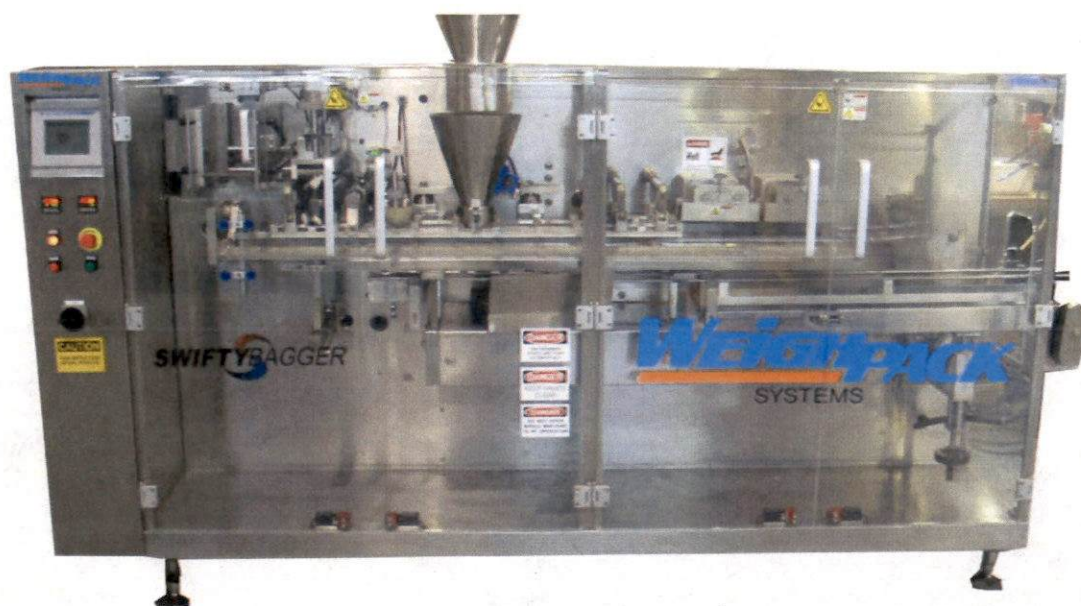


Swiftly Bagger

SB-3600 Horizontal Bagging Machine

(non-encoder model)
with encoder model addendum

OPERATOR MANUAL



WEIGHPACK
Systems, Inc.

Preface

Thank you for purchasing the Swifty Bagger from Weighpack System Inc. In order to use this machine correctly, it is strongly recommended that you read this manual carefully before installation.

This manual contains detailed descriptions of the structure, function, operation and maintenance of the Swifty Bagger. Please note that due to continual improvements, the contents of this manual may be slightly different than the actual machine. If you have any questions, or encounter any problems while using this machine and the answer cannot be found in this manual, please do not hesitate to contact our service department immediately.

Please contact us at 1-888-934-4472 or visit our web site www.weighpack.com. Ensuring that your Swifty Bagger is performing correctly is our top priority and we are at your disposal should you require further assistance. We appreciate your business and understanding.

Sincerely

The WeighPack Systems Team

Serial #: _____



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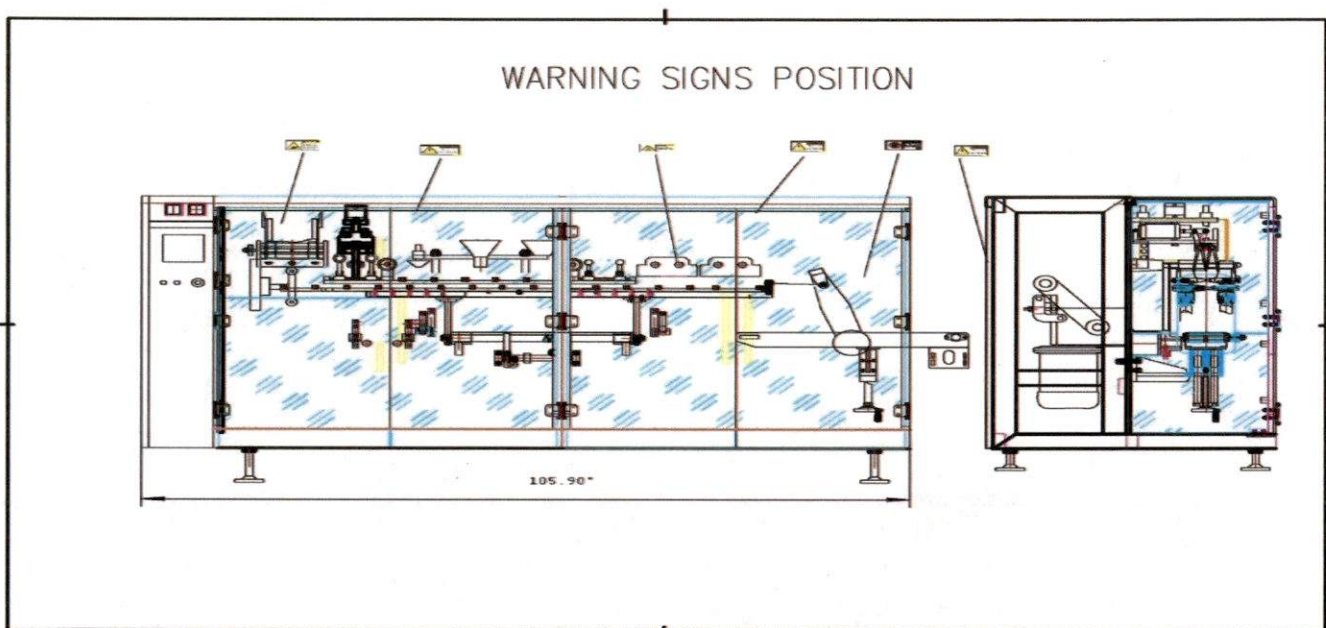
Encoder Addendum 70

1. Safety

1.1 General description

WeighPack has added multiple safety switches, alarms and warning signs on this machine, however different users have different requirements, please do not hesitate to add your own safety devices if required.

1.2 Safety Signs on the Machine



1.1.1 Caution sign



When the machine is in operation, the bag dispenser rotates up and down even when the machine is out of bags. Do not place hands in or under the bag dispenser in order to avoid hand(s) being pinched.

1.1.2 Warning sign



If the doors are opened when the machine is in operation, the machine should stop operating and the warning alarm should sound. The machine cannot be run until the doors have been closed and the alarm has been reset from the touch screen.

1.2.3 Attention sign



A heat sealer is used in the sealing section of the Swifty Bagger. During and after operation, the heater could still be hot. Do not touch the heater it can reach temperature of 130°C to 160°C. Please shut down the machine and wait until the sealer cools to room temperature before touching or servicing it.

1.2.4 Warning sign



Do not touch the conveyor and or the conveyor motor when they are in operation. The operators should be aware of any hanging objects (ties, sleeves, hair or jewelry) while the machine is in operation

1.2.5 Electricity Safety-Awareness



It is very dangerous to open the electrical panel unless the power has been turned off. In order to avoid electrocution, only trained professionals should, examine and maintain the electrical panel.

1.3 Safety regulation

All operators should be familiar with their own Labor Protection guidelines.

1.4 Fire and Water Prevention

1.4.1 Fire Prevention

- Put out sparks, flames or other flammable materials. Smoking is prohibited near the machine. Maintenance can only be carried out when the machine power is off.
- Turn off all power before maintaining or cleaning the machine
- Ensure that the electrical circuit (including connection terminals and contacts) are in good condition. Change wires if they are broken, scratched, corroded, color-faded, lost insulation or the wire end is damaged. Keep the wire ends and connectors clean.
- Keep the ground-connector and electrical-conductive objects (such as tools) away from the uncoated electrical parts (such as the input terminal) to avoid producing sparks.
- If welding is necessary during maintenance, move all flammable material to a safe place.
- Dispose of oily rags
- Keep a fire extinguisher near the machine.

1.4.3 Water Prevention

- Make sure that no water is spilled into the electrical cabinet, control panel, motor, security switch and all the other electrical components to avoid short-circuit accidents.

- Do not open the back doors when cleaning to prevent water from entering the machine.
- Turn off the power immediately if water is spilled into or on the machine. Dry up the water and turn on the machine again. Test the electrical components to make sure they are working correctly.
- Drain the air reservoir tank every day to avoid water accumulation
- Make sure no liquid is splashed on the machine or the electrical components when filling with liquids. Clean immediately if any liquids are spilled on the machine

1.5 Moving Parts

- During operation do not touch any of the moving parts with hands, arms or clothes.
- Do not turn the machine on if the covers for the fan, coupling, springs, bearings, sensors have been removed.
- The front and back doors should always be closed
- When maintaining and adjusting the machine, make sure the power is off
- Clean water and oil from hands and the control components to avoid slipping.

1.6 Protection from Electrical Shock

- Your body, hand-held tools, and other conductive objects should be kept away from the uncoated terminals of the circuit.
- Maintenance should be carried out in a clean and dry environment with proper lighting.
- Do not leave the machine before the electrical cabinet is fully connected.
- After installation, ensure that the ground wire is firmly connected with the ground before starting the machine. If possible, use double grounding for added protection.
- After installation, please test all the closed circuits before starting the machine.

2. Machine Description

2.1 Specifications

	SB-3600
Power Supply	220 VAC, Single Phase, 50-60 Hz, 20 A
Power Consumption	3 kW
Bag Lengths	5" to 11" (12.5 cm to 28 cm)
Bag Widths	3.5" to 8" (9 cm to 20 cm)
Bag Shape	Flat end pre-made bags, stand-up bags
Bag Gusset	1.25" to 3" (3.2 cm to 7.6 cm)
Bag Materials	Laminated and Polyethylene
Bag Types	Flat Bottom, Gusset, Pillow, Stand-up and Zipper
Yield	1200 – 2400 bpm
Decibel Level	72 decibels – doors closed 1' distance
Air Pressure	90 psi (620.5 kPa)
Air Consumption	25 cfm (0.708 m ³ /min)
Dimensions	39" (991 mm) W x 118" (2997 mm) L x 87" (2210 mm) H
Weight	525 lbs (239 kg)

Table 2.1.1

2.2 Layout

Swiftly Bagger Structure

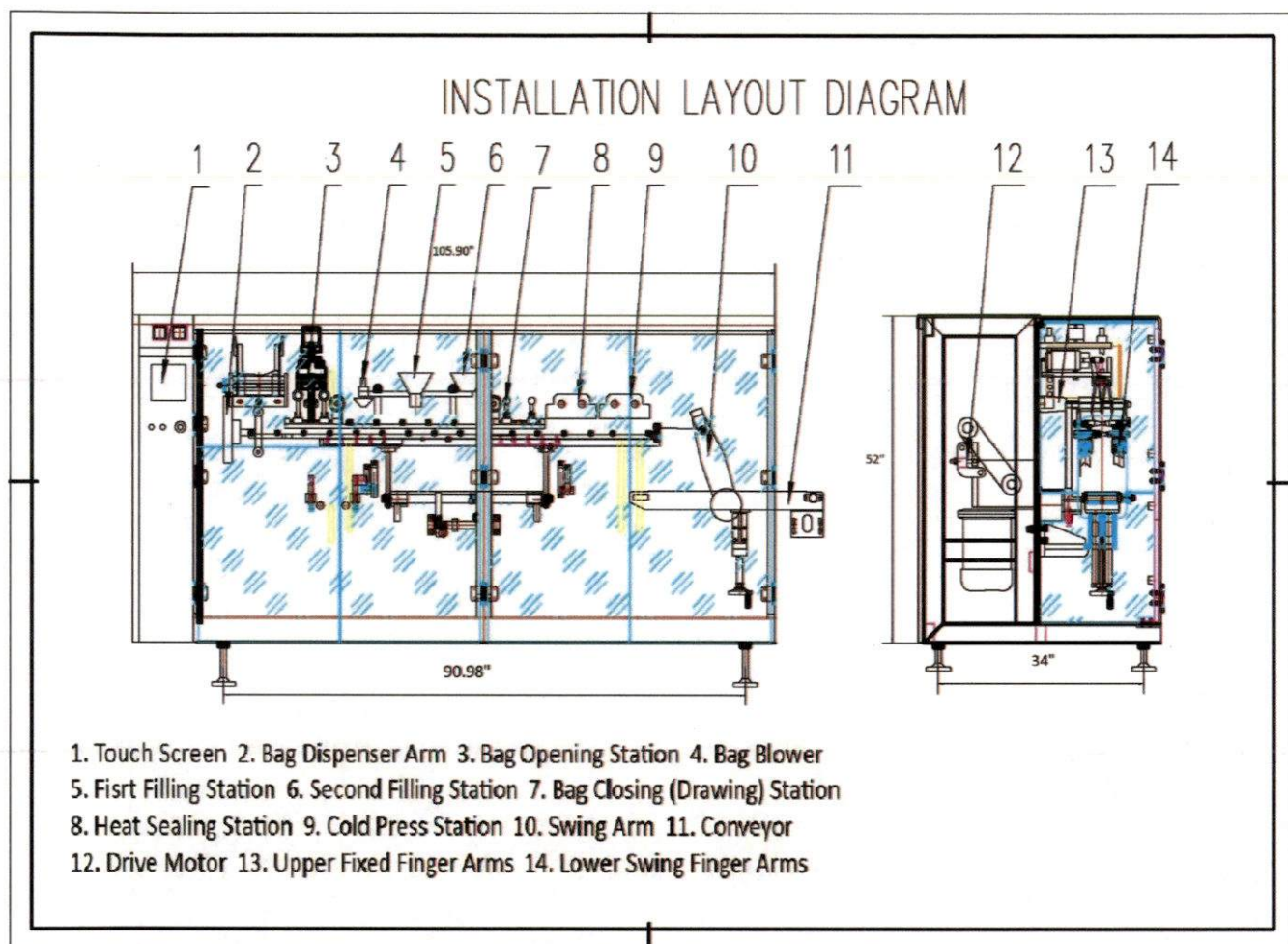


Figure 2.2.1

This machine is constructed in stainless steel. The moving parts and joints are composed of CAM follower bearings, ball bearings, linear bearings, and oil-free bearings. The front of the machine is made of aluminum material to reduce the weight, increase the speed, and to improve the stability.

2.3 Pneumatic Section

The air exhausted by the air compressor goes into to the air container after being stabilized and removed of water. The air will be distributed to each valve by a manifold. The valves control the air circuit. Please refer to Pneumatic Schematic Diagram for the flow direction of air in the pipes. (Picture 2.3.1)

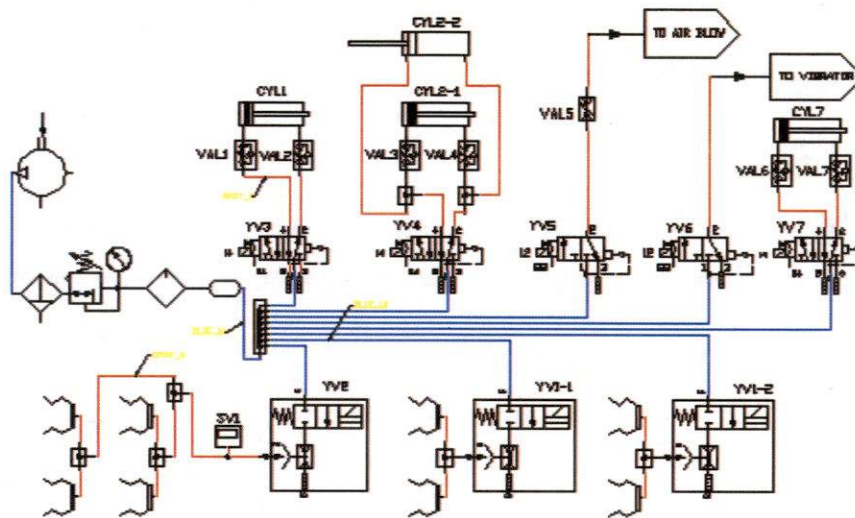


Figure 2.3.1

2.4 Attention

- Do not change the pipeline of the pneumatic system
- Make sure the pressure of the air resource is in the range of 0.45Mp~0.7Mp (90 PSI). Ensure the inlet air is dry and clean, otherwise the performance of the machine will be effected
- The pressure gauge of the bag opening station is set at the default factory setting. Only trained professionals should make changes to it. Please read the pressure meter instructions carefully or consult a trained professional.



Air Pressure Gauge – Mounted behind blower plunger station

Figure 2.4.1

2.4 Control System Structure

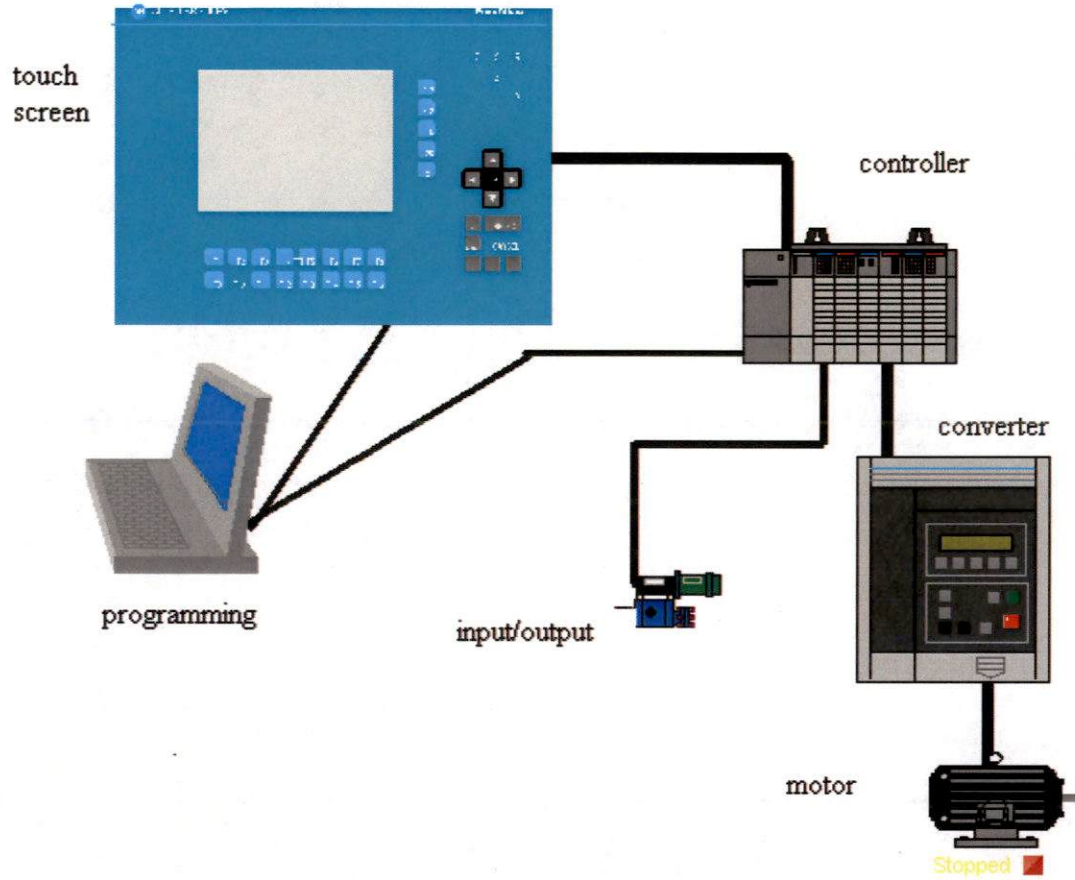


Figure 2.5.1

3. Installation

3.1 Ventilation and Cooling

To ensure a steady working temperature, the machine should be placed in a well ventilated area. Do not position the machine next to walls. See drawings below:

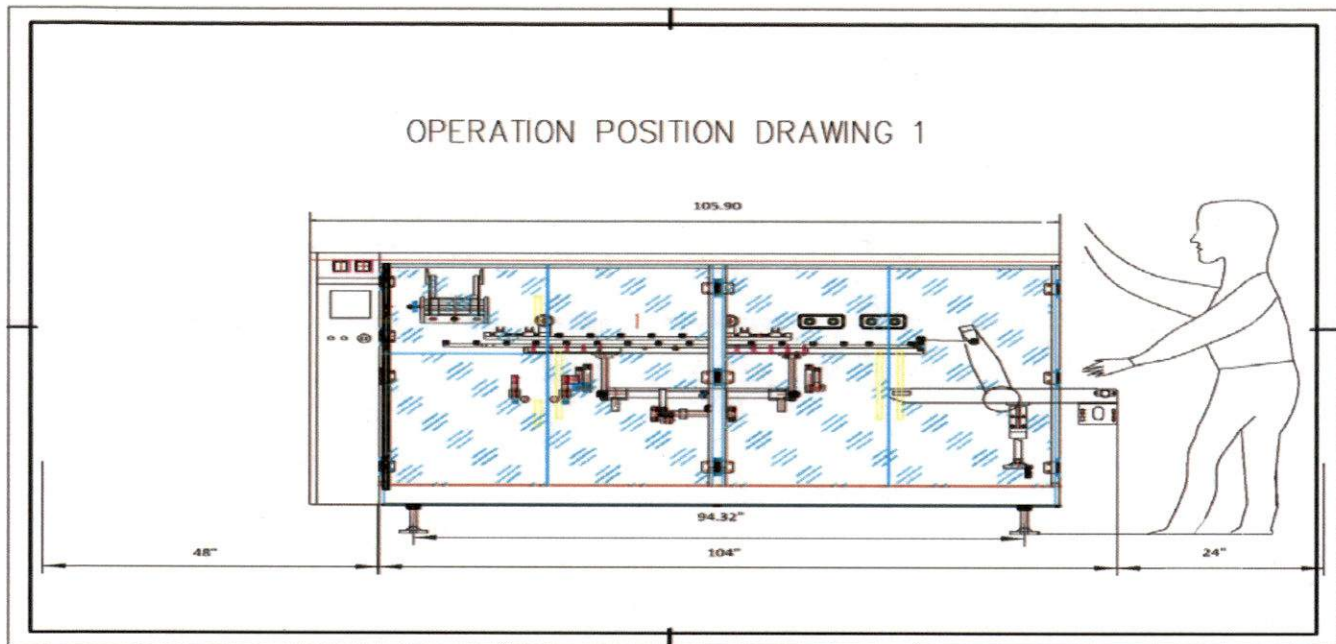


Figure 3.1.1

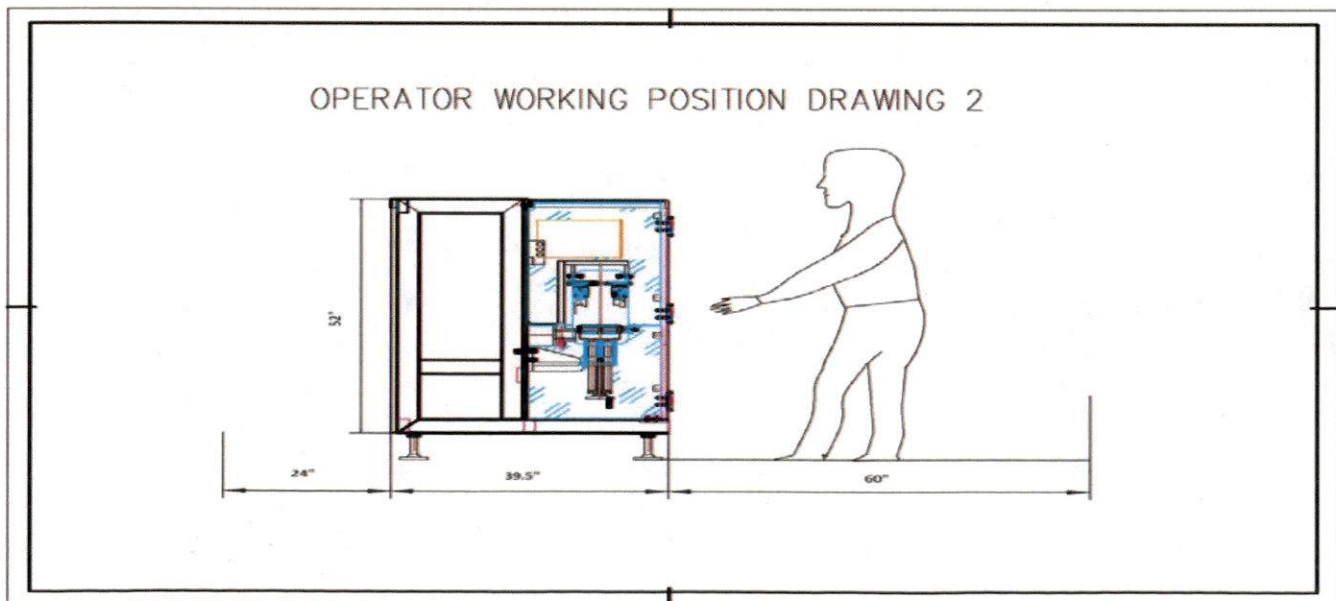


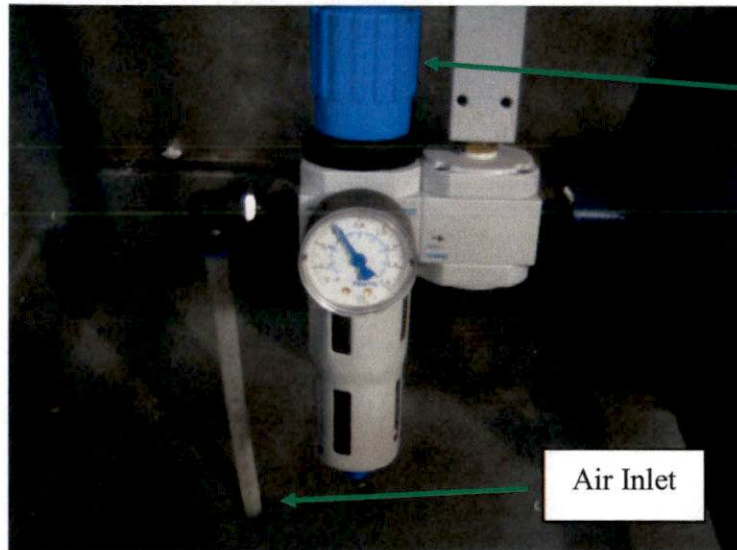
Figure 3.1.2

3.2 Preparation

- Connect the power supply and grounding of the machine
- Connect the compressed air hose to the air reservoir tank.
- Connect the machine with filler or scale.

3.3 Installation of air supply

When standing at the back of the machine open the right side doors, located on the floor below the air regulator you will see an inlet hole for the air line. Feed your air line through this hole and connect to the air regulator (see photo below).



To Adjust Air Pressure

1. Pull up on the knob
2. Rotate the knob clockwise; the inlet pressure increases; counter clockwise, it decreases
3. When the pressure reaches the working pressure, press down on the knob.

Figure 3.3.1

3.4 Installation of Electricity

- Only a qualified electrician should make electrical connections to your plant's electrical circuit. It is important to check if the ground wire is firmly connected to ground and whether its resistance meets your requirements.
- Check the voltage and phase of the incoming line of the machine after supplying the power. Close each line and press the Start button on the control panel to supply power to the interface and the PLC. If there are abnormal noises, stop the machine and turn off the power. Do not power again before determining what is causing the noise.

3.5 Grounding and Static Protection

Static electricity can cause problems with electrical equipment and with operation, ensure your equipment is properly grounded during installation. Double ground the machine and test its ground resistance, resistance less than 5 OHM, it is acceptable. Grounding from auxiliary equipment to Swifty should be bonded. If static is present in bags, the installation of static eliminator tools may be required, please contact WeighPack if you require additional information.

4. Machine Operation

4.1 Overview

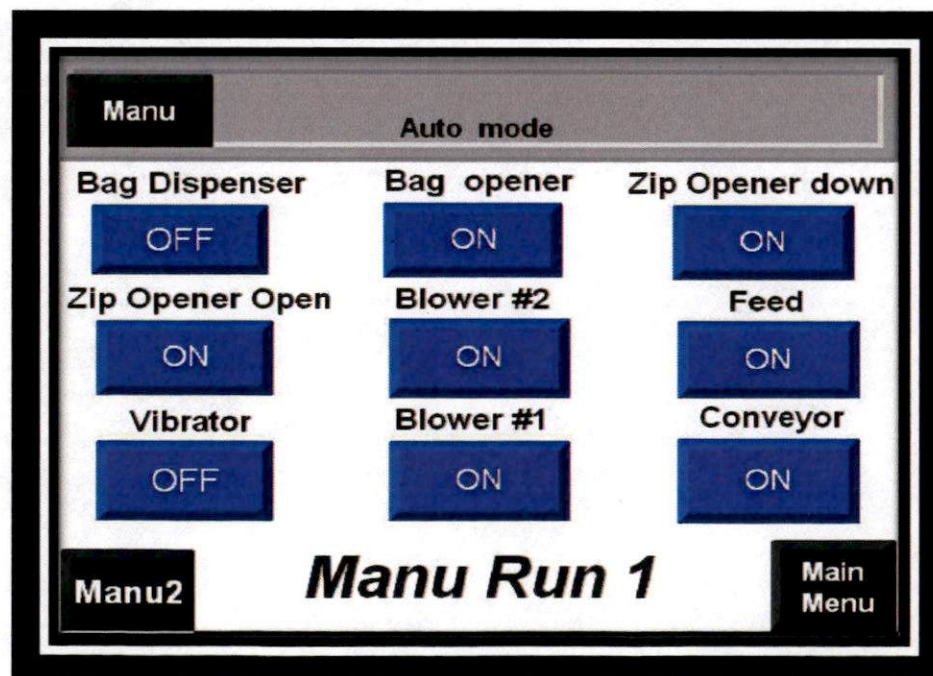
- Selecting the start button on the touch screen starts the main motor and conveyor. The main motor drives the spindle to rotate. The spindle drives the indexer, upper fixed finger arm and lower swing finger arms.
- The bag dispenser arm rotates the bags from a horizontal position to vertical position. The swing finger indexer drives the swing finger, and the fixed finger indexer drives the fixed finger alternately to move the bags from the head of the machine to the end of the machine. These bags will be sent out by the conveyor.
- The bag opening station opens the bag mouth. The bag blower station blows open the bag from top to bottom. The bag is then moved to the filling station where it will be filled with product.
- The sealing station seals the fully filled bags.

4.2 Set-Up

Before operation can begin, the Swifty Bagger must be set-up to accommodate your bags; the following chapter will explain all the stages of setting up and the related screen functions that you will use to set-up your bags and the process involved.

We recommend that you have the following tools available when making adjustments or maintaining the Swifty Bagger: Metric Allen Keys, Metric Socket Set, Metric Wrenches, Volt Meter, Screw Drivers, Tape Measure, Caliper, Adjustable Wrenches, Grease Gun

4.2.1 Manual Screen Descriptions Manu Run 1



*access this menu from the main menu page by selecting Manu Run

Before being able to use the various button in this screen you must ensure that the top left button shows “Manu”, if not pressing it twice will bring it to “Manu”

Bag Dispenser – pressing once will operate the vacuum generator, you should feel and hear suction from the suction cups. Pressing this button a second time will turn off the vacuum.

Bag Opener – pressing once will operate the vacuum generator; you should hear and feel suction from the suction cups. Pressing this button a second time will turn off the vacuum.

Zip Opener Down – will bring the zipper opener to the down position, pressing the button again will return the zipper to the up position.

Zip Opener Open – will operate the zipper fingers open, pressing again will close the zipper fingers.

Blower #1 and #2 – will turn the air onto the bag-blower: pressing again will turn off the air supply.

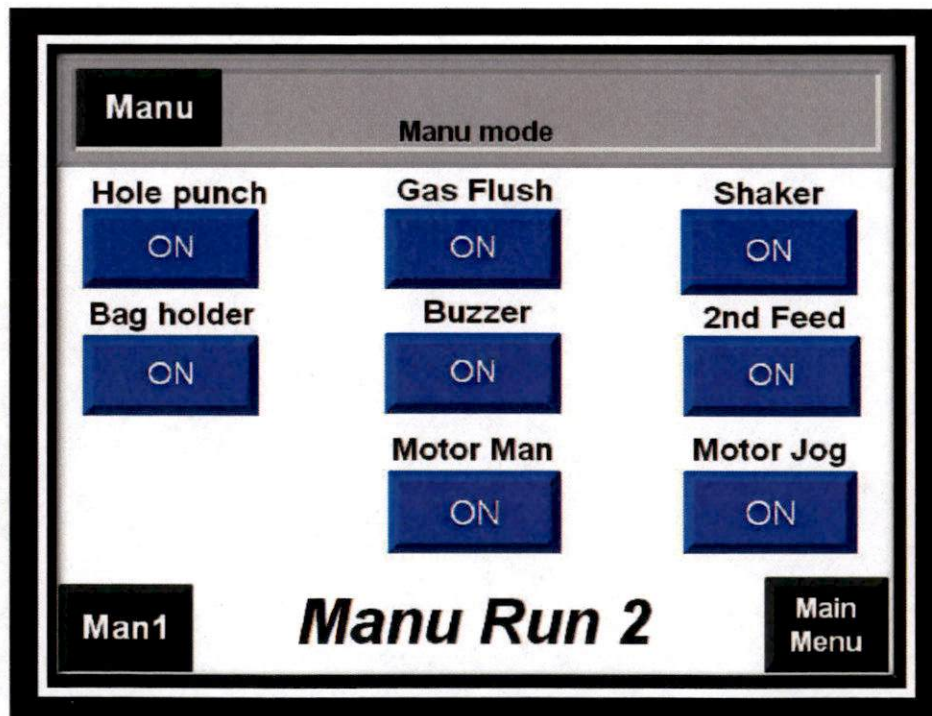
Feed – will discharge the feeder once.

Vibrator – will start the funnel vibrator, pressing again will turn off the vibrator.

Conveyor – will start the conveyor, pressing again will turn off the conveyor.

Manu2 – brings you to page two of the manual operations screen

4.2.2 Manual Screen Descriptions Manu Run 2



Hole Punch – if equipped will operate the hole punch once.

Gas Flush – if equipped will operate the gas flush once.

Shaker – if equipped will operate the shaker (used to help settle product in bag during filling).

Bag Holder – if equipped will turn on the vacuum generator, you should hear and feel suction of the suction cups. Pressing this button again will turn off the vacuum.

Buzzer – will turn on the alarm, pressing again will silence the alarm.

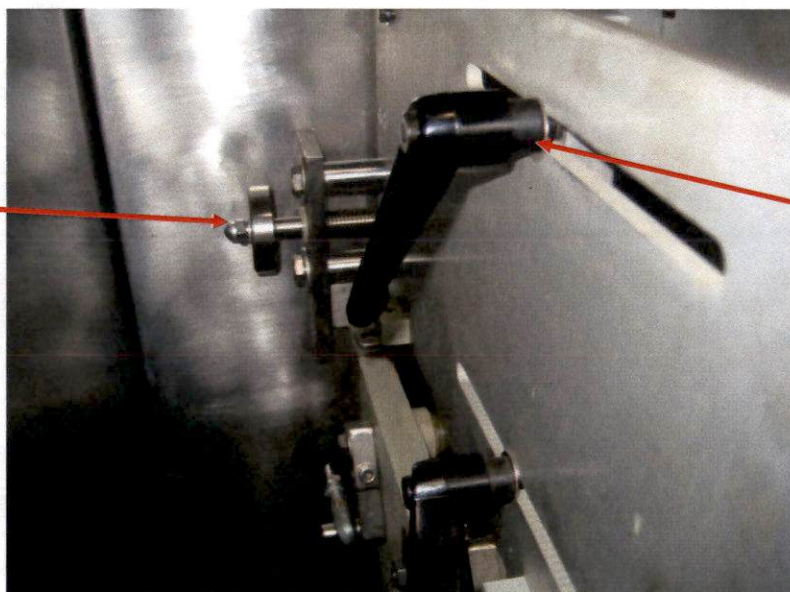
2nd Feed – if equipped will discharge product one time from second feeder.

Motor Man – pressing this button once will allow the operation of the Swifty without the air blower(s) or vacuums: you can stop the machine at any position by pressing the button a second time, pressing the button continues from last position.

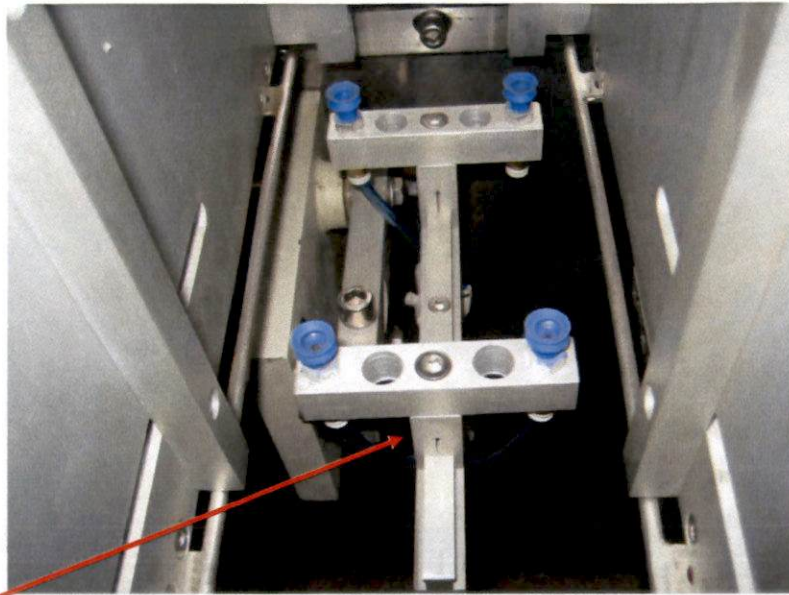
Motor Jog – operates in the same manner as “Motor Man” but you must keep your finger on the button for the operation to continue, releasing your finger at any point stops the machine instantly.

4.2.3 Setting Bag Magazine for Various Sized Bags

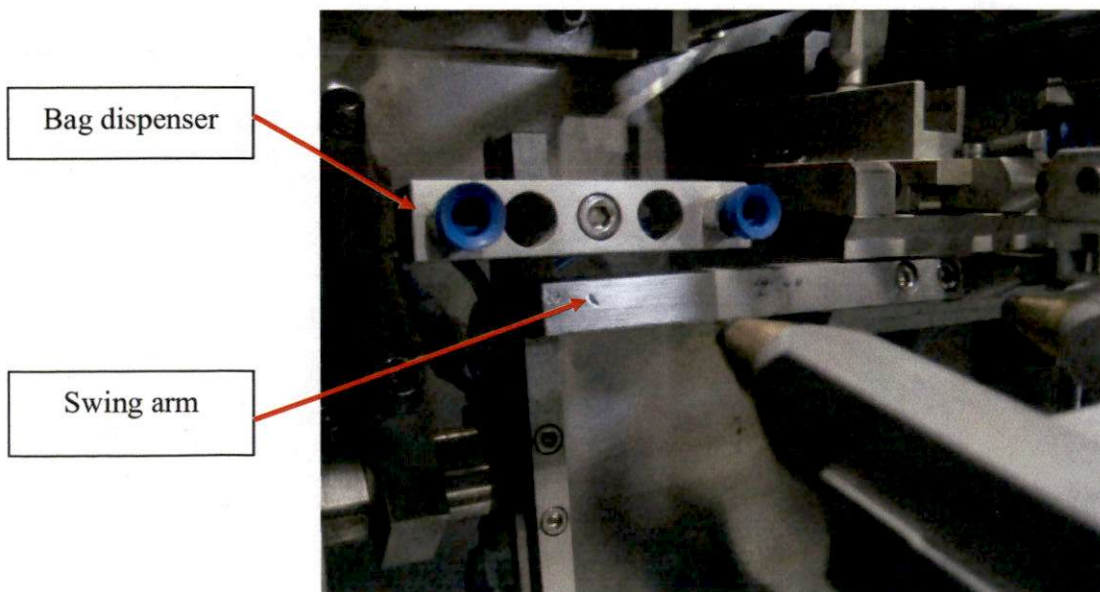
Control knob
adjusts width of
magazine: bag
should have 1/16”



Rear
alignment
adjustments
bars knob:
set within

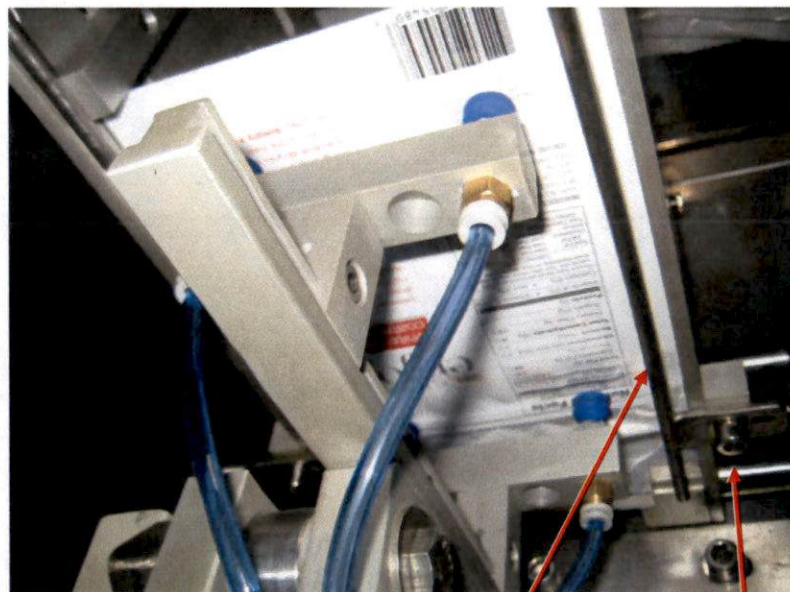


Loosen set screw located just below suction cup, slide top and bottom suction cups to position: bottom cups should be approximately 1" from bottom of bag. Top suction cup should be approximately 1" from top of bag. If bag features zipper closure on the top or bottom of your bag adjust the suction cups to be just above or below the closure. In Manual Mode, use the "motor jog" function to slowly bring the dispensing arm to the vertical position, ensure the arm does not come into contact with lower swing finger arm as shown in the next photo. Make adjustments if required.





Bag set in magazine correctly.



Suction cups set in correct position. Please note support guide rods, loosen screws and move in and out as required. Bars should be positioned to not restrict the bag from being pulled down by the dispensing arm but enough to prevent the bags from falling when being loaded into the magazine

4.2.4 Finger Adjustments



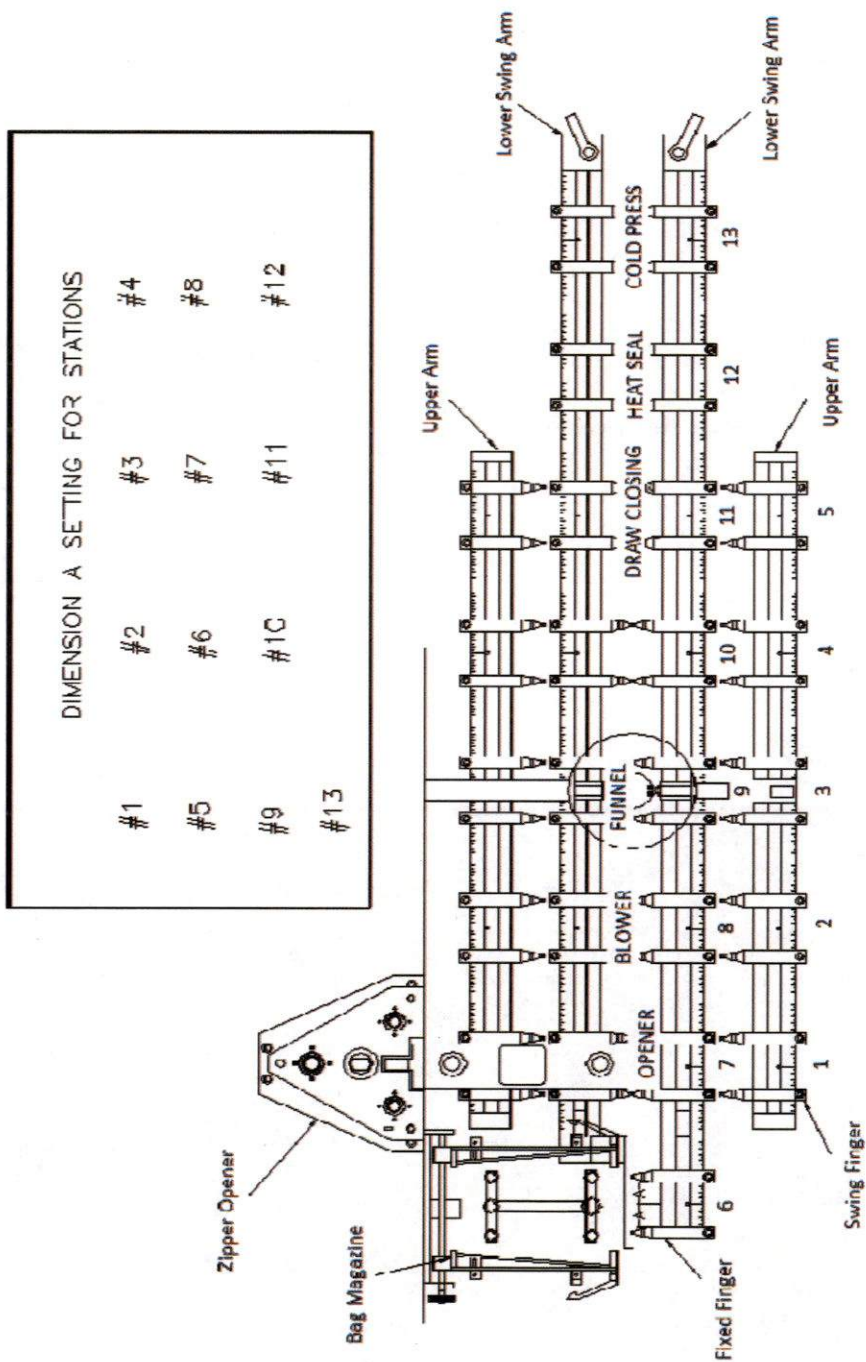
To begin adjusting fingers the touch screen should be in the Manu Run 2 mode, using Motor Man or Motor Jog to open and close finger assemblies to allow easy access to finger set screws. Using an Allen key loosen all the fingers, and then slide fingers to desired positions, then retighten all fingers. Once fingers have been positioned, place a few bag in the magazine and start the bagger in Auto Run mode (scale should be in test mode). Observe placement of opened bags in the fingers. Some adjustments may be required, fingers should be within $\frac{1}{4}$ " to $\frac{3}{8}$ " of bags edge as shown in the next photo.



Notice placement of fingers to the edge of the bag. If fingers to be repositioned stop machine and make required adjustments. For your convenience we have include a Swifty Stations drawing to record your settings for future reference

4.2.5 Swifty Stations Reference Drawing

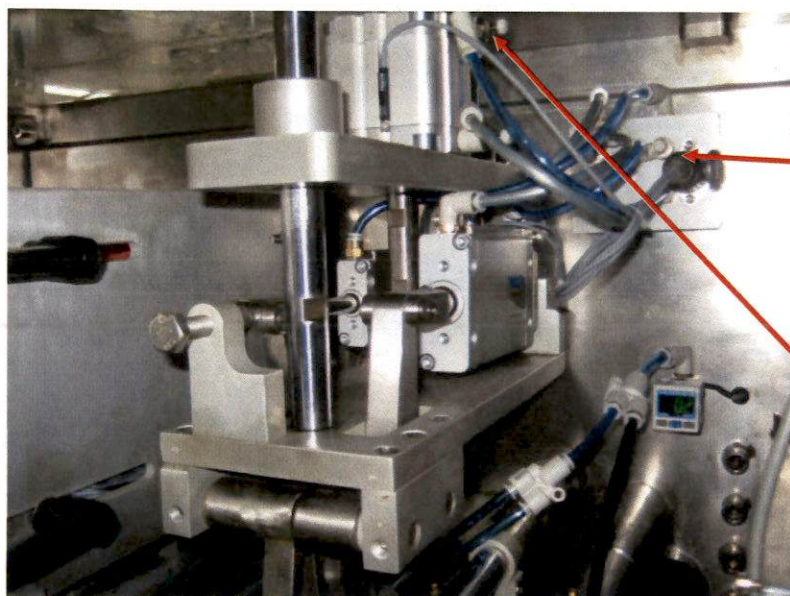
SWIFTY STATIONS



Please use this copy for future reference

4.2.6 Bag Opening Zipper Attachment (if equipped)

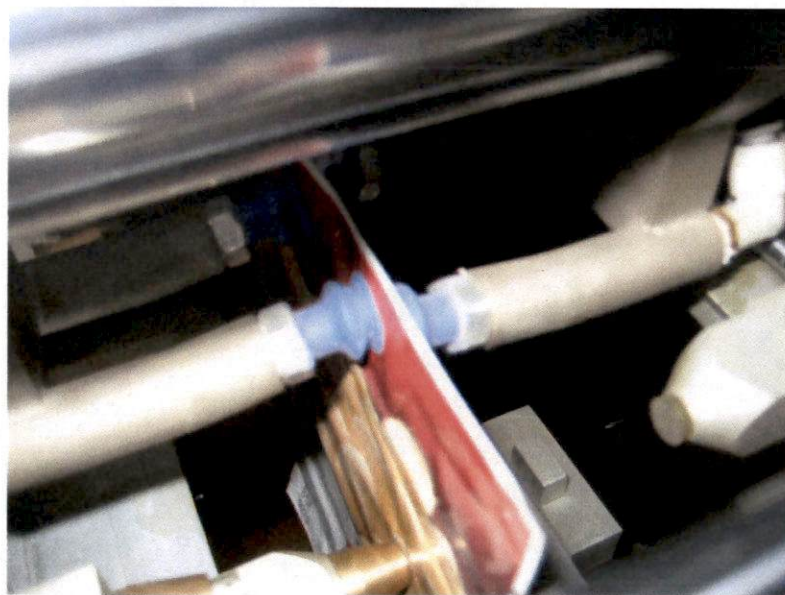
When the bag is partially opened from the suction cups the zipper attachment descends into the partially opened bag, the fingers will then secure the bag and start to pull the bag open as the suction cups travel back. Once fully opened the zipper finger releases the bag and the entire zipper attachment returns to the up position for the next bag.



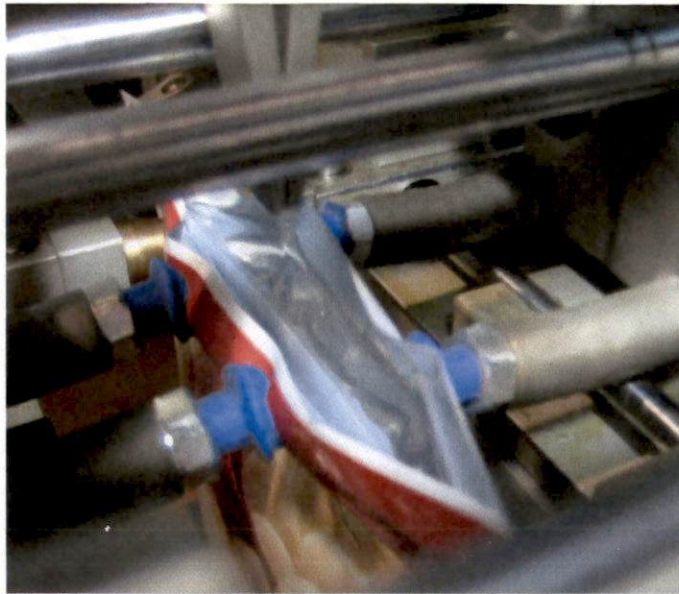
Zipper Opener Attachment

Flow control valves –
controls finger opening and
closing action

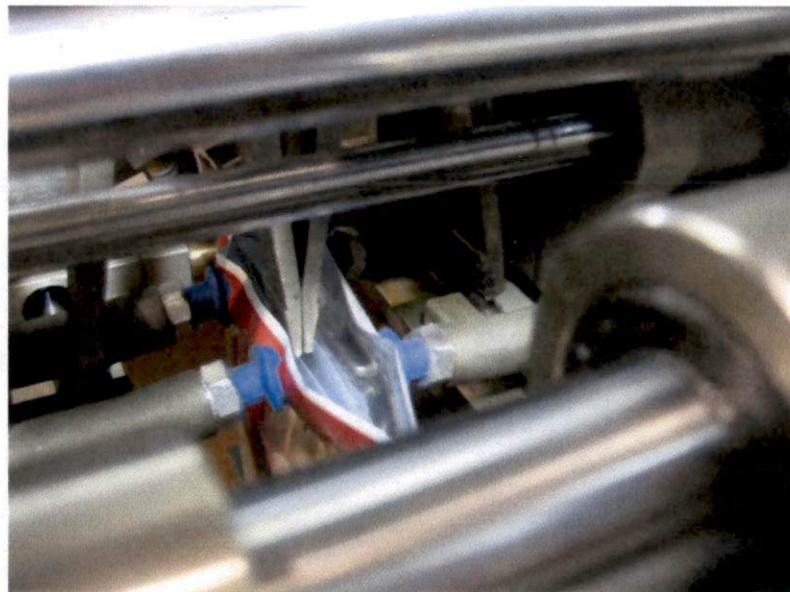
Flow control valves –
controls the up and down
speed of zipper travel



When equipped with a Zipper attachment the Swifty Bagger utilize a two stage cam lobe to give the suction cups two stages in the opening sequence. The first movement of the suction cups is to be drawn into the bag; the vacuum generator will engage and create suction against the bag. The 1st stage for the cam lobe will partially open the bag to allow the Zipper Opener fingers entry into the bag (see photo below)



The 1st stage of the cam lobe is to open the top portion of the bag to allow the Zipper fingers to enter the bag.

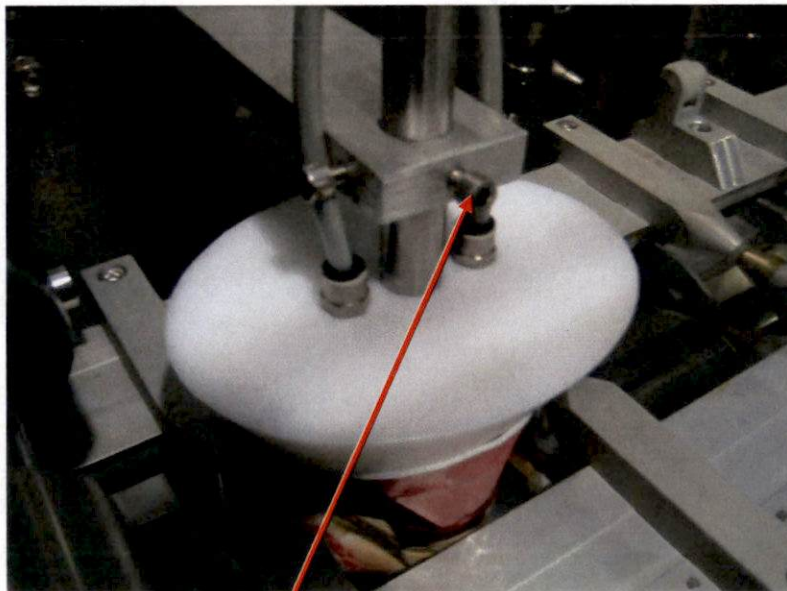


Zipper fingers entering bag



Zipper fingers engaged in bag and open thru second stage of cam lobe, the suction cups follow through the opening sequence.

4.2.7 Bag Blower Adjustment

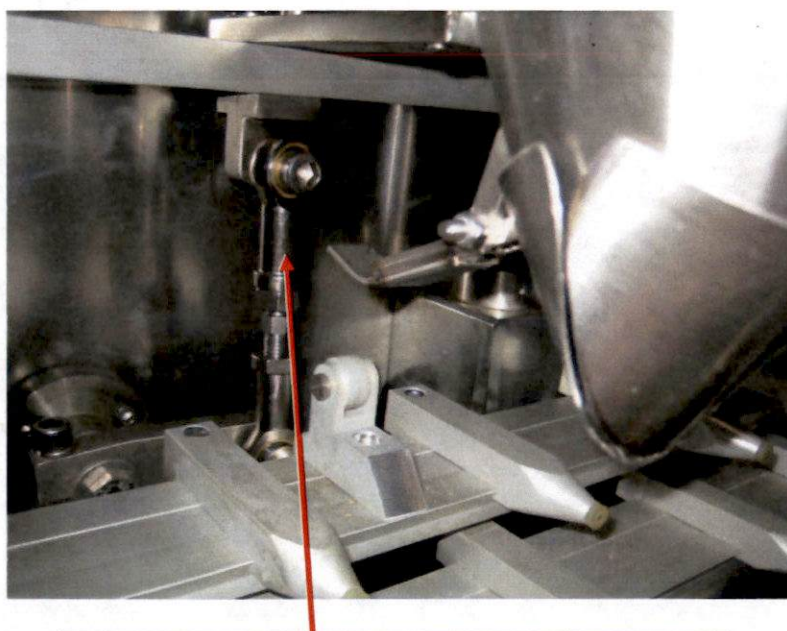


Blower plunger height adjustment set screws

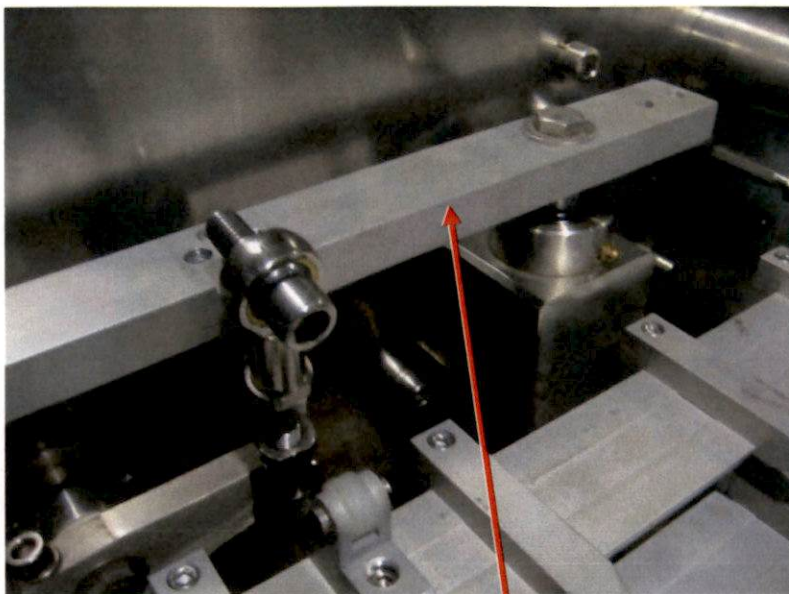


Plunger should enter into the bag enough to allow maximum air pressure but not low enough to push down the bag.

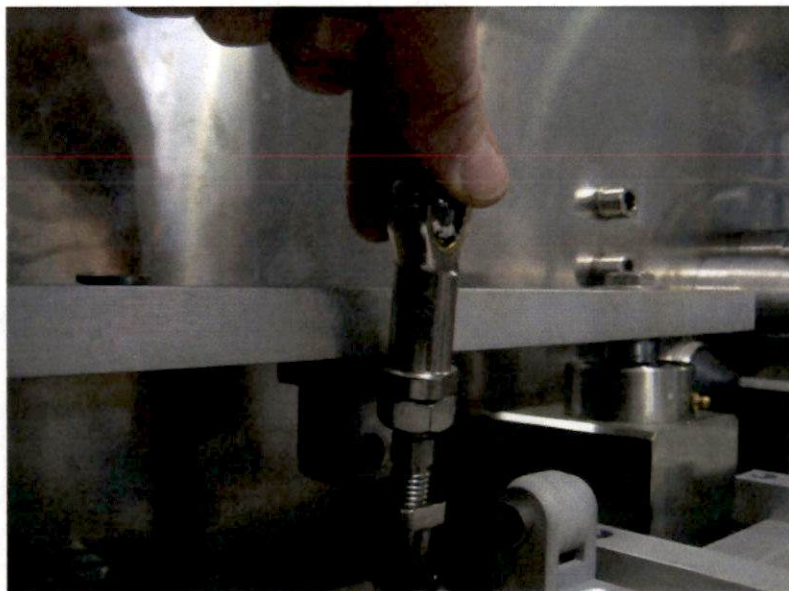
4.2.8 Funnel Adjustment



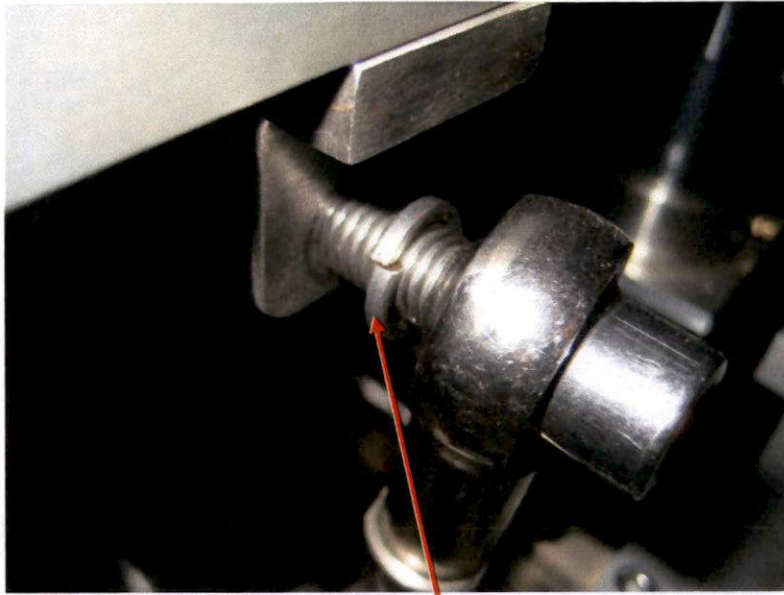
Funnel Height Adjuster



With Allen screw removed, gently lower bar assembly



Turn clevis clockwise or counter clockwise to raise and lower the funnel height



Reinstall Allen screw to mounting bar, take note of washer placement, and re tighten. Reinstall your funnel, and then in manual mode use the Motor Jog to slowly lower the funnel, ensure funnel is not too low or too high. Readjust if necessary.

4.2.9 Temperature Control and Cartridge Heater Replacement

1. Temperature Control:

The temperature control is located below the touch-screen; you will note that there are two controllers in this location. The 2nd heater is an option & might not be equipped, please use the controller on the left side.



Toggle start and stop

Decrease temperature

Increase temperature

- Turn On Heater - Press the toggle button and then press the arrow down button which will display RUN and the heater will now be activated, press the toggle button a second time to return to the

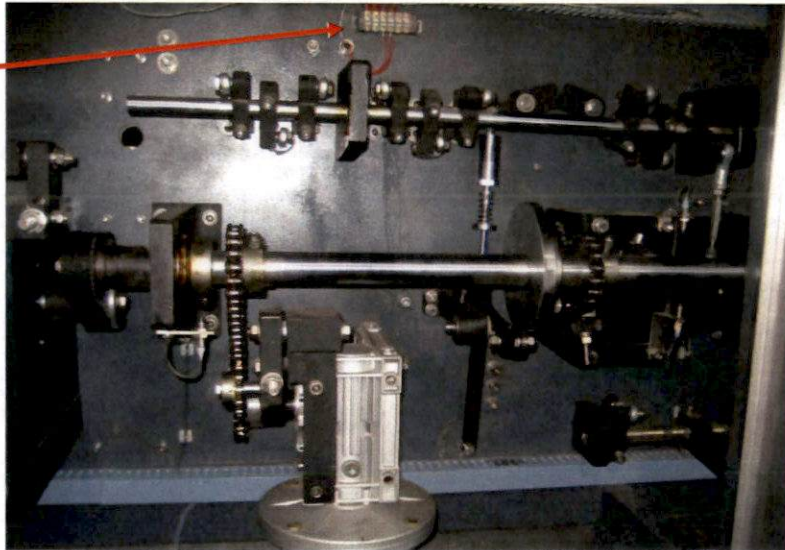
run screen. "Out" will flash confirming the heater is now on, and heater temperature will begin to rise.

- Turn Off Heater – 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.
- Use the up and down arrow keys to raise or lower the temperature

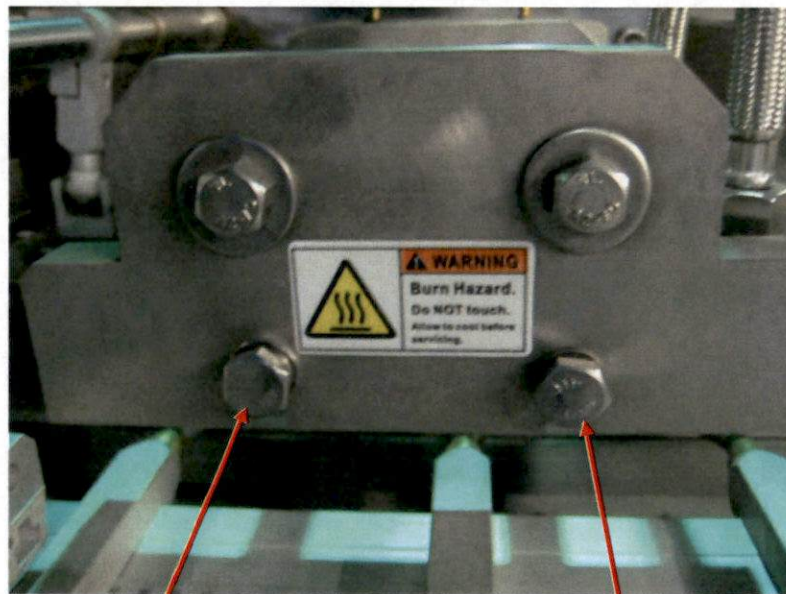
2. Cartridge Heater Replacement:

Before servicing heater, disconnect power from the Swifty Bagger

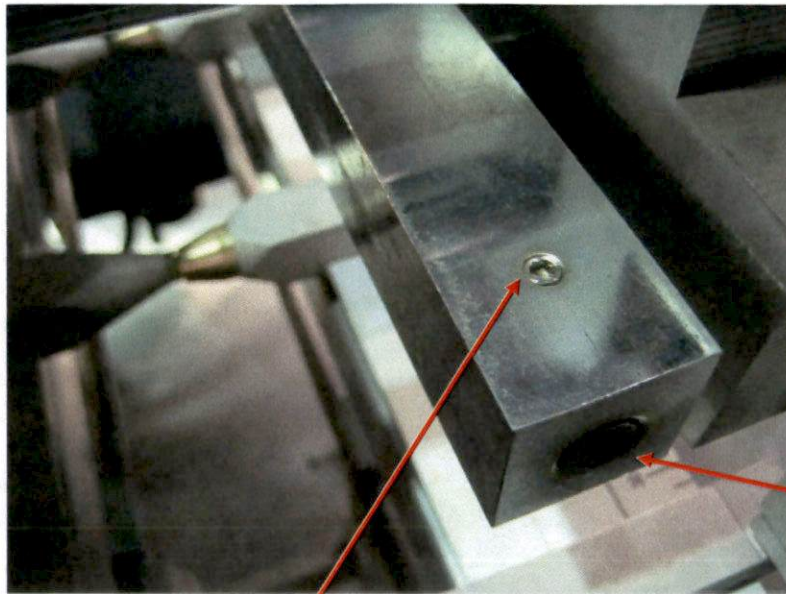
Heater connection



Heater connections are located at the back of the machine on the left side

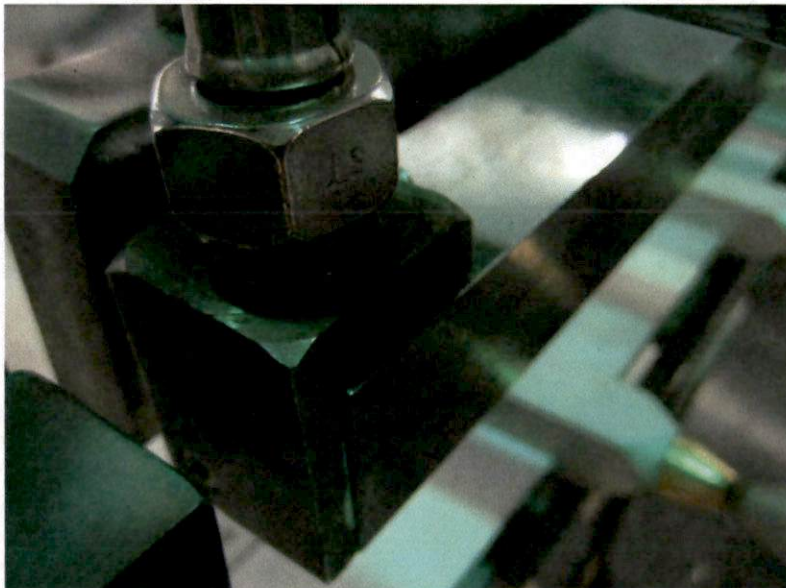


Remove two bolts to free heating element from housing



Cartridge heater

Remove set screw



Remove two screws, and then carefully slide out heater. Disconnect connection from the back of the machine and feed thru protective housing. Install new heater in the reverse.

4.2.10 Manual Run Test Running

After setting up the machine, and all bolts have been checked, check to ensure there are no tools left in or on the machine.

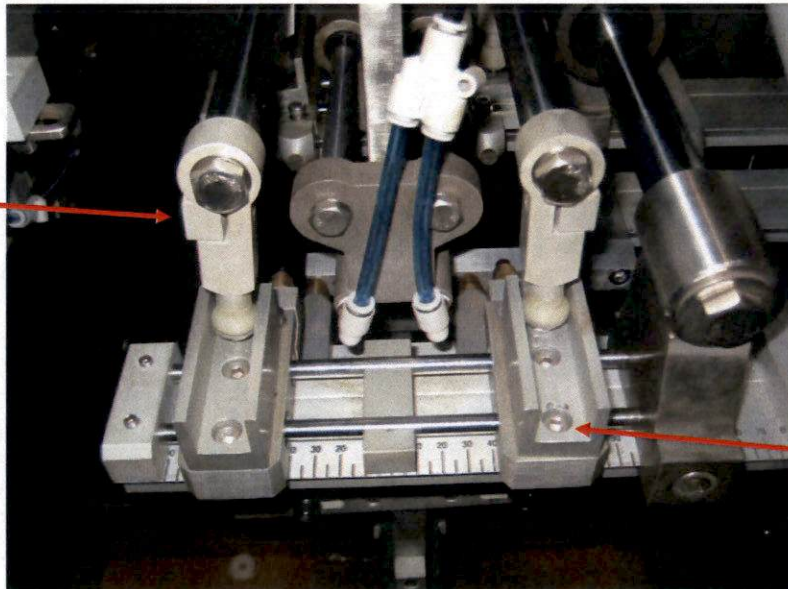
- To begin: from the Main Menu select Manu Run, and then select Manu2.
- In Manu2 select Motor Man, machine will begin to operate, however air blowers and vacuum generators will not function in this screen. Only the swing finger, fixed fingers, bag dispenser and funnel will operate.
- Observe each station carefully.
- Check finger alignment.
- Check the funnels travel: adjust height if the funnel travel is to low or too high.

4.2.11 Auto Run Test Running High and Low Speed

Set the speed at 20bags/minute. Turn on the machine to test. If everything is normal increase the speed to 30bags/minute, run the machine for 5-10 minutes. If there are no abnormal issues, turn off the machine and examine each station and re tighten any loose parts. Increase the bag speed to 40 bags/minute and start the machine, listen for any abnormal noise, if everything is functioning correctly let the machine run for 5 -10 minutes. Turn off the machine and re-inspect each station re tighten any loose parts, inspect back of the machine, re tighten any loose parts.

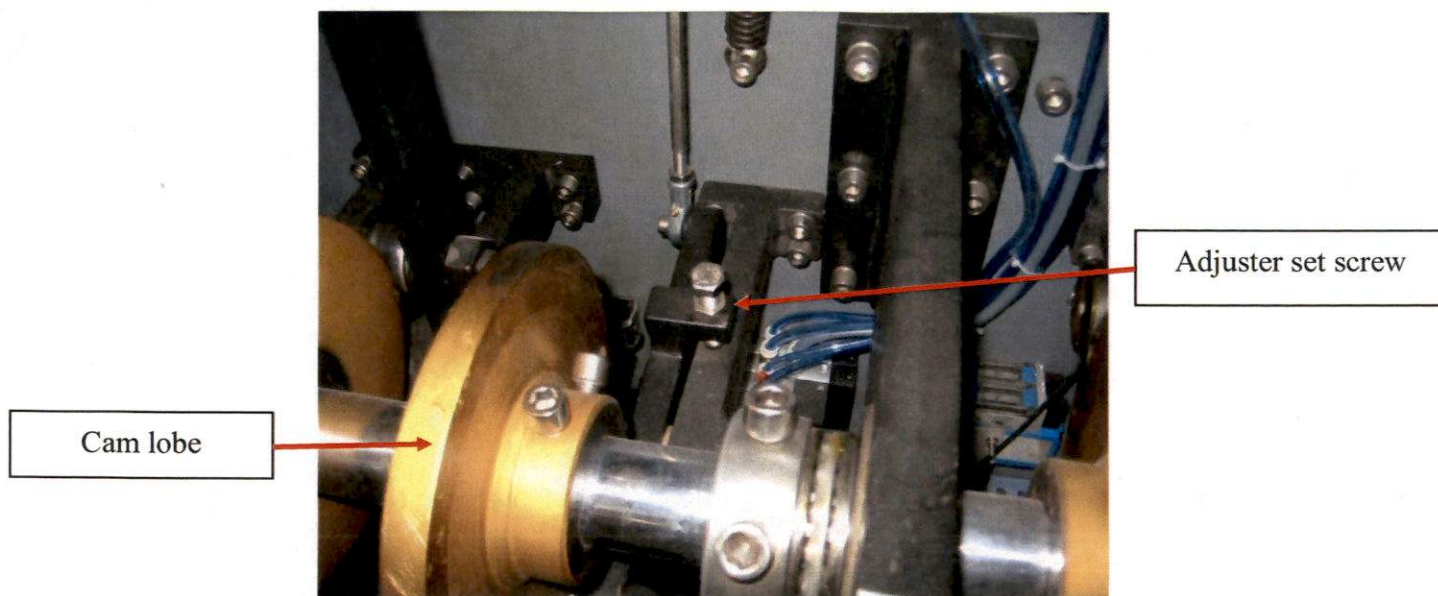
4.2.12 Drawing station – Bag Opening

Loosen 4 bolts:
arms will now be
able to move.
Adjust and re
tighten.



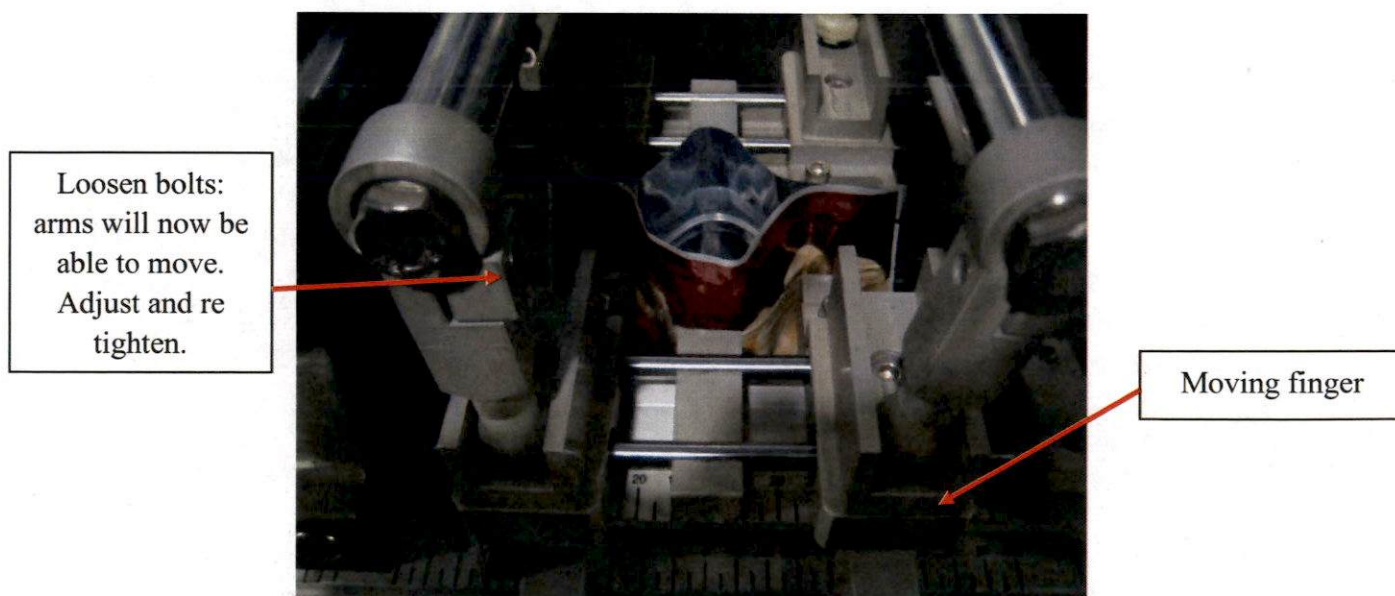
Moving finger

Drawing station to assist opening of bags

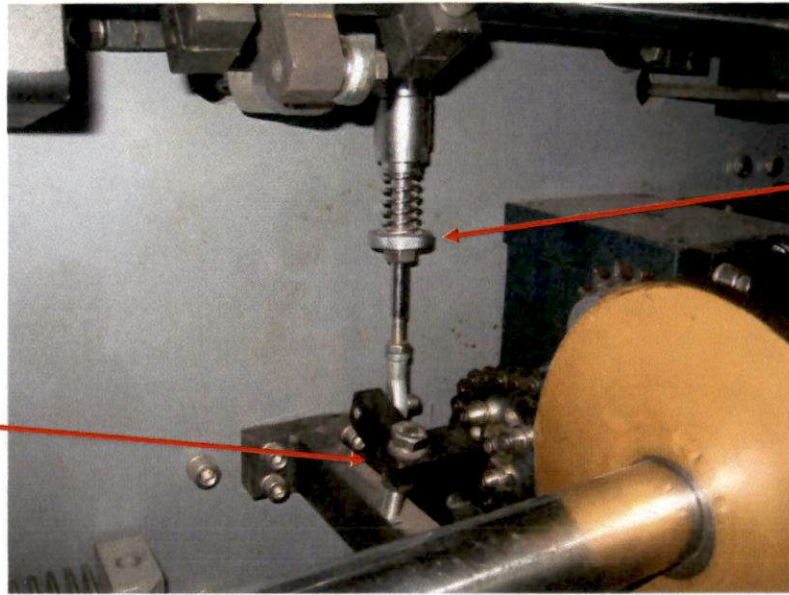


If more or less draw is required loosen nut on the adjuster set screw, then increase or decrease amount of travel by turning screw clockwise or counter clockwise. Please use extreme caution; machine should be in Manu Run mode during this adjustment. As the cam lobe moves through its cycle, pressure will be on and off the set screw which will allow you to turn it. When position is set retighten nut on set screw.

4.2.13 Drawing station – Bag Closure



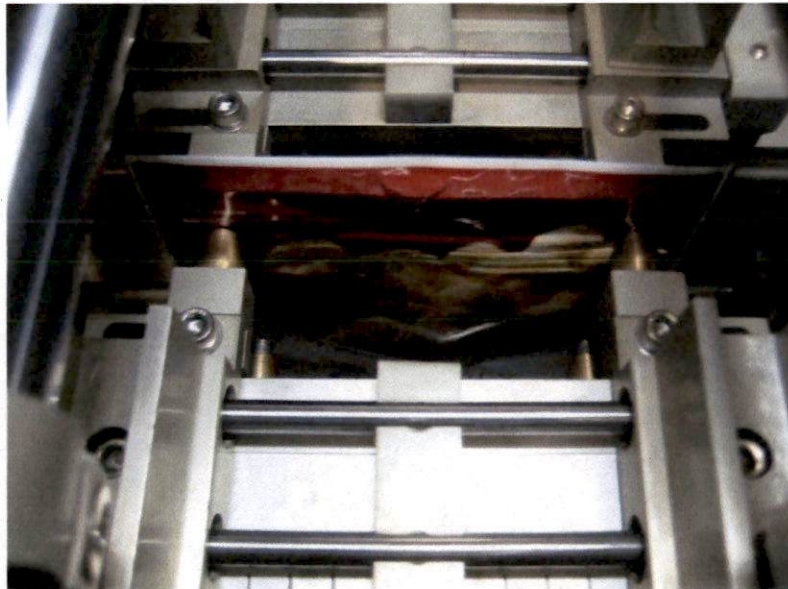
If the moving fingers are too far in or out loosen the 4 bolts and adjust as required



Fine adjustment

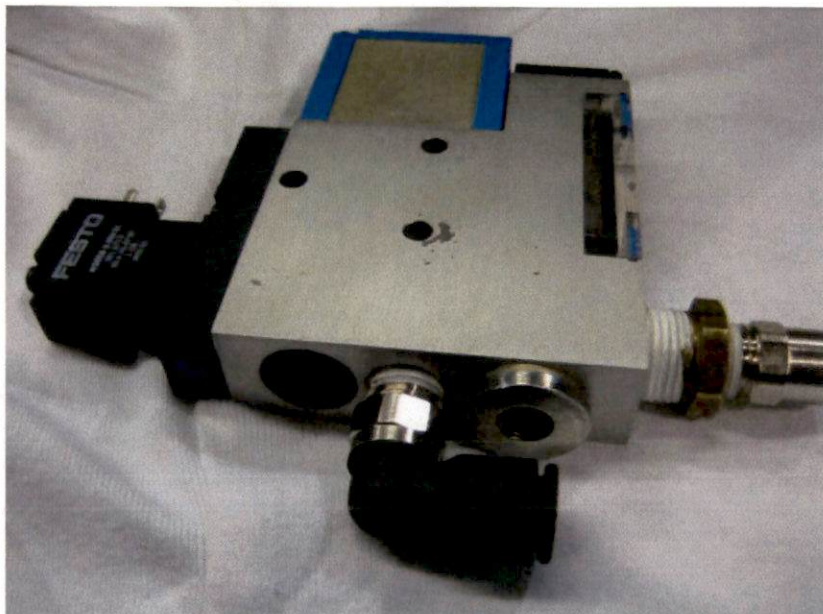
Set screw for
general
adjustment.

If more or less drawing in the closing station is required, the set screw is used for general adjustment. The turn buckle with spring will then be used for fine adjustment.

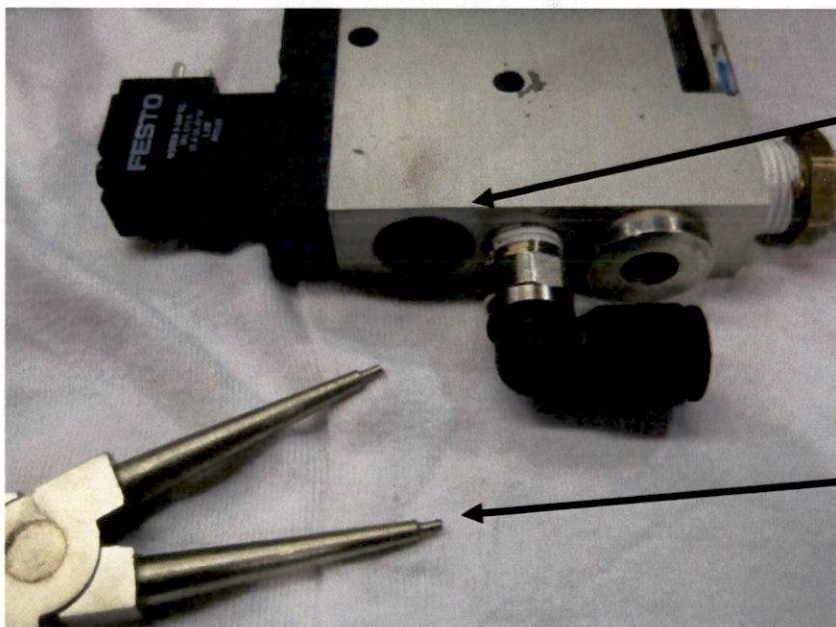


After correct adjustments bag is drawn closed completely. Use caution when setting draw, if there is too much drawing, the bags can be damaged.

4.2.14 Replacement of springs for Vacuum Generator Valves



Vacuum Generator
Models 200 and 300
P107381-031
P107381-054



Using snap ring pliers
remove snap ring

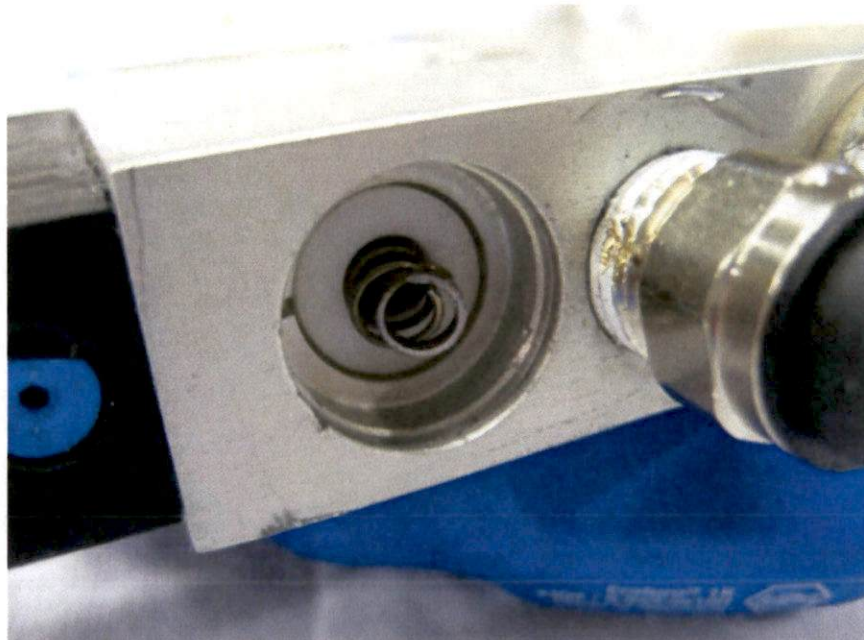
Snap ring pliers



Snap ring removed



Using small flat blade screw driver remove plastic cover to expose spring



Remove the broken spring



Insert new spring part no.
P107381-058



Reinstall plastic cover and snap ring. Identify part with notation of spring replacement, and reinstall in machine or return to stock.

4.3 Auto Run Process

4.3.1 Main Menu



Auto Run – enables you to run the Swifty with your filler with automatic cycles

Manu Run – enables you to run the various components individually to verify machine operations, trouble shooting or set-up

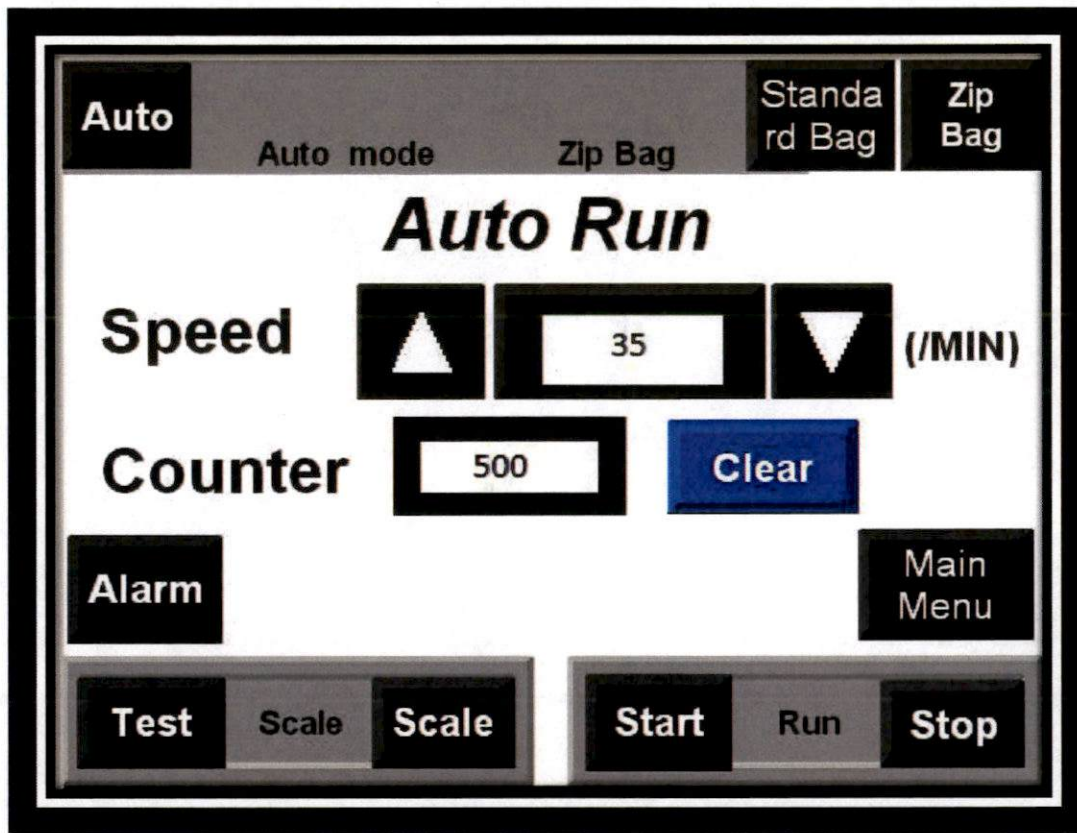
PLC Input – shows the activation of inputs during operation

Options – allows you to turn on various options such as bag shaker, gas flush or hole punch (when equipped)

Screen Config – allows you to change the date and time or operating programs. Only WeighPack Systems Inc. technicians should use this screen.

4.3.2 Auto Run

Turn on the machine main power switch once power is supplied to the system. The Swifty bagger Main Menu page will be displayed, by pressing Auto Run on the touch screen it will enter into the Auto Run screen. You can only start the machine when the four security doors are firmly closed and scale is ready. You can run the machine without the scale when the test button is pressed on the bottom left corner of the touch screen.



Auto Mode (top left corner) must show: AUTO mode to start machine. When returning from the manual screen it will still show MANU, pressing this button twice will put the machine into the Auto mode for operation.

Standard Bag/Zip Bag –These buttons allow you to enable the standard bag operation or zipper bag operation. Only use the Zip Bag mode when you have the zipper attachment equipped.

Speed –By pressing and holding the middle of this button it will bring up the number key pad screen which will enable you to select your bag/minute speed setting. Pressing the arrow up or down will allow you to change the speed one at a time.

Clear – Press and hold this button to clear your bag counter.

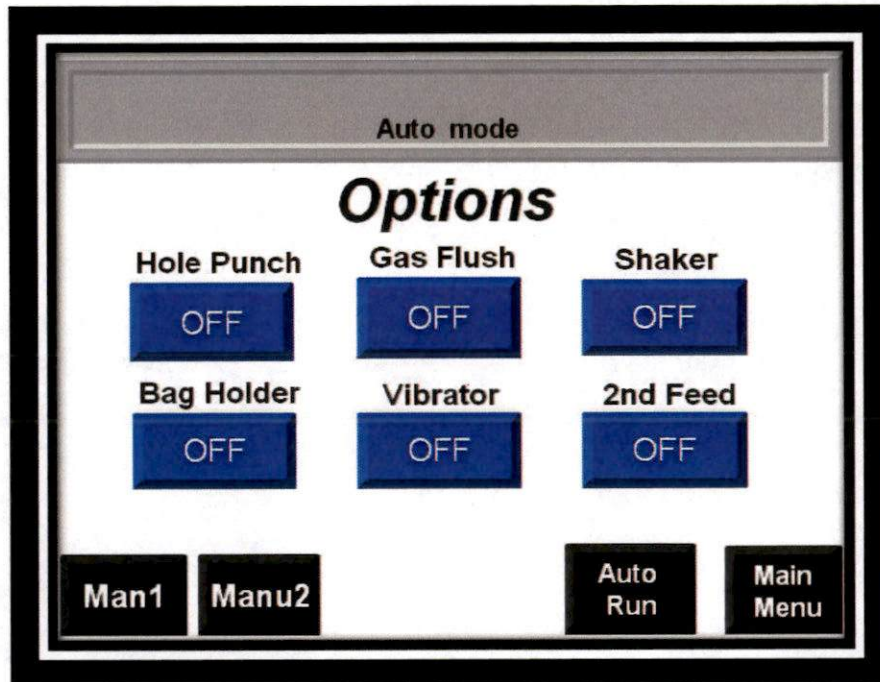
Alarm – Use the alarm button to return to the alarm screen.

Main Menu – returns you to the Main Menu screen

Test – Scale – This button toggles the communication off & on to the filler. When the middle window is in test this allows you to run the Swifty with bags but no filling. When the Scale button is selected the filler will

4.3.3 Options Screen

Return to the Main Menu & select the Options button.



In the Options screen you can activate various components by toggling them on & off. Note that these options must be equipped with your Swifty Bagger

Hole Punch –The hole punch punches a hole into the sealed bag

Gas Flush –Nitrogen can be injected in to the bags

Shaker – Activates the shaker table

Bag Holder – Vacuum suction cup holders to transfer bags into the filling section

Vibrator – Activates the vibrator on the funnel

2nd Feed – if two filling stations are used will allow for second signal for discharging

Manu 1 and Manu 2 – will jump to the manual mode screens

Auto Run – returns you to the Auto Run screen

Main Menu – returns you to the Main Menu page

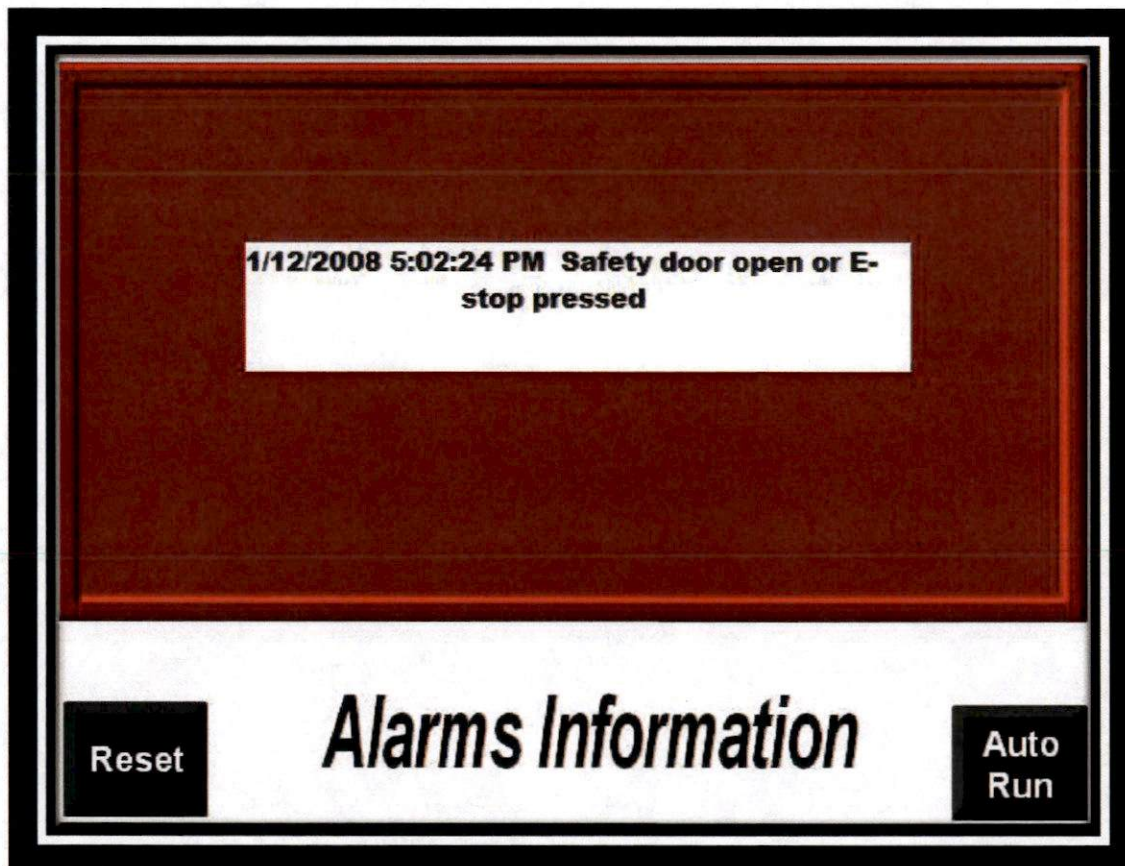
4.3.4 Running Process

Depending on bag style select Standard Bag or Zip Bag by pressing on the appropriate button

- Press the “start” button and the main motor will begin, the bag dispensing arm will travel up into the bag magazine, the vacuum switch will activate and the suction cups will then secure the bag.
- The bag dispensing arm will travel back to the down position
- Once the bag is in the ready position the Swing Fingers will secure the bag and transfer the bag to the opening station.
- At the bag opening station the fixed fingers will move in to secure the bag and then the swing fingers will release the bag and travel back to the bag dispenser.
- At the bag opening station the bag opening suction cups will travel in to meet the bag, the vacuum will activate as the suction cups grab the bag.
- The moving fingers will draw in to assist as the suction cups begin to travel back and top of the bag is opened.
- Once the top of the bag is opened the vacuum for the suction cup shuts off and the swing finger comes back to the bag to secure it and then advances the bag to the next station.
- The swing fingers transport the partially opened bag to the air blower station. Once at the blower station the fixed fingers secure the bag and then the blower descends partially into the bag and air is blown in to fully open the bag.
- When the fixed finger is at the closed position and the bag is being blown, the scale will start releasing material in to the previously opened bag and stops 0.2 seconds later.
- During filling the vibrator mounted to the funnel (if equipped) will start when the fixed finger is fastened and scale finishes releasing product.
- After filling the swing fingers transport the now filled bag to the drawing station.
- At the drawing station the moving fingers will draw the bag closed.
- The bag is then transported by the swing fingers to the heat sealing station.
- Once sealed the swing fingers transport the sealed bag to the cold press station.
- Once pressed the swing fingers move and discharge the bag onto the conveyor

4.3.5 Alarms

- **Alarm Stop:** When the machine is in Auto Run, it will shut down immediately if the security doors are opened. The Alarm Information screen will appear. With the doors closed you must reset the Alarm.
- **Scale Not Ready:** When machine is in Auto Run, it will continue running, however if there is no discharge signal from the scale for 3 cycles the bagger will stop and the alarm screen will display a message "Scale Not Ready". After re-filling the scale you must reset the Alarm.



Reset – pressing reset clears the alarm signal, only when the source of alarm has been cleared

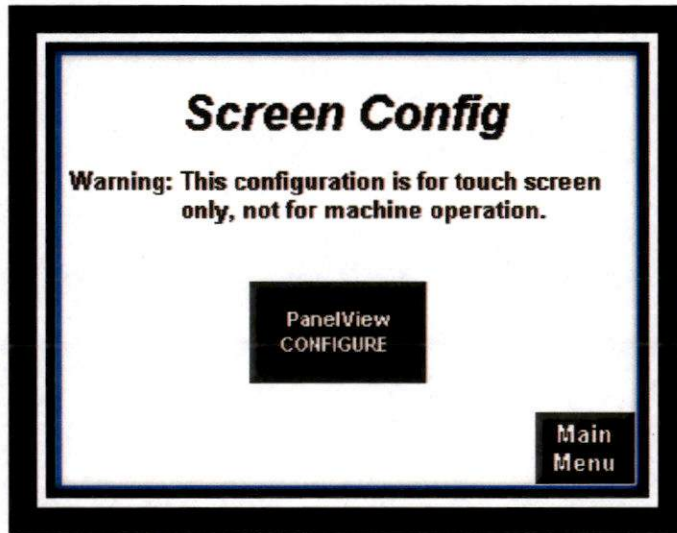
Auto Run – returns you to the Auto Run screen to resume operation.

If your machine will not start after resetting the Alarm, return to the Alarms screen & reset it again to ensure that the Alarms are returned to normal.

4.3.6 Special Notes

Touch screen function configuration (**Only Weighpack Technicians should use this screen**)

From the main menu, press  to enter this screen as shown below:



The screen Config, allows you to change the date and time, and is also used for uploading new operational programs.

5. Maintenance & Cleaning

5.1 Cleaning

5.1.1 Safe Cleaning

Please follow these rules when maintaining the machine:

- Power off the machine before maintenance.
- Use proper tools
- Do not forget to reinstall any covers or parts removed.
- Do not throw away bolts, spring washer, etc.

5.1.2 Instructions for cleaning

- Use soft cloths to clean the front end of the machine before you start using it. Do not clean the machine while it is running.
- If cleaning detergent or other liquid is required in cleaning, ensure they are not spilled onto the machine or the electrical components.
- If the touch screen is dirty clean with a soft cloth
- Clean all finger tips on the upper and lower arms.

5.1.3 Notes

- Install air cleaner at the air supply pipe to filter the air.
- Do not disassemble the touch screen, PLC or power flex converter. Please contact Weighpack or Allen Bradley for maintenance.

5.2 Maintenance

5.2.1 Operator Qualifications

Maintenance personnel should have a strong electro-mechanical background and be familiar with auto-control theory. They must have experience in maintaining auto-control systems, and be familiar with all the components of the machine such as PLC functions and temperature controls. They must understand the operating manual, and be able to troubleshoot mechanical and electric components.

Operators should have relevant machine operating experience and be familiar with all of the functions of this machine.

5.2.2 Daily Maintenance

Daily Check List

Photocopy & use our template

Date: _____

Operator Name: _____

1. Verify Fingers are firmly secured
2. Apply grease to all fittings on the front of the machine
3. Drain air reservoir tank to eliminate water build up
4. Air is connected
5. Verify air pressure setting
6. Power is supplied
7. Suction cups are not torn or ripped
8. Turn on Heat sealer
9. Cycle machine in manual observe each station for misaligned fingers, re adjust and tighten if required
10. Check drawing stations
11. Verify funnel is centered to fixed finger arm
12. Stop Machine
13. In Manual Mode verify the following:
 - Operate the Bag Dispenser On/Off
 - Operate the Bag Opener On/Off
 - Operate Blower #1 On/Off
 - Operate the Conveyor On/Off
14. Cycle machine in Manual Mode observe funnel travel, fingers of funnel should open and close easily
15. Check funnel movement and springs
16. With machine running open doors, alarm should sound
17. Per lubricating schedule apply lubricate as indicated
18. Prepare bags for production

[illegible]

X

Sign here _____

5.2.3 Monthly Maintenance

Front of Machine:

1. Ensure fingers are tight to railings
2. Check spring tension on finger tips
3. Refer to Maintenance and Lubrication drawing 1 for all lubrication points (Layouts & Drawings Appendix)
4. Apply lithium #2 grease to all fittings
5. Apply lithium #2 grease to Zipper attachment
6. Replace Teflon tape if required
7. Check funnel springs
8. Check fasteners on zipper attachment if equipped
9. Retighten all bolts
10. Check all suction cups for damage and replace if damaged.
11. With a damp cloth clean all suction cups
12. Clean all finger tips
13. Clean sealing station seal bars and cold press station
14. Check all air lines and fittings for any signs of wear

Back of Machine:

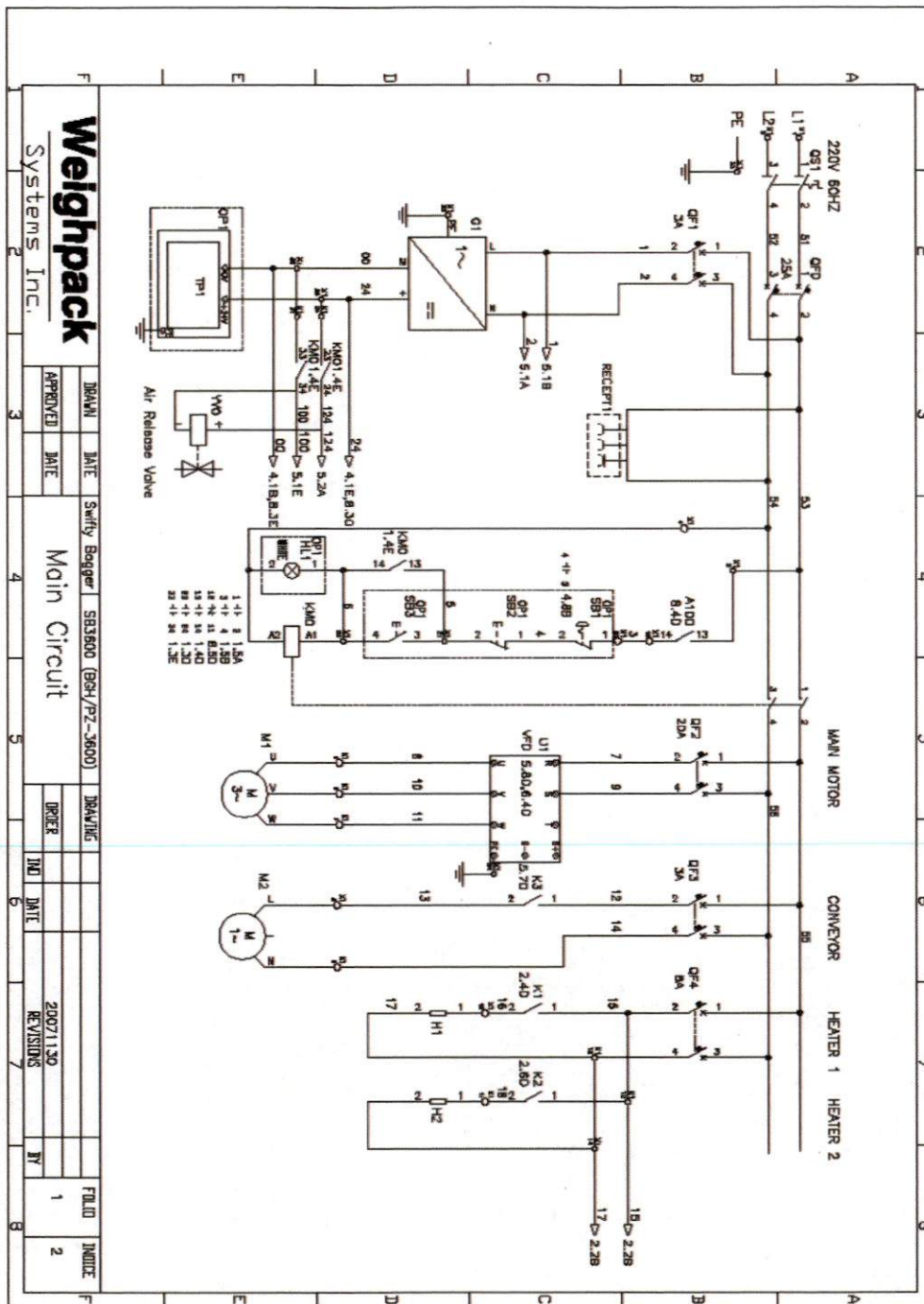
1. Remove and clean all vacuum generator filters
15. Refer to Maintenance and Lubrication drawing 2 for all lubrication points (Layouts & Drawings Appendix)
2. Apply lithium #2 grease to chains and bearings
3. Check all wires in electrical cabinet that they are secure
4. Tighten all bolts and Allen screws
5. Check oil level in gear box
6. Check oil level in cam boxes
7. Carefully tighten all proximity sensors (shifting position will affect machine timing)
8. Remove drain plug from air reservoir tank
9. Check tension on all springs
10. Check tension on all chains
11. Check all air lines for any signs of wear

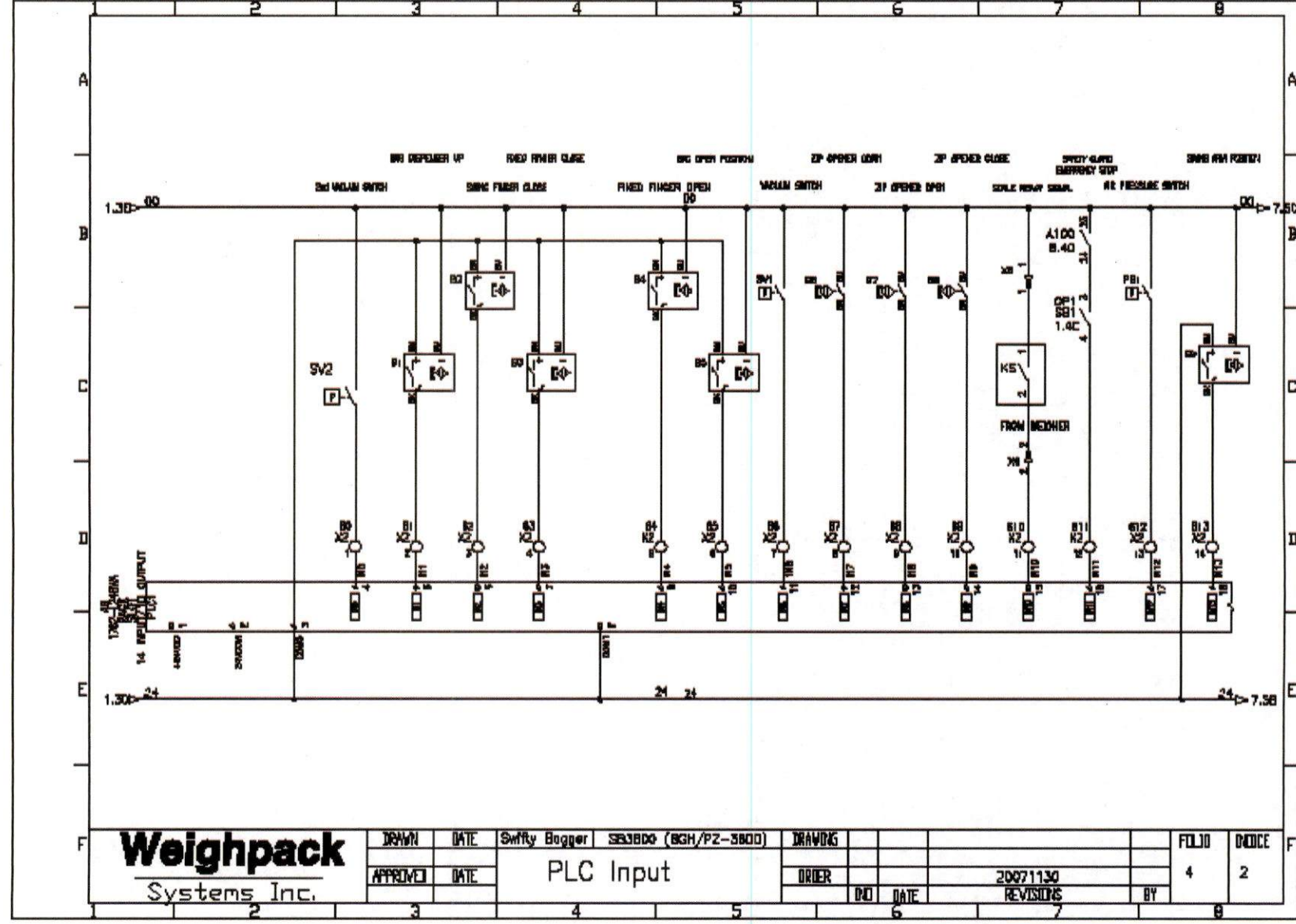
6. Troubleshooting Guide

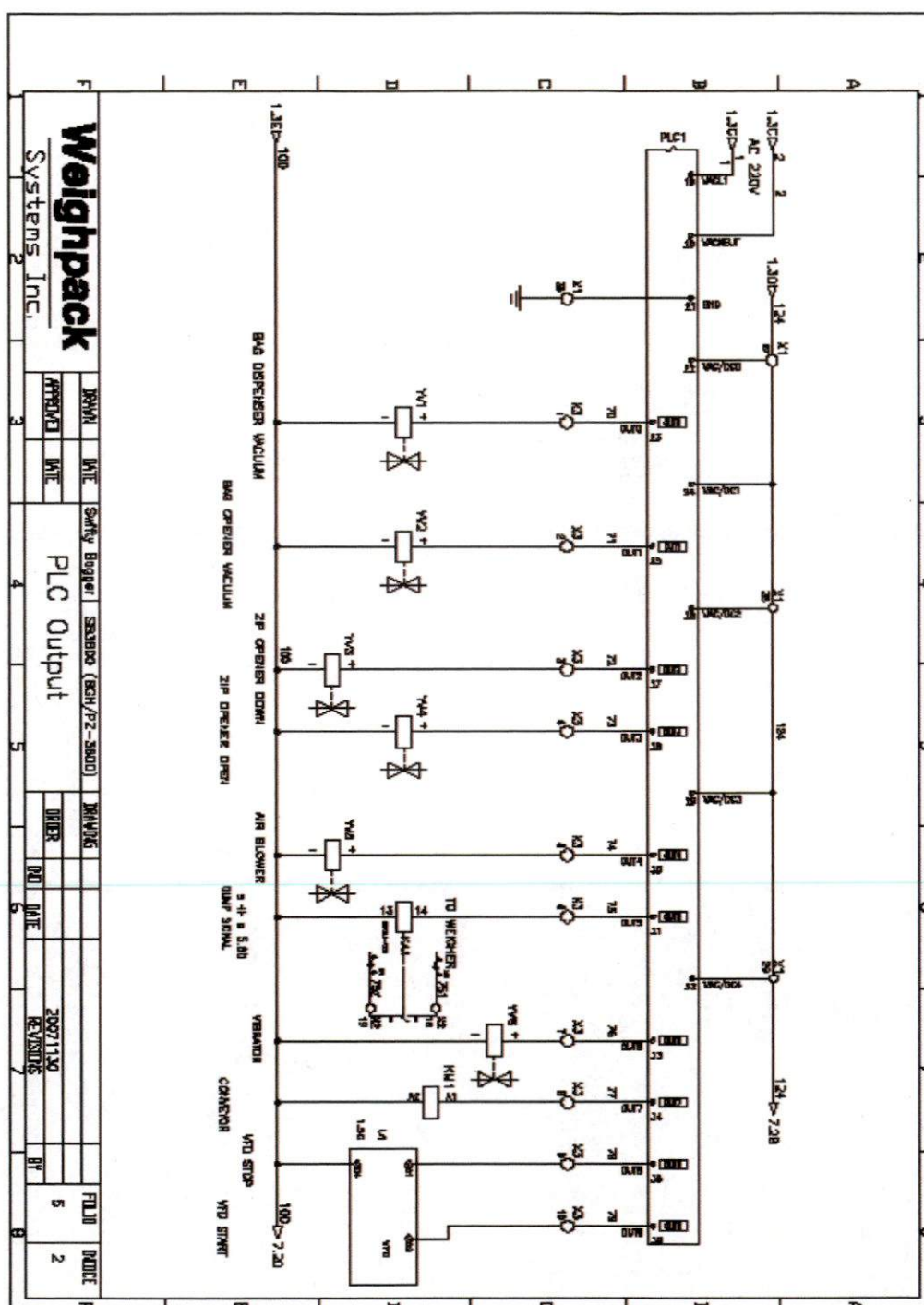
This troubleshooting guide is designed to assist in dealing with the most common scenarios that you may encounter.

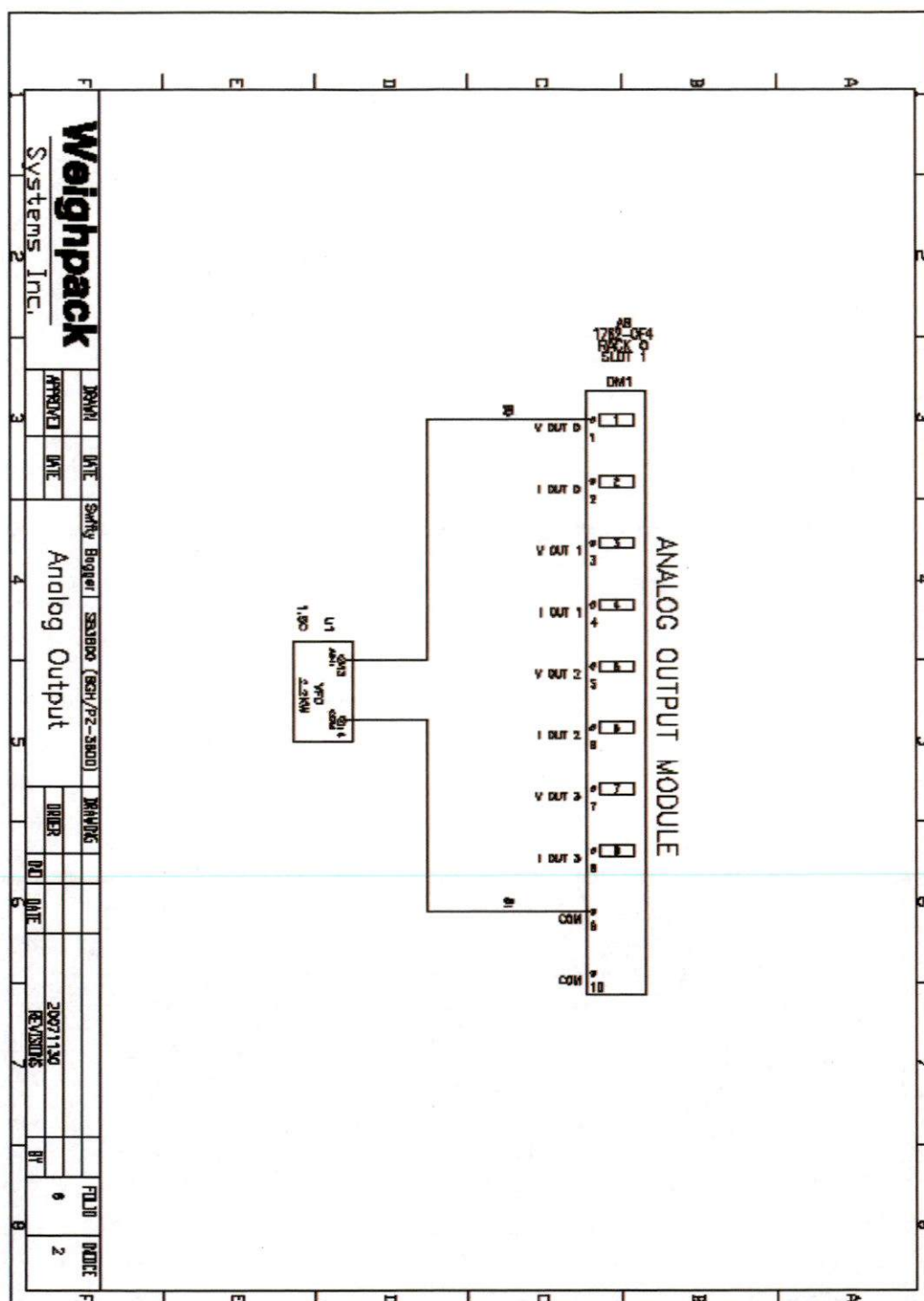
Problem	Solution
1. Vacuum Generator will not turn off	➤ Refer to Spring replacement instruction located in this manual ➤ Verify proximity sensor switch is in correct position ➤ Check connection ➤ Possible broken vacuum
2. Bags dropping from fingers	➤ Check finger alignment ➤ check finger spring tension ➤ check bag placement in magazine ➤ Clean finger tips
3. Bag Dispensing	➤ Check placement of suction cups & verify position with bag in magazine ➤ Check magazine adjustments ➤ Check incoming air pressure ➤ Suction cups damaged ➤ proximity sensor switch out of position ➤ alignment bars out of position
4. Suction cup vacuum stays on constantly	➤ proximity sensor switch out of position ➤ spring in vacuum generator damaged refer to replacement instruction
5. Machine will not stop when pressing Stop	➤ Press and hold stop button for 5 seconds ➤ adjust proximity sensor switch on cam box (see section 13.3 machine layout 1)
6. Scale not discharging at correct time	➤ advance or retard collar on main shaft (see 13.4 machine layout 2)
7. Zipper operation	➤ Confirm zipper option was selected on touch screen ➤ Timing is essential, observe timing of fingers with movement of suction cups, they should move together ➤ Adjust flow control valves for more or less air flow

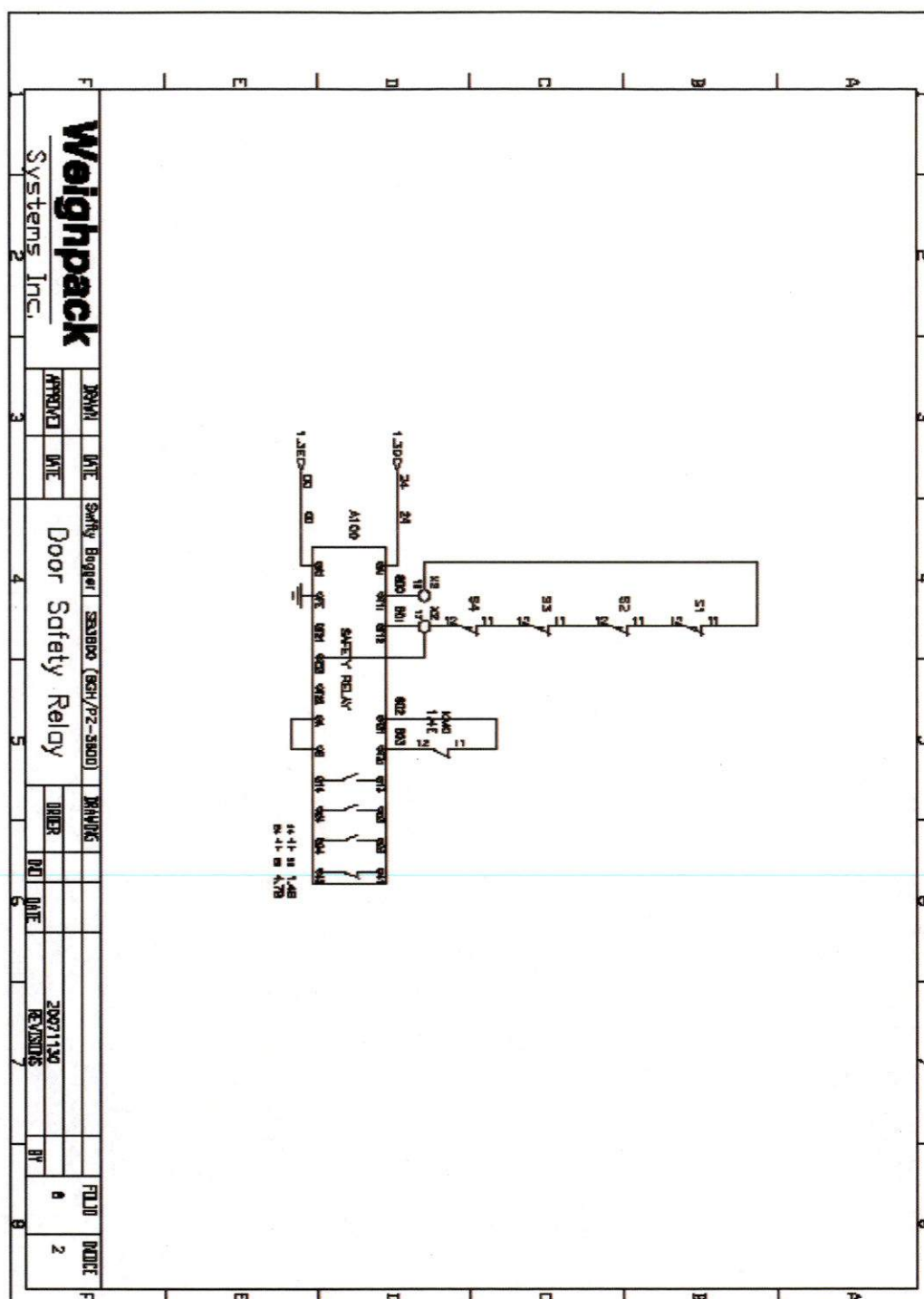
Appendix A: Electrical Schematics

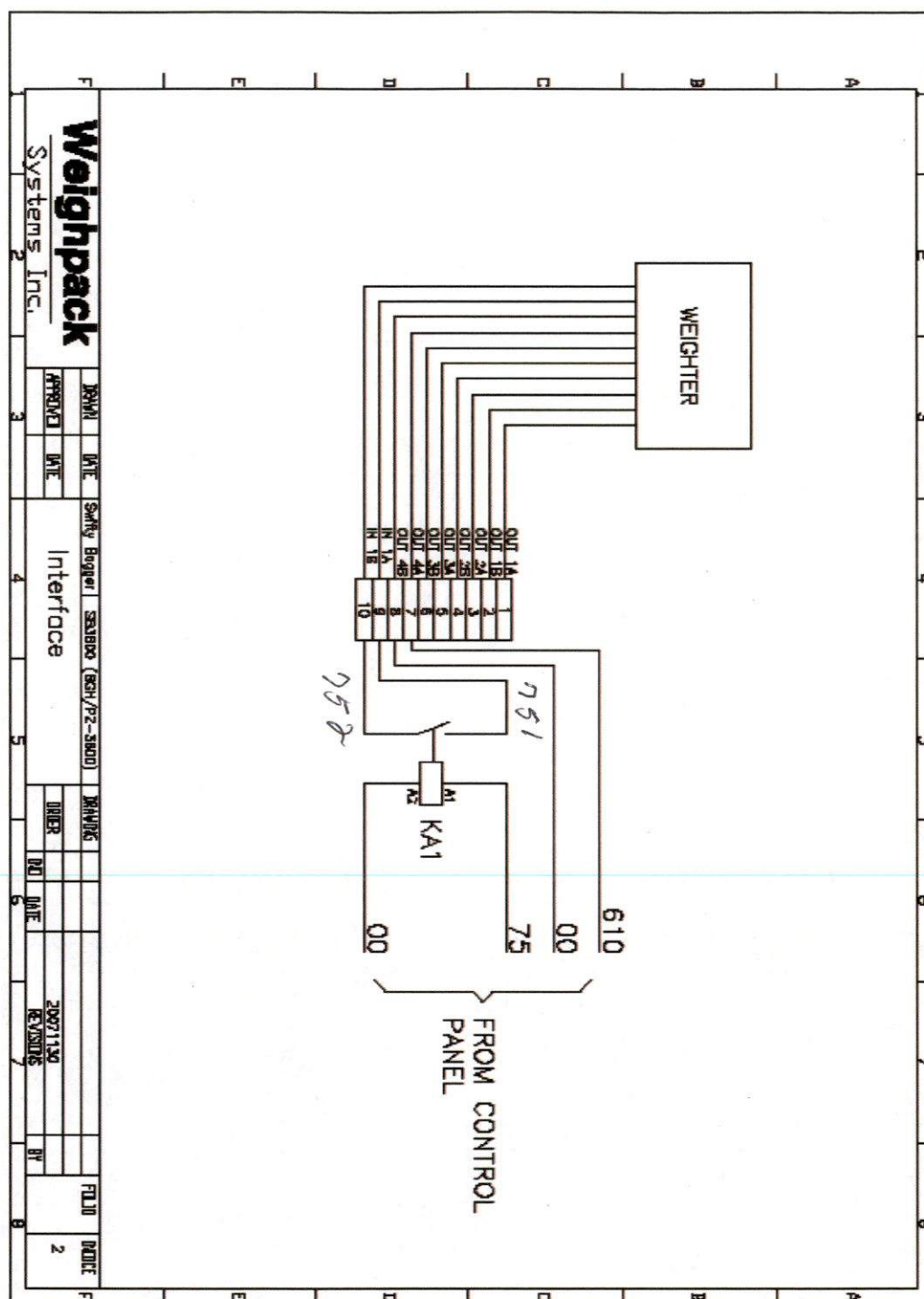


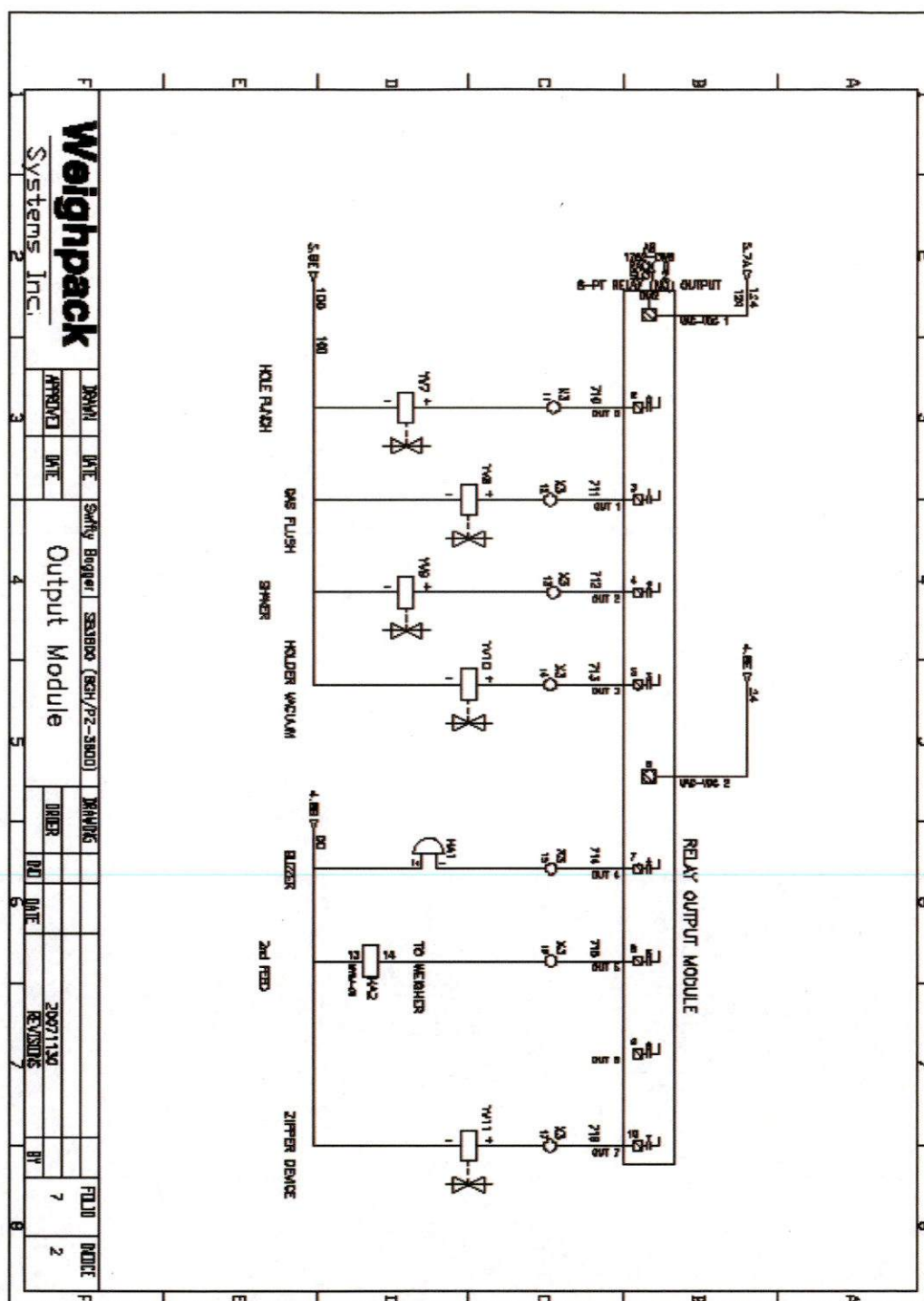


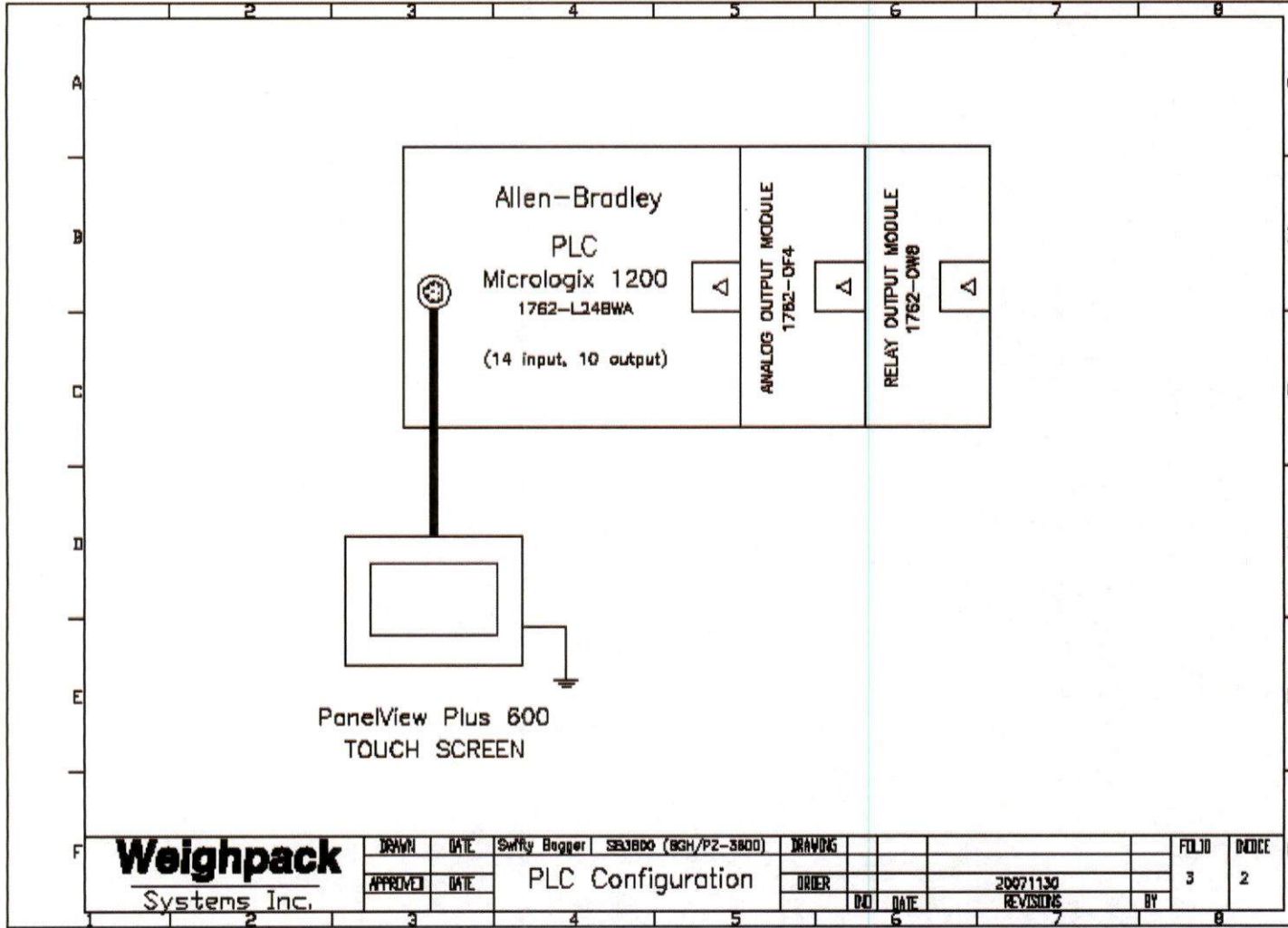






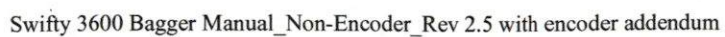


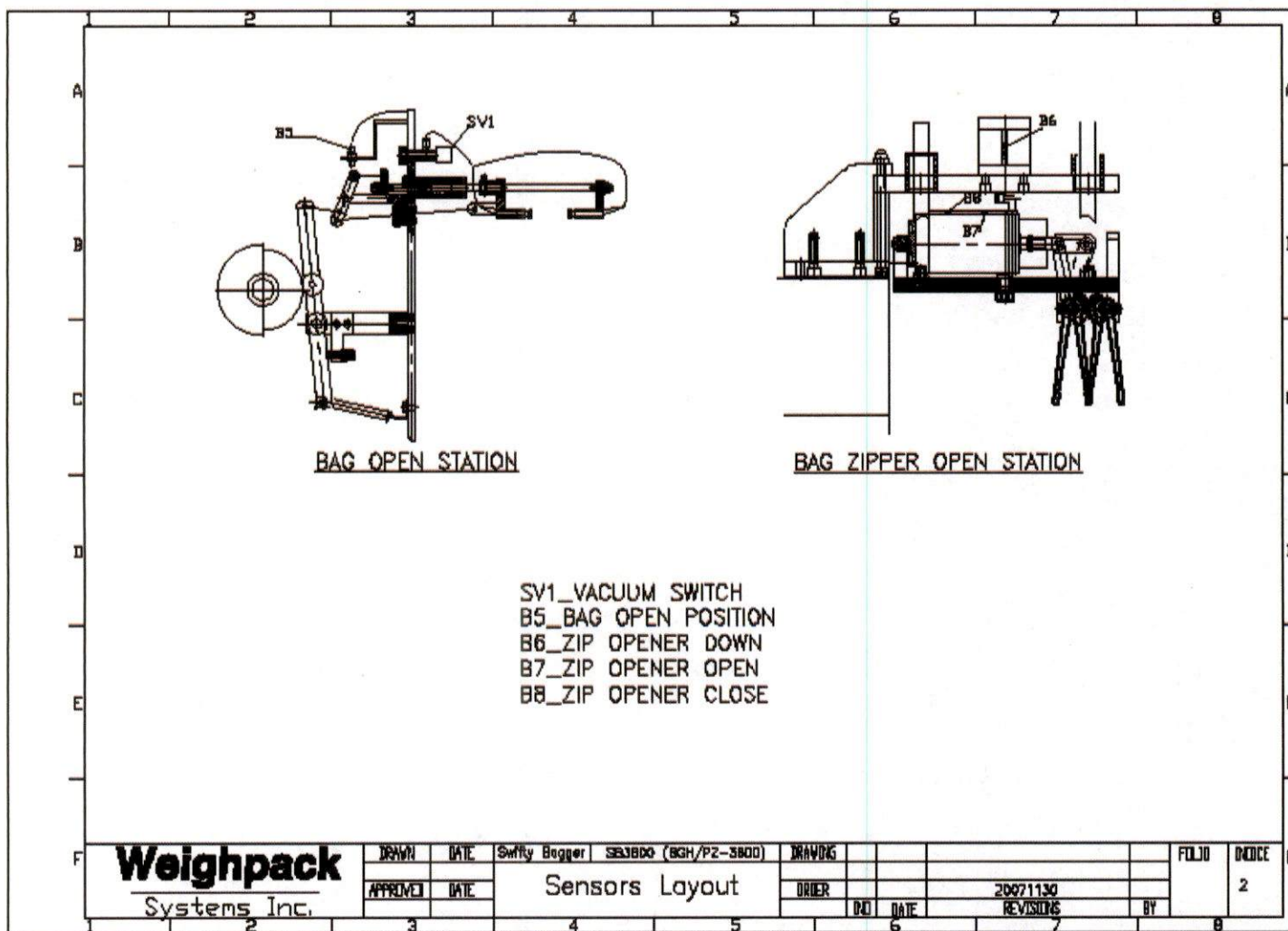


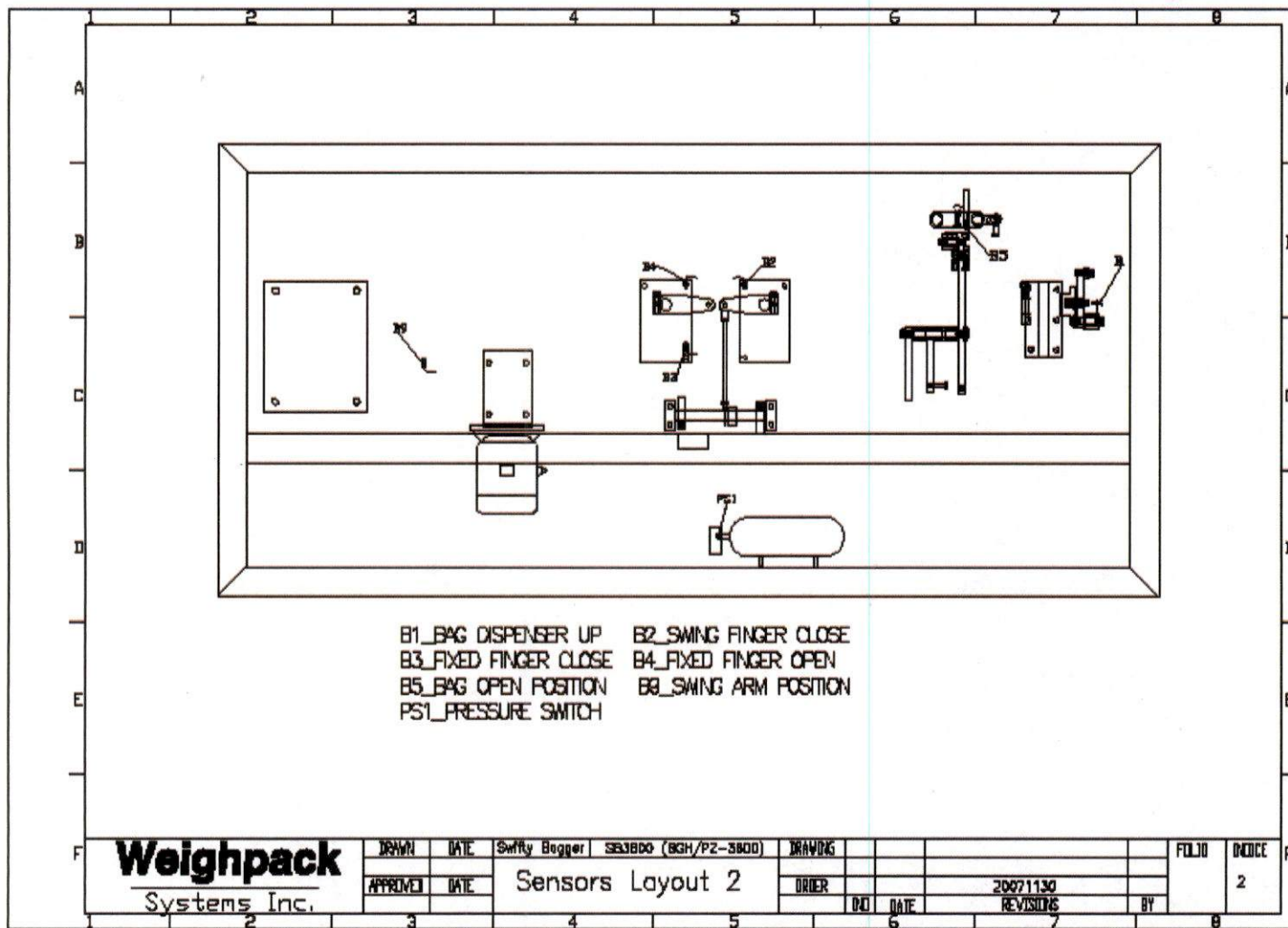


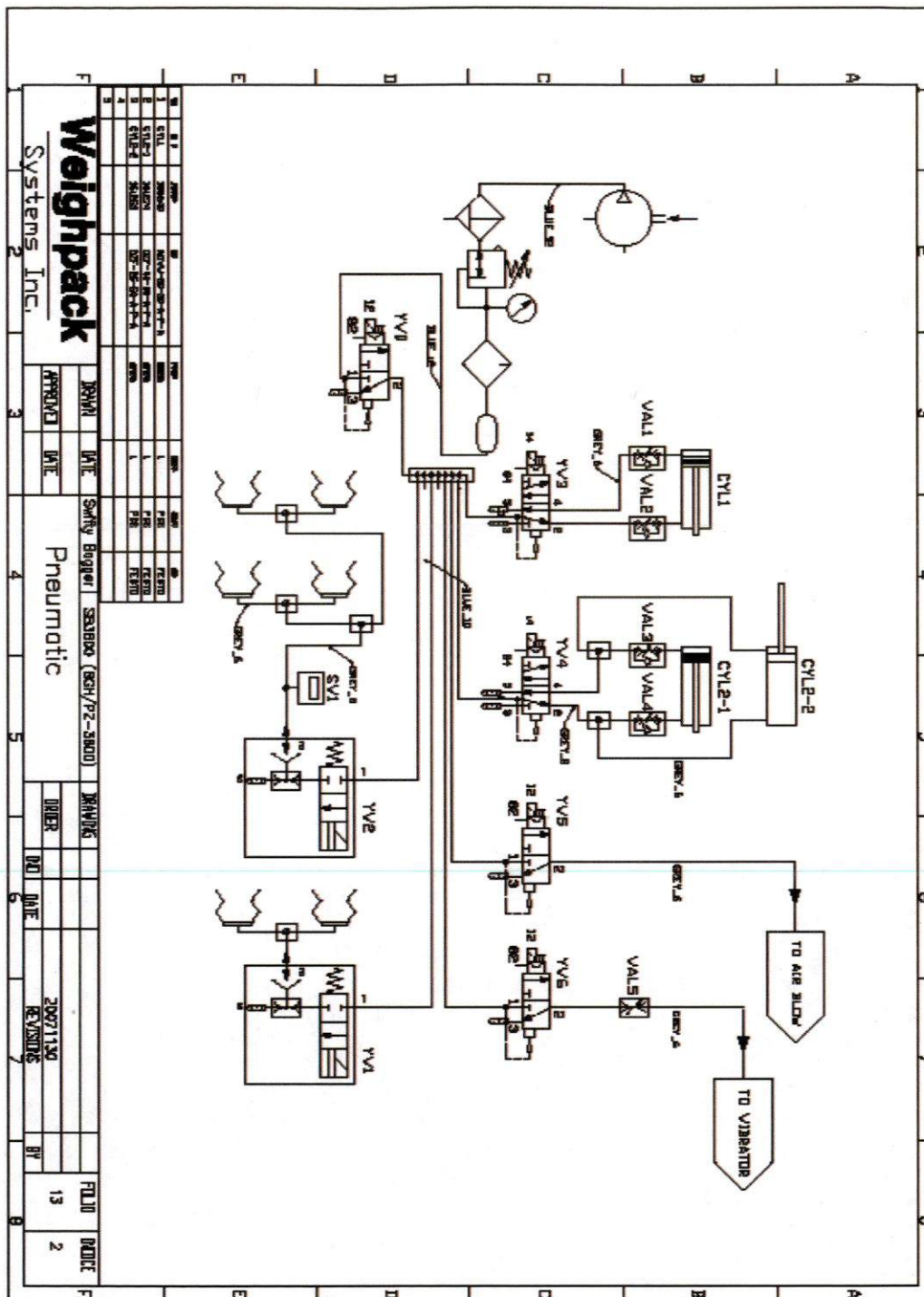
Weighpack
Systems Inc.

DRAWN	DATE	Swiftly Bagger	SB3600 (BGH/PZ-3600)	DRAWING						FOLD	DVICE
APPROVED	DATE	PLC Configuration			ORDER			20071130		3	2
					DD	DATE		REVISIONS	BY		









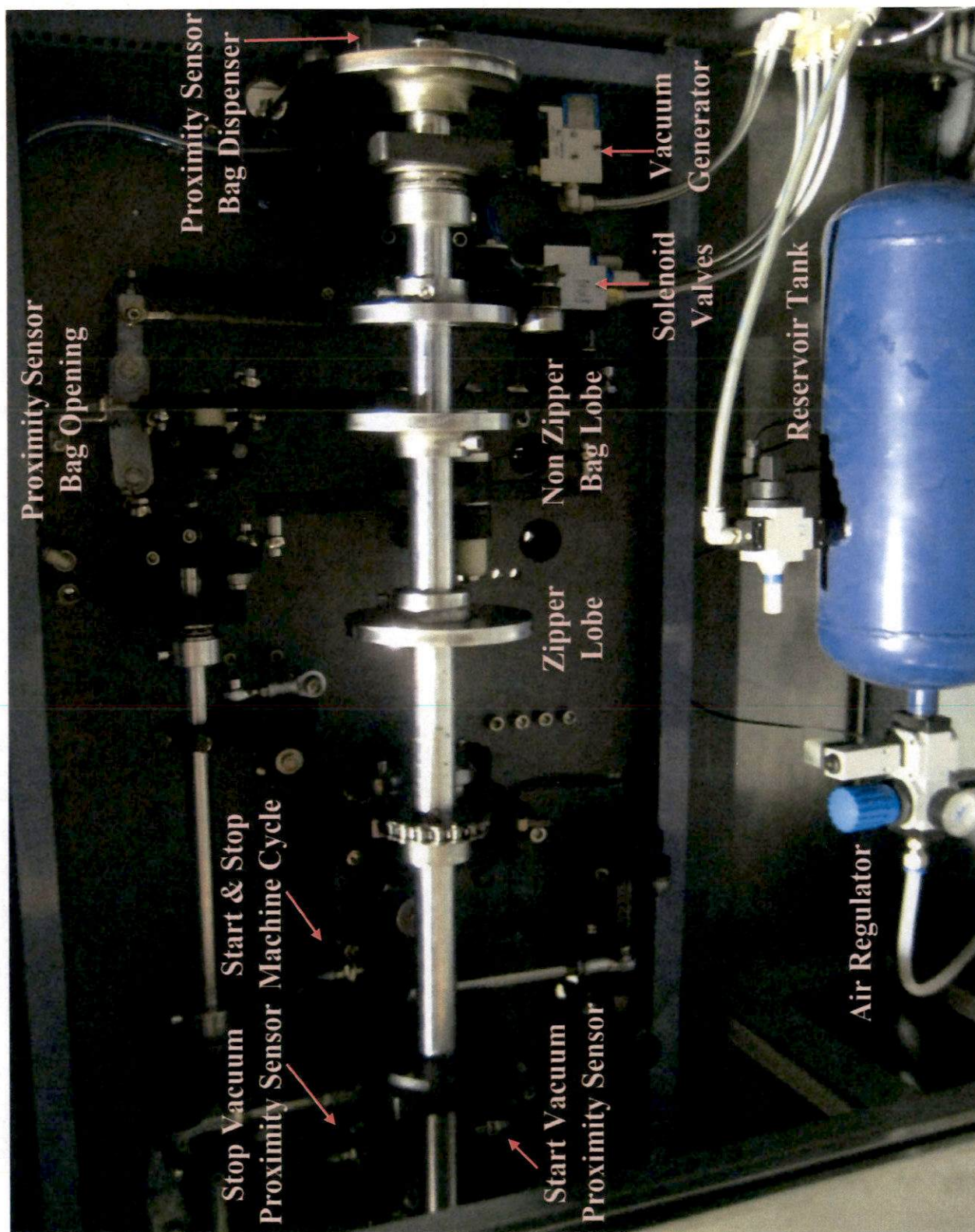
Appendix B: Spare Parts List

Recommended Spare Parts

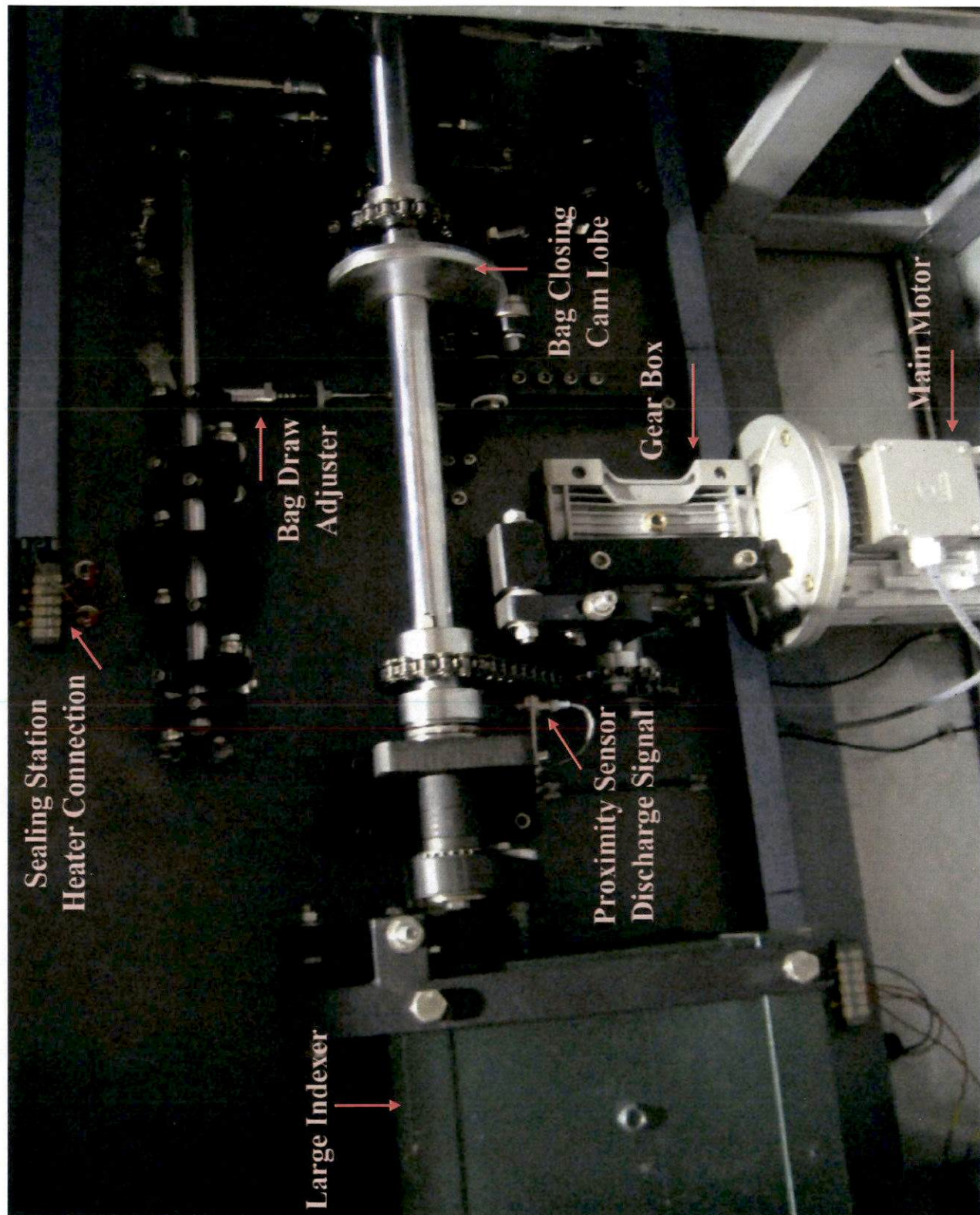
Part Number	Description	Quantity
A100759-141	Brass Tip Finger Assembly (brass housing, pin and spring)	10
P107381-011	Nylon Finger Tip	10
P107381-021	Cartridge heating element	1
P107381-031	Vacuum Generator Model 200	1
P107381-054	Vacuum Generator Model 300	1
P108218-000	Solenoid Valve	1
P108218-001	Solenoid Valve	1
P107381-072	Solenoid and Vacuum Valve Connectors	1
P107815-000	Suction Cups 15mm dia.	4
P107814-000	Suction Cups 30mm dia.	4
P107381-059	Torsion Spring for Funnel (per funnel)	2
P107167-003	Double Lip Seal 30mm x 40mm x7mm	2
P107381-029	Proximity Sensor with Cable	1

Appendix C: Layouts & Drawings

Machine Interior Layout 1

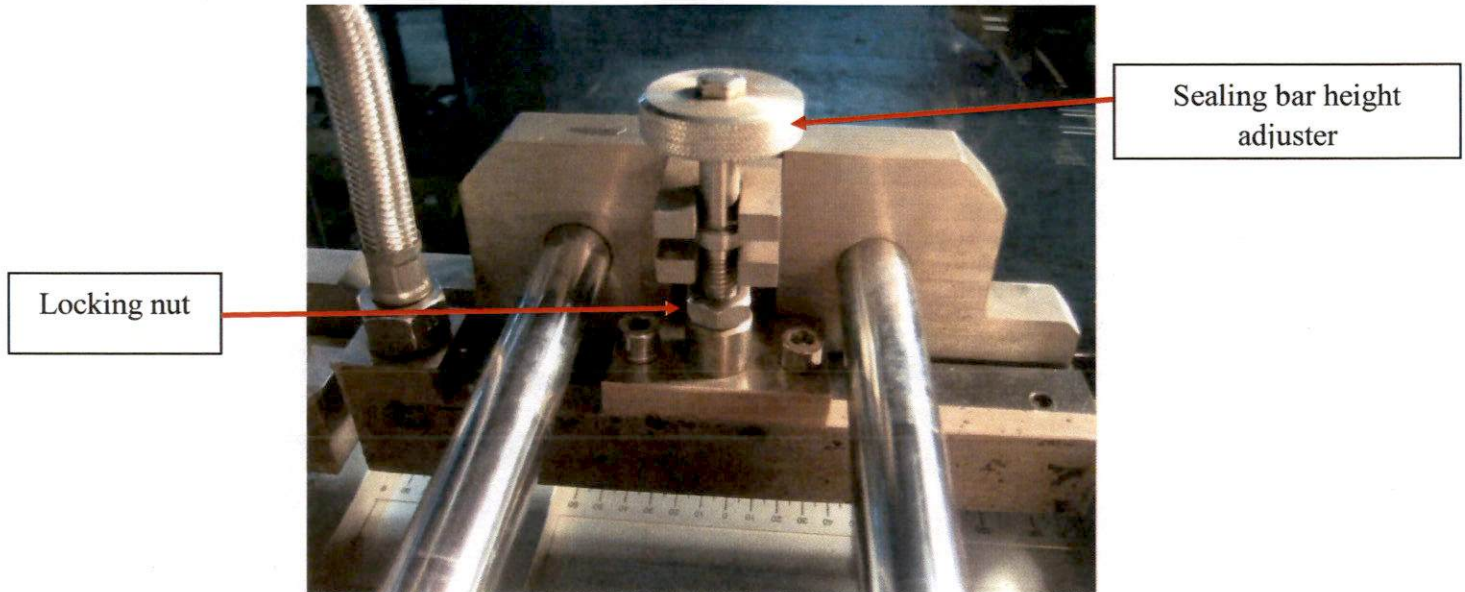


Machine Interior Layout 2



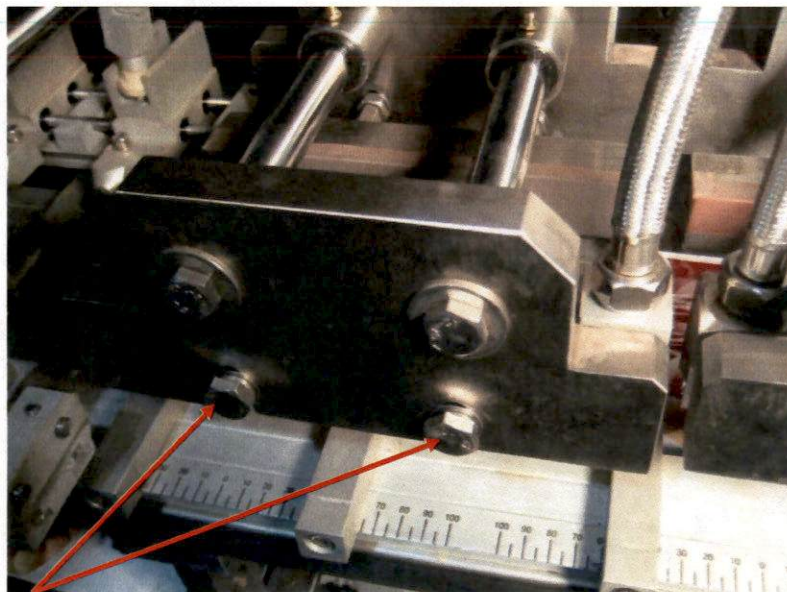
Heat Sealing Stations Layout- 2 Versions

Version 1



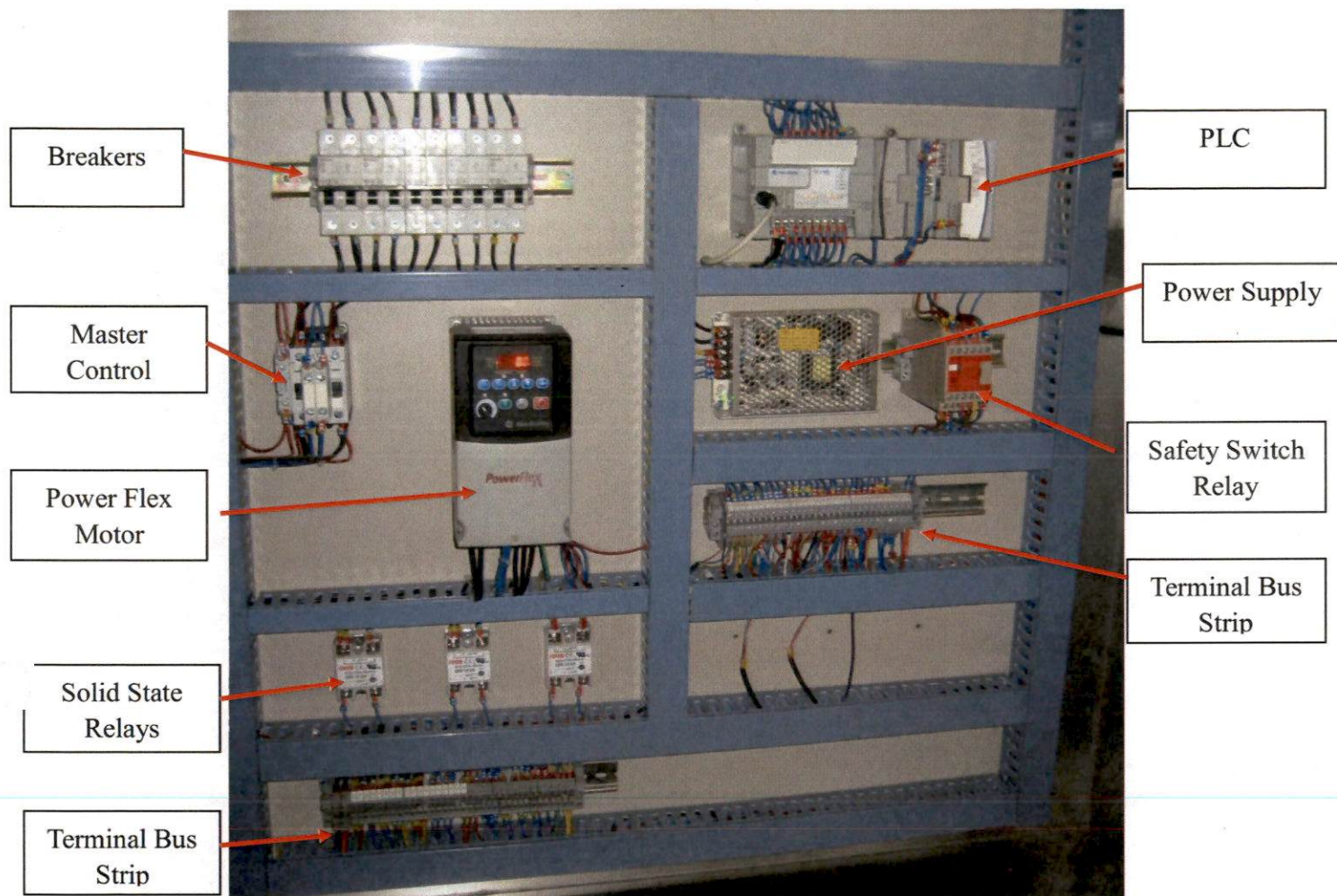
Depending on the model, some Swifty Baggers will be equipped with this style of heat sealing station. The locking nut should be checked daily.

Version 2



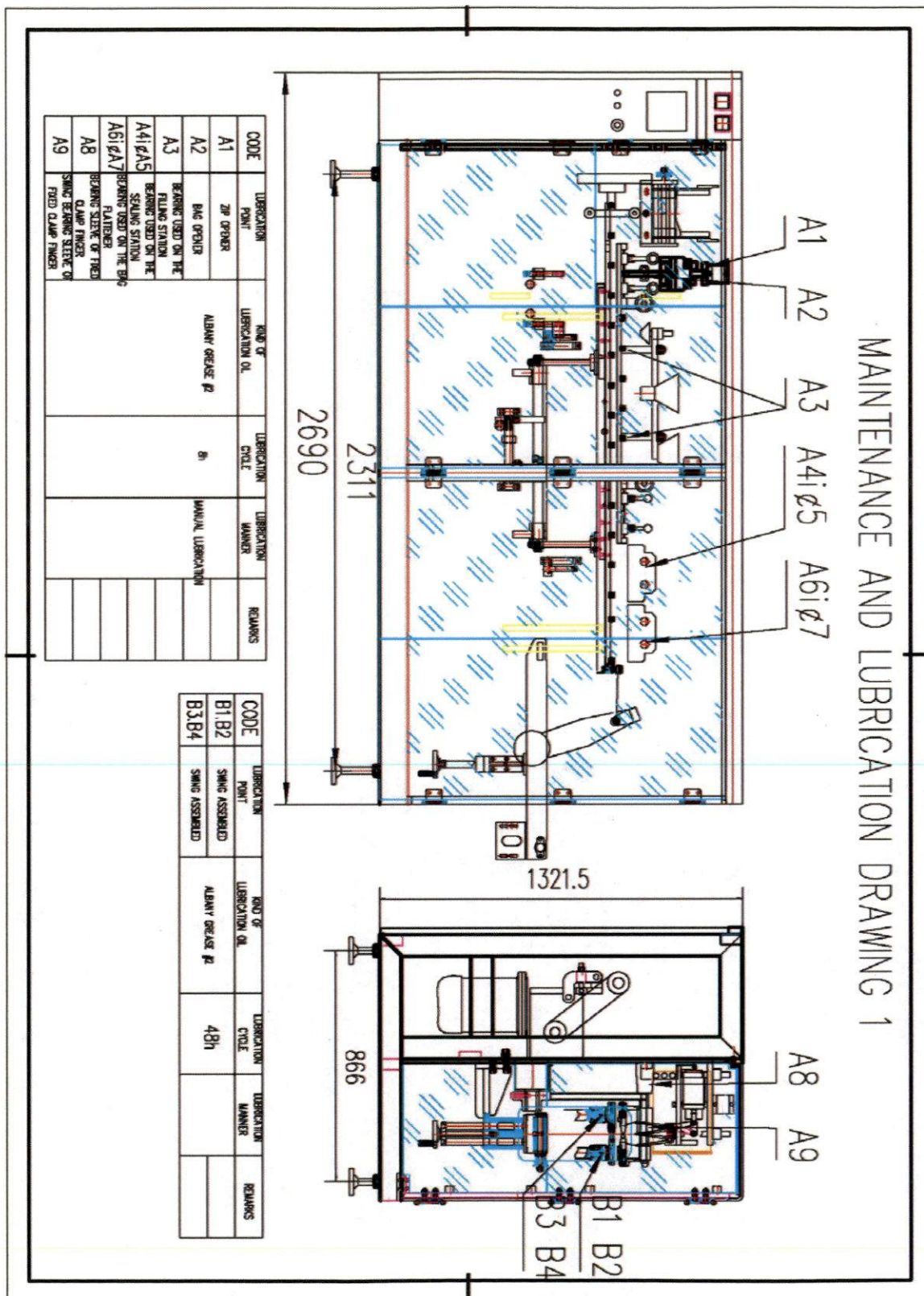
On this version the two lower bolts secure the sealing bar to the housing and are also used to set the height of the sealing bar.

Electrical Cabinet Layout

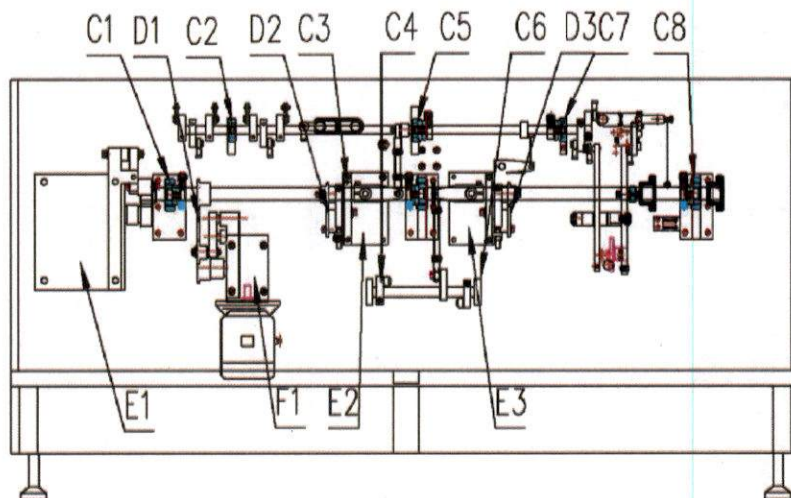


Front Control Panel Layout





MAINTENANCE AND LUBRICATION DRAWING 2



CODE	LUBRICATION POINT	KIND OF LUBRICATION OIL	LUBRICATION CYCLE	LUBRICATION MANNER	REMARKS
C1	LEFT BRACKET OF REAR PRINCIPAL SHAFT	ALBANY GREASE #2	100h	MANUAL LUBRICATION	
C2	LEFT BRACKET OF REAR DRIVEN SHAFT				
C3	MIDDLE BRACKET OF REAR DRIVEN SHAFT				
C4	LEFT BRACKET OF REAR SMALL SHAFT				
C5	MIDDLE BRACKET OF REAR DRIVEN SHAFT				
C6	RIGHT BRACKET OF REAR DRIVEN SHAFT				
C7	RIGHT BRACKET OF REAR DRIVEN SHAFT				
C8	RIGHT BRACKET OF REAR PRINCIPAL SHAFT				

CODE	LUBRICATION POINT	KIND OF LUBRICATION OIL	LUBRICATION CYCLE	LUBRICATION MANNER	REMARKS
D1	MOTOR CHAIN	ALBANY GREASE #2	60h	MANUAL LUBRICATION	
D2	CHAIN FOR FIXED CLAMP FINGER				
D3	CHAIN FOR SWING FINGER				

CODE	LUBRICATION CHANGEMENT	KIND OF LUBRICATION OIL	LUBRICATION CYCLE	OIL QUANTITY	REMARKS
E1	BIG INDEXER	G-N680W	5000h	LESS THAN OIL WINDOW	
E2	FIRST SMALL INDEXER				
E3	SECOND SMALL INDEXER				
F1	MOTOR	G-N680W	4000h	1000mL	

REMARKS: PUT LUBRICATION OIL ON EACH JOINT BEARING ONCE TIME/48HOURS

Swifty Bagger

Horizontal Bagging Machine

Encoder Addendum



WEIGHPACK
Systems, Inc.

Foreword

This addendum is provided to give you more information on your Swift Bagger whether equipped or retro fitted with **Encoder**. It is upgraded to give the end user more flexibility and easier adjustment of the options and output included.

The main difference between the **Encoder** and **Proximity sensors** model is the type of input that was being used to synchronize each individual output and function on the bagger.

In the **Proximity sensor model**, proximity sensors located on the cam are use to synchronize the sequence of the output and option on the machine. The outputs and options timing adjustment can be done manually by adjusting the position of the proximity switches located on the back of the machine see pages 44 and 45 of your USER MANUAL for reference.

In the **Encoder model** Encoder attached to the main shaft that holds all the cams reads the exact position of the shaft axis then sends the exact position of the axis with a very high precision to the PLC to synchronize movement precisely. The outputs and options timing can be done easily on the **Parameter Setting Screen** on the touch screen which this addendum explains.

IMPORTANT: The Encoder **zero** position of the Swift 3600 Bagger is the highest position of the bag dispenser suction cups.

A 3 Main Menu

Note: This replaces Main Menu on page 26 of your USER MANUAL.



Auto Run – Enables you to run the Swifty with your filler into automatic cycles.

Manu Run – Enables you to run various components individually to verify machine operations, trouble shooting or set-up.

PLC Input – Shows the activation of inputs during operation.

Parameter – Allows you to change the activation time of each output and option included on the machine.

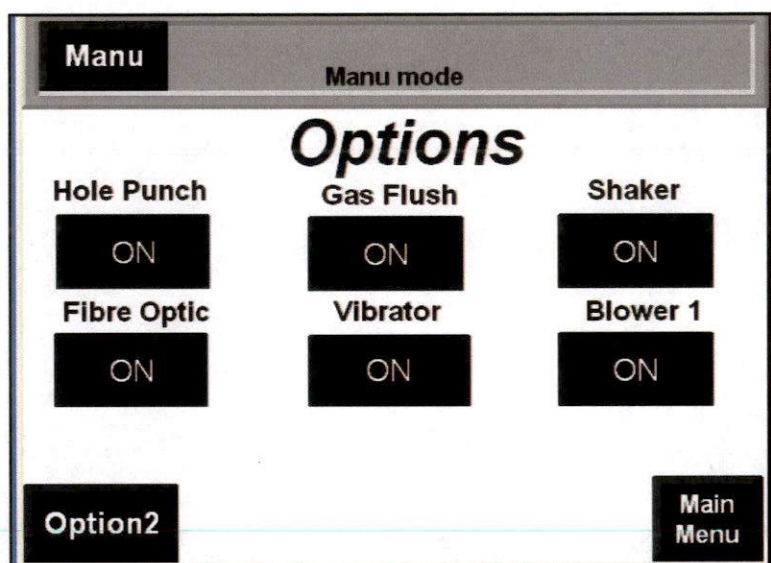
Options – Allows you to turn on various options such as bag shaker, gas flush or hole punch (when equipped).

Screen Config – Allows you to change the date and time or operating programs. Only WeighPack Systems Inc. technicians should use this screen.

A 3.1 Options Screen

Note: This replaces the Options Screen on page 28 of your USER MANUAL.

Note: In the Options screen you can activate various features by toggling them on & off. Note that these options must be equipped with your Swifty Bagger.



Hole Punch – Touch this button to enable Hole punch Option ON or OFF. This option is use to punch a hole into the sealed bags.

Gas Flush – Touch this button to enable Gas Flush Option ON or OFF. This option is use to fill nitrogen gas inside the filled bag.

Shaker – Touch this button to enable Shaker Option ON or OFF. This option is use to shake the product allowing it to fit nicely in the bag.

Fiber Optic – Touch this button to enable Fiber Optic Option. This option is use to detect if the bag is completely open before getting into the filling station. The sensor is usually attached into the plunger in the bag blowing station. If bag is not detected by front and back sensor in the plunger product is not going to be dumped in the bag. *Note: If your machine is equipped with Bag opener Vacuum Sensor you will have to choose only one of the two.*

Vibrator – Touch this button to enable the vibrator Option ON or OFF. This option uses a vibrator usually attached to the funnel to allow easier flow of product in the funnel.

Blower 1 – Touch this button to enable Blower 1 Function ON or OFF. This option is use to blow the bag open on the bag opening station normally if your equipment is not equipped with Zipper Opener.

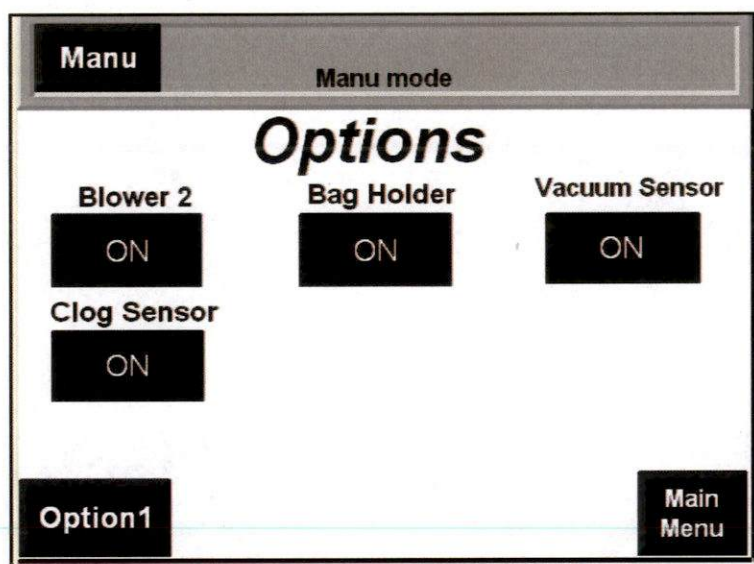
Option 2 – Brings you to Option 2 screen.

Main Menu – Touch this key to go back to the main menu.

A 3.2 Options Screen

Note: This replaces the Options Screen on page 28 of your USER MANUAL.

Note: In the Options screen you can activate various features by toggling them on & off. Note that these options must be equipped with your Swifty Bagger.



Blower 2 – Touch this button to enable Blower 2 Option ON or OFF on Bag Blower Station your machine is not equipped with Zipper Opener Attachment

Bag Holder – Touch this button to enable Bag Holder Option ON or OFF. This function activates the suction cups vacuum to hold bag and to make sure that the bag is completely open before getting into the filling station.

Vacuum Sensor – Touch this button to enable Vacuum Sensor Option ON or OFF on the Bag Holder. This option is used to add extra condition to be satisfied to detect if bag is still open from the Bag Opener Station to Filling Station. *Note: If your machine is equipped with Fibre optic sensor you will have to choose either one of the two.*

Clog Sensor – Touch this button to enable the Clog Sensor Option ON or OFF. This function is use to detect if there is a clog on the funnel.

Option 1 – Brings you to Option 1 Screen.

Main Menu – Touch this key to go back to the main menu.

A 3.3 Parameter Setting: Allows you to change the activation time of each output and option included on the machine. **Note.** This is an additional section on Chapter 6 of your USER MANUAL. NNNNN is for illustration purposes only it stands for any number on the button. To change the Setting touch the buttons then inscribe the desired number.

System Parameter 1

Machine stop position	NNNNN
Bag dispenser up start position	NNNNN
Bag dispenser up end position	NNNNN
Bag opener start position	NNNNN
Bag opener end position	NNNNN
ZIP open position	NNNNN

Para 2
Axis position **NNNNN**
Main Menu

Machine stop position – Axis position when fixed finger is close. This is a factory default setting you do not have to change this setting.

Bag dispenser up start position – Touch this button to change the starting activation time of the bag dispenser suction cups vacuum.

Bag dispenser up end position – Touch this button to change the end activation time of the bag dispenser suction cups vacuum.

Bag opener start position – Touch this button to change the start activation time of the bag opener suction cups vacuum.

Bag opener end position – Touch this button to change the end activation time of the bag opener suction cups vacuum.

Zip open position – Touch this button to change the zipper opener finger opening activation time.

Para 2 – Touch this button to go to parameter setting 2 screen.

Axis position – Shows the actual axis position.

Main Menu – Touch this key to go back to the main menu.

A 3.4 Parameter Setting: Allows you to change the activation time of each output and option included on the machine. **Note.** This is an additional section on Chapter 6 of your USER MANUAL. NNNNN is for illustration purposes only it stands for any number on the button. To change the Setting touch the buttons then inscribe the desired number.

System Parameter 2	
ZIP close position	NNNNN
Bag Holder start position	NNNNN
Bag Holder end position	NNNNN
Blower 1 start position	NNNNN
Blower 1 end position	NNNNN
Blower 2 start position	NNNNN
Blower 2 end position	NNNNN
Para3	Factory setting
	Main Menu

- Zip close position** – Touch this button to change the zipper opener finger closing activation time.
- Bag holder start position** – Touch this button to change the starting activation time of the bag holder suction cups vacuum.
- Bag holder end position** - Touch this button to change the end activation time of the bag holder suction cups vacuum.
- Blower 1 start position** - Touch this button to change the starting activation time of the blower 1.
- Blower 1 end position** - Touch this button to change the end activation time of the blower number 1.
- Blower 2 start position** - Touch this button to change the starting activation time of the blower number 2, if equipped.
- Blower 2 end position** - Touch this button to change the end activation time of the blower number 2, if equipped.
- Para 3** – Touch this button to go to parameter setting 2 screen.
- Factory setting** – Touch this button for 5 seconds to reload the factory default parameter settings. You can use this feature to recall the original setting of the machine if you lost them or if you feel it is not right.

Main Menu – Touch this key to go back to the main menu.

A 3.5 Parameter Setting: Allows you to change the activation time of each output and option included on the machine. **Note.** This is an additional section on Chapter 6 of your USER MANUAL. NNNNN is for illustration purposes only it stands for any number on the button. To change the Setting touch the buttons then inscribe the desired number.

System Parameter 3

Gaz Flush start position	NNNNN
Gaz Flush end position	NNNNN
Feed start position	NNNNN
Feed end position	NNNNN
Reference start position	NNNNN
Reference end position	NNNNN

Para4
Factory setting
Main Menu

Gas flush start position-Touch this button to change the starting activation time of the gas flush feature.

Gas flush end position - Touch this button to change the end activation time of the gas flush feature.

Feed start position - Touch this button to change the starting activation of the feed output signal.

Feed end position - Touch this button to change the end activation of the feed output signal.

Reference start position – Axis reference start position for all parameter. This is a factory default setting you do not have to change this setting.

Reference end position – Axis reference end position for all parameter. This is a factory default setting you do not have to change this setting.

Para 4 – Touch this button to go to parameter setting 2 screen.

Factory setting – Touch this button for 5 seconds to reload the factory default parameter settings. You can use this feature to recall the original setting of the machine if you lost them or if you feel it is not right.

Main Menu – Touch this key to go back to the main menu.

A 3.6 Parameter Setting: Allows you to change the activation time of each output and option included on the machine. **Note.** This is an additional section on Chapter 6 of your USER MANUAL. NNNNN is for illustration purposes only it stands for any number on the button. To change the Setting touch the buttons then inscribe the desired number.

System Parameter 4

Shaker start position	NNNNN
Shaker end position	NNNNN
Vibrator start position	NNNNN
Vibrator end position	NNNNN
Hole Punch start position	NNNNN
Hole Punch end position	NNNNN
Axis position	NNNNN

Para1
Save setting
Load setting
Main Menu

Shaker start position - Touch this button to change the starting activation time of the shaker feature.

Shaker end position - Touch this button to change the end activation time of the shaker feature.

Vibrator start position - Touch this button to change the starting activation time of the vibrator feature.

Vibrator end position - Touch this button to change the end activation time of the vibrator feature.

Hole punch start position - Touch this button to change the starting activation time of the hole punch feature.

Hole punch end position - Touch this button to change the end activation time of the hole punch feature.

Axis position – Shows the actual axis position.

Save setting – Touch this button for 3 seconds to save your own setting. This will allow you to save 1 of your own setting.

Load setting – Touch this button to recall your own saved setting if you are currently on factory setting.

Main Menu – Touch this key to go back to the main menu.

PL 2000

WEIGHPACK

SYSTEMS INC.

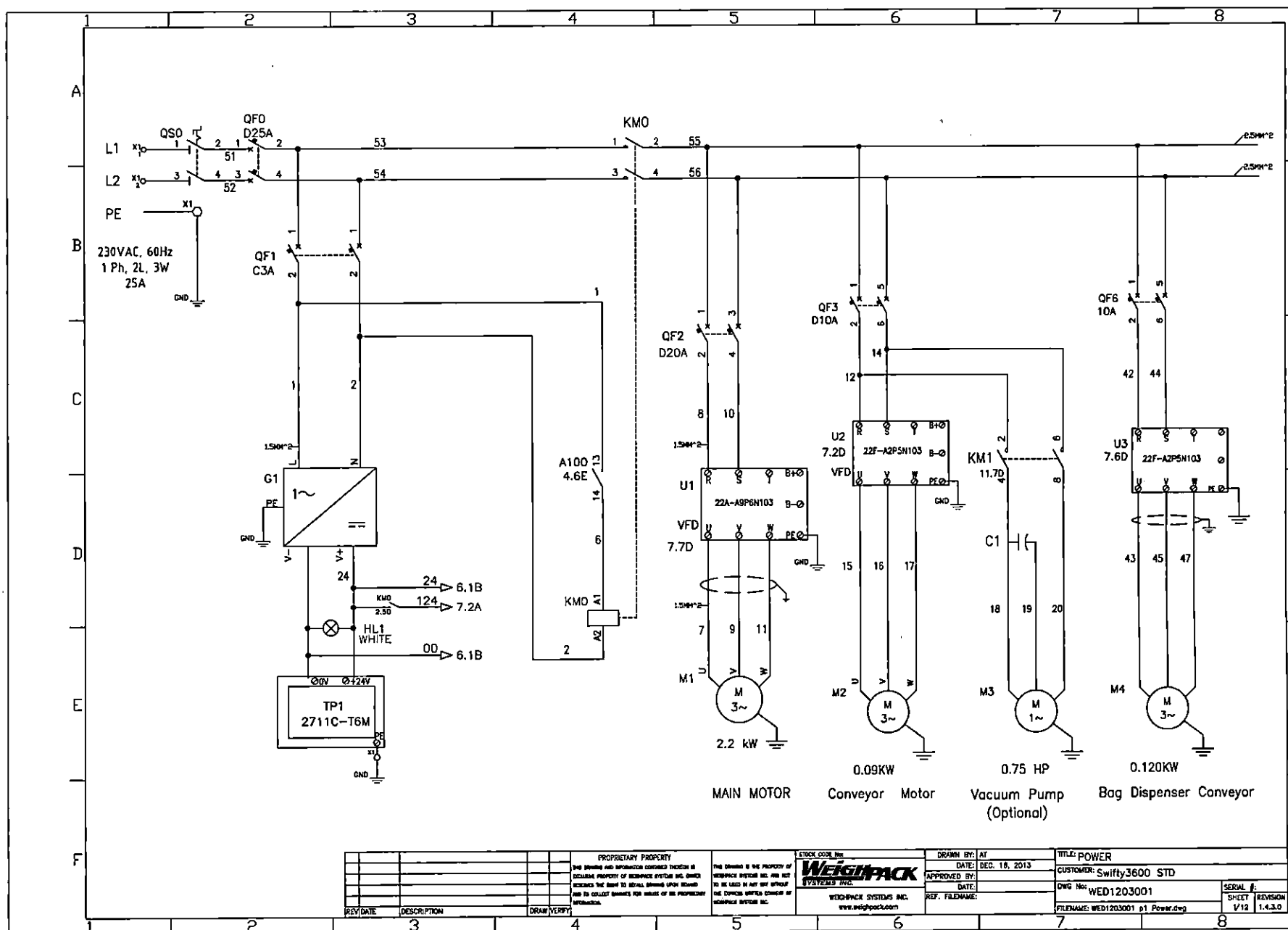
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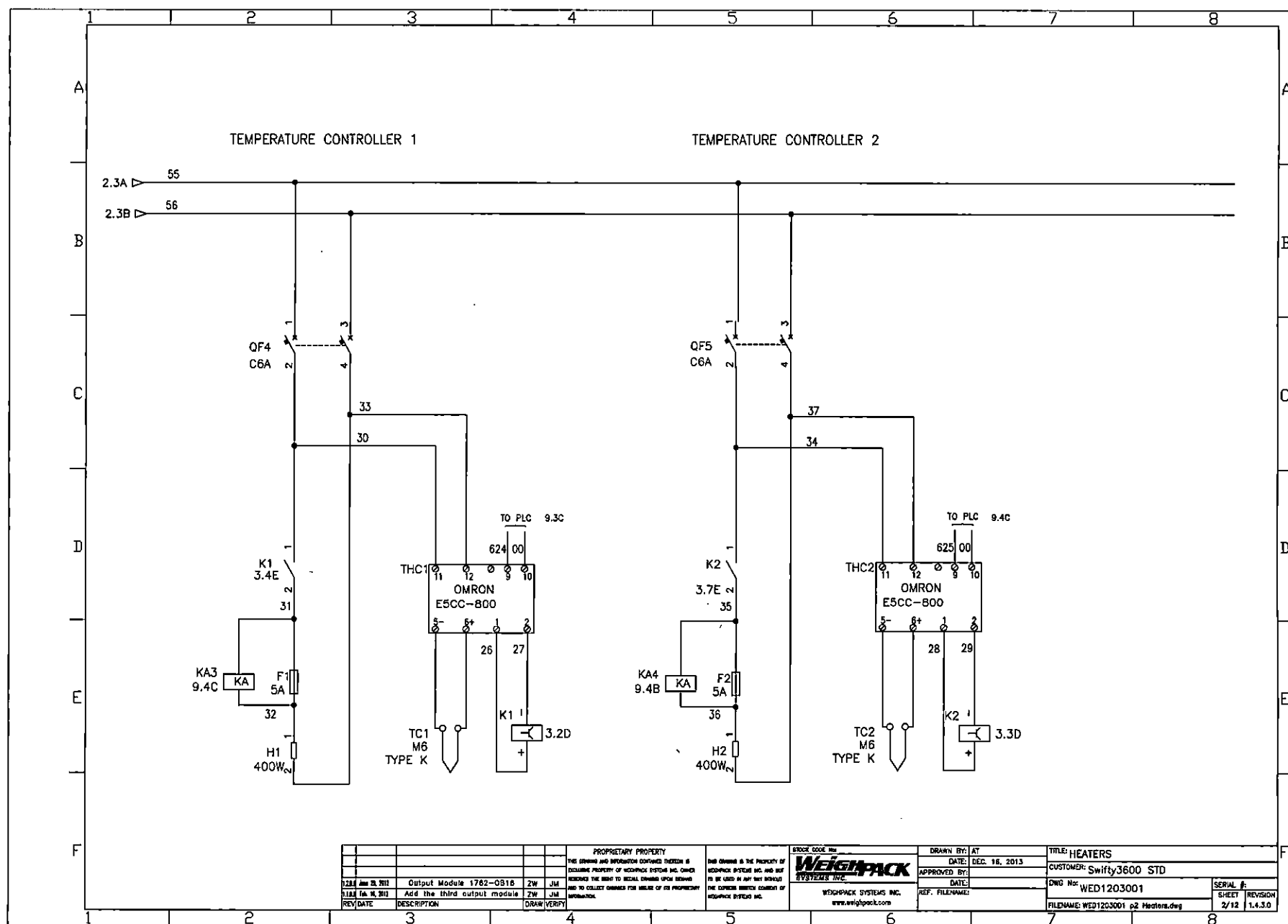
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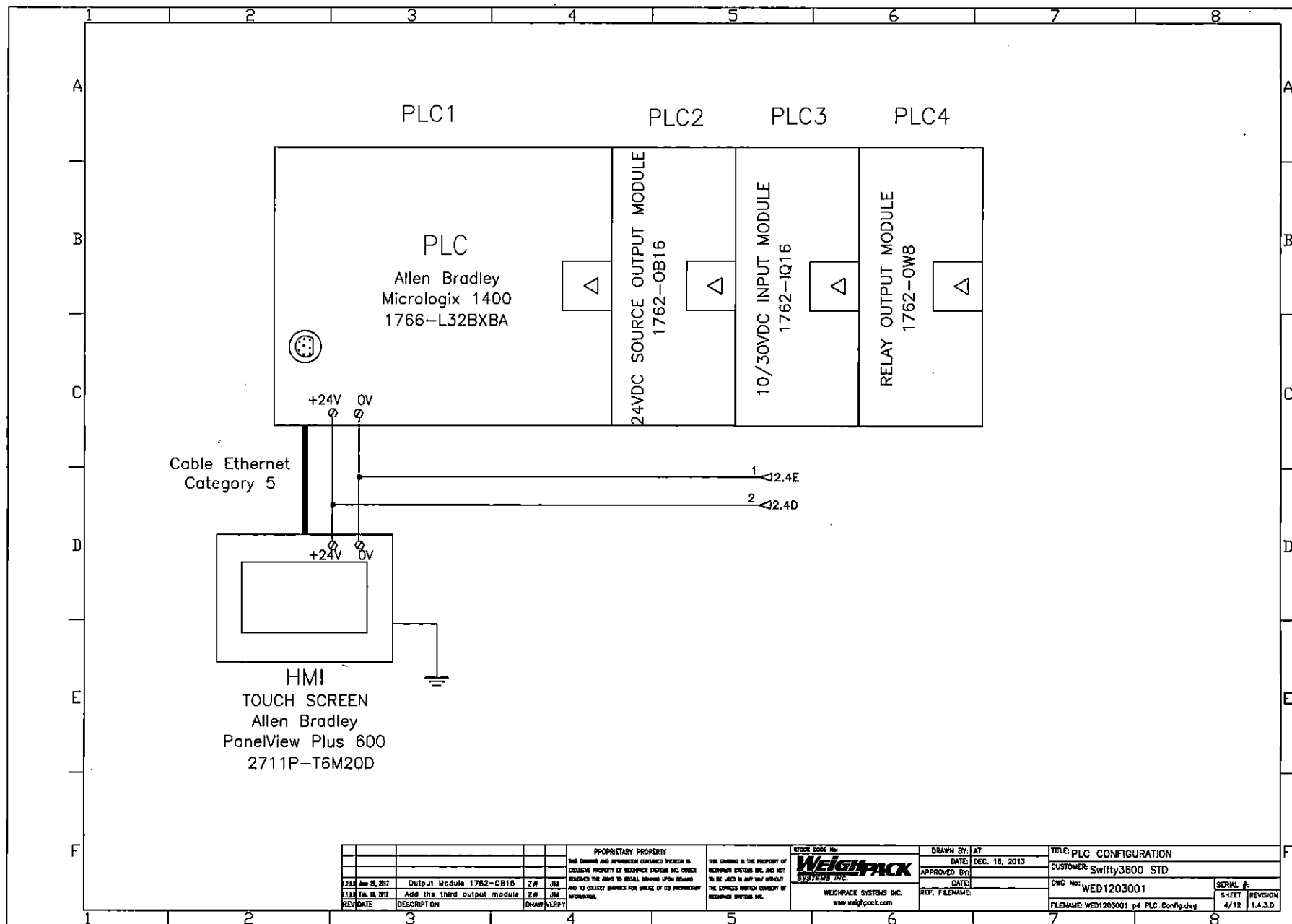
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MAX	-	-	-

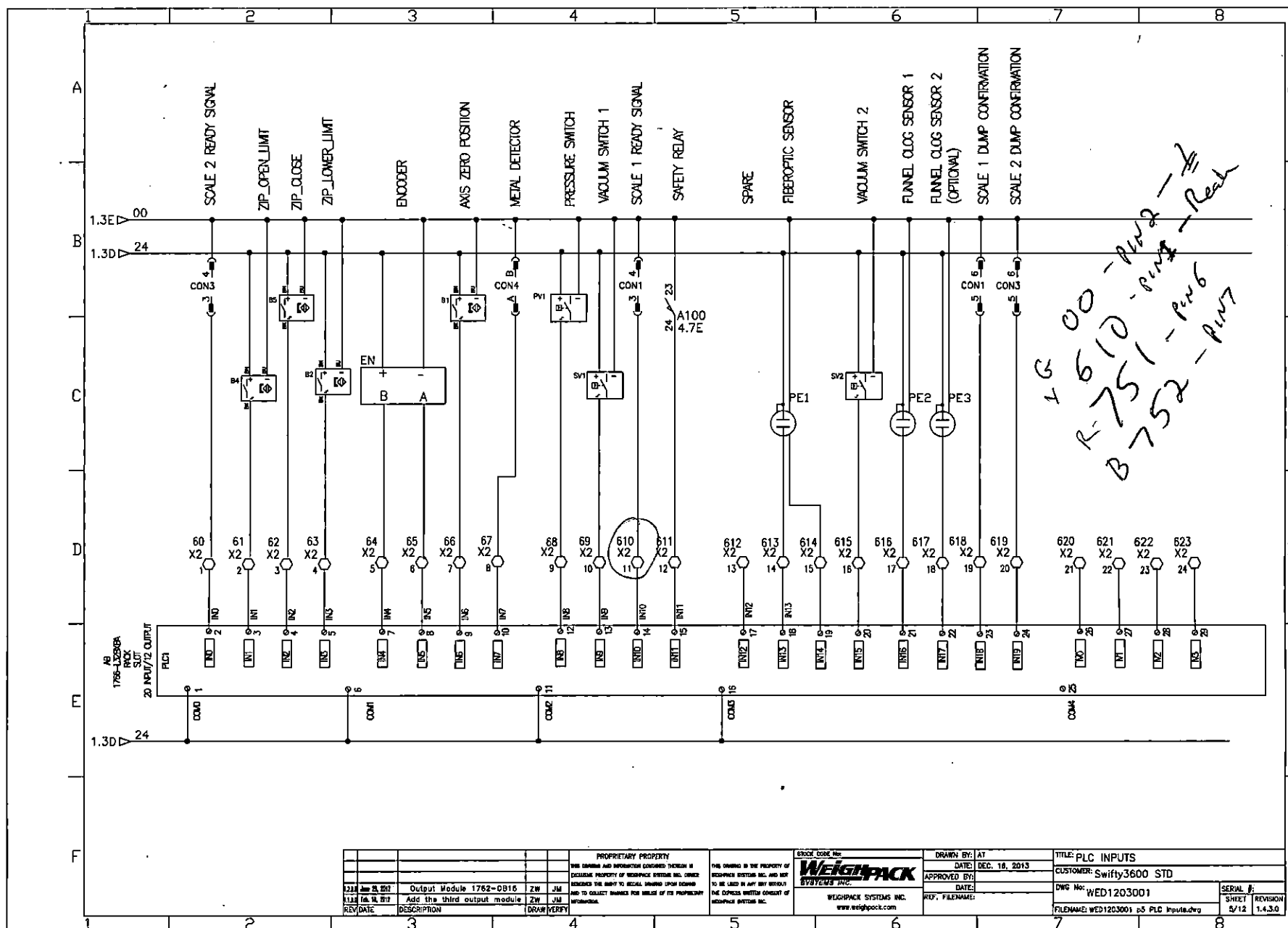
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11	LAYOUT
10	CONNECTORS
9	OUTPUT MODULE 2
8	INPUT MODULE
7	OUTPUT MODULE 1
6	PLC OUTPUTS
5	PLC INPUTS
4	PLC CONFIGURATION
3	SAFETY
2	HEATERS
1	POWER
0	COVER AND INDEX
PAGE	C O N T E N T S

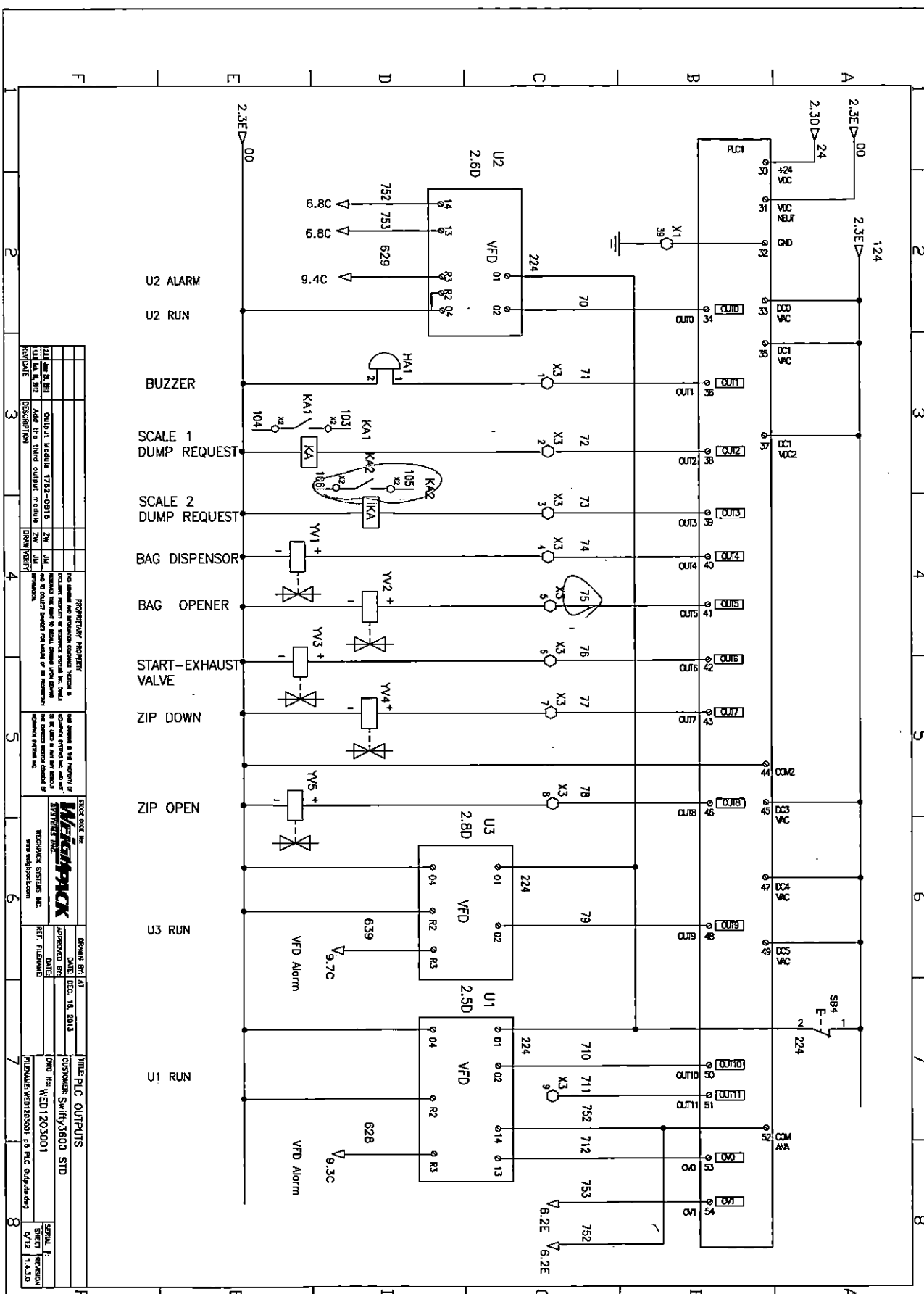
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								www.weighpack.com		REF. FILENAME:		Dwg No: WED1203001		SHEET 0/12	
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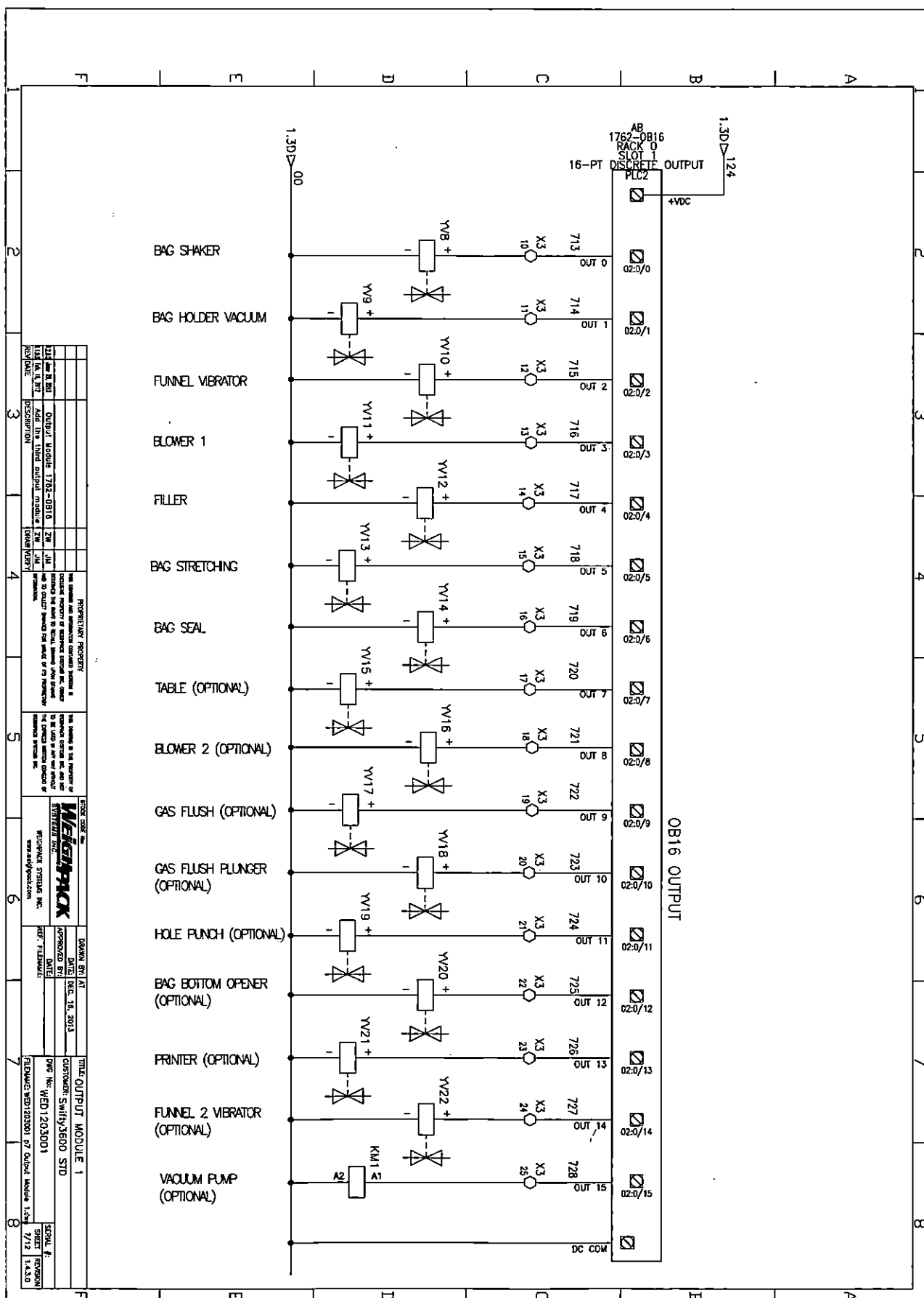


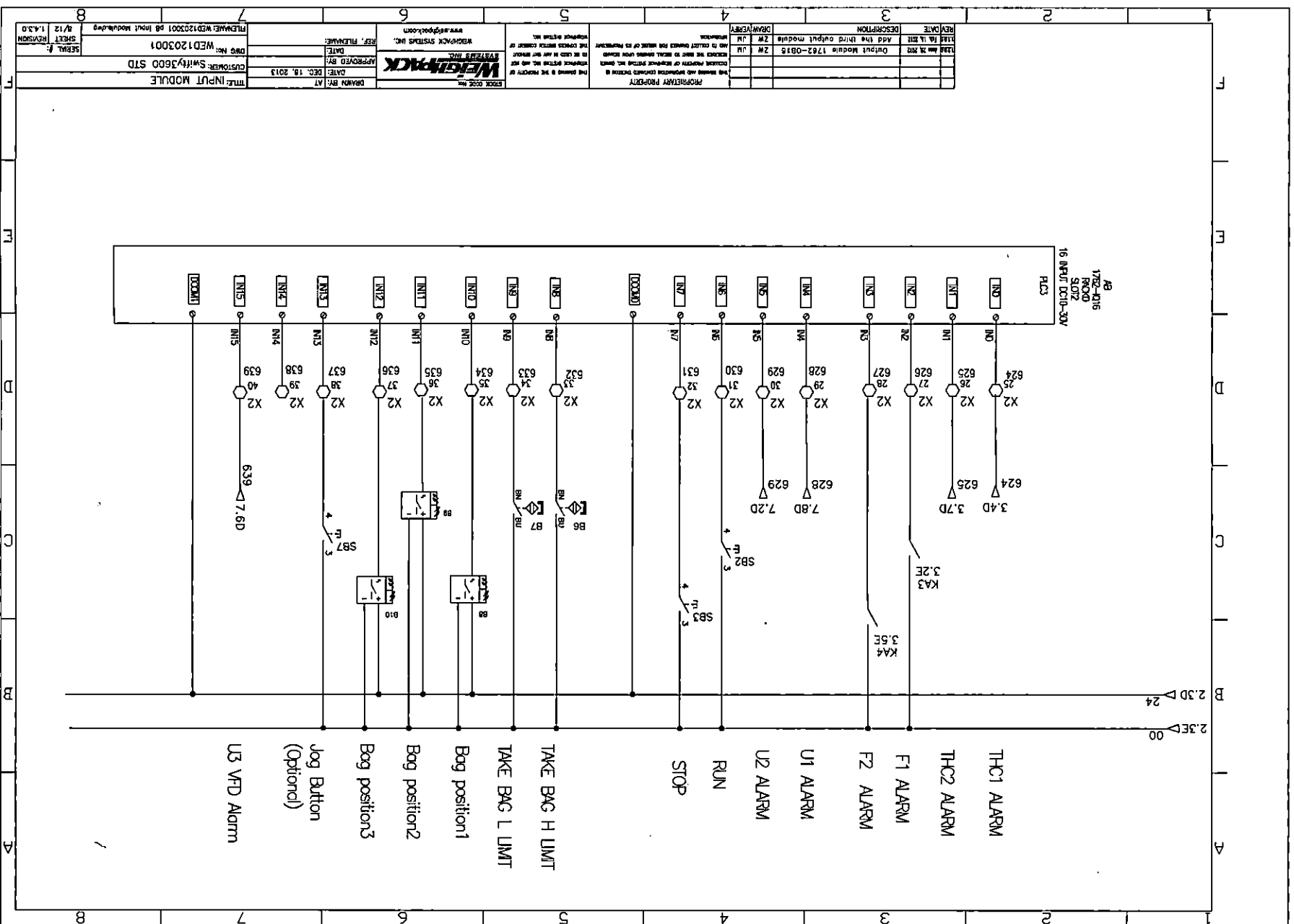


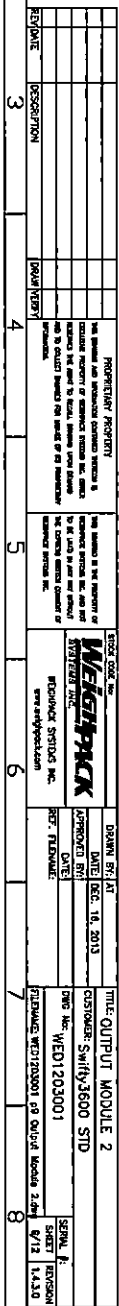


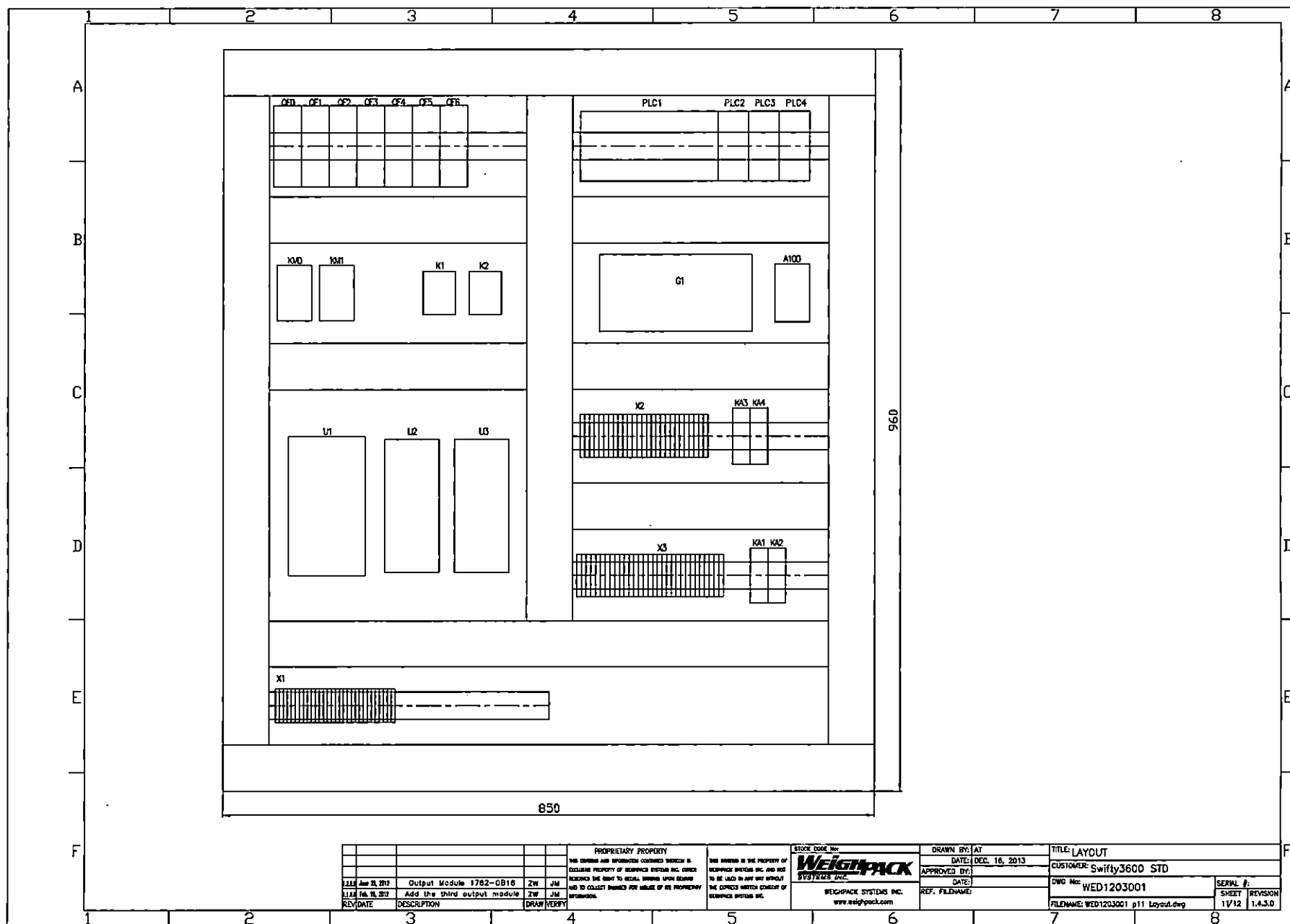












	1	2	3	4	5	6	7	8										
		X1		X2			X3											
A	QS0: L1				1	L1	PLC1: 60				1	60: CON3	PLC1 :71				1	71: HA1
	QS0: L2				2	L2	PLC1: 61				2	61: B4	PLC1 :72				2	72: KA1
	QF0: 53				3	53:	PLC1: 62				3	62: B5	PLC1 :73				3	73: KA2
	KM0: 53				4	53	PLC1: 63				4	63: B2	PLC1 :74				4	74: YV1
	QF0: 54				5	54:	PLC1: 64				5	64: EN B	PLC1 :75				5	75: YV2
	KM0: 54				6	54:	PLC1: 65				6	65: EN A	PLC1 :76				6	76: YV3
					7		PLC1: 66				7	66: B1	PLC1 :77				7	77: YV4
	K1: 31				8	32: F1	PLC1: 67				8	67: METAL DETECTOR	PLC1 :78				8	78: YV5
B	K2: 35				9	36: F2	PLC1: 68				9	68: PV1	PLC1 :711				9	711: SPARE
	F1: 32				10	32: H1	PLC1: 69				10	69: SV1	PLC2 :713				10	713: YV8
	KA3: 32				11		PLC1: 610				11	610: CON1	PLC2 :714				11	714: YV9
	QF4: 33				12	33: H1	PLC1: 611				12	611: A100	PLC2 :715				12	715: YV10
	F2: 36				13	36: H2	PLC1: 612				13	612: KM0	PLC2 :716				13	716: YV11
	KA4: 36				14		PLC1: 613				14	613: PE1-1	PLC2 :717				14	717: YV12
	QF5: 37				15	37: H2	PLC1: 614				15	614: PE1-2	PLC2 :718				15	718: YV13
					16		PLC1: 615				16	615: SV2	PLC2 :719				16	719: YV14
	K1: 26				17	26: TC1	PLC1: 616				17	616: PE2	PLC2 :720				17	720: YV15
C	K1: 27				18	27: TC1	PLC1: 617				18	617: PE3	PLC2 :721				18	721: YV16
	K2: 28				19	28: TC2	PLC1: 618				19	618: CON1	PLC2 :722				19	722: YV17
	K2: 29				20	29: TC2	PLC1: 619				20	619: CON3	PLC2 :723				20	723: YV18
	103				21	103	PLC1: 620				21	620: SPARE ANALOG	PLC2 :724				21	724: YV19
	104				22	104	PLC1: 621				22	621: SPARE ANALOG	PLC2 :725				22	725: YV20
	105				23	105	PLC1: 622				23	622: SPARE ANALOG	PLC2 :726				23	726: YV21
	106				24	106	PLC1: 623				24	623: SPARE ANALOG	PLC2 :727				24	727: YV22
	752				25	752	PLC3: 624				25	624: THC1 ALARM	PLC2 :728				25	728: KM1
	752				26	752	PLC3: 625				26	625: THC2 ALARM	PLC4 :730				26	730: YV23
D	82				27	82	PLC3: 626				27	626: KA3, F1 ALARM	PLC4 :731				27	731: YV24
	83				28	83	PLC3: 627				28	627: KA4, F2 ALARM	PLC4 :732				28	732: SPARE
	800				29	800	PLC3: 628				29	628: U1 VFD ALARM	PLC4 :733				29	733: SPARE
	801				30	801	PLC3: 629				30	629: U2 VFD ALARM						
	24				31	24	PLC3: 630				31	630: RUN BUTTON						
	24				32	24	PLC3: 631				32	631: STOP BUTTON						
	124				33	124	PLC3: 632				33	632: BAG DISPENSER H LIMIT						
	124				34	124	PLC3: 633				34	633: BAG DISPENSER L LIMIT						
E	00				35	00	PLC3: 634				35	634: BAG POSITION 1						
	00				36	00	PLC3: 635				36	635: BAG POSITION 2						
	GND				37	GND	PLC3: 636				37	636: BAG POSITION 3						
	GND				38	GND	PLC3: 637				38	637: JOG BUTTON						
	GND				39	GND	PLC3: 638				39	638: SPARE						
	18				40	18	PLC3: 639				40	639: U3 VFD ALARM						
	19				41	19												
F	20				42	20												

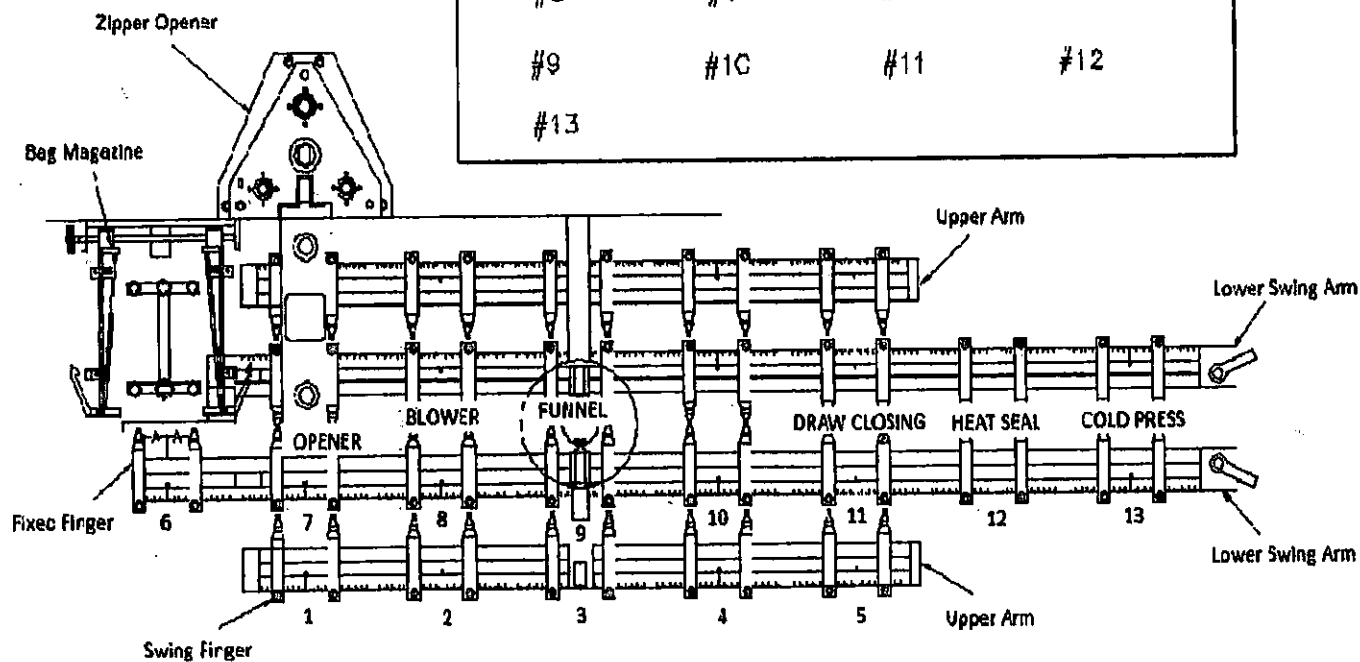
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11/16/16	11/16/16	Output Module 1762-0816	ZW	JM													

11/15/2013 11:16:16 AM 11/15/2013 11:16:16 AM 11/15/2013 11:16:16 AM		Output Module 1762-0816 Add the third output module	ZW JM ZW JM	PROPRIETARY PROPERTY This drawing and information contained herein is the property of Weighpack Systems Inc. and shall not be used in any way without the express written consent of Weighpack Systems Inc.	STOCK CODE: 100 WEIGHPACK SYSTEMS INC. WEIGHPACK SYSTEMS INC. www.weighpack.com	DRAWN BY: AT DATE: DEC. 16, 2013 APPROVED BY: DATE: REF. FILENAME:	TITLE: TERMINAL BLOCKS CUSTOMER: Swifty3600 STD DWG No: WED1203001 FILENAME: WED1203001 p12 Terminal Blocks.dwg	SERIAL #: SHEET REVISION 12/12 1.4.3.0
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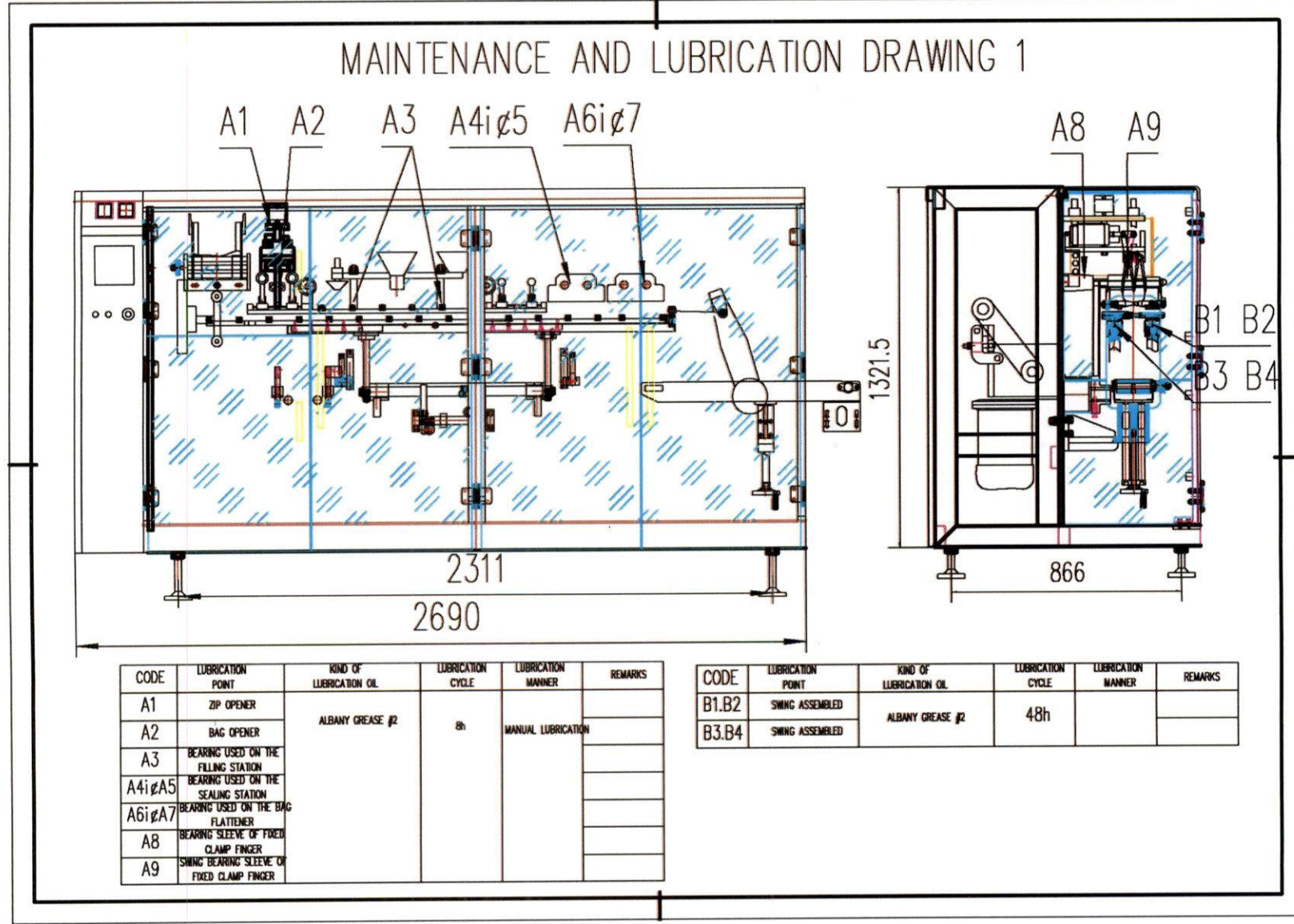
4.2.5 Swifty Stations Reference Drawing

SWIFTY STATIONS

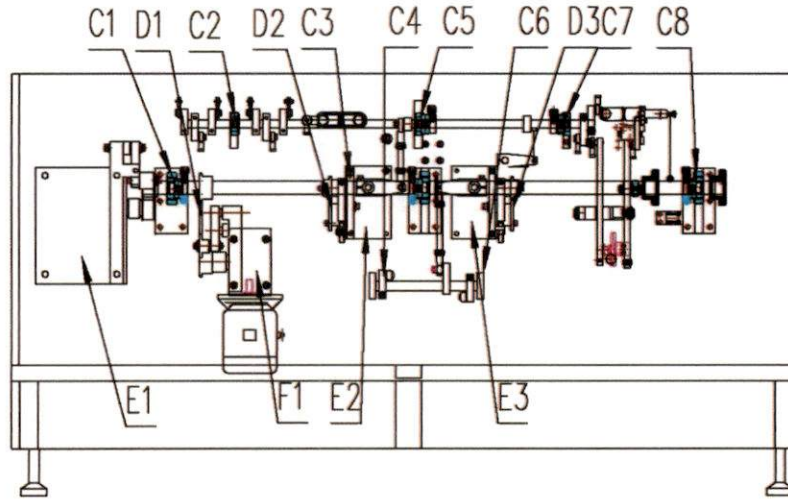
DIMENSION A SETTING FOR STATIONS			
#1	#2	#3	#4
#5	#6	#7	#8
#9	#10	#11	#12
#13			



Please use this copy for future reference



MAINTENANCE AND LUBRICATION DRAWING 2



CODE	LUBRICATION POINT	KIND OF LUBRICATION OIL	LUBRICATION CYCLE	LUBRICATION MANNER	REMARKS
C1	LEFT BRACKET OF REAR PRINCIPAL SHAFT	ALBANY GREASE #2	100h	MANUAL LUBRICATION	
C2	LEFT BRACKET OF REAR DRIVEN SHAFT				
C3	MIDDLE BRACKET OF REAR DRIVEN SHAFT				
C4	LEFT BRACKET OF REAR SMALL SHAFT				
C5	MIDDLE BRACKET OF REAR DRIVEN DRIVEN SHAFT				
C6	RIGHT BRACKET OF REAR DRIVEN SHAFT				
C7	RIGHT BRACKET OF REAR DRIVEN SHAFT				
C8	RIGHT BRACKET OF REAR PRINCIPAL SHAFT				

CODE	LUBRICATION POINT	KIND OF LUBRICATION OIL	LUBRICATION CYCLE	LUBRICATION MANNER	REMARKS
D1	MOTOR CHAIN	ALBANY GREASE #2	60h	MANUAL LUBRICATION	
D2	CHAIN FOR FIXED CLAMP FINGER				
D3	CHAIN FOR SWING FINGER				

CODE	LUBRICATION CHANGEMENT	KIND OF LUBRICATION OIL	LUBRICATION CYCLE	OIL QUANTITY	REMARKS
E1	BIG INDEXER	G-IN680W	5000h	LESS THAN OIL WINDOW	
E2	FIRST SMALL INDEXER				
E3	SECOND SMALL INDEXER				
F1	MOTOR	G-IN680W	4000h	1000mL	

REMARKS: PUT LUBRICATION OIL ON EACH JOINT BEARING ONCE TIME/48HOURS