

GILES CHEMICAL CORPORATION		
COMPANY PROCEDURE		
<b>CARTON MACHINE START UP</b>	Page : 1 of 1	Date : Revision : 10/2/2006
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## Purpose

Inform the operators of the correct procedure to start production on the carton machine.

## Scope

Liquipak 800 Machine's #1 and #2

## Responsibility

Machine Operator, Lead Operators, Repack Manager, Maintenance

## Procedure

### *Warm Up*

1. Check to make sure the air compressor, oil pump, chiller circulation pump, chiller, flexicons, screws, and conveyors are either turned on or have power (see **Opening procedure**).
2. Proceed to the front of the carton machine where the cartons are loaded.
3. Turn the main power switch (handle) from "Off" to "On".
4. Press and hold the button marked "Pump Start" until the button lights up.
5. Press and hold the button marked "Index Start" until the button lights up.
6. On the left side of the control box check the three heater readings to make sure the power lights are on and that the readings are the same as the set points.

### *Start of Production*

7. Set the switch just above the "Emergency Stop Button" to:  
 Slow – For 3 and 4 pound fillings (CM2) 35 per minute  
 Medium or Fast – For 1 and 2 pound fillings (CM1) 50-55 per minute.
8. At the AMS Filling Control Box set the machine for 1,2,3 or 4 pound fillings as needed.
  - 1 pound #390
  - 2 pound #890      All settings listed at left will go up and down.
  - 3 pound #1290
  - 4 pound #1820
9. Place the cartons to be filled in the machine feed chute seam side down smoothly arranged to avoid hang-ups.
10. Press the button marked "Picker Start". Cartons should start being fed into the machine.
11. Adjust the AMS as needed after performing weight checks.