
	<b>GILES CHEMICAL</b>		
	<b>STANDARD OPERATING PROCEDURE</b>		
	<b>Bagger - Trouble Shooting</b>	Page : 1 of 2	Revision : 1 Date : 02/12/07
	Author: <b>Maintenance</b>		Report #:

### TROUBLESHOOTING GUIDE:

AREA	CAUSE	SOLUTION
WEIGHT VARIATIONS	BULK FLOW RATE	Check the product flow rate by observing the dribble cycle time. If the time is less than 2 seconds, decrease the bulk feed opening until a satisfactory feed is achieved
	HOPPER DOOR SPEED	Ensure that the weigh hopper doors are opening long enough for all of the product to discharge, and are fully closed before the next weight cycle begins.
	VIBRATION	Check for vibration which may be transmitted to the weighing system. Other equipment in close proximity to the scale may also be a source of vibration and may require some vibration dampening
	MISC. INFLUENCE	Check for possible sources of influence to weighing system such as hoses or cables, product buildup, loose or missing hardware, etc.
MOTORS	MOTOR WILL NOT START	No power – Examine fuses or circuit breaker in control panel. Inspect for loose terminal connection. Replace electrical components if required.
		Overload – Inspect for obstruction to belt and material on belt. Look for frozen or sluggish pulley bearings. Check size of heaters to see they are large enough.
		Damage to exterior wiring – Inspect conduit and wiring to and from control panel and motor.
		Damage to interior wiring – If repairs are required, install replacement units.
	MOTOR SLOW TO START	Overload – Inspect for obstruction to belt and material on belt. Look for frozen or sluggish pulley bearings. Check size of heaters to see they are large enough.
		Low line voltage - Check line voltage
		Loss of one of three phases - Inspect fuses in control panel and replace as required
	REPEATED STALLING	Interruption of power – Excessive amperage causes heater to open circuit. Inspect for overload.
	MOTOR RUNS HOT	Overload, too much drag – Look for binding of mechanical devices, excessive belt tension, frozen or sluggish pulley bearings, etc.
		Low line voltage – Check line voltage
		Loss of one of three phases - Inspect fuses in control panel and replace as required
	EXCESSIVE NOISE	Insufficient belt tension – Properly tension belt, then tighten down drive. Drive sheaves misaligned – Reposition drive sheaves using a straight edge across the sheave faces. Properly tension belt, then tighten down drive.
BEARINGS	FROZEN BEARING	Damaged or worn bearing – Replace bearing
		Dry Bearing – Replace bearing
	EXCESSIVE NOISE	Lack of lubrication - Lubricate or replace as required
		Loose bearing – Tighten or replace as required

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## TRAINING DOCUMENTATION

	EMPLOYEE	TITLE	SIGNATURE	DATE
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