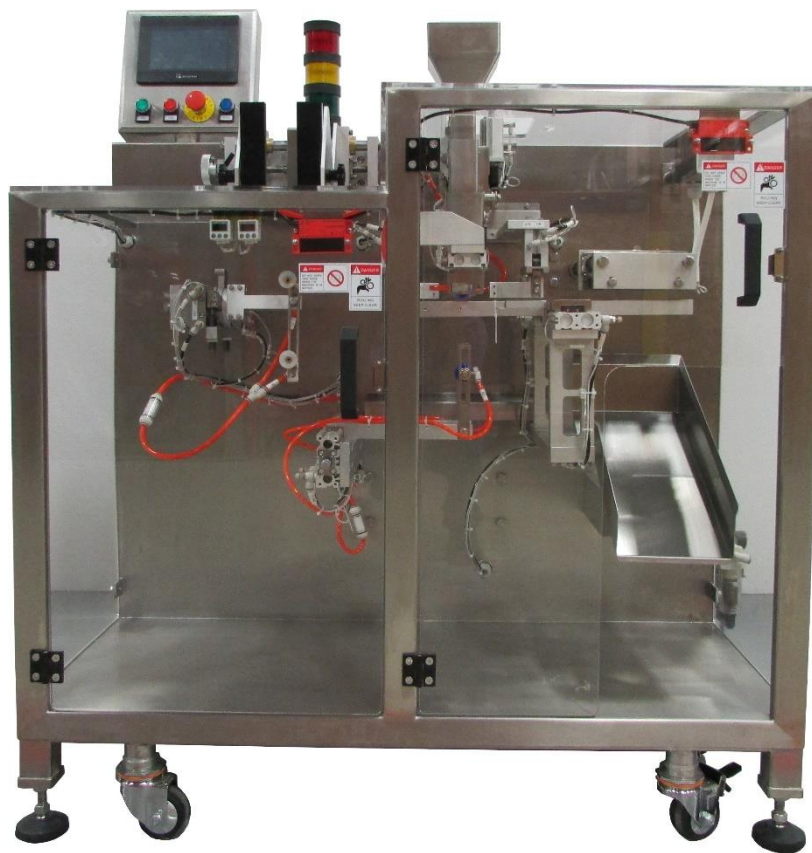


WEIGHPACK

SYSTEMS INC.

SWIFTY BAGGER MINI



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 Weighpack machine.

This manual contains detailed descriptions of the structure, function, operation and maintenance of the Weighpack machine. 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.

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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.

Warnings

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
	<p><u>PHYSICAL HARM</u></p> <p>Take caution when in the presence of moving parts as they may cut, crush, dismember or otherwise injure body parts in close proximity.</p> <p>Loose clothing or accessories around moving components may get caught and pull the operator into the machine.</p>
	<p><u>BURN HAZARD</u></p> <p>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.</p> <p>Surfaces will remain hot for an extended period of time after powering down the machine. Ensure the machine is completely cool before contact.</p>
	<p><u>HIGH VOLTAGE</u></p> <p>While powered, the machine's electrical systems possess sufficient voltage to electrocute any who misuse it.</p> <p>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.</p>

2. SPECIFICATIONS

Machine Name					
Power Supply	230	Vac			
	60	Hz			
	6	Amps			
	1	Phase			
Speed	Up to 50 Cycles per minute				
Bag Width	150 [6]	mm (in)	to	90 [3-1/2]	mm (in)
Bag Length	201 [8]	mm (in)	to	130 [5]	mm (in)
Air Pressure	80	PSI		6	Bar
Air Consumption	1	CFM		0.5	LPS
Weight	750	lbs		340	kg
Dimensions	Length:	135.5 (53-1/4) cm (in)			
	Width:	33 (84) cm (in)			
	Height:	144 (56-1/2) cm (in)			

(Speeds may vary based on bag dimensions, material and application)

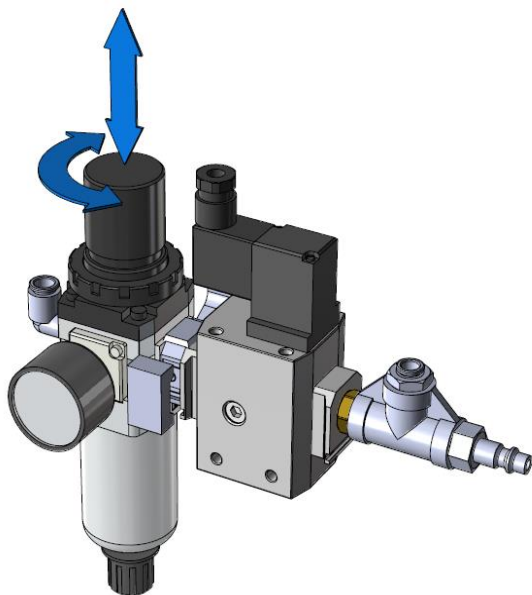
3. INSTALLATIONS

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 bags, the installation of static eliminator may be required. If this feature is needed, please contact the company for additional information.

3.2 Pneumatic

The Filter Regulator is located on the right panel of the Swiftly Bagger Mini. The Swiftly Bagger Mini operates at 80psi and has an air consumption of 1cfm. It is important to ensure that the air supply of the owner's facility can meet these specifications.



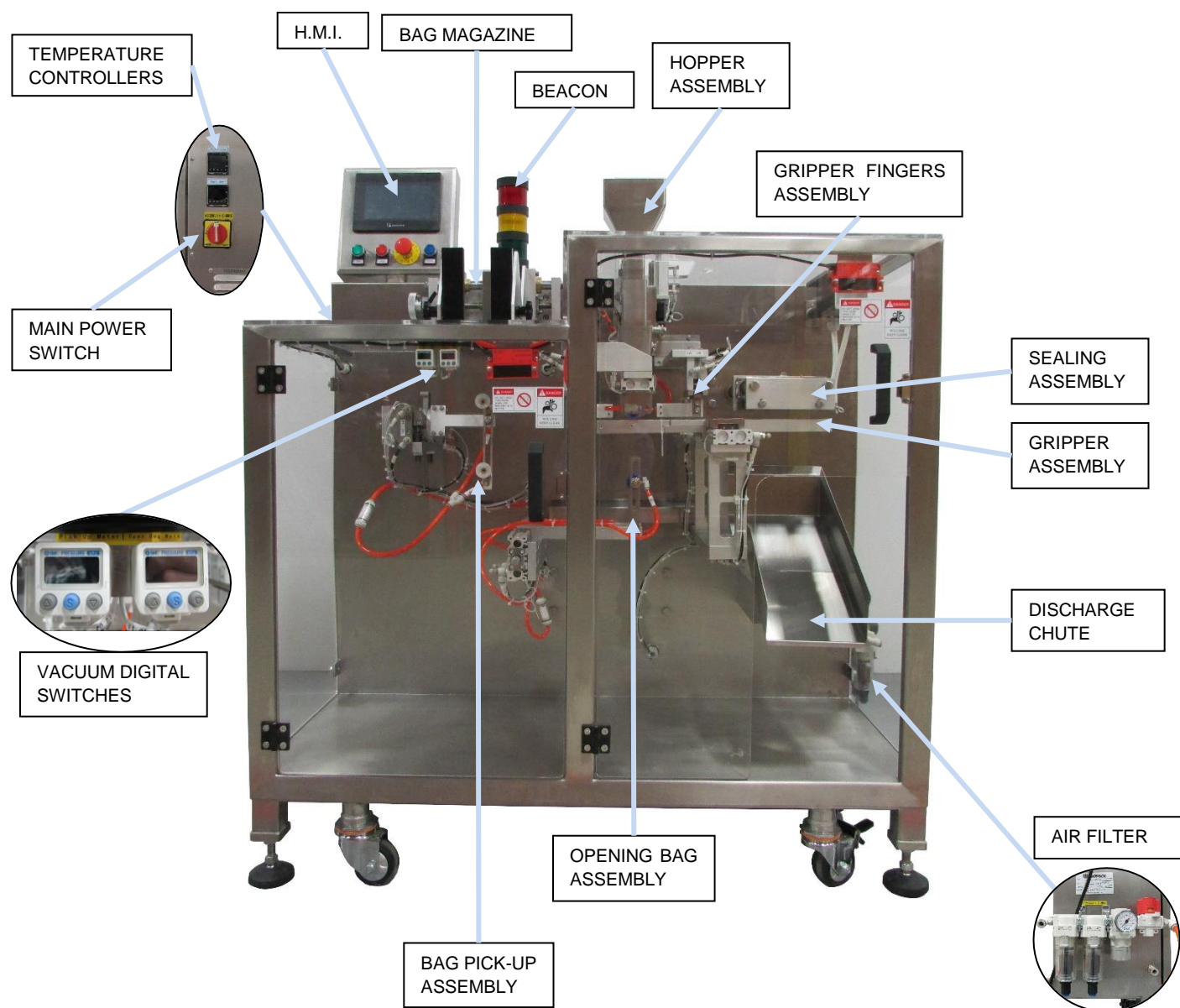
To Adjust Air Pressure

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



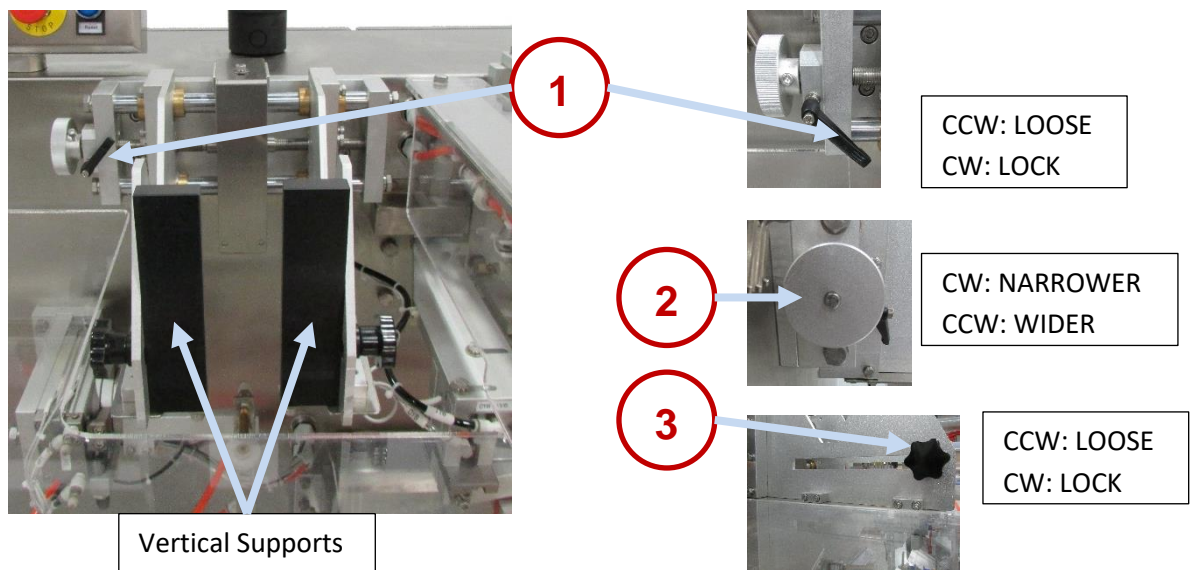
5. MECHANICAL ASSEMBLIES

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.

Bags must be centered on the magazine opening to ensure proper loading by the Bag Pick-Up Assembly.



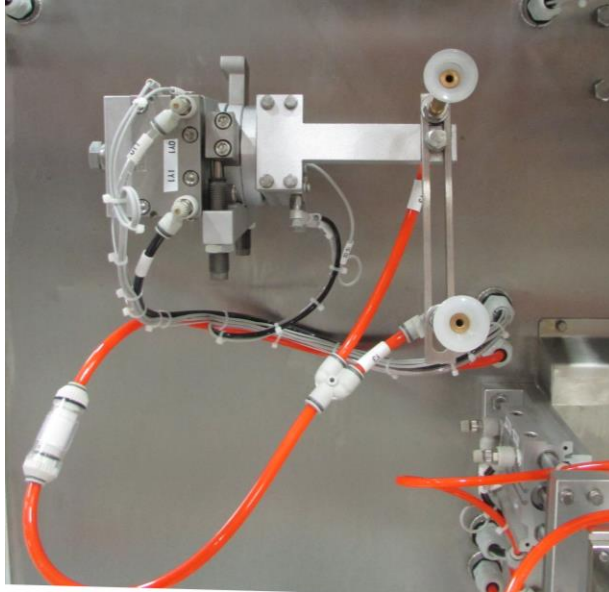
To adjust the width of the Bag Magazine to a new bag size, follow these steps:

1. Begin by loosening the Kipp handle to adjust the magazine width.
2. Adjust the magazine width and lock the Kipp handle.
3. Loose the Bag Magazine Vertical Supports knobs.

4. Slide the supports front/back to adjust for the bags size (leaving a 1/16" gap between the Bag and the supports).
5. Lock the Bag Magazine Vertical Supports knobs.

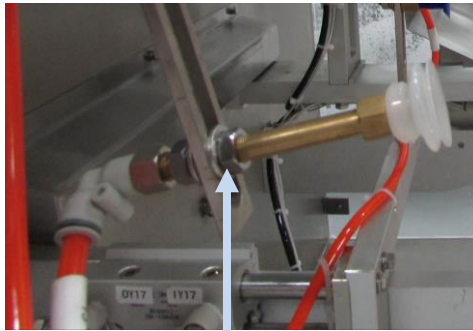
5.2 Bag Pick-Up Assembly

The Bag Pick-Up Assembly retrieves the bags from the Bag Magazine in preparation to position them under the Hopper Assembly for filling.



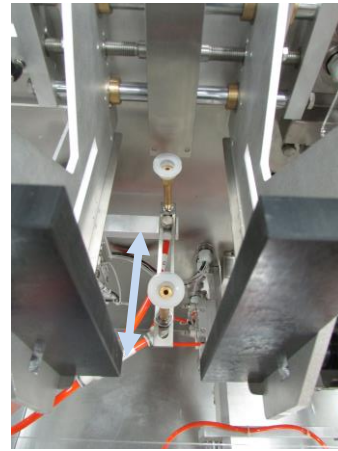
The bags are retrieved by means of suction cups mounted on a bar. Once the bag is retrieved, the bar rotates clockwise 90° and the Gripper Assembly takes hold of the bag advancing it towards the Bag Opening Assembly, where the bag is picked-up by the Gripper Fingers Assembly and another set of suction cups become in contact with the bag applying vacuum to the cups and pulling apart to open the bag.

Depending on the size of the bag, the bottom suction cup position may need to be adjusted:



CCW: LOOSE
CW: LOCK

SLIDE CUP AS
NEEDED



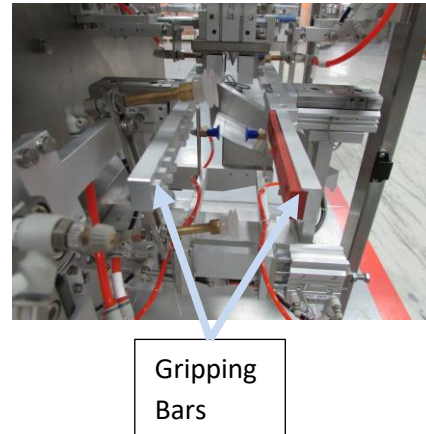
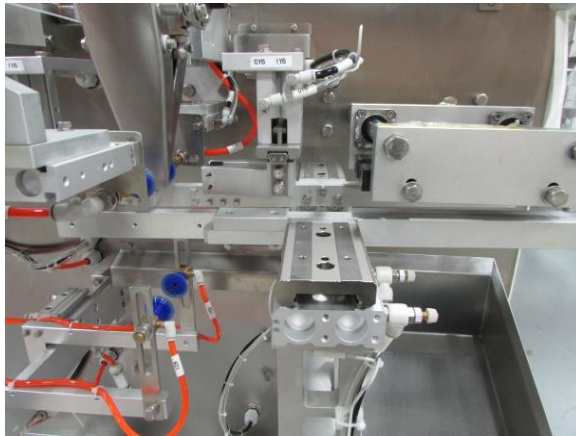
1. Loose the bottom cup securing nut.
2. Position the assembly for a bag pick-up.
3. Slide the cup front/back until position is satisfactory.
4. Secure the cup position.

The vacuum setting is adjusted by means of the Pick Up Meter situated in front of the machine.

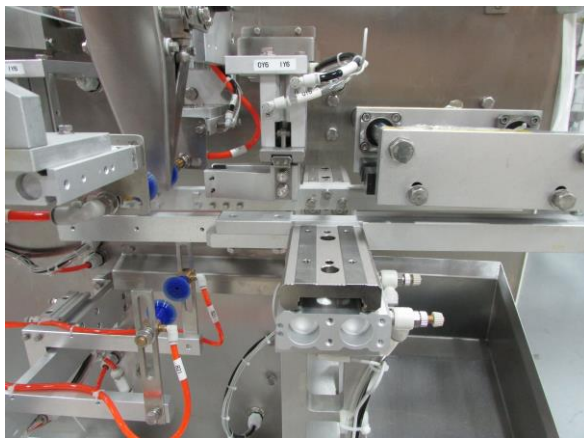


5.3 Gripper Assembly

The Gripper Assembly gets hold of bags from both the Bag Pick-Up and the Bag Opening Assemblies and transports them sideways inside the machine by means of a servomotor.



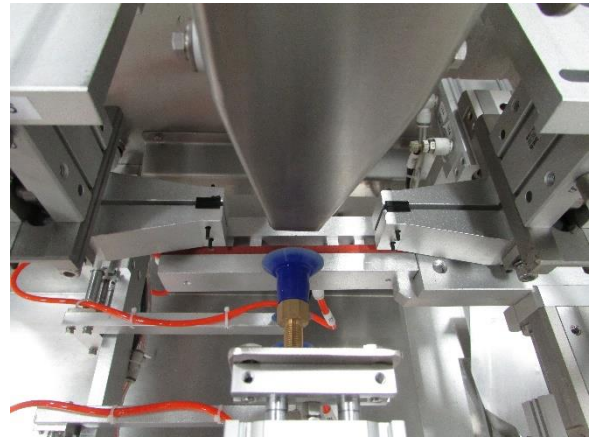
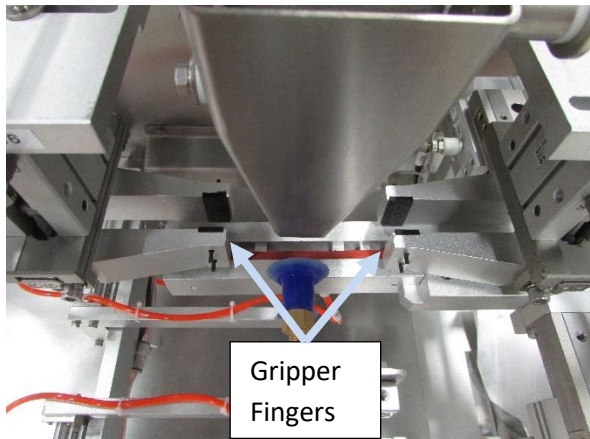
Four pneumatic cylinders advance the gripping bars to get hold of the bags at the Bag Pick-Up (new bag) and Bag Opening (filled bag) assemblies at the end of the filling cycle, and transports them sideways to the Bag Opening and Sealing assemblies respectively.



The Gripper Fingers and the Sealing assemblies take hold of the bags and the gripping bars retract, effectively releasing the bags.

5.4 Gripper Fingers Assembly

The Gripper Fingers Assembly gets hold of the bag during the filling process.



Two pneumatic cylinders advance the grippers to get hold of the sides of the bag. At the end of the filling cycle, the gripper assembly picks-up a new bag and the bag that just filled, the Gripper Fingers release the bag's sides, the bags are advanced towards the right, the bag is sealed and then dropped onto the exit chute. The Gripper Fingers adjust to accommodate a variety of bags as the recipes are loaded into the H.M.I.

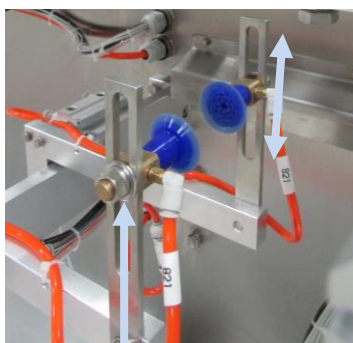
5.5 Opening Bag Assembly

The Opening Bag Assembly opens the bag while it is under the Hopper Assembly for the filling process to start.



The Griper Assembly positions the bag under the Hopper Assembly, the Gripper Fingers Assembly take hold of the bag, the suction cups are put into contact with the bag, vacuum is applied to the suction cups, at which point both sets retract effectively opening the bag.

Depending on the size of the bag, the bottom suction cups position may need to be adjusted (adjust one cup at a time):



SLIDE CUP AS
NEEDED

CCW: LOOSE
CW: LOCK

1. Position a bag under the Hopper Assembly.

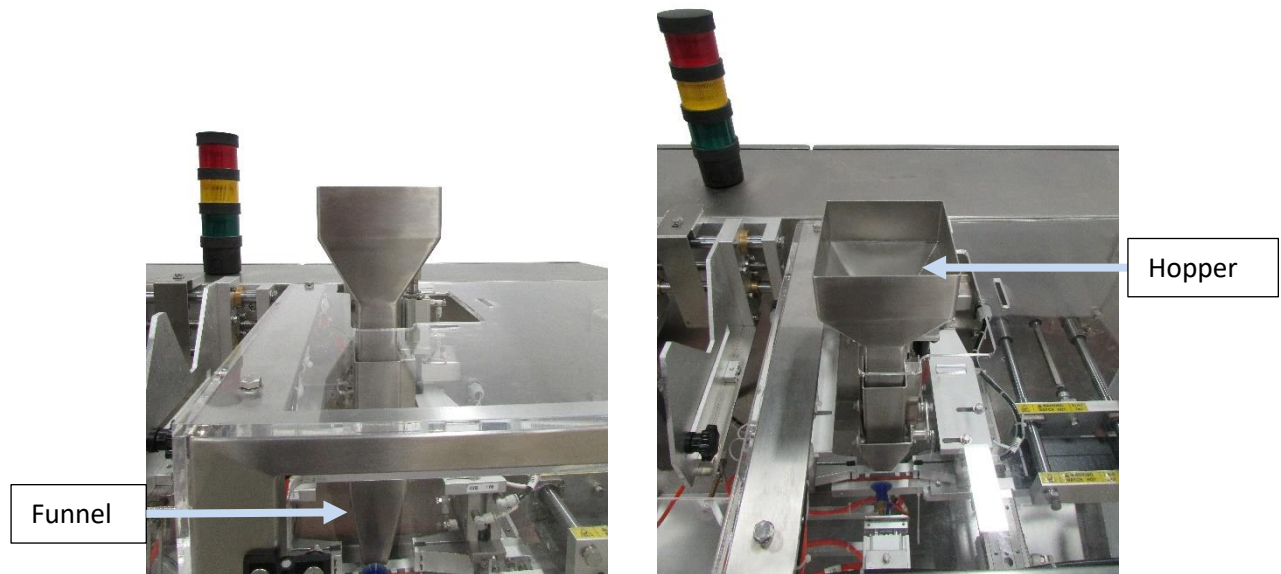
2. Loose the bottom cup securing nut.
3. Slide the cup up/down until position is satisfactory.
4. Secure the cup position.

The vacuum setting is adjusted by means of the Open Bag Meter situated in front of the machine.



5.6 Hopper Assembly

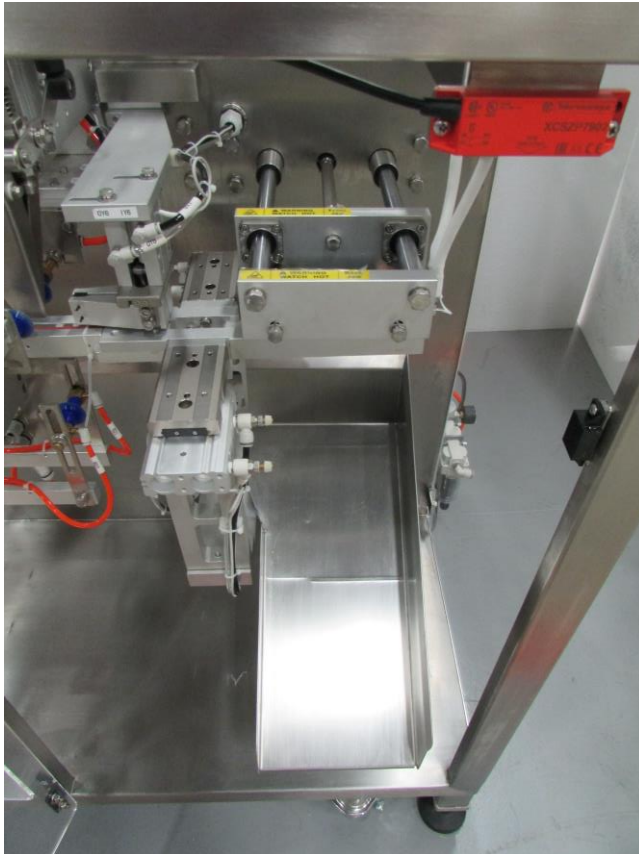
The Hopper Assembly consists of the hopper itself and a funnel that is plunged inside the bag.



The hopper guides the product into the funnel. At the right time, the assembly is lowered, plunging the funnel inside the bag, and the funnel is opened to allow the dumping of the product. Then the funnel is then closed and the hole assembly is risen to clear the opening of the bag in preparation of the sealing process.

5.7 Sealing Assembly

The Sealing Assembly consists of a pair of heating jaws that press together the front and back sides of the bag while applying heat. This process completes the filling cycle of the machine.

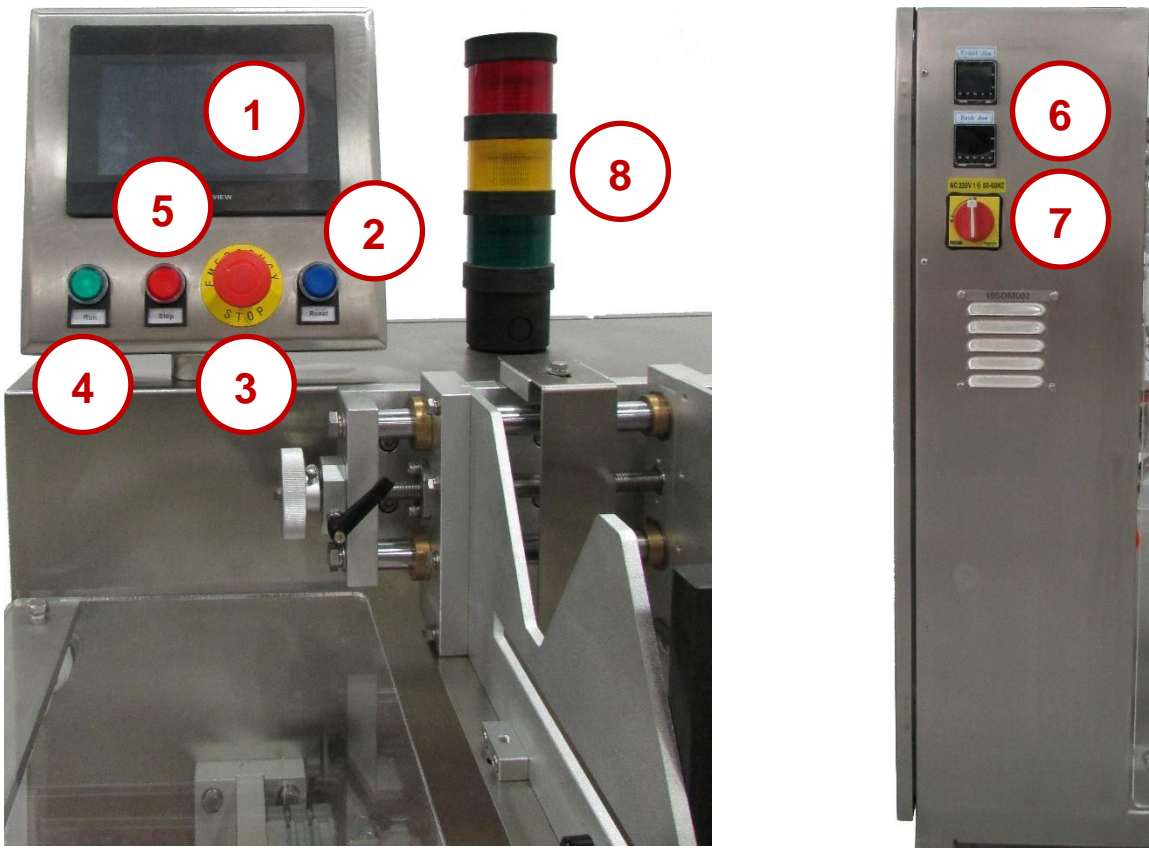


The Gripper Assembly transports the filled bag in between the jaws, the front and back heating jaws are pressed together while applying heat to the bag's opening. Once the sealing of the bag is achieved, the jaws are withdrawn, the Gripper Assembly releases the bag, and the bag is discharged onto the exit chute.

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 Swiftly Mini Bagger is equipped with a 7" TFT color graphic touchscreen that is used to input variable data and to control the machine.
2	Reset Button	The reset button is used to restore the MCR (Master Control Relay) immediately after an Emergency Stop.

CONTROL PANEL

Item	Description	
3	Emergency Stop Button	The Emergency Stop button is used to bring the machine to a total stop in case a dangerous situation arises.
4	Start Button	Press to start cycling the bagger.
5	Stop Button	Press to stop cycling the bagger. The machine will finish the current cycle before coming to a total stop.
6	Temperature Controllers	These controllers are used to set-up the jaws temperature.
7	Power Switch	Use this switch to turn the machine ON/OFF .
8	Beacon	The beacon indicates the actual state of the machine (Section Error! Reference source not found.).

6.1.1 TEMPERATURE CONTROLLERS

The Temperature Controllers are located on the left side panel, on top of the Power Switch; the operator will note that there are two controllers in this location. These controls are responsible for the temperature of the Hot Jaws in the Sealing Assembly.

The **TOP** temperature controller controls the **FRONT JAW**. whereas the **BOTTOM** controller controls the **BACK JAW**.



TEMPERATURE CONTROLLER

Item	Description
------	-------------

TEMPERATURE CONTROLLER

Item	Description	
1	Toggle START / STOP	Press to START / STOP the controller: Turn Heater ON: 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. Turn Heater OFF: Press the toggle button and then 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.
2	Decrease Temperature	Press to decrease the temperature by 1° Celsius.
3	Increase Temperature	Press to increase the temperature by 1° Celsius.
4	Present Value	Displays the actual temperature value.
5	Set Value	Displays the temperature set-point value

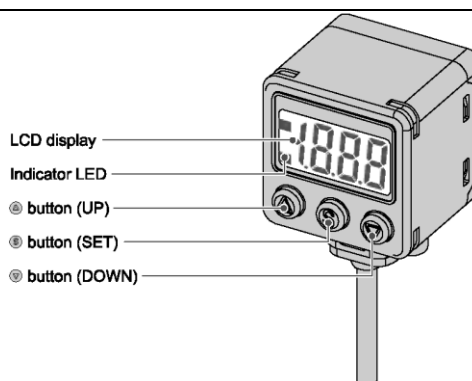
6.1.2 VACUUM SWITCH DESCRIPTION

The Vacuum Switches are located on the front of the machine, just behind the front guard; the operator will note that there are two switches in this location. These switches are responsible for the vacuum setting of the Bag Pick-Up and Opening Bag assemblies.

The **LEFT** switch senses the **BAG PICK-UP** vacuum, whereas the **RIGHT** switch senses the **OPENING BAG** vacuum.

VACUUM DIGITAL SWITCH

Item	Description
Orange LED	Displays the switch output condition.
LCD Display	Displays the current pressure, setting mode, and error code.
Arrow (UP)	Selects the mode or increases the set value.
Button (SET)	To change to either mode and to set a value.
Arrow (DOWN)	Selects the mode or decreases the set value.



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 8.2** for a more detailed description.

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.

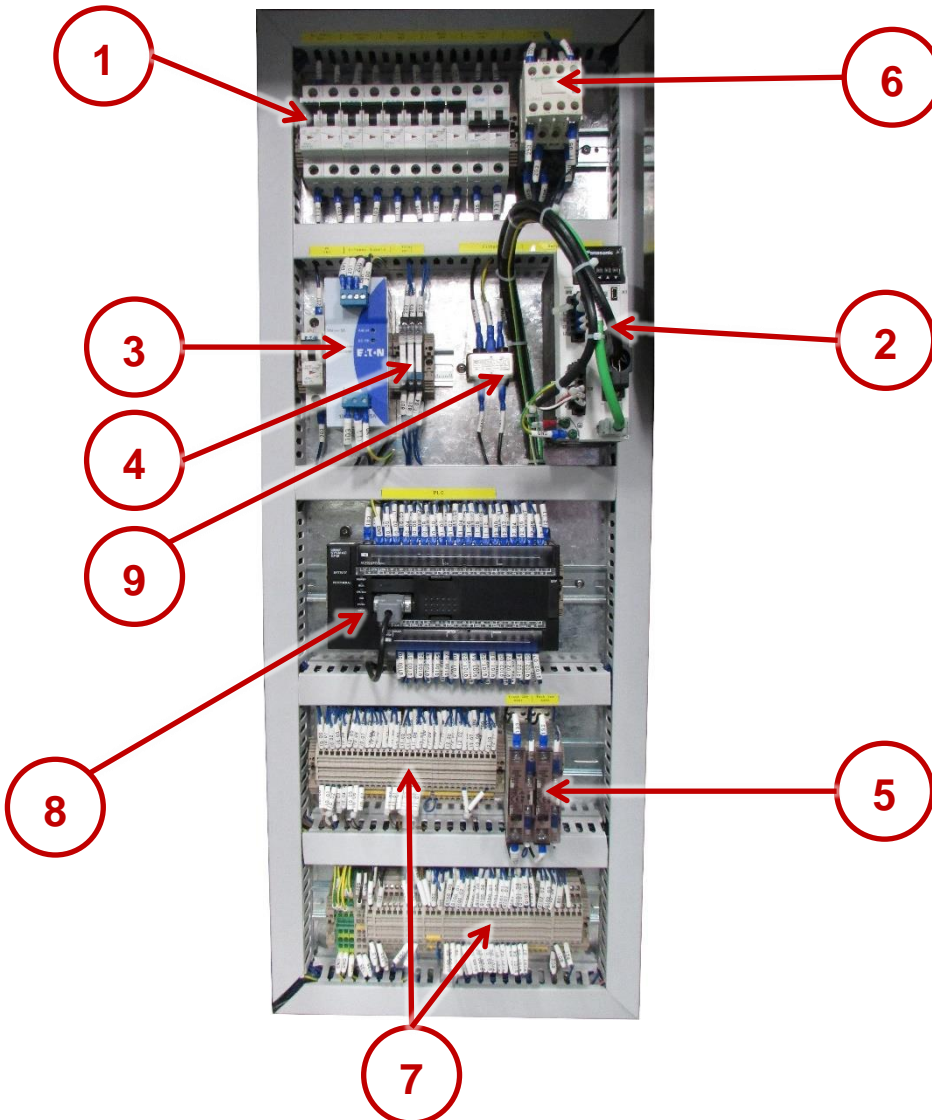
Immediately following the use of the Emergency Stop button, the operator may also need to halt the functions of any auxiliary machinery feeding the bagger.

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 “MCR Enabled” Button to reactivate the machine. The machine should now be ready to run.

6.2 Control Box Interior

ELECTRICAL COMPONENTS

Item	Description
1	Breakers
2	Servo Drive
3	Power Supply
4	Control Relay
5	Solid State Relays
6	Master Control Relay (MCR)
7	Terminal Block
8	Programmable Logic Controller (PLC)
9	E.M.I. Filter

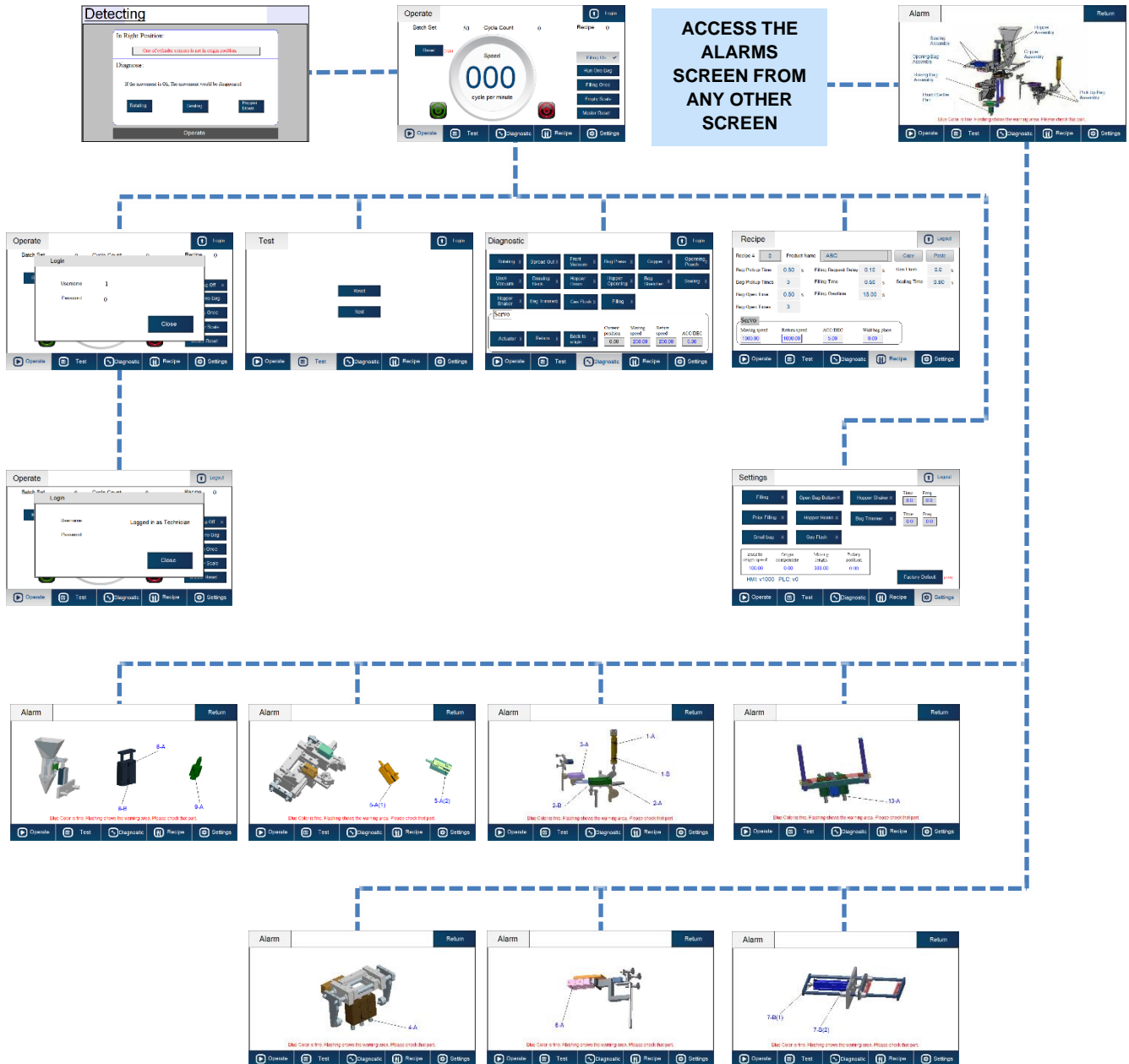


6.3 Electrical Schematics

For detailed Electrical Schematics, please see attached Appendix A.

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

7.1 Screen Layout

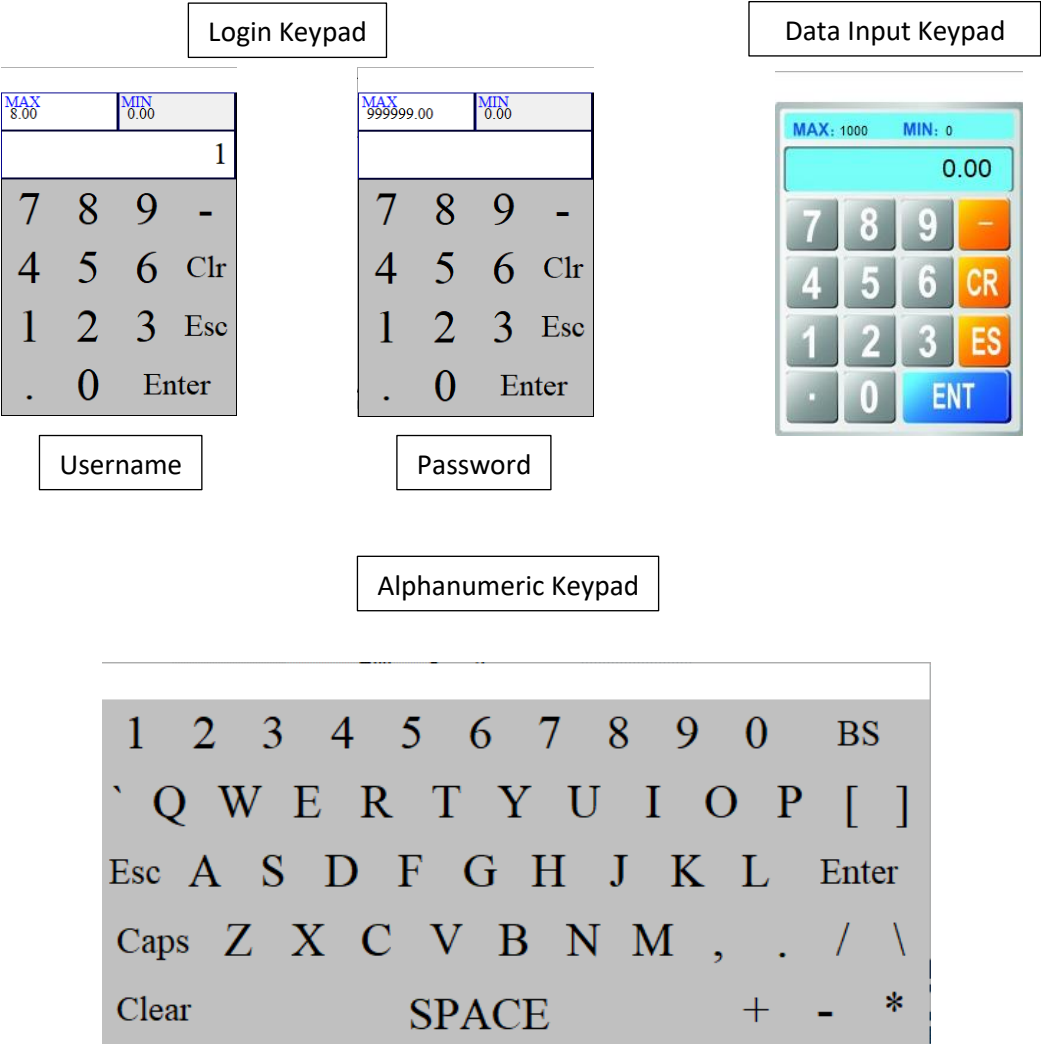


7.2 Screen Description

7.2.1 NUMERIC AND ALPHANUMERIC KEYPADS.

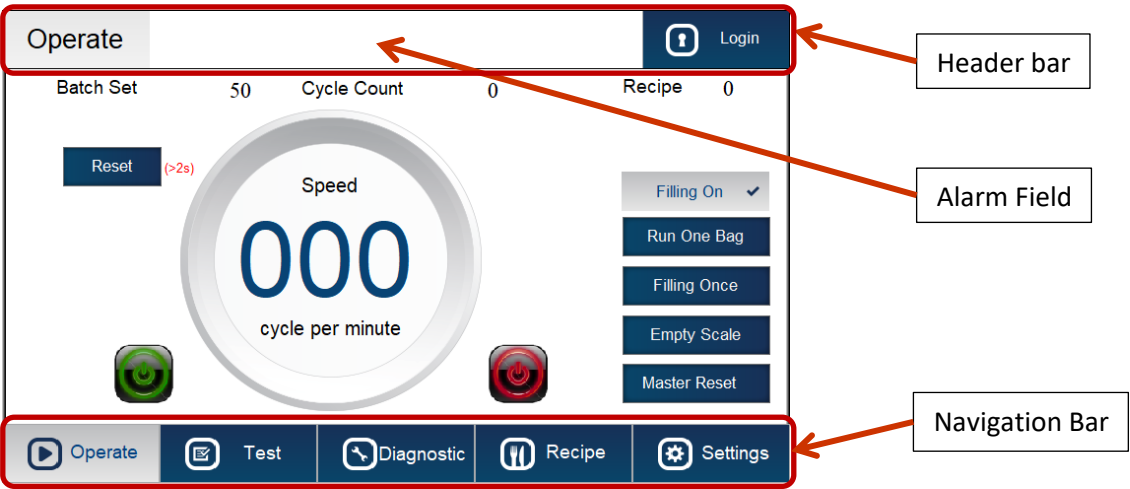
These pads pop-up when entering data values or to type the name of a recipe.

The numeric keypads indicate the minimum and maximum values available for the variable.



7.2.2 HEADER AND NAVIGATION BARS

The Header and Navigation bars are common to all screens



Header Bar

The top of the screen displays the **HEADER BAR**: The name of the selected menu and the Alarm Field and Login button that can be accessed at any time in any screen. These components will always be displayed.



HEADER BAR	
Item	Description
Alarm Field	Displays the system's alarm messages. Tap to access the ALARM screen (page 7-17) where the operator can access the different assemblies alarm screens.
Login	Tap to access the LOGIN screen where the operator can enter their password to access locked screens of the H.M.I. The button description turns to LOGOUT once an operator has logged in.

Navigation Bar

The bottom of the screen displays the **NAVIGATION BAR**: The Operate, Test, Diagnostic, and Recipe buttons that can be accessed at any time in any screen. These buttons will always be displayed, unless entering a submenu.



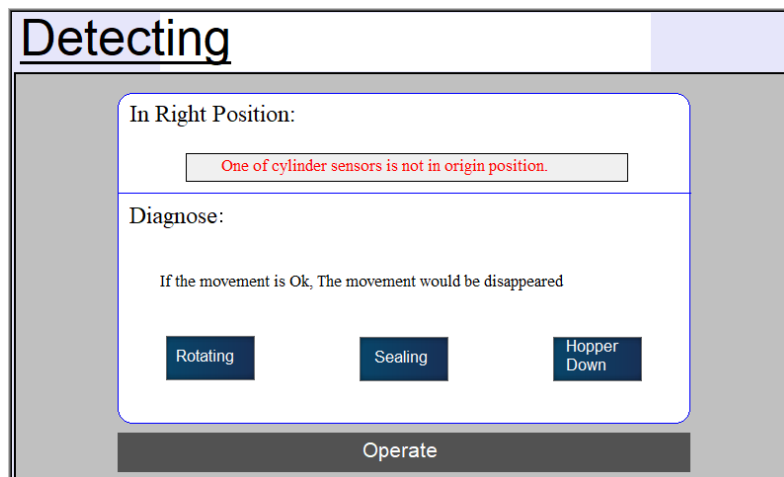
NAVIGATION BAR	
Item	Description
Operate	Tap to access the OPERATE screen (page 7-7).
Test	Tap to access the TEST screen (page 7-9).
Diagnostic	Tap to access the DIAGNOSTIC screen (page 7-10).
Recipe	Tap to access the RECIPE screen (page 7-13).
Settings	Tap to access the SETTINGS screen (page 7-15).

7.3 Menu Description

The following paragraphs provide descriptions for the different screens displayed in the system's H.M.I.

7.3.1 DETECTING SCREEN

When the bagger is first powered **ON**, the **DETECTING** screen appears, indicating it is detecting the position of different cylinders sensors.



The three buttons at the bottom are colored dark blue with white lettering by default and turn light gray with blue lettering when taped on.

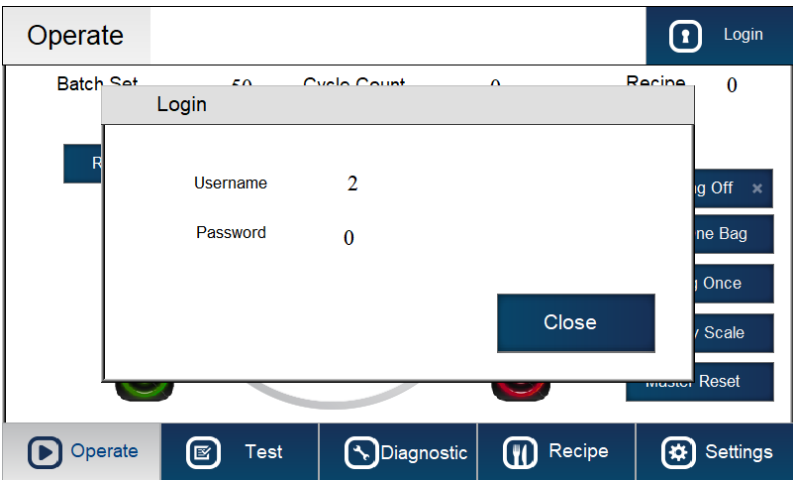
These buttons are used to home the Bag Pickup assembly, the Sealing assembly, and the Hopper assembly cylinders. These assemblies must first be homed before normal operation can be attempted.

Tap and hold until the button disappears (at this point, the assembly is already at its home position). Once all the assemblies have been homed, tap the **OPERATE** bar to proceed to the Operate screen.

7.3.1 LOGIN

The Login button is available through all the screens. 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.

Once the user has logged in, the name of the user appears on this screen.



LOGIN

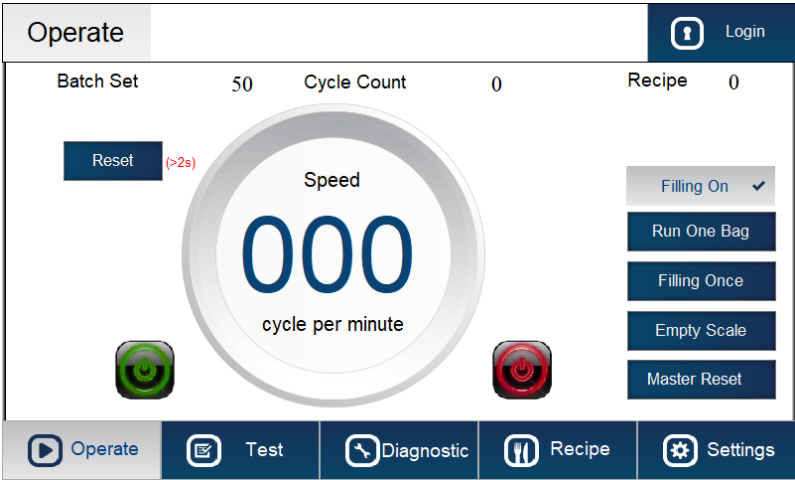
Item	Description
Username	Tap the field to enter the username. A numeric keypad pops-up. User names range from 0 to 7.
Password	Tap the field to enter the user's password. A numeric keypad pops-up. The password is displayed at the screen. Passwords range from 0 to 999999 (the password is provided to the client during commissioning of the machine).
Close	Tap to exit the login screen and go back to the previous screen.

7.3.2 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.

An alarm will display if there is a malfunction with the bagger, such as a jam. The machine must be inspected and the alarm reset before the bagger can be restarted.



The alarm must be manually reset in the H.M.I, except when the E-Stop button is pressed.



OPERATE SCREEN

Item	Description
Batch Set	Tap to enter the number of bags in a batch Value ranges from 0 to 100000000, in steps of 1 bag. The machine will stop when the value is reached. A value of 0 means non-stopping production. [Tap the number field to enter a value]
Cycle Count	Displays the number of cycles (bags produced) in a given production run.
Recipe	Displays the number of the Recipe that is presently loaded. Entering a value will load another recipe. [Tap the number field to enter a value]
Reset	Tap to reset the Cycle Counter to 0. The Cycle Count can be reset at any time.
Speed	Displays the average number of bags per minute for the current production run.

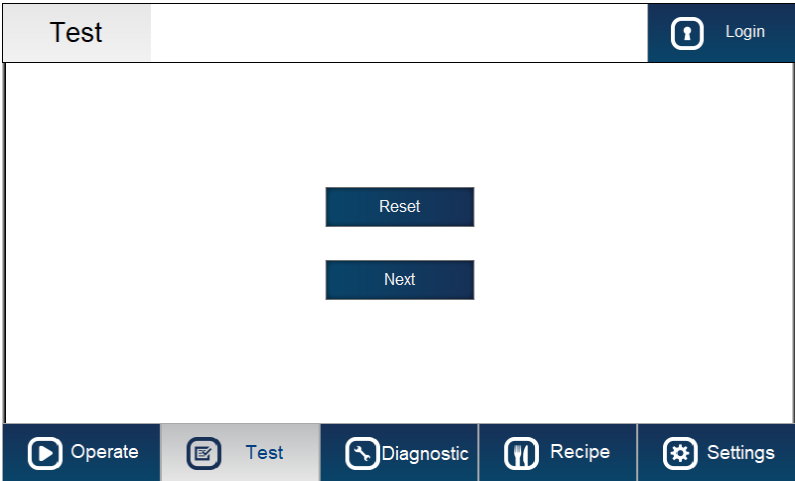
OPERATE SCREEN

Start () /Stop ()	<p>Taping the start button will automatically cycle the bagger.</p> <p>Taping the stop button will stop cycling the bagger. The machine will finish the current cycle before coming to a total stop.</p>
Filling ON	Tap to ENABLE / DISABLE the filling.
Run One Bag	Tap to command the execution of one filling cycle just to form a bag.
Filling Once	Tap to command the execution of one filling cycle.
Empty Scale	Tap to command the evacuation of all the product in the scale and set the tare.
Master Reset	Tap to reset the Cycle Counter to 0 and reset all machine sequences, equivalent to turning the machine OFF then ON again.

7.3.3 TEST SCREEN

The Test screen allows the operator to run the bagger in a semi-automatic mode. In this mode, the machine can be tested in a controlled manner.

The test is performed to fill and seal one bag only. The cycles will repeat for as long as the user keeps tapping the **NEXT** button.



TEST SCREEN	
Item	Description
Reset	Tap to stop the machine and reset the machine to the first step in the filling cycle.
Next	Tap to advance one step forward in the filling cycle.

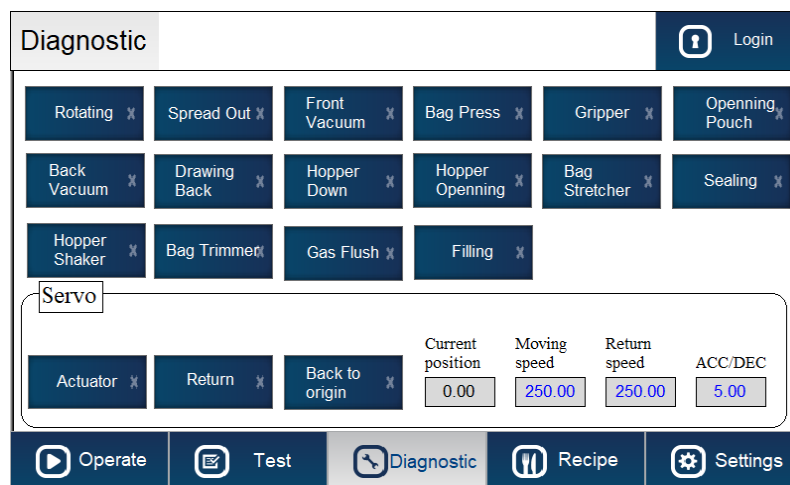
7.3.4 DIAGNOSTIC SCREEN

The Diagnostic screen allows the operator to manually activate the machine's functions. Each function is activated when its button is tapped. An active function will become light gray with blue lettering and will display a blue check mark, while deactivated functions are dark blue with white lettering. Tap an active function to deactivate it.

It is useful for testing the speed of pneumatic actuators and adjusting their speed controls located on each actuator. It is also useful for troubleshooting and maximizing the speed of the machine.

Some of the following features may not be included on all bagging machines.

Some baggers will come with additional functions that the software is designed to control. If the bagger does not perform these functions, the label for that component will be left greyed out.



DIAGNOSTIC SCREEN

Item	Description
Rotating	Tap to rotate the Bag Pick-Up assembly in either direction (up/down).
Spread Out	Tap to command the extension of the Bag Pick-Up Assembly's vacuum cups. Tap again to retract them
Front Vacuum	Tap to activate the vacuum in the Bag Pick-Up Assembly's cups. Tap again to shut it off.
Bag Press	Tap to command the closing of the Gripper Assembly's gripping bars. Tap again to open them.
Gripper	Tap to command the closing of the Gripper Fingers Assembly's fingers. Tap again to open them.
Opening Pouch	Tap to command the extension of the Opening Bag Assembly's back and front suction cups. Tap again to retract them.
Back Vacuum	Tap to activate the vacuum in the Opening Bag Assembly's back and front cups. Tap again to shut it off.
Drawing Back	Tap to close in the Gripper Fingers Assembly's fingers. Tap again to bring them back to their home position.
Hopper Down	Tap to lower the hopper. Tap again to raise it.
Hopper Opening	Tap to open the hopper's funnel. Tap again to close it.
Bag Stretcher	Tap to separate further the Gripper Fingers Assembly's fingers. Tap again to bring them back to their home position.
Sealing	Tap to command the closing of the Sealing Assembly's jaws. Tap again to open them.
Hopper Shaker	Tap to start the hopper shaker. Hopper will shake for 3 seconds.
Bag Trimmer	Tap to active the bag trimmer
Gas Flush	Tap to purge the oxygen from a bag by filling the bag with an inert gas.
Filling	Tap to command one filling sequence.
SERVO	
Actuator	Tap command the displacement of the Gripper Assembly towards the Bag Pick-Up Assembly. Short taps produce short movements. Continuous taping moves the actuator all the way.
Return	Tap command the displacement of the Gripper Assembly towards the Sealing Assembly. Short taps produce short movements. Continuous taping moves the actuator all the way.
Back to Origin	Tap command the displacement of the Gripper Assembly to its home position (underneath the Sealing Assembly).

DIAGNOSTIC SCREEN

Item	Description
Current Position	Displays the current speed
Moving Speed	Tap to enter the Pickup assembly moving speed
Return Speed	Tap to enter the Pickup assembly return speed
Acceleration / Deceleration	Tap to enter the ACCELERATION / DECELERATION speed.

7.3.5 RECIPE SCREEN

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

A recipe is the program of the bagger's settings for a particular bag. Several variables are available to configure the machine's recipe, and up to 20 recipes can be stored in the P.L.C. memory.

Tap the **Save** button to save the changes made to the recipe.

The screenshot shows the 'Recipe' screen with the following elements:

- Recipe #**: Input field with value 0.
- Product Name**: Input field.
- Copy** and **Paste** buttons.
- Bag Pickup Time**: 0.00 s
- Filling Request Delay**: 0.00 s
- Gas Flush**: 0.0 s
- Bag Pickup Times**: 0
- Filling Time**: 0.00 s
- Sealing Time**: 0.00 s
- Bag Open Time**: 0.00 s
- Filling Overtime**: 0.00 s
- Bag Open Times**: 0
- Servo** section:
 - Moving speed**: 0.00
 - Return speed**: 0.00
 - ACC/DEC**: 0.00
 - Bag waiting position**: 0.00
- Bottom navigation bar: **Operate**, **Test**, **Diagnostic**, **Recipe** (active), **Settings**.

RECIPE SCREEN

Item	Description
Recipe #	Tap the field to enter the number of the recipe to be configured. Recipes are numbered 0 through 7.
Product Name	Tap to enter the product's name associated with the recipe #.
Copy	Tap this button to copy the recipe.
Paste	Tap this button to paste copied data to a new recipe.
Bag Pickup Time	Tap to enter, in seconds the time it will take the bagger to pick up a bag from the dispensing magazine.
Bag Pickup Times	Tap to enter the number of attempts the bagger will try to pick up a bag after which it will stop.
Bag Open Time	Tap to enter, in seconds the time the bag must remain opened for filling.
Bag Open Times	Tap to enter the number of attempts the bagger will try to open the bag after which it will stop.

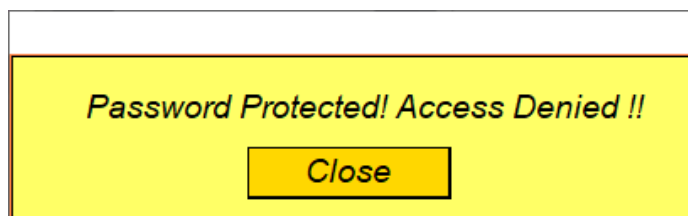
RECIPE SCREEN

Filling Request Delay	Tap to enter, in seconds the time the hopper must remain opened after a filling sequence.
Filling Time	Tap to enter, in seconds the time the hopper is open for product dispensing. This timing varies for all programs and is based on bag size. The more product volume there is to dump, the more time the hopper will need to be open. Different product types may require different Hopper Open Time.
Filling Overtime	This time is used to force the machine to stop when the machine keeps opening the bag and waits for the Filler to fill. E.g. if you set 20s, then the machine will stop and a warning message "Filling Overtime" will be displayed as the machine waits for the filler for 20s.
Gas Flush	Tap to enter, in seconds the time needed to purge the oxygen from a bag by filling the bag with an inert gas.
Sealing Time	Tap to enter, in seconds the time it will take the Sealing Assembly to seal the bag.

SERVO

Moving Speed	Tap to enter the Pickup assembly moving speed
Return Speed	Tap to enter the Pickup assembly return speed
Acceleration / Deceleration	Tap to enter the ACCELERATION / DECELERATION speed.
Bag Waiting Position	Tap to enter the Gripper Assembly position to wait, while a bag is filling up, to grab a new bag from the Bag Pick-Up Assembly.

If no user has logged in, a pop-up window displays indicating access to the screen is denied.



7.3.6 SYSTEM SETTINGS SCREEN

The System screen allows updates to the H.M.I. software to represent the features particular to the model of bagger.



ONLY QUALIFIED TECHNICAL PERSONNEL SHOULD ALTER SYSTEMS SETTINGS.

Settings

Logout

Filling ✕

Open Bag Bottom ✕

Hopper Shaker ✕

Time 0.0

Freq 0.0

Prior Filling ✕

Hopper Beaks ✕

Bag Trimmer ✕

Time 0.0

Freq 0.0

Small bag ✕

Gas Flush ✕

Back to origin speed 100.00

Origin compensate 0.00

Moving length 300.00

Rotary position 0.00

HMI: v1000 PLC: v0

Factory Default (>3s)

Operate

Test

Diagnostic

Recipe

Settings

SYSTEM SETTINGS

Item	Description
Filling	Tap to ENABLE / DISABLE the filling.
Open Bag Bottom	Tap to ENABLE / DISABLE the bottom suction cups in the Bag Pick Up and in the Opening Bag assemblies.
Hopper Shaker	Tap to ENABLE / DISABLE the Hopper Shaker option. When ENABLED , set the TIME (in seconds) that the Shaker must be active and the FREQUENCY (in Hertz) at which the Shaker must vibrate every filling cycle. [Tap the number field to enter a value]
Prior Filling	Tap to ENABLE / DISABLE the Prior Filling option.
Hopper Beaks	Tap to OPEN / CLOSE the Hopper Beaks.
Bag Trimmer	Tap to ENABLE / DISABLE the Bag Trimmer option. When ENABLED , set the TIME (in seconds) that the Trimmer must be active and the FREQUENCY (in Hertz) at which the Trimmer must vibrate every filling cycle. [Tap the number field to enter a value]
Small Bag	Tap to indicate a small bag will be filled on.
Gas Flush	Tap to ENABLE / DISABLE the Gas Flush option.

SYSTEM SETTINGS

Back to Origin Speed	Tap to set the speed at which the machine assemblies must go to their home position
Origin Compensate	Tap to set the home position offset.
Moving Length	Tap to enter the distance the Gripper Assembly must travel.
Rotary Position	Tap to enter home position for the Bag Pickup assembly before rotation is started.
Factory Default	Tap to revert to the factory settings.
HMI	Displays the HMI program version.
PLC	Displays the PLC program version.

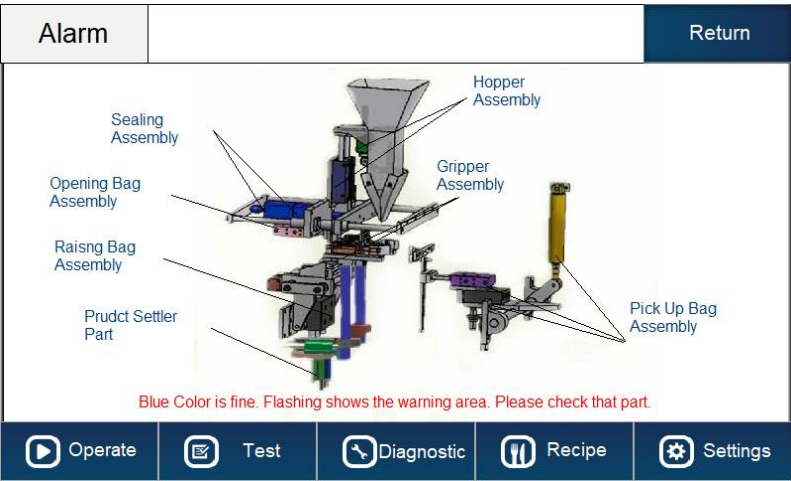
7.3.7 ACTIVE ALARM SCREEN

This window is accessed by tapping the **ALARM FIELD** on the **HEADER BAR** (Section 7.2.2).

Alarm messages always display in red color on this field and must be attended immediately.

Tapping on the assemblies’ description on the screen opens its respective description screen.

Tap any of the menus on the **NAVIGATION BAR** to exit this screen.



ACTIVE ALARMS	
Item	Description
Return	Tap to go back to the previous screen.

For a description of the alarms and how to treat them, please refer to **Section 8.2**.

8. MACHINE OPERATION

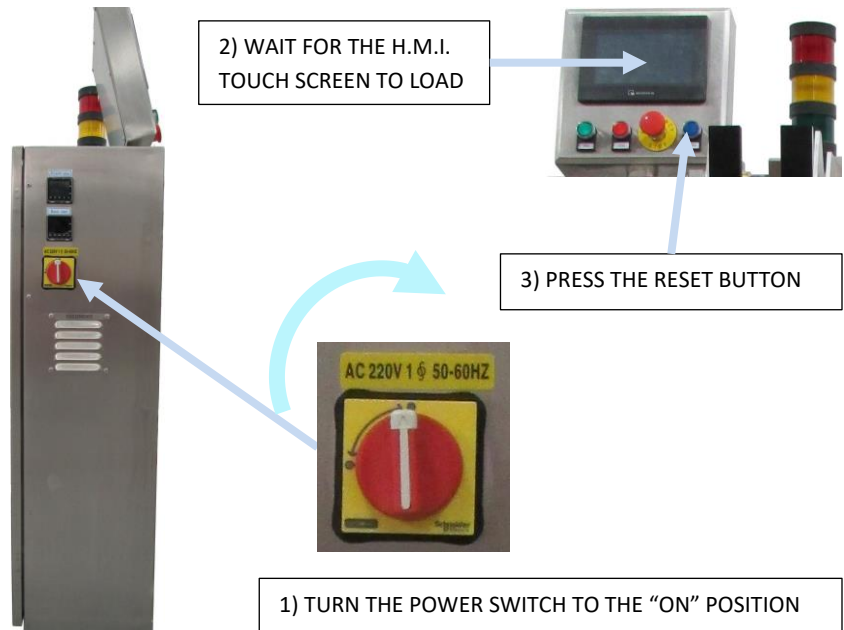
8.1 Starting the Machine



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

Follow the steps bellow:

1. Locate the Power Switch on the Control Box. Turn the Power Switch to the "ON" position. It will take a few seconds for the H.M.I. Touch Screen to power up.
2. Once the H.M.I. screen has loaded, home all three major assemblies (**SECTION 7.3.1**).



3. Navigate to the H.M.I.'s Operate Screen. Login and setup the bagger's settings by ensuring that the machine is loaded with the correct Recipe.
4. Press the **RESET** blue button (**M.C.R.**).
5. Allow time for the Heating Elements to reach their set points. The Temperature of the Front and Back Sealing Jaws are displayed on the Temperature Controllers.
6. Either tap the green **"Start"** button on the **OPERATE SCREEN** or press the **"Start"** button on the **panel** to begin the bagging process. The bagging process will repeat until the operator either taps the red **"Stop"** button on the **OPERATE SCREEN**, presses the **"Stop"** button on the **panel**, or the Cycle Count has reached the Batch Set.
7. 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 and servos will immediately stop.

8. To resume using the machine: resolve any issues with the machine, close all covers, pull out the Emergency Stop Button and press the **RESET** blue button.

8.2 Machine Status

The beacon indicates the actual status of the machine:

MACHINE STATUS	
Beacon	Description
Red Light	Lights-up to indicate the machine is stopped and ready to be run.
Yellow Light	Lights-up to indicate an alarm has been triggered.
Green Light	Lights-up to indicate the machine is running. Blinks when performing a cycle STOP. Blinks when running a One Bag cycle.

8.3 Alarms

Alarms display on all the screens available to the user on the H.M.I. They display on the Alarm field in the Header Bar (**SECTION 7.2.2**).

Click on the Alarm Field and open the Assembly screen by right-clicking on its name (the name you click on depends on the alarm message).

A message at the bottom of the screen, over the **NAVIGATION BAR** guides you to the possible faulty component.

Alarm	Description	Solution
BAG PICK-UP		
Actuator No Bag Alarm	The Bag Pick-Up Assembly has tried to pick-up a bag without success.	<ul style="list-style-type: none"> - Check the Bag Pick-Up Assembly is attempting to pick-up a bag. - Check the Bag Pick-Up Assembly has vacuum applied to the cups. - Clear the alarm. - Push the green RESET button and resume normal operation.
IY1, Rotating Back Error	The Bag Pick Up Assembly was not detected at its home position	<ul style="list-style-type: none"> - Check that nothing is blocking the Bag Pick Up Assembly movement. - Check the Bag Pick Up Assembly pneumatics. - Clear the alarm. - Push the green RESET button and resume normal operation.
IY5, Spread Back Error	The Bag Pick Up Assembly was not detected to spread the vacuum cups	<ul style="list-style-type: none"> - Check that nothing is blocking the Bag Pick Up Assembly cups cylinders movement. - Check the Bag Pick Up Assembly pneumatics. - Clear the alarm. - Push the green RESET button and resume normal operation.
HOPPER		
IY6, Gripper Back Error	The Gripper Fingers did not open.	<ul style="list-style-type: none"> - Check the Gripper Finger Assembly's pneumatic mechanism. - Check nothing is blocking the Gripper Fingers preventing them from opening. - Check the machine's pneumatics. - Clear the alarm. - Push the green RESET button and resume normal operation.

Alarm	Description	Solution
IY12, Hopper Down Back Error	The hopper was not detected to descend.	<ul style="list-style-type: none"> - Check the Hopper Assembly's pneumatic mechanism. - Check nothing is blocking the Hopper preventing it from descending. - Check the machine's pneumatics. - Clear the alarm. - Push the green RESET button and resume normal operation.
IY13, Hopper Opening Back Error	The Hopper Funnel was not detected opened.	<ul style="list-style-type: none"> - Check the Hopper Assembly's pneumatic mechanism. - Check nothing is blocking the Hopper Funnel preventing it from opening. - Check the machine's pneumatics. - Clear the alarm. - Push the green RESET button and resume normal operation.
Hopper Down Failure	The Hopper didn't descend	<ul style="list-style-type: none"> - Check nothing is blocking the movement. - Check the Hopper Assembly pneumatics. - Clear the alarm. - Push the green RESET button and resume normal operation.
Hopper is inserting out of the bag	The Hopper is missing the bag opening.	<ul style="list-style-type: none"> - Make sure the bag is opened beneath the hopper. - Clear the alarm. - Push the green RESET button and resume normal operation.
GRIPPER		
IY4, Bag Holder Back Error	The Gripper Bars were not detected to have extended.	<ul style="list-style-type: none"> - Check the Gripper Assembly's pneumatic mechanism. - Check nothing is blocking the Gripper Bars preventing them from closing. - Check the machine's pneumatics. - Clear the alarm. - Push the green RESET button and resume normal operation.
OPENING BAG		
IY7, Open Bag Back Error	The Opening Top Bag Suction Cups were not detected to have been closed.	<ul style="list-style-type: none"> - Check the Opening Bag Assembly's pneumatic mechanism. - Check nothing is blocking the Suction Cups movement. - Check the machine's pneumatics. - Clear the alarm. - Push the green RESET button and resume normal operation.

Alarm	Description	Solution
IY17, Open Bag Bottom Back Error	The Opening Bag Bottom Suction Cups were not detected to have been closed.	<ul style="list-style-type: none"> - Check the Opening Bag Assembly's pneumatic mechanism. - Check nothing is blocking the Suction Cups movement. - Check the machine's pneumatics. - Clear the alarm. - Push the green RESET button and resume normal operation.
JAWS		
Temp Of Back Jaw Over than Setting	The back-jaw temperature is over the setpoint.	<ul style="list-style-type: none"> - Check the back-jaw temperature controller. - Clear the alarm. - Push the green RESET button and resume normal operation.
Temp Of Front Jaw Over than Setting	The front-jaw temperature is over the setpoint.	<ul style="list-style-type: none"> - Check the front-jaw temperature controller. - Clear the alarm. - Push the green RESET button and resume normal operation.
BAGGING		
No Bag in Magazine or Not Enough Vacuum	The Pick Up Assembly did not pick up a bag from the Magazine. Bag magazine is empty.	<ul style="list-style-type: none"> - Check the Pick Up Assembly is working properly (suction cups, pneumatics). - Refill the bag magazine. - Clear the alarm. - Push the green RESET button and resume normal operation.
IY15, Sealing Back Error	The back-jaw did not heat enough to properly seal the bag	<ul style="list-style-type: none"> - Check the back-jaw temperature controller. - Check the back-jaw heating element. - Clear the alarm. - Push the green RESET button and resume normal operation.
Sealing Failed	The bag did not seal properly	<ul style="list-style-type: none"> - Check the Sealing Assembly is working properly (jaws are closing, jaws temperature, knife). - Check the temperature controllers are working properly. - Clear the alarm. - Push the green RESET button and resume normal operation.
Filling Overtime	The machine is counting down the preset Filling Overtime	<ul style="list-style-type: none"> - Nothing to do.
Batch Done	The bagger has finished processing the batch.	<ul style="list-style-type: none"> - Clear the alarm. - Refill the bag magazine, set a new batch count or continue with the same. - Push the green RESET button and resume normal operation.

Alarm	Description	Solution
VACUUM & GAS FLUSH		
Vacuum Failure	Vacuum is not being detected	<ul style="list-style-type: none"> - Check the Vacuum pump. - Check the Vacuum hosing. - Check Vacuum Digital switches are working properly. - Clear the alarm. - Push the green RESET button and resume normal operation.
Gas Flush Plunger Failure	The Gas Flush Plunger did not move	<ul style="list-style-type: none"> - Check nothing is blocking the Plunger movement. - Clear the alarm. - Push the green RESET button and resume normal operation.
Gas Flush Choker Failure	Gas could not be flush into the bag.	<ul style="list-style-type: none"> - Check the Gas Flush Assembly. - Clear the alarm. - Push the green RESET button and resume normal operation.
PRINTER		
Ink Jet Printer Failure	A faulty condition has aroused at the printer.	<ul style="list-style-type: none"> - Check the printer's H.M.I. for information on the issue and take corrective actions. - Clear the alarm. - Push the green RESET button and resume normal operation.
Printer Alarm	A faulty condition has aroused at the printer.	<ul style="list-style-type: none"> - Check the printer's H.M.I. for information on the issue and take corrective actions. - Clear the alarm. - Push the green RESET button and resume normal operation.
IY0, Inkjet printer not in origin	The printer is not at its home position.	<ul style="list-style-type: none"> - Reset the printer to its home position. - Clear the alarm. - Push the green RESET button and resume normal operation.
Ink ribbon ran out. Please replace and reset the counter.	The printer has run out of printing ribbon.	<ul style="list-style-type: none"> - Check the printer's H.M.I. for information on the issue and take corrective actions. - Clear the alarm. - Push the green RESET button and resume normal operation.
MISCELLANEOUS		
Actuator Servo Alarm	A fault has been detected at the Actuator Servo Drive.	<ul style="list-style-type: none"> - Check the Actuator Drive screen and User's Manual for information on the alarm and how to fix it. - Clear the alarm. - Push the green RESET button and resume normal operation.
Emergency Stop	The emergency stop has been pushed.	<ul style="list-style-type: none"> - Make sure to pull the E-stop button. - Clear the alarm. - Push the green RESET button and resume normal operation.

Alarm	Description	Solution
Rotating Failure	The Bag Pick Up Assembly did not rotate the bag.	<ul style="list-style-type: none"> - Check the nothing is blocking the Bag Pick Up Assembly movement. - Check the Bag Pick Up Assembly pneumatics. - Clear the alarm. - Push the green RESET button and resume normal operation.
Please Reset	A Reset is required prior to continuing normal automatic operation.	<ul style="list-style-type: none"> - Clear the alarm. - Push the green RESET button and resume normal operation.

8.4 Resetting The Alarms

Proceed as follows in order to clear the alarms from the system:

1. Check the **ALARM FIELD** for a description of the alarm.
2. Solve the alarm as per the table.
3. Clear the alarm.
4. Either tap the green **START** button at the **OPERATE SCREEN** or press the green **START** button at the panel.

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

During the course of a normal operation the machine can build-up particles and debris on and between various components. It is recommended to clean the machine after each operation cycle has ended.

If there is any doubt as to which cleaning products can or cannot be used on the machine, please contact us with detailed information on the cleaning product in question.

Unless otherwise noted the exteriors and interiors of the machine are not to be exposed to water.

Always use clean materials when wiping the machine in order to avoid cross contamination.

Cleaners with synthetic ingredients, acids, chlorine, bleach and other caustic substances can lead to surface rust and discoloration and eventual failure of the stainless steel.

Halogen salts such as fluorine, chlorine, bromine, iodine and astatine are highly corrosive.

Remaining residue on the stainless steel from cleaning products can cause corrosion due to any salt or chlorine content. Please keep the machine surface dry and clean between each use. Unlike other materials, it is not possible to wear out stainless steel by excessive cleaning.

Be sure to wipe stainless steel in the direction of its grain finish lines for the best cleaning result. The grain of the metal is visible.

Do not use scouring pads/mesh cloths or metal tools such as scrapers or steel wool, as this can damage and contaminate the stainless-steel surface of the machine and cause rust.

Failure to comply with the above criteria may result in voiding the machine's warranty.

9.4 Cleaning Steps

USE OF CLEANING SOLUTIONS:

It is important to be aware of the effects certain cleaning products have on stainless steel and aluminum components. Cleaners with excessive chlorine can damage the outer layer of stainless steel and corrode it thus allowing it to rust.

RECOMENDATIONS:

Do not pressure wash or run liquids over the machine. The machine is designed to withstand indirect contact with water and liquids, such as splashing and damp cleaning clothes. Avoid exposing the machine to water. If cleaning other equipment near the machine, ensure that the machine is covered with an industrial water proof cover.

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 pans, buckets, chutes, funnel, center cone and the hopper 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.

9.5 Pneumatics

9.5.1 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



NOTE: the pneumatic filters may not be present if the machine is equipped with a dust protection.

PNEUMATIC FILTERS ARE LOCATED INSIDE THE MACHINE, NEAR THE BOTTOM OF THE FRAME



1. TWIST OPEN THE HEAD OF THE FILTER



2. PULL OFF THE HEAD OF THE FILTER



3. CLEAN THE FILTER WITH WATER AND DRY OUT UNTIL NO MOISTURE REMAINS



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.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Clear any debris from the suction cups and carefully clean them with a damp cloth.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
SEALING JAWS					
Clean the Knife and remove any residue on its surface.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Clean Jaws and inspect for damage, such as chipping.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
PNEUMATICS					
Clean all the pneumatic filters.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Check all air lines and fittings for signs of wear.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
ELECTRONICS					
Machine must be powered ON for this test.					
Power it OFF and Lock Out when completed					
Test the safety switches by opening the doors and checking if the machine stops.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Test the Emergency Stop button.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

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 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. ☐ ☐ ☐ ☐

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.

☐

11. TROUBLESHOOTING

You can also access troubleshooting information from our web resources. This information is constantly updated.

Go to <https://www.paxiom.com/service/>, click on **SELF-SERVE – IT’S AWESOME!**, follow the registration instructions and access the machine’s FAQ.

Problem	Possible Cause	Solution
H.M.I. Not Powering ON	Missing facility's power	<ul style="list-style-type: none"> - Make sure the machine is plugged in. - Make sure there is power from the facility to the machine. - Check power wiring.
	Defective MCR	<ul style="list-style-type: none"> - Check the MCR is being powered. - Check MCR wiring. - Check the MCR is working properly.
	Defective 24VDC Power Supply	<ul style="list-style-type: none"> - Check the Power Supply is being energized. - Check the Power Supply is providing 24VDC. - Check Power Supply wiring.
Pouches Falling Out During Cycle	Not enough air pressure	<ul style="list-style-type: none"> - Check air regulator pressure is set properly. - Check air filters are clean. - Check pneumatic hoses and connections.
	Suction cups defective	<ul style="list-style-type: none"> - Check the integrity of the suction cups at both the Bag Pickup and the Gripper assemblies. - Check suction cups are firmly secured on both the Bag Pickup and the Gripper assemblies.
Temperature is not Settling to Set Point	Defective thermocouple	<ul style="list-style-type: none"> - Check the thermocouple for visual damage. - Change the thermocouple. - Perform the TEMPERATURE CONTROLLER AUTOTUNE procedure (SECTION 12.1).
	Loose thermocouple	<ul style="list-style-type: none"> - Check the Thermocouple is well connected to the controller. - Perform the TEMPERATURE CONTROLLER AUTOTUNE procedure (SECTION 12.1).

12. PROCEDURES

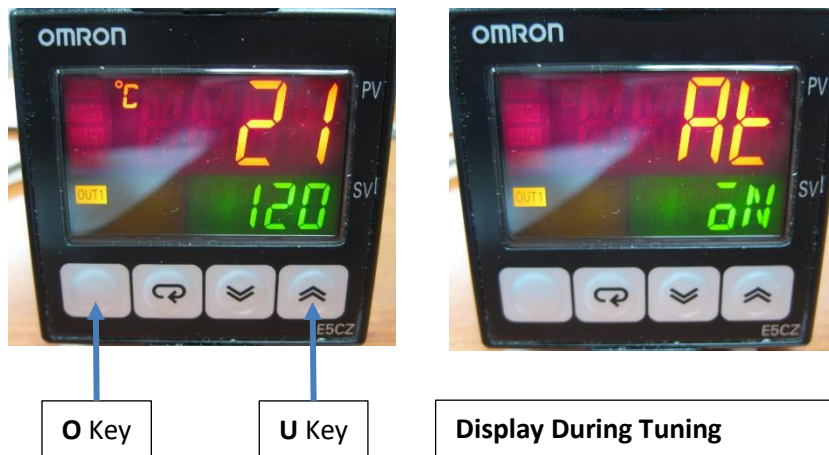
12.1 Temperature Controller Auto-Tune

This procedure will take approximately 30 minutes to complete.

Prior to start the procedure, the following criteria must be met:

- The Swiftly Mini bagger sealer unit must be cool before the auto-tune is performed.
Ideally, auto-tuning should be performed prior to a work shift, e.g. when the Swiftly has been turned **OFF** all night.
- Turn the bagger's main power switch to the **ON** position, and set the approximate temperature set point you will be working with.

Procedure:



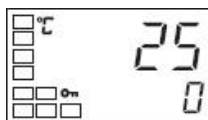
1. Press the **O** Key to move from the operation level to the adjustment level.



2. Press the **U** Key to start execution of AT (auto-tuning).
ON will be displayed during AT execution.



3. **OFF** will be displayed when AT ends.



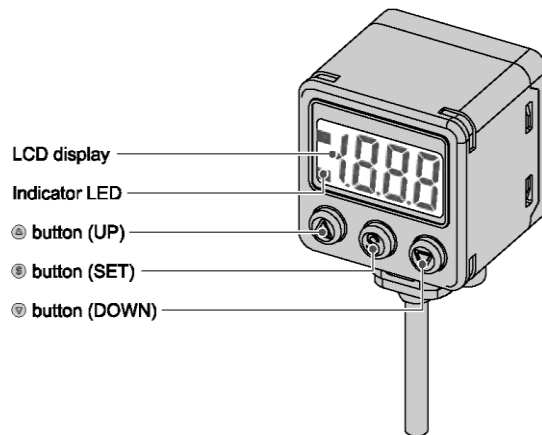
4. Press the **O** Key to return to the operation level.

12.2 Vacuum Digital Switch Set-up

This procedure describes how to set-up the Vacuum Digital Switch for the Bag Pick-Up Assembly and the Bag Opening Assembly.

12.2.1 BAG PICK-UP ASSEMBLY SET POINT

If each suction cup is covered at the pick-up station, the vacuum set-point value will be met. This will trigger the output to let the machine know there is a bag in place.



To establish the set point:

1. Ensure you have the appropriate air supply to your system. (6 bar).
2. Navigate to the “**DIAGNOSTIC**” screen (**SECTION 7.3.5**).
3. Activate “**FRONT VACUUM**”.
4. Place a bag over each suction cup at the pick-up station. (See image below).



5. Record set-point value. (Ex. **-81.4**).
6. Press the blue (**SET**) button once (**P1** setting will be displayed).
7. Press the **UP/DOWN** arrows to **INCREASE/DECREASE** the set point. E.g., If the reading was **-81**, then the proper **P1** setting should be **-79** (two points lower than the actual reading).
8. Press **SET** button **TWICE** to return to the main display.

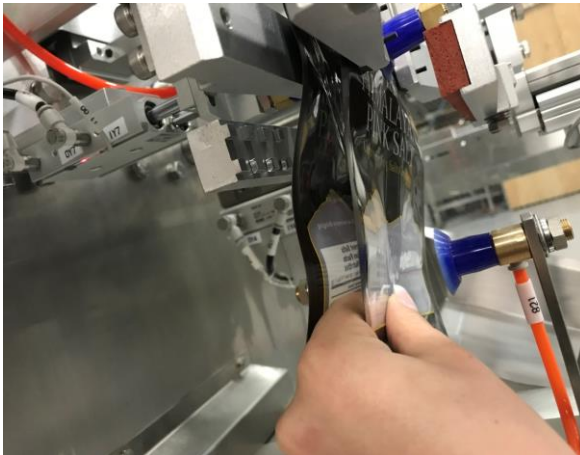
12.2.2 BAG OPENING ASSEMBLY SET POINT

If each suction cup, front and back is covered at the Opening Bag Assembly, the set point condition will be met. This will let the machine know there is a bag in place at the filling station. The machine will now continue to funnel down step & filling steps.

To establish the set point:

1. Ensure you have the appropriate air supply to your system. (6 bar).
2. Navigate to the “**DIAGNOSTIC**” screen (**SECTION 7.3.5**).

3. Activate “**BACK VACUUM**”.
4. Place a bag over all front and rear suction cups at the Opening Bag Assembly.
(See image below).



5. Record set-point value. (Ex. **-82.2**)
6. Press the blue (**SET**) button once (**P1** setting will be displayed).
7. Press the **UP/DOWN** arrows to **INCREASE/DECREASE** the set point. E.g., If the reading was **-81**, then the proper **P1** setting should be **-79** (two points lower than the actual reading).
8. Press **SET** button **TWICE** to return to the main display

12.2.3 TESTING THE ENTERED SET POINTS

To verify the procedure was correctly executed:

1. Navigate to the “**OPERATE**” screen (**SECTION 7.3.3**).
2. Tap “**RUN ONE BAG**”. If all conditions are met, the value displayed on the Vacuum Digital Switch will turn green and the “**OUT 1**” LED indicator (LCD screen top left corner) will light up **ORANGE**.

The set-up procedure is complete.

When running the machine, if the actual vacuum values sensed are below the set points entered, the machine will try multiple times depending on the values set forth in the

RECIPE screen (**SECTION 7.3.6**):

BAG PICKUP TIMES

BAG OPEN TIMES