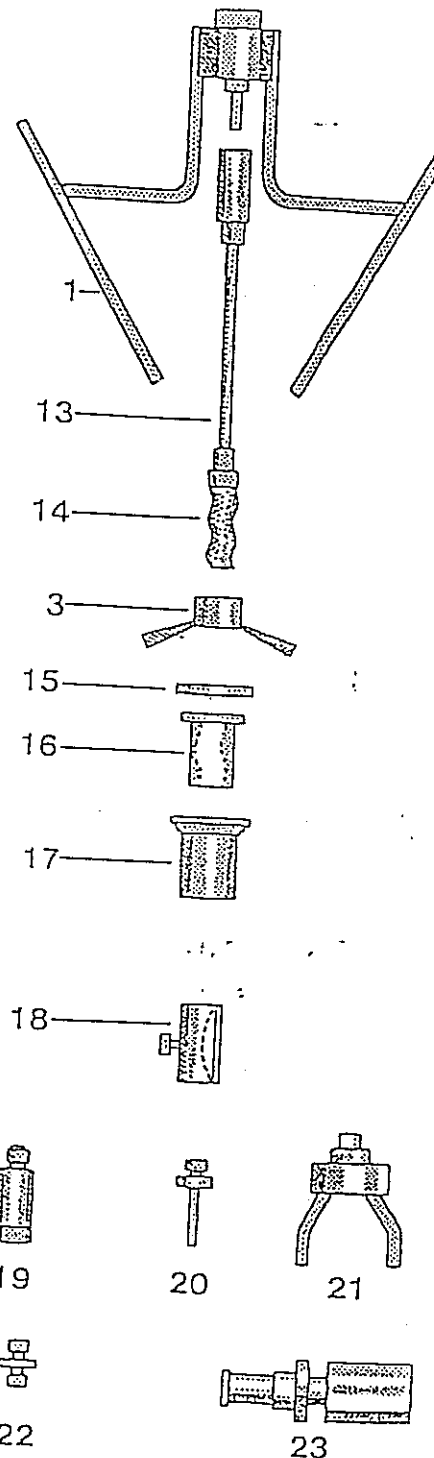
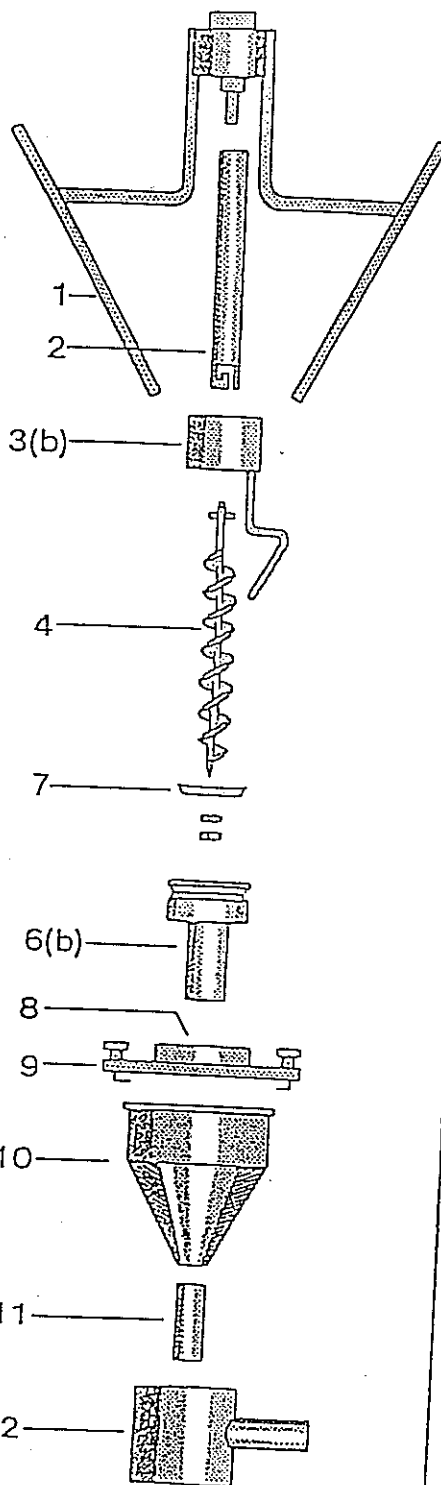
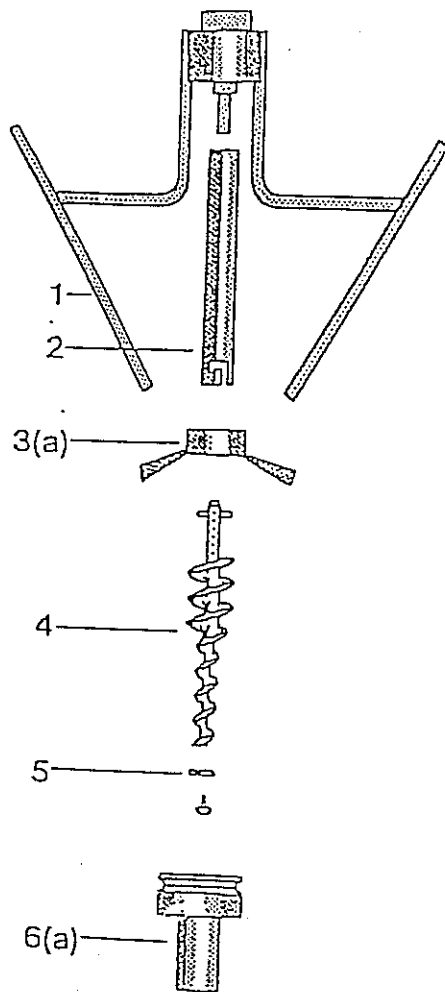
WHEN ASSEMBLING, ALL PARTS MUST USE "O" RING SEAL FOR PROPER CONNECTION

A M S A M S FILLING SYSTEMS INC MALVERN, PA. 19355 U.S.A.		
TITLE: GENERAL ORIENTATION OF LIQUID TOOLING		
FIRST USED	DRAWN BY: SAM	DRWG NO:
DATE 01/04/94		<input type="checkbox"/> AI-1016-1

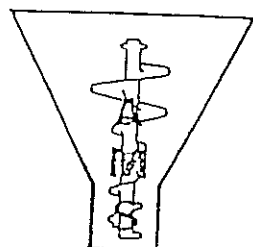
Non Free-flowing Products

Free-flowing Products

Liquids/Creams/Pastes



1. Slow speed agitator blade(s)
2. Auger shaft
3. High speed agitator
 - (a) Type A3
 - (b) Type D
4. Auger
5. Drip washer with left hand thr'd screw
6. Funnel
 - (a) Lip Funnel - most cases
 - (b) Straight Funnel - most cases
7. Spinner plate with left hand thr'd nuts
8. Clamp Ring
9. Cover for Collector Funnel
10. Collector Funnel
11. Discharge Nozzle
12. Dust shroud with vacuum nozzle
13. Pump rotor with vacuum nozzle
14. Rotor
15. Spacer
16. Stator
17. Pump Housing
18. Diaphragm cut-off
19. Ball check valve
20. Nozzle
21. Manifold
22. Adapter
23. Piston suck-back



AMS FILLING SYSTEMS, INC.

53 Great Valley Parkway
Malvern, Pennsylvania 19355 USA