



1.0

Purpose

The purpose of this procedure is to provide a reference for correct setup positions at each station for the 1lb. pouch.

2.0 Scope

This procedure is a guide for operators to aid in the 1lb. pouch setup for Auto 3 Pouch Machine.

3.0 Responsibility

Auto 3 Operator

4.0 Safety Considerations

Safety glasses, steel toe shoes, hair/beard net(s), and smock are required when working in the Repackaging facility.

Safety is a condition of employment. Employees are not authorized to work in an unsafe manner and are prohibited from harming the environment of the facility or community.

5.0 Materials/Equipment

Wrenches (10 mm, 13 mm, Allen Wrench); Small Fill Funnel

6.0 Procedure

Step 1: Bag Magazine Adjustment

- Turn adjustment knobs in until there is about 1/8" gap on each side of the pouch (needs some play to keep pouch from becoming stuck).

Step 2: Top Rail Gripper Finger Adjustment

- Change speed of machine to **8 bags per minute**.
- Press **Test** button on screen so salt will not dispense.
- Place machine in **Manual Run** mode.
- Press **Motor Jog** button on screen to align gripper fingers until they are almost touching.
 - This includes top and bottom rails at the same time.
 - Hold button to cycle through stations until correct position has been achieved.
 - It is important to leave a small gap between the fingers so they can slide to the new position easily.
- Go to Fill Funnel Station (10 mm wrench).
 - Start on top rail and adjust Left & Right gripper fingers to **3 cm**.

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- Move left one station to the Blow Station and adjust top rail Left & Right gripper fingers to **3 cm**.
- Move right one station from Fill Funnel and adjust top rail Left and Right gripper fingers to **3 cm**.

Step 3: Bottom Rail Gripper Finger Adjustment

- Adjust bottom rail gripper fingers to align with previously adjusted top rail fingers.
 - Only adjusting 3 stations at this time.
 - Disregard the measurements on the bottom rail. **Only use measurements on top rail.**
- Left two out of the three previously adjusted stations should be set inward about ½ of a finger width to help hold and transfer “pucker” from zipper opener station.
 - This step is vital for the fill funnel to enter the mouth of the pouch correctly.

Step 4: Zipper Opener Station Adjustment

- Move small suction cups (Red) all the way in for 1lb. (These fingers will be offset inward for reference.)
- Adjust both front and back fingers.
- Zipper opener DOES NOT need to be adjusted. (The outside of the opener when fully opened should be **3 cm**. If adjustment is made then sensor on lower horizontal air cylinder will have to be adjusted. The cylinder has a band holding the sensor. Move sensor until it lights up and then tighten back in place.)
- Make sure air nozzle is turned on and adjusted correctly to help pop the bottom gussets open on the pouch (need to hear air blowing when running machine but not blowing the pouch out of the gripper fingers).
- Bottom gusset suction cups need to be in the lower corners of the pouch (13 mm wrench).

Step 5: Stretch Station Adjustment

- Move gripper fingers on stretcher station all the way in. These fingers will be offset inward.
- Adjust both front and back fingers.

Step 6: Seal Transfer to Cooling Station

- No adjustment needed (Same setup works for all pouch sizes).

Step 7: Change Fill Funnel

- Change fill funnel to smallest size (total of 3 fill funnels with machine).
- May need to jog machine to open rails to gain access to funnel for removal and installation.

Step 8: Blow Station Height Adjustment

- Load 2 bags and manually jog until bags stop at Blow Station and Fill Station.
- Adjust height of blower until it is barely sealing the top of the bag.

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- Tighten in place.

Step 9: Settling Table Height Adjustment

- Move settling table up until it is just touching the bottom gusset (Allen wrench).
- Tighten in place.

Step 10: Run Test Bags

- Adjust stretch stop bolt in far right back corner of machine – Need less stretch for 1lb. when changing from larger pouch. (Remember how many turns of the bolt you make each time so you know how to get back if the wrong adjustment is made.)
- Change speed of machine back to **25 bags per minute**.
- Place machine back in **Auto** run mode.
- Press **Weigher** button on screen to turn salt back on.
- Check Blower Station to make sure head is going into pouch correctly and giving a fill signal.
- Check Stretcher Station and make adjustments as needed.
 - Check weight of pouch to verify correct weight before making adjustments.
 - If gripper finger slips off of pouch then it is over stretching. Reduce stretch and try again.
 - Check seal quality for wrinkling/puckering and adjust the amount of stretch needed to remove wrinkles from seal. Typically more stretch is needed if pouch seal is wrinkled.
 - High weights can also cause wrinkled seals and puckering in the middle of the seal.
 - Puckered seals can also be caused by dirty or worn out stretcher bearings.
 - Clean stretcher bearings by blowing out with air and spraying food grade lubricant on the bearings and manually working the stretcher bar to work in the lubricant.

7.0 Reference Documents

N/A

8.0 Change Information

New Document

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