



**GILES CHEMICAL
COMPANY PROCEDURE**

Palletizer Procedure

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Revision : 02
Date : 05/27/09

Author: **Selwyn Scoggin**

Job Specific

Personnel responsible:

Lead Operator and / or Salt Operator

Safety equipment:

All safety glasses and appropriate safety apparel is to be worn at all times.

Summary:

The Palletizer and associated conveyors receive the filled bags from the bagger, convey them to the Palletizer where they are arranged into layers and stacked on a pallet. The full pallet is discharged from the Palletizer and conveyed to the stretch wrapper, where it is wrapped and sent to the pick up area.

Procedure:

~~A.~~

~~B.~~A. Starting Palletizer

~~1.~~

~~2.~~1. Inspect Palletizer for loose and/or damaged components.

~~3.~~2. Clean up loose bags and salt from conveyors and Palletizer (do not use water).

~~4.~~3. Clean all photo eyes with a damp rag.

~~5.~~4. Reset safety chord.

~~6.~~5. Insure doors on electrical panels for conveyor and Palletizer are closed.

~~7.~~6. Press start button on Palletizer.

~~8.~~7. Select number of bags per layer and number of layers per pallet.

~~8.~~ Insert adequate number of slip sheets into placer, ~~and~~.

~~9.~~ Place no more than 12 pallets into dispenser.

~~9.~~10. Reset and start the safety switch at the bagger.

~~10.~~11. Press start button on conveyor panel.

~~11.~~12. System is now ready to receive bags.

~~C.~~B. Operating Palletizer

~~1.~~

~~2.~~1. The operator will make rounds as required by the log sheet to observe for proper operation and potential problems.

~~3.~~2. Make corrective interventions as required.

~~D.~~C. Stopping Palletizer

~~1.~~

~~2.~~1. Stop the bagger from sending bags to the Palletizer. Hopefully, the right number of bags to finish a pallet.

~~3.~~2. If it is necessary to stop with an uncompleted pallet, press the clear button, and the Palletizer will empty itself.

~~4.~~3. Press stop button on Palletizer.

~~5.~~4. Insure that all bags, broken and unbroken are removed from conveyors, catwalks, Palletizer, and floor.

~~6.~~5. Clean up any residual salt that may have spilled.

~~7.~~6. Press stop button on conveyor control panel.



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TRAINING DOCUMENTATION

| | EMPLOYEE | TITLE | SIGNATURE | DATE |
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