



1.0

Purpose

This procedure defines the proper use of the Palletizer machine. The steps of operation include receiving the fifty pound bags from the bagger conveyor, stacking them to specified quantities and layout, wrapping pallets making ready for shipment.

2.0 Scope

This procedure applies to the stacking and wrapping for shipment fifty pound bags for shipment.

3.0 Responsibility

Operation of the Palletizer is the responsibility of the Salt Operator and Lead Operator

4.0 Safety Considerations

Observe all manufacturing safety requirements: Safety glasses and steel toed shoes.

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

N/A

6.0 Procedure

A. Starting Palletizer

1. Inspect Palletizer for loose and/or damaged components.
2. Clean up loose bags and salt from conveyors and Palletizer (do not use water).
3. Clean all photo eyes with a damp rag.
4. Reset safety cord.
5. Insure doors on electrical panels for conveyor and Palletizer are closed.
6. On control panel press start button on Palletizer.
7. Select number of bags per layer and number of layers per SCR.
8. Insert adequate number of slip sheets into placer
9. Place no more than 12 pallets into dispenser
10. Reset and start the safety switch at the bagger
11. Press start button conveyor panel
12. System is now ready to receive bags

B. Operating Palletizer

1. The operator will make rounds as required to observe for proper operation and potential problems.

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Company Procedure

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2. Make corrective interventions as required.

C. Stopping Palletizer

1. Stop the bagger from sending bags to the Palletizer.
2. If it is necessary to stop with an uncompleted pallet, press the clear button, and the Palletizer will empty itself
3. Press stop button on Palletizer.
4. Insure that all bags, broken and unbroken are removed from conveyors, catwalks, Palletizer, and floor.
5. Clean up any residual salt that may have spilled.
6. Press stop button on conveyor control panel.

7.0 Reference Documents

N/A

8.0 Change Information

General updates throughout procedure to clarify instructions on palletizer operations and conversion to new format for Doc system.

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