



USER'S MANUAL

**Evisceration system
Intestine pack unloading station
Nuova**

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1 PREFACE

1.1 User's Manual identification

The data on the machine plate can be found in the index of the documentation set. It contains a reference to the document number of this User's Manual.

Check if the User's Manual belongs to the machine.

The index can also contain references to corresponding documentation.

1.2 General information

The User's Manual provides information and instructions for proper and safe use of the machine and applies to the life of it.

All users of the machine must be acquainted with the presence and contents of the User's Manual, which for that reason has to be kept in an accessible place.

Carefully read through the User's Manual before starting to use the machine. Familiarize yourself with the information and follow the instructions.

If you have questions, require explanation of subjects related to the machine or the User's Manual, please contact the manufacturer. You can find the address on the front page.

Replace damaged and missing User's Manuals.

Always mention the data of the machine plate below in correspondence about the machine:

- Machine
- Model / Machine code
- Serial no.

See fig. 1.

1.3 Reading indicator

The User's Manual uses the term machine. By "machine" is meant: the specific module, installation, unit or system with the corresponding equipment.

This User's Manual contains several boxes. They draw your attention to dangerous situations for the user, control panel and/or product and give you tips. They have been subdivided and displayed as follows:

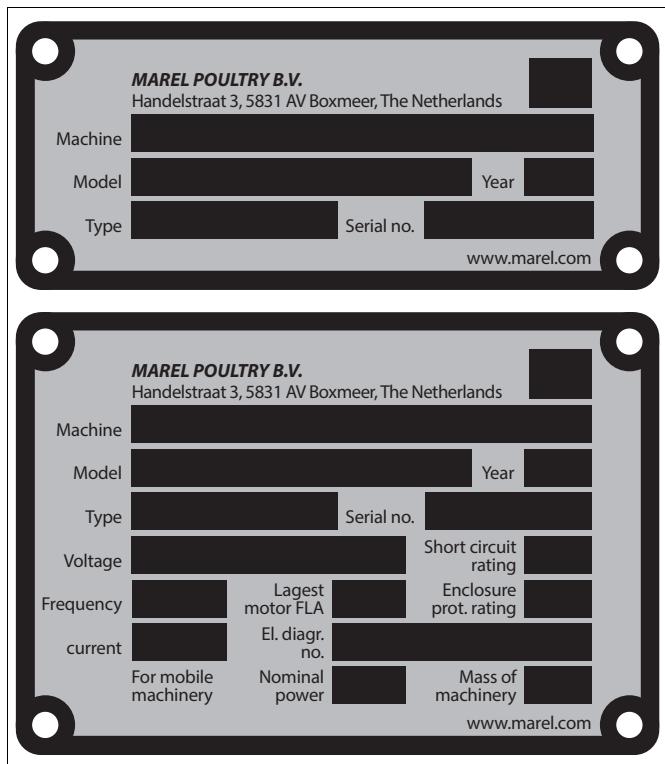
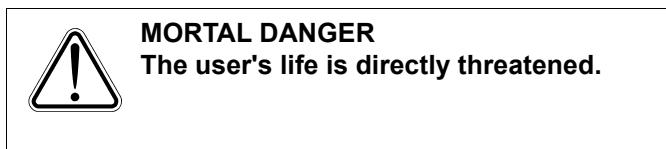


fig. 1 Machine plate example

**WARNING**

The user can be (seriously) injured or seriously damage the machine.

The picture in this box depends on the risk-bearing action that is discussed.

**TAKE CARE**

The user can damage the machine or products when the instructions are not carried out with care.

**NOTE**

Observation containing additional information for the user.

**TIP**

Provides suggestions and advice to the user to carry out certain instructions more skilfully and easier.

Page and document numbers

Each page has a unique identification and consists of:

- The page number with the total number of pages.
Example:
4 / 24
- The document number and the date of issue.
Example:
90952_00_01_ENG / 17-08-2013

Position numbers and letters in text

Bold printed position numbers and letters in the text refer to the specific section in the figure.

Example:

Product guides **40** and **41** stop the legs when

**NOTE**

The pictures in this User's Manual can deviate from your machine. Keep this in mind when reading this User's Manual and carrying out operations on the machine.

Some components can have documentation of their own. Consult the index on this.

1.4 Keeping machine data up to date

We advise you to keep a logbook.

You can enter data regarding production, maintenance, cleaning, inspections, defects, repairs, overhauls, modifications and other operations on the machine. See appendix: LOGBOOK.

We also advise you to keep a registration form for entering the setting data.

See appendix: SETTINGS.

1.5 General terms of delivery

The general terms of delivery of the manufacturer apply to the machine. These can be found in the documentation set.

1.6 Responsibilities of the purchaser

By "purchaser" this User's Manual means every enterprise that uses the machine, regardless if it concerns purchase, rent, lease or another user's right.



MORTAL DANGER

If the machine is not installed in accordance with our layout drawings, or if local regulations or the individual circumstances make this necessary, than additional safety measures are necessary.

The purchaser has a duty to familiarize all users with the information and instructions given in this User's Manual.

The purchaser is obliged to take care of the safety of the users and the machine.

In particular:

- he makes sure that all required information is available to all users.
- he allocates authorities to the users per chapter of the User's Manual.
- only authorized, skilled and instructed users are allowed to carry out the instructions.
- he supervises the users to make sure they meet all regulations and instructions.
- he makes sure that the machine is only used within the limits mentioned in the User's Manual and "Technical Data".
- he makes sure that the original state of the machine must not be changed by modifications, repairs and/or other influences by or on behalf of the purchaser or a third party without prior written permission of the manufacturer.
- he makes sure that settings, maintenance and cleaning of the machine are properly carried out in time.

1.7 Modifications to the machine

The data contained in this User's Manual are based on the latest information.

The manufacturer reserves the right to change the design and/or configuration of its machines at any time, without any obligation on our part to change any previous supplies accordingly.

The original state of the machine must not be changed by modifications, repairs and/or other influences by or

on behalf of the purchaser or a third party without prior written permission of the manufacturer.

If the CE-2A-status is applicable to the machine (see EC-declaration), this can become defunct due to modifications to the machine.

1.8 Use of the machine

- The machine can only be used for industrial ends.
- The machine can only be used within the limits mentioned in the User's Manual and "Technical Data".
- Prior written permission of the manufacturer is required for other use.
- It is not allowed to install parts that have not been supplied, installed and/or released beforehand by the manufacturer.

2 SAFETY

2.1 Safety at work

The manufacturer has made every possible effort to provide you with comprehensive, accurate information as regards any hazards relating to the operation of the machine. The purchaser himself shall be responsible for the implementation and proper observance of these rules of conduct.

You must not let minors of 14 years old or younger work on this machine, even if local legislation of the country where the machine is in operation permits it.

Observe the current state of labour, safety and environmental regulations when carrying out any operations.

MORTAL DANGER

Do not wear:

- loose-fitting and loose articles of clothing.
 - jewellery and suchlike.
- They can come into contact with moving parts.**

Wear footwear that prevents slipping.

2.2 Safety labels

The adjacent safety labels alert the user to possible dangers. You will find them on the machine and in the text of this User's Manual.

2.3 Noise pollution

The manufacturer designs and constructs machines where noise pollution has been reasonably reduced to a minimum.

However it is possible that users, due to local circumstances, will be exposed to noise pollution which may cause hearing impairment.

WARNING

To prevent hearing impairment due to noise pollution, you should always observe the legal standards and regulations relating to noise pollution and take proper measures if required.

The noise pollution of the machine is mentioned in the "Technical Data".

We draw your attention to the fact that wrong settings and overdue maintenance can cause an increase in

noise pollution.

2.4 Hygiene and environment

Uphold the rules of hygiene and environment during (maintenance) operations on the machine.

Make certain that the production process does not absorb any damaging influences from outside, such as detergents and maintenance tools.

Recycling

Offer materials for recycling sorted as much as possible.

Chemical waste

Materials that come under the category of chemical waste should be separated when discharged. This includes, for example, batteries, oil filters, oils and greases.

Waste discharge

Waste should only be offered to recognized waste-disposal companies that meet local legislation, standards and regulations.

Putting machine out of operation

If the machine is not used over a longer period of time or is dismantled, the purchaser must remove all components that can cause danger, such as knives, guides sticking out, batteries.

3 TRANSPORT



MORTAL DANGER
Activities described in this chapter must
be carried out by competent,
professional and trained personnel.

3.1 Transport and storage

- During transport of the machine/control panel follow instructions on the packing. Consult the weight marking on the packing for transport weights.
- Check if the machines or spare parts are correct and available by means of the documents that have also been supplied.
- Check the machine for transport damage.
- In case of incorrect delivery or damage contact the manufacturer.
- Keep the machine dry, clean and safeguarded against humidity, dust and dirt.

4 MACHINE DESCRIPTION

4.1 Implementation

The viscera pack unloading station is one of the machines of the evisceration line.
The viscera pack unloading station releases the viscera pack from the viscera shackle.

The viscera pack unloading station is available in the following executions:

- Viscera pack unloading station Nuova
The unloading station releases the viscera pack from the viscera shackle.
- Viscera pack unloading station Nuova-S
The unloading station is suitable for the Selective release of the viscera pack from the viscera shackle.
- Viscera pack unloading station Nuova with washer
The viscera pack unloading station with washer releases the viscera pack from the viscera shackle. The viscera shackles are cleaned after production.
- Viscera pack unloading station Nuova disconnectable
The unloading station releases the viscera pack from the viscera shackle. It is manually disconnectable, so the viscera pack is not released.

See fig. 2, fig. 3, fig. 4 and fig. 5.

The viscera pack unloading station is available:

- with viscera shackle pivoting station **1** for pivoting viscera shackles.
- without viscera shackle pivoting station for fixed viscera shackles.
- with single discharge trough **2**.
- with a short or long double discharge trough **3**. **The discharge trough has a product distributor with switch box for the distribution of the products over:**
 - two gizzard harvesters.
 - two heart/lung separators.
 - one gizzard harvester or heart/lung separator and one collecting bin.

See fig. 6.

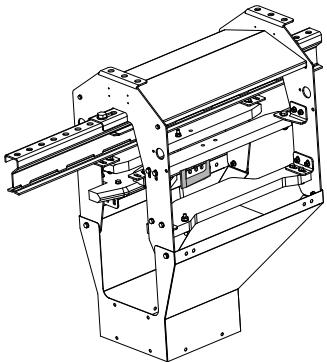


fig. 2 Viscera pack unloading station Nuova

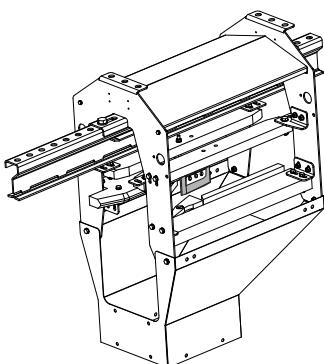


fig. 3 Viscera pack unloading station Nuova-S

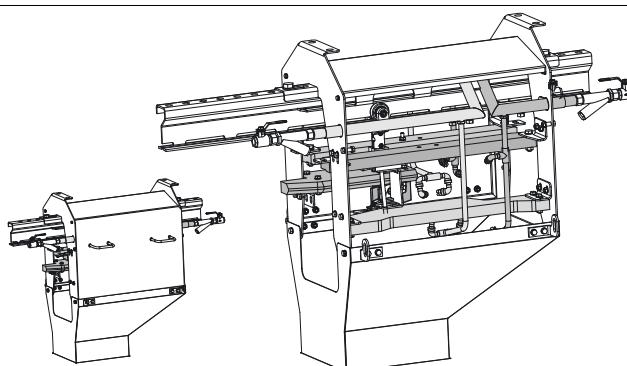


fig. 4 Viscera pack unloading station Nuova with washer

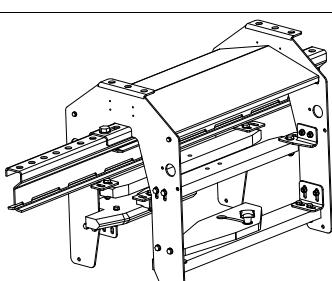


fig. 5 Viscera pack unloading station Nuova disconnectable



NOTE

If the machine is not mentioned separately, the information applies to all models and executions.



NOTE

The illustrations in these user's manuals show the viscera pack unloading station Nuova with washer. The illustrations can deviate from other machines.

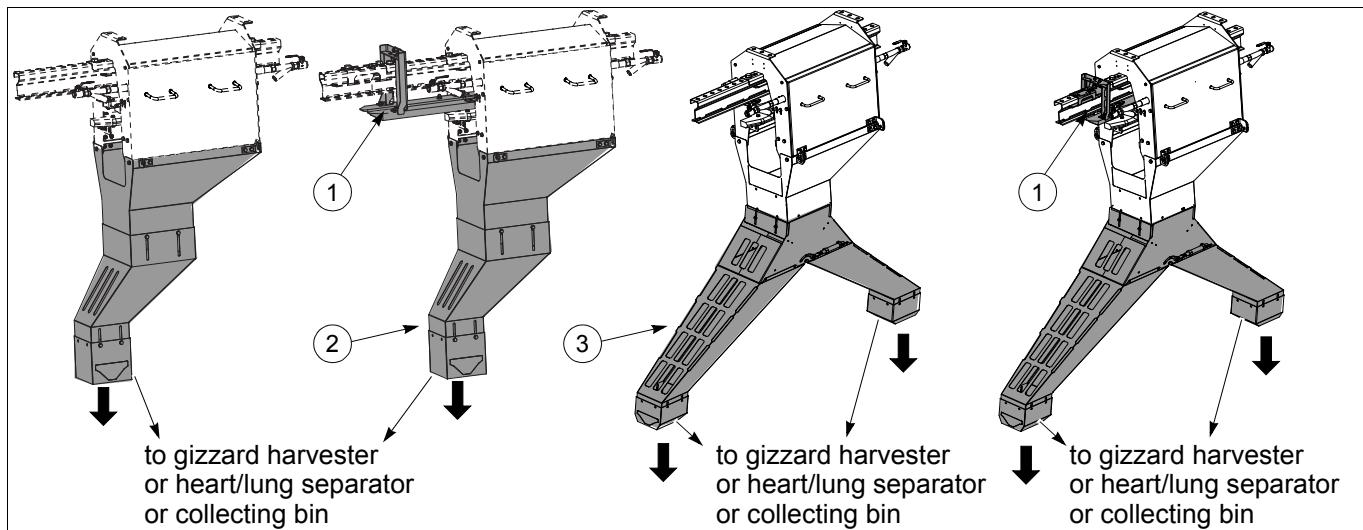


fig. 6 Viscera pack unloading station

The viscera pack unloading station with shackle washer is available in a:

- right-hand execution **R**.
- left-hand execution **L**.

See fig. 7.

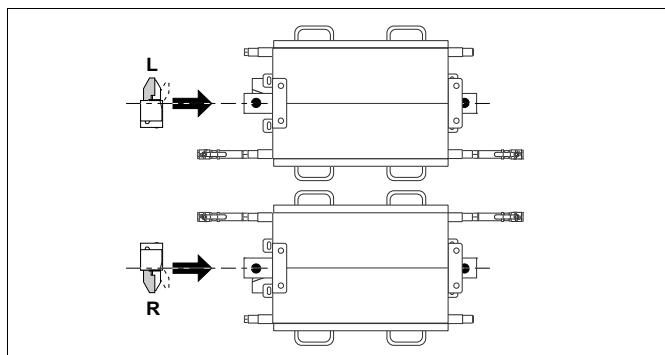
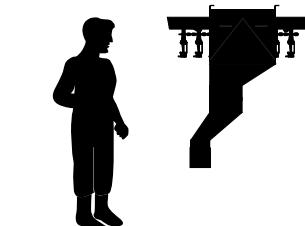


fig. 7 Executions



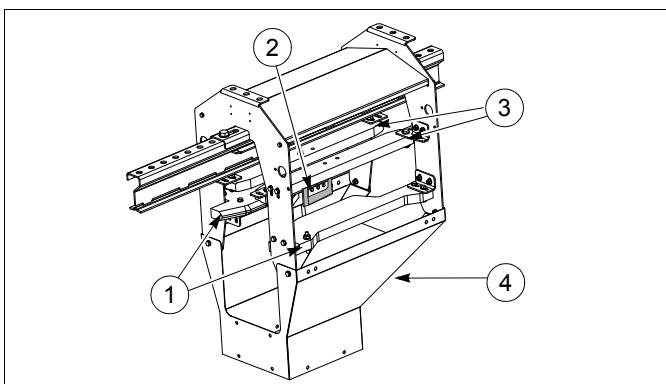


fig. 8 Viscera pack unloading station Nuova

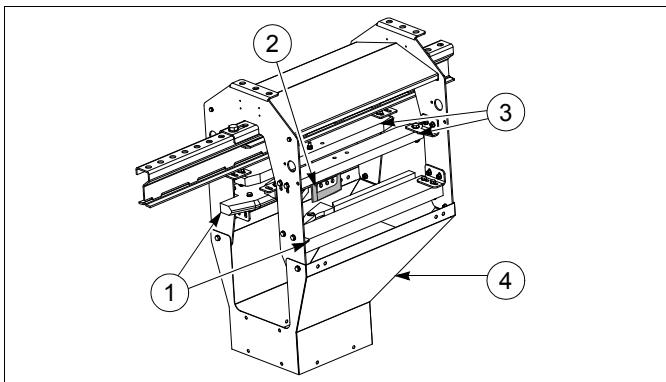


fig. 9 Viscera pack unloading station Nuova-S

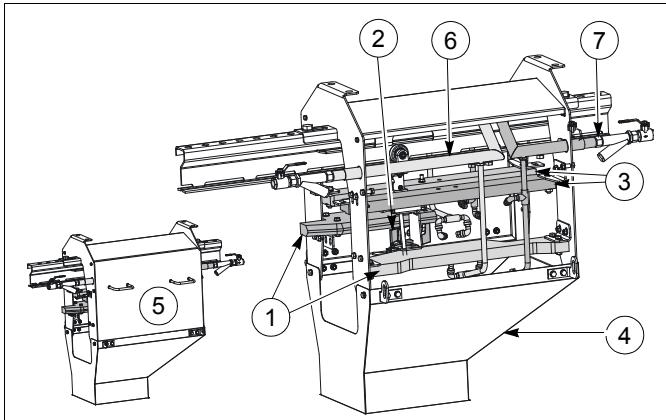


fig. 10 Viscera pack unloading station Nuova with washer

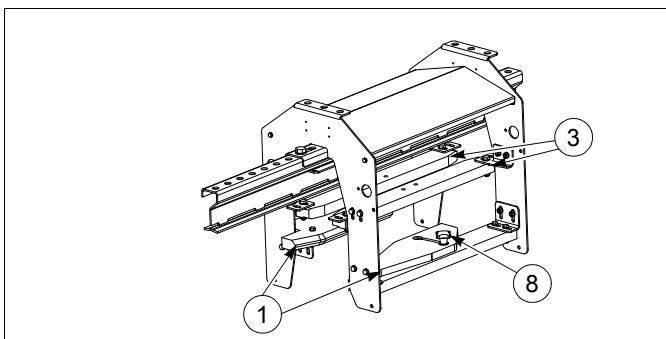


fig. 11 Viscera pack unloading station Nuova disconnectable

4.2 Names used

The machine consists of the following main components:

1. Infeed blocks
2. Scraper
3. Viscera shackle guide
4. Collecting bin
5. Safeguard
6. Unloading spray nozzles
7. Cleaning spray nozzles
8. Trip-out pin
9. Viscera shackle pivoting station
10. Positioning pins
11. Pivoting viscera shackle
12. Fixed viscera shackle
13. Single discharge trough
14. Double discharge trough

See fig. 8, fig. 9, fig. 10, fig. 11 and fig. 12.

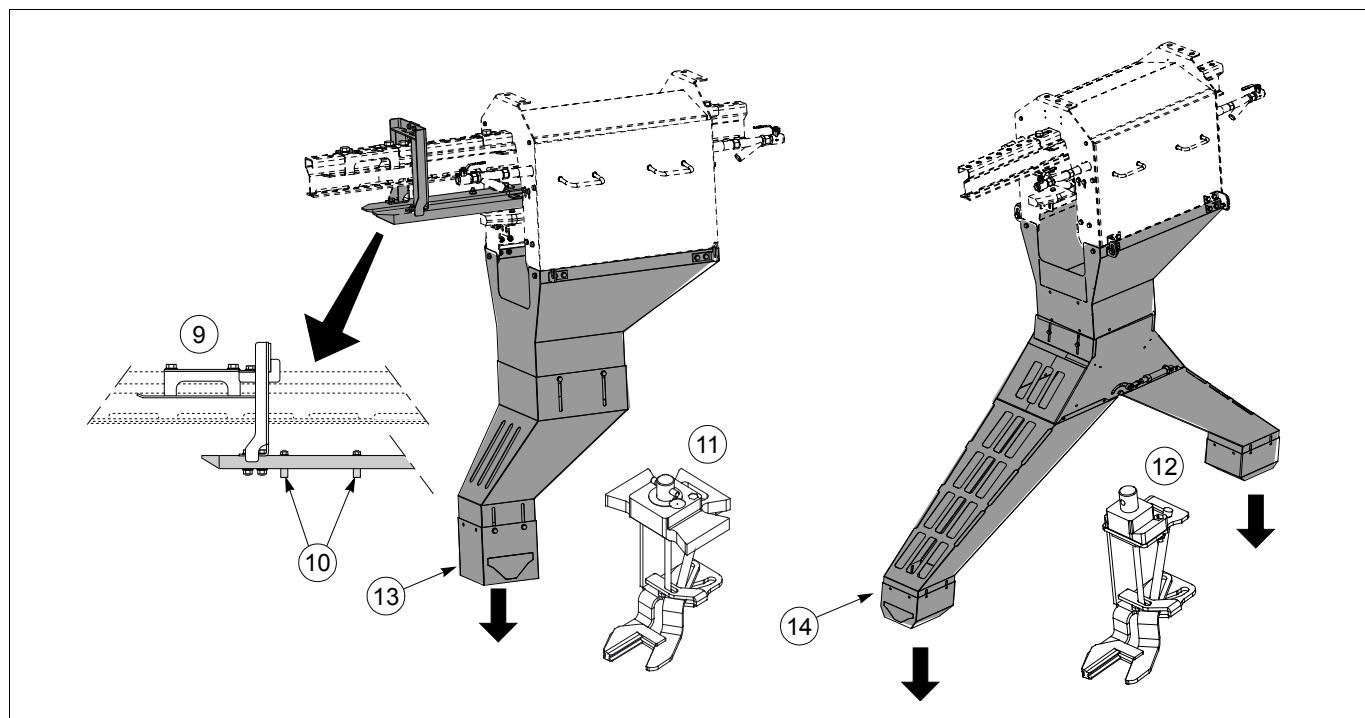


fig. 12

4.3 Switch box names

The viscera shackle unloading station with double product distributor has a switch box.

The switch box consists of the following components, see fig. 13 and tab. 1:

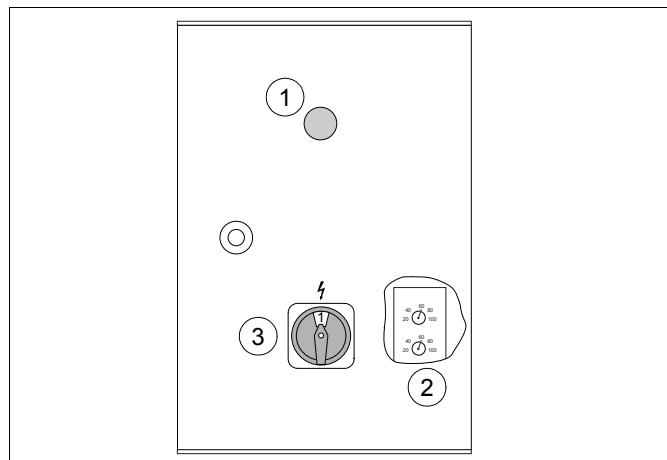


fig. 13 Switch box names

tab. 1 Function of the switch box

	Name	Function/remark
1.	Signal light	Control voltage 24 VAC available.
2.	Time relay	Switching the product distributor on and off.
3.	Main switch	Switching the main power on and off.

4.4 Process description

Viscera pack unloading station

The viscera shackle is conveyed into the unloading station. Infeed blocks 1 move the plastic pin of the clamping device, causing the viscera shackle to open and the viscera pack to be released.

See fig. 14 and fig. 15.

Viscera pack unloading station with washer

Unloading spray nozzles 2 hose down the viscera shackle after the viscera pack has been released.

Cleaning spray nozzles 3 clean the viscera shackles after production.

See fig. 15.

Viscera shackle unloading station disconnectable

The unloading station has one adjustable infeed block 4. The infeed block is manually disconnectable, so the products are not released.

See fig. 16.

Viscera pack unloading station S

The unloading station has one selective infeed block 5 which releases every other product from the viscera shackles.

See fig. 17.

An overhead conveyor with pivoting viscera shackles requires an unloading station fitted with viscera shackle pivoting station 8. Control pins 9 turn the viscera shackles in the correct position before they reach the unloading station.

The unloading station can be fitted with a single or a short or long double discharge trough 10. **The double discharge trough has a product distributor with switch box for the distribution of the products over:**

- two gizzard harvesters.
- two heart/lung separators.
- one gizzard harvester or heart/lung separator and one collecting bin.

See fig. 18.

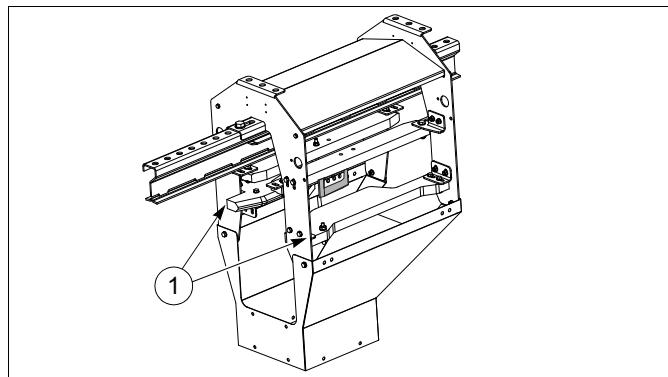


fig. 14 Viscera pack unloading station Nuova

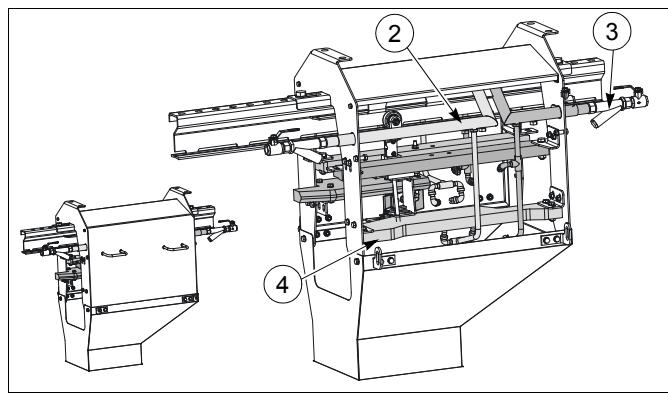


fig. 15 Viscera pack unloading station Nuova with washer

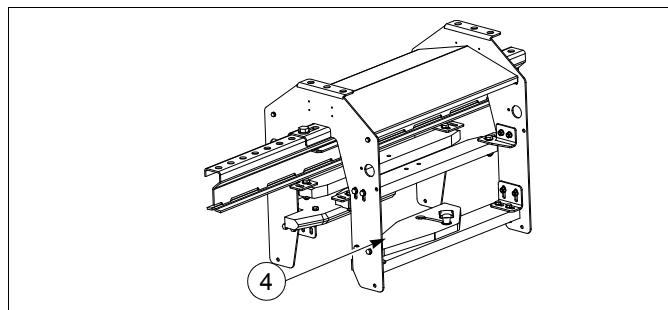


fig. 16 Viscera pack unloading station Nuova disconnectable

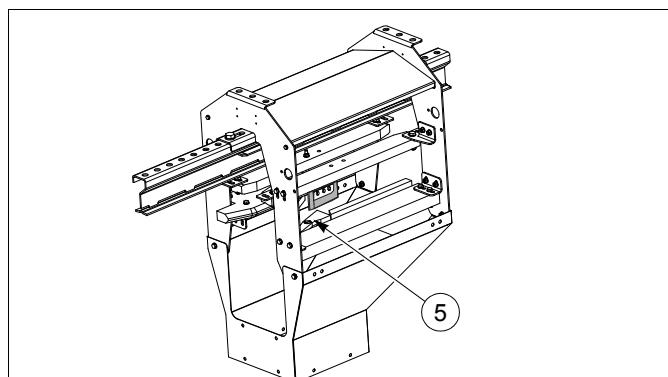


fig. 17 Viscera pack unloading station Nuova-S

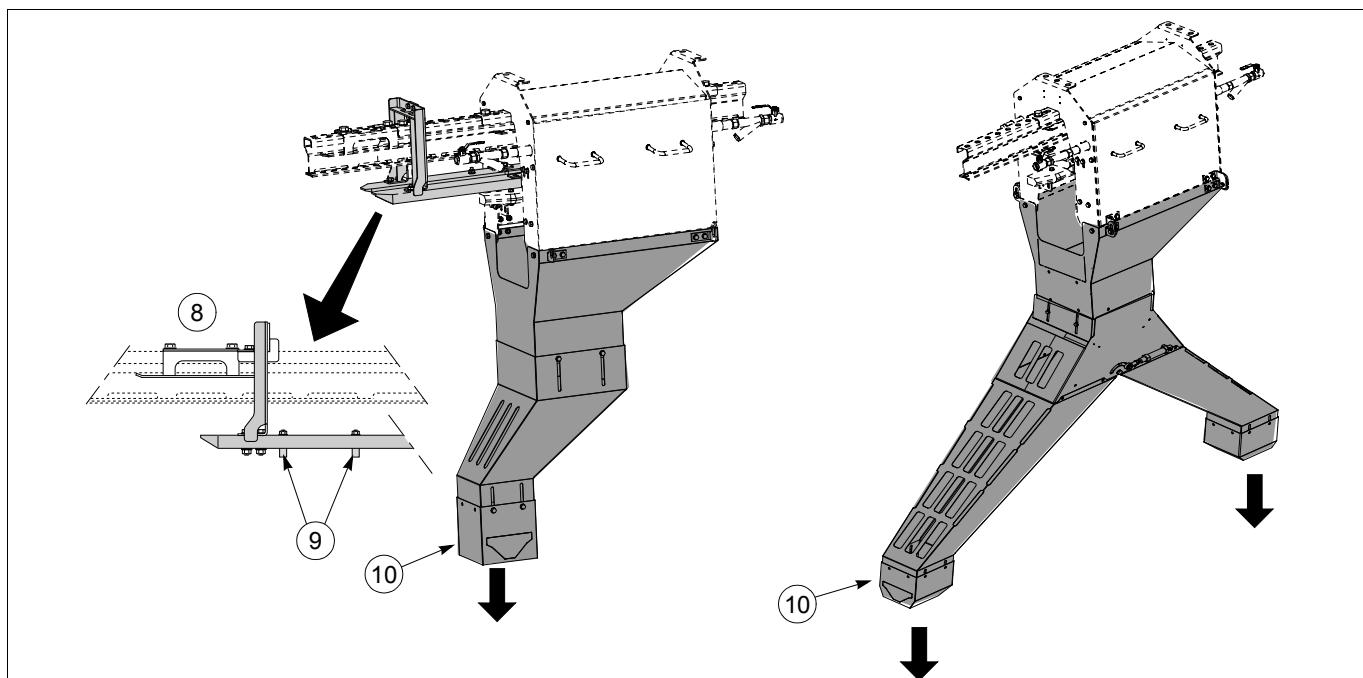


fig. 18

4.5 Safety provisions



MORTAL DANGER
Never remove, bridge or block safety provisions.

The viscera pack unloading station has the following safety provisions:

- Safeguards 1.
See fig. 19.



MORTAL DANGER
If necessary, take extra safety measures when:

- changes are made to the manufacturer's recommendations and instructions during installation of the machine.
- local regulations, legislation or circumstances require this.

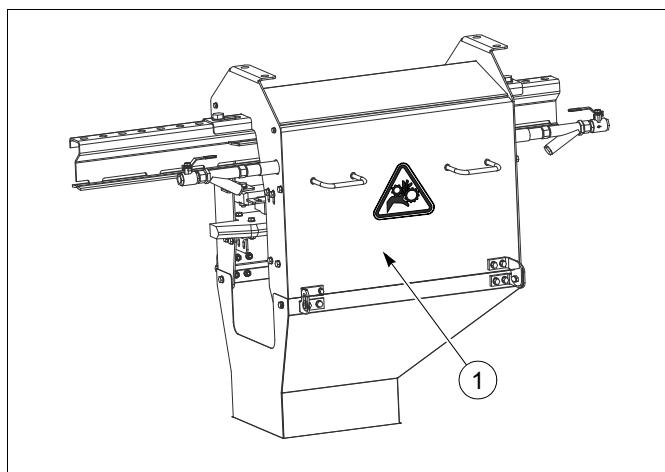


fig. 19 Pictographs

On the viscera pack unloading station with washer you can find pictographs as indicated in fig. 19.
See 2.2 Pictographs for an explanation of the pictographs.

**WARNING**

Check at regular intervals if all pictographs are present and legible in the relevant positions on the machine. If any pictographs have been lost or damaged, apply new pictographs. See User's Manual Pictographs.

4.6 Product specifications

With normal use of the machine the following specifications apply:

tab. 2

Products	Abs. live weight	Max weight range within a flock
Broiler viscera packs	- 1100 - 4000 g [2.4 - 9.0 lb.]	± 200 g [0.44 lb.]

4.7 Machine specifications

Technical details of the machine such as consumption, connection sizes, prints and dimensions are specified in the "Technical Data".

With normal use of the machine the following specifications apply:

tab. 3

Machine capacity
10500 shackles/hour at a 6" pitch

5 SET-UP

The machine will be installed by the manufacturer or by others commissioned by the manufacturer.
If the purchaser carries out the installation himself, the following instructions apply.



MORTAL DANGER

Activities described in this chapter must be carried out by competent, professional and trained personnel.

5.1 Set-up

Set up the machine as shown on the manufacturer's layout drawings. See also the "Technical Data".



MORTAL DANGER

If necessary, take extra safety measures when:

- changes are made to the manufacturer's recommendations and instructions during installation of the machine.
- local regulations, legislation or circumstances require this.

The viscera pack unloading station with shackle washer is mounted in the overhead conveyor for viscera packs. The viscera pack unloading station can be mounted over the following machines:

- Gizzard harvester 1
The viscera pack remnant with gizzard is unloaded straight into the gizzard harvester.
- Heart/lung separator 2
The viscera pack remnant with esophagus, heart and lungs is unloaded straight into the heart/lung separator.

The outlet chute can be fitted with an opening so you can connect discharge trough 3 to it. viscera packs that have dropped from the viscera shackles are discharged through the trough to the heart/lung separator or gizzard harvester.
See fig. 21.

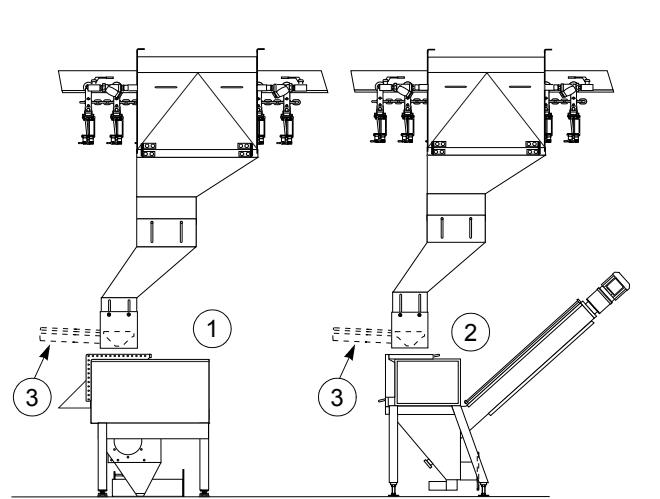


fig. 20 Set-up

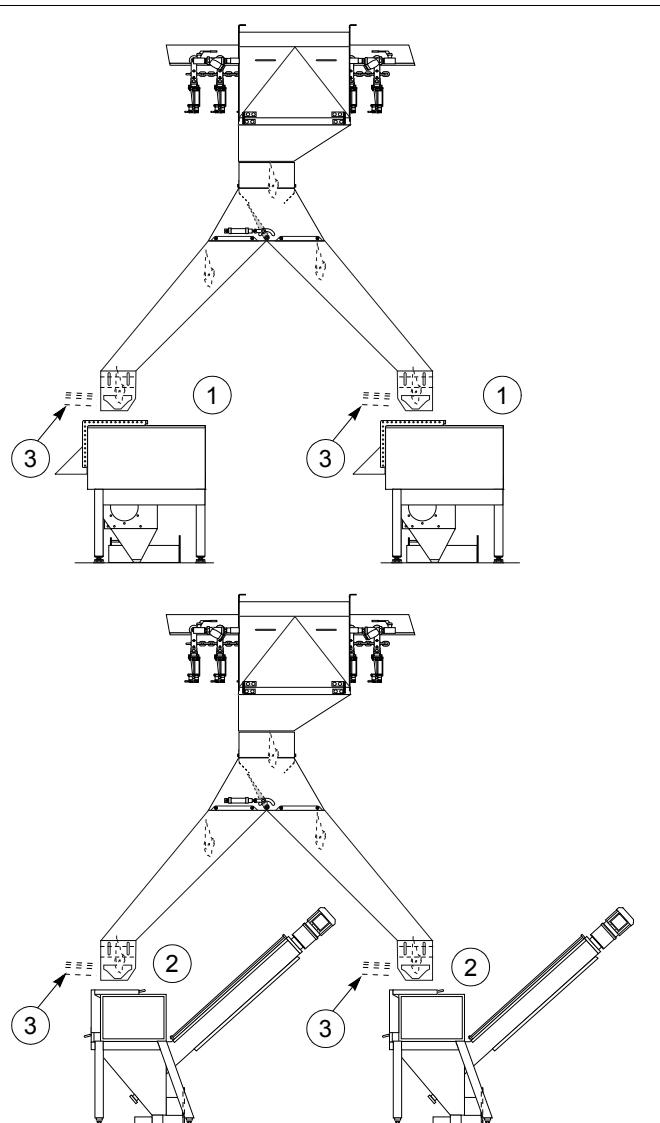


fig. 21 Set-up of the viscera pack unloading station with washer and product distributor

5.2 Connections

5.2.1 Connecting the electricity

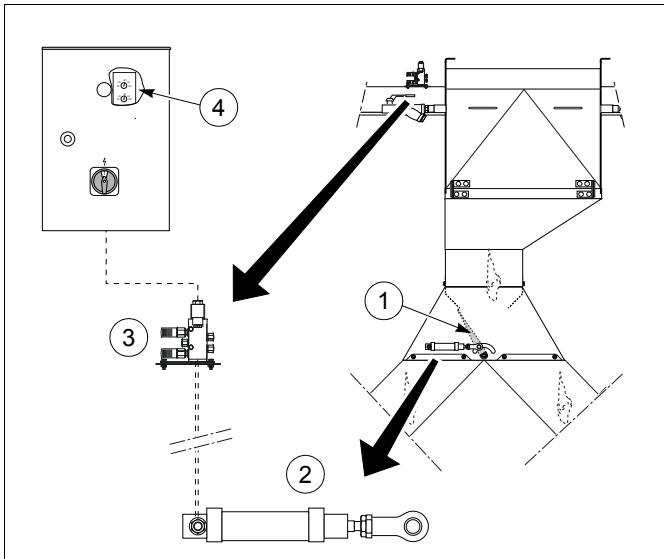
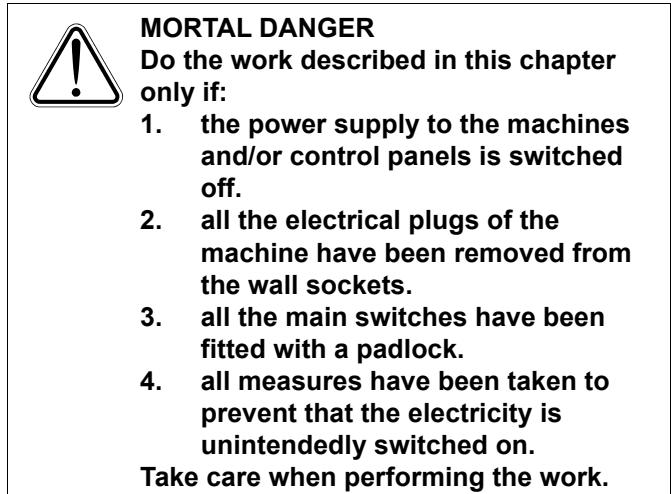


fig. 22 Connecting the valve



Before connecting, check if the power supply and frequency match the data on the type plate of the main drive. Follow local regulations when connecting the machine.

For data about the connections, see the electric circuit diagrams supplied by the manufacturer.

For connection and consumption details consult the "Technical Data".

Double product distributor

Pneumatic cylinder 2 operates product distributor 1.

- Connect valve 3 to the switch box of the unloading station.
- Check after the connection operation the functioning of the valve. The valve connects when time relay 4 connects.

See fig. 22.

5.3 Connecting the compressed air

Double product distributor

The machine contains pneumatic components that are moved by compressed air. The pneumatic components are connected in box 1.

- Connect point 2 to the compressed air supply system.
- Check the functioning of the valve. The valve connects when time relay 3 connects.

For connection and consumption details consult the "Technical Data".

See fig. 23.

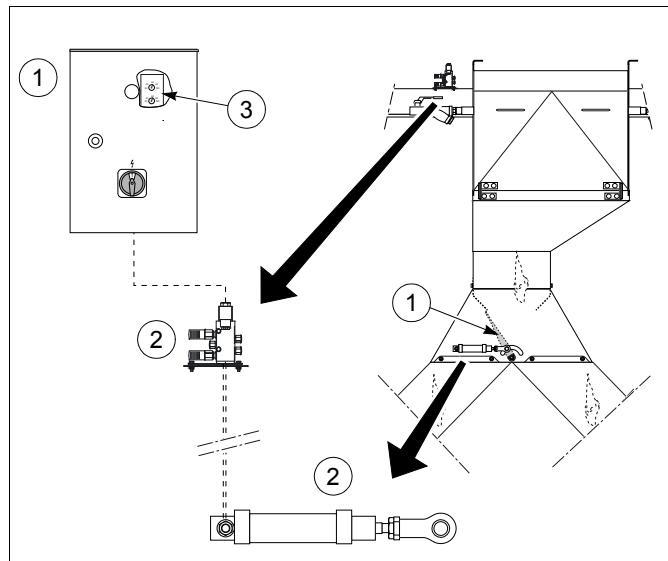


fig. 23 Connecting the valve

CAREFUL

The compressed air must meet the following requirements:

- The size of the contaminated particles must not exceed 5µm.
 - The dew point must not exceed 3-4°C.
 - It must not contain any chemically contaminated particles.
 - The compressed air must be oilproof.
- Oil, water and contaminations in the compressed air cause failures and early wear.

The requirements above correspond with ISO8573-1, class:

- 3 for particles.
- 4 for water.
- 1 for oil.

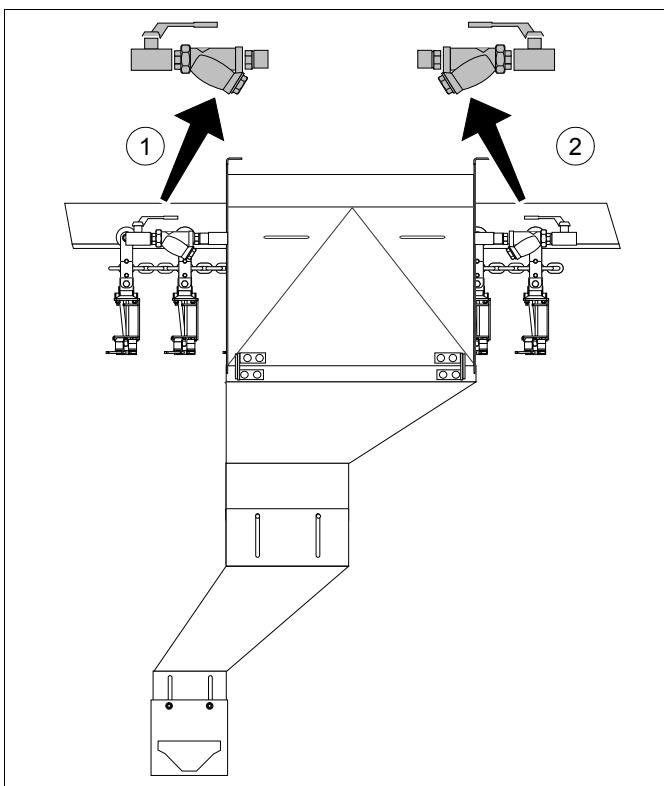


fig. 24 Water connection

5.3.1 Connecting the water supply

Viscera pack unloading station with washer

Unloading spray nozzles hose down the viscera shackle after the viscera pack has been released.

- Connect point 1 to the cold water supply system. For connection and consumption details consult the "Technical Data".



WARNING

The water must meet the following requirements:

- Be of drinking water quality.
- The iron (less than 0.1mg/l) and calcium (hardness of water) levels in the water must be low.
- The PH value must be between 6.5 and 9.5.
- Do not add disinfectants or detergents to the water.

A lower quality water can have a negative effect on the products and the machine.

After production the viscera shackles are cleaned with hot water containing a detergent or disinfectant.

- Connect point 2 to the cleaning system. For connection and consumption details consult the "Technical Data". See fig. 24.

5.4 Cleaning the machine after set-up

Clean the machine thoroughly before putting it into operation for the first time.

See chapter 8.1 Cleaning after production.

6 SETTINGS

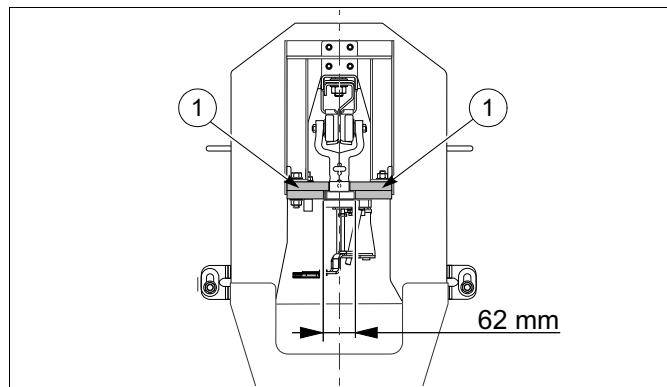


fig. 25 Setting the viscera pack guides of the viscera pack unloading station with pivoting station

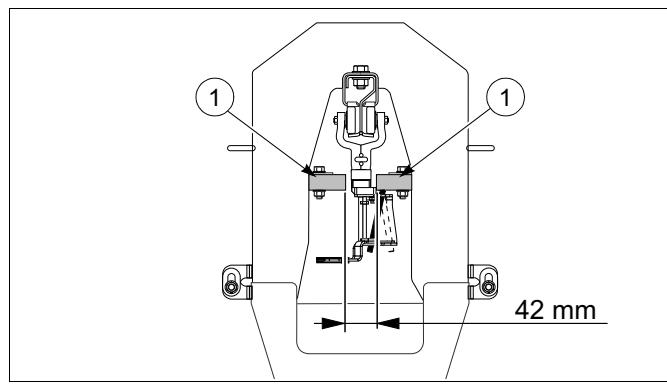


fig. 26 Setting the viscera pack guides of the viscera pack unloading station without pivoting station

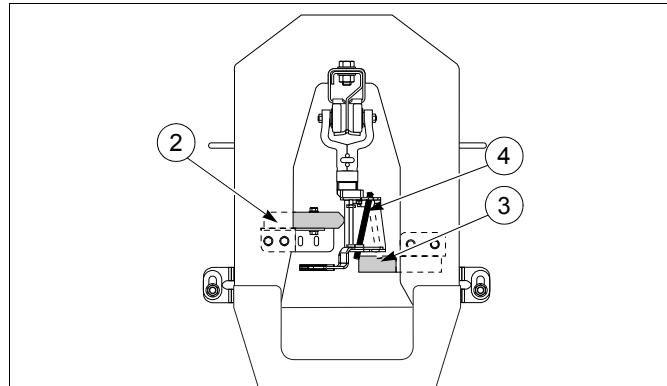


fig. 27 Setting the infeed blocks

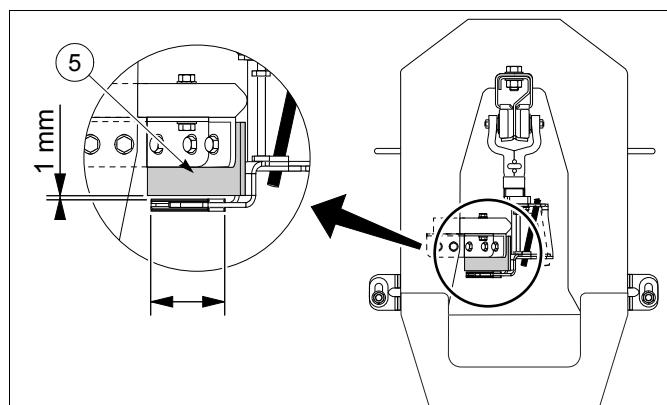


fig. 28 Setting the scraper

MORTAL DANGER

Activities described in this chapter must be carried out by competent, professional and trained personnel.



NOTE

The setting and adjustment data you read in the User's Manual are the basic settings. They may need changing to make the machine work better. Write down the old settings and the corrected settings in the appendix Settings.

6.1 Setting the viscera pack guides

Viscera shackle guides 1 guide the viscera shackle and must have been set symmetrically in relation to the machine.

- Set the width between the viscera shackle guides according to fig. 25 and fig. 26. Set the guides symmetrically in relation to the centre line.

6.2 Setting the infeed blocks

Infeed blocks 2 and 3 open the clamp of the viscera shackle, so the viscera pack is released.

- Set infeed block 2 so that when the clamp is opened the viscera shackle is kept in the position.
 - Set infeed block 3 so that fixating pin 4 of the viscera shackle is completely pushed forward, so the clamp is opened.
- See fig. 27.

6.3 Setting the scraper

Scraper 5 pushes the viscera pack remnant out of the clamp.

- Set the scraper in such a way that the distance between the bottom of the scraper and the top of the clamping device is 1 mm.
 - Set the scraper so that it covers the entire clamp.
- See fig. 28.

6.4 Setting the spray nozzles

Viscera pack unloading station Nuova with washer
The viscera pack unloading station with shackle washer contains the following spray pipes:

- A spray pipe on the infeed side for unloading the viscera pack remnant and for cleaning the viscera shackles during production.
- One spray pipe on the exit side for cleaning after production.

6.4.1 Setting the spray pipe on the infeed side

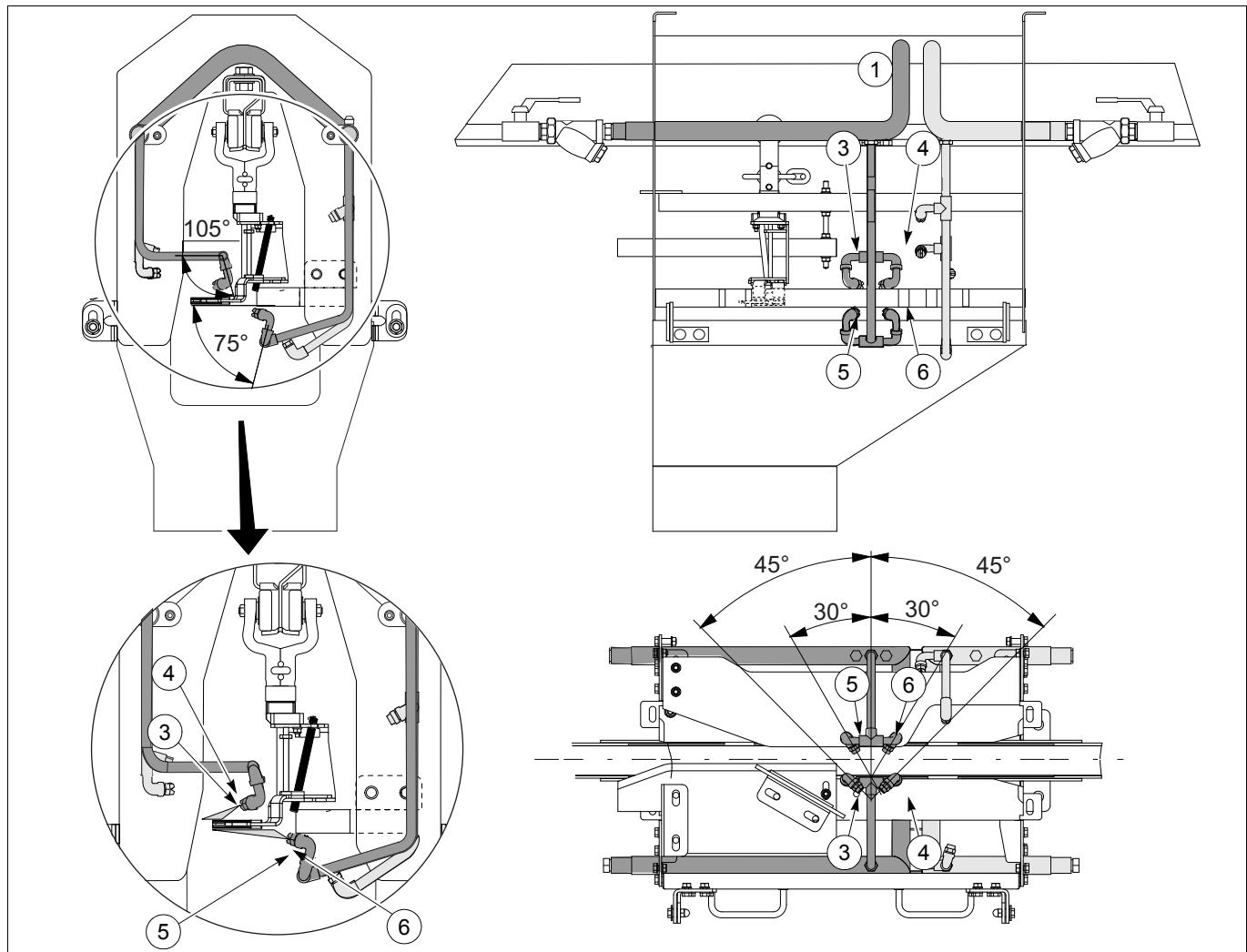


fig. 29 Setting the spray nozzles

Spray pipe **1** on the infeed side contains four flat jet spray nozzles **3**, **4**, **5** and **6** with a 25° spray angle.

- Set flat jet spray nozzle **3**, **4**, **5** and **6** as indicated in fig. 29.
Aim the spray nozzles at the clamp of the viscera shackle.

6.4.2 Setting the spray pipe on the exit side

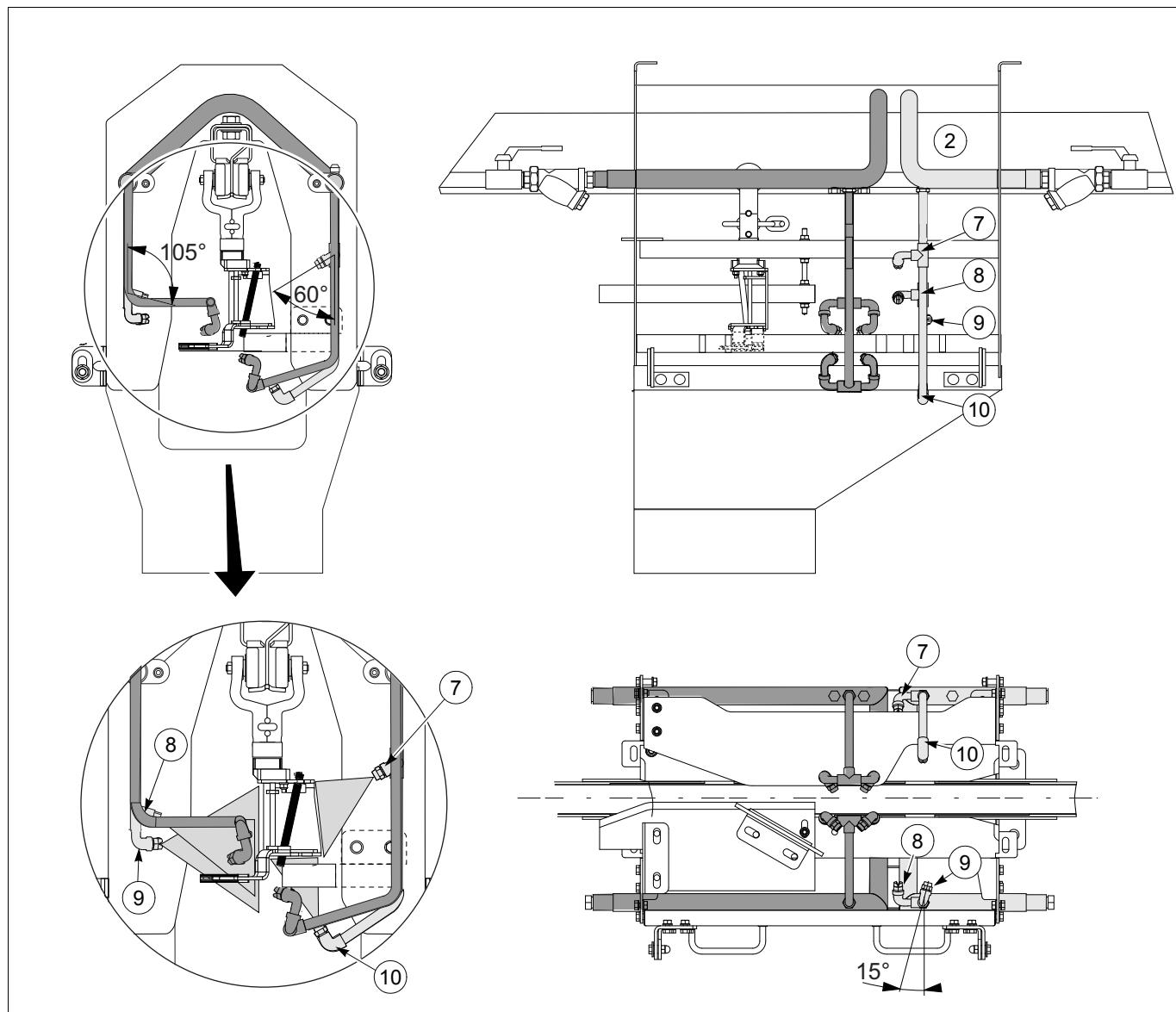


fig. 30 Setting the spray nozzles

Spray pipe **2** on the exit side contains four flat jet spray nozzles **7**, **8**, **9** and **10** with a 65° spray angle.

- Set spray nozzle **7** so that it cleans the back of the vertical section of the viscera shackle.
- Set spray nozzle **8** so that it cleans the side of the viscera shackle.
- Set spray nozzle **9** so that it cleans the inside of the vertical section of the viscera shackle.
- Set spray nozzle **10** so that it cleans the bottom of the viscera shackle.

See fig. 30.

6.5 Setting the time relay

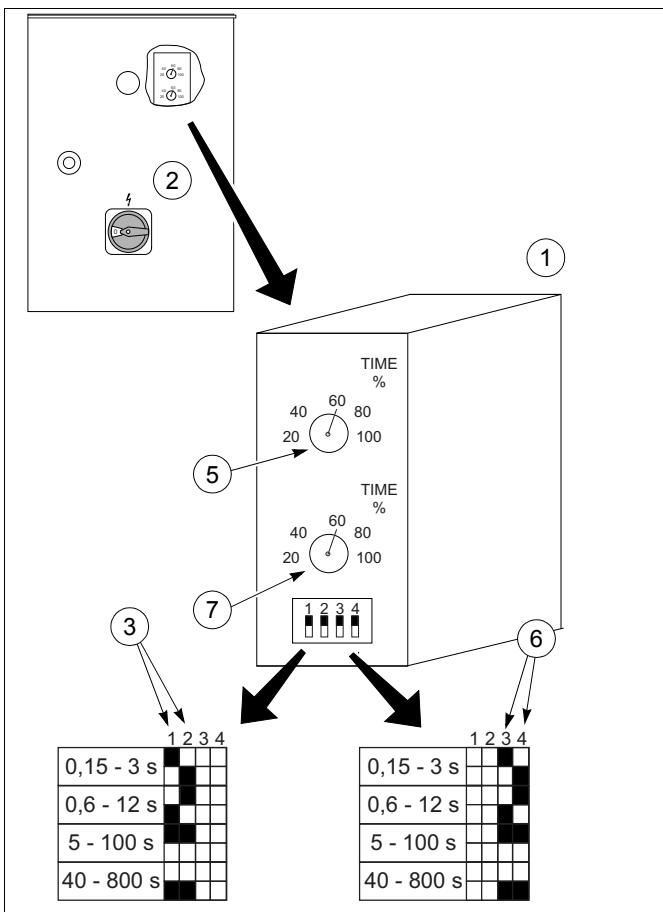


fig. 31 Setting the time relay

WARNING
Setting operations are carried out when
the switch box is open.
Proceed with due care.

The product distributor controls the distribution of the products over the discharge troughs. A time relay activates the product distributor.

Set the time relay as follows:

1. Put switch **2** on the switch box in the "OFF" position.
2. Open the switch box.
3. Set the time for product distributor **4** to be in position **A**. The products come out of the right-hand discharge trough.
Proceed as follows:
 - Set the required time limit with switches **3**.
 - Set the percentage of the time limit with potentiometer **5**.
4. Set the time for product distributor **5** to be in position **B**. The products come out of the left-hand discharge trough.
Proceed as follows:
 - Set the required time limit with switches **6**.
 - Set the percentage of the time limit with potentiometer **7**.

See fig. 31, fig. 32 and fig. 33.

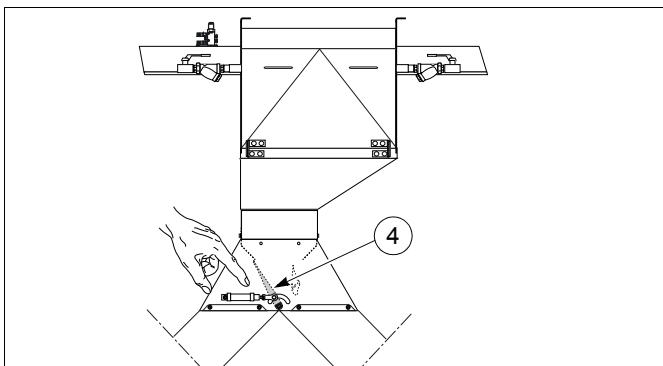


fig. 32 Product distributor in position A

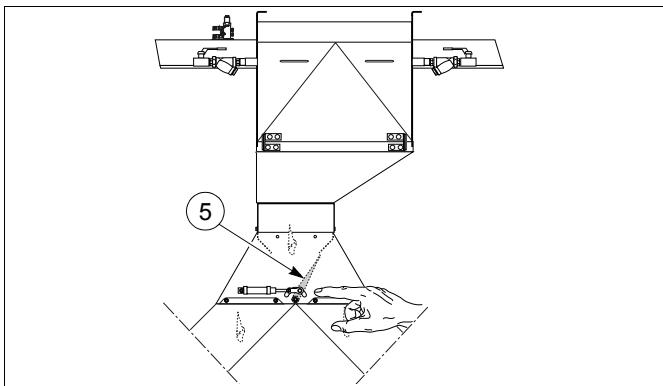


fig. 33 Product distributor in position B

7 OPERATION



MORTAL DANGER
Activities described in this chapter must be carried out by competent, professional and trained personnel.



MORTAL DANGER
It is forbidden to approach within the protected or the non-protected zone of a machine which is switched on.



WARNING
First read chapter 7 Operation prior to starting the machine.



NOTE
Before putting the machine in operation:
The machine is driven by an overhead conveyor and is switched on and off at the same time.

7.1 Emergency stop



NOTE
Only use the emergency stop in an emergency situation.

In case of an emergency:

- pull the emergency stop cord.
- press the emergency stop button.

When the emergency stop has been operated the overhead conveyor/eviscerating system stops. An alarm report appears on the switch box, see User's Manual Overhead conveyor switch box.

Solve the emergency as follows:

1. Have an authorized person solve the emergency.



MORTAL DANGER
Make sure that nothing is done on the machine until the emergency stop is released.
Warn everybody near the machine before you start the machine again.

2. Deblock the emergency stop. See User's Manual Overhead conveyor switch box/Eviscerating system switch box and User's Emergency Stop Provisions.
3. Proceed with processing the products, see chapter 7.5 Starting and stopping the machine.

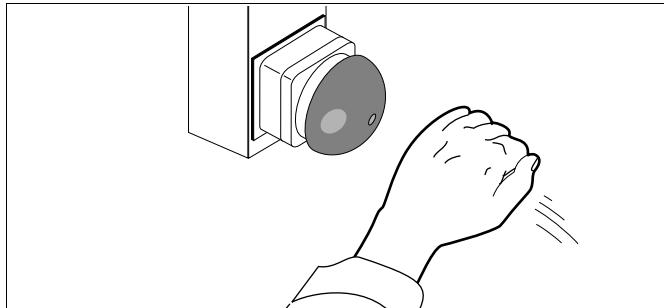


fig. 34 Emergency stop button

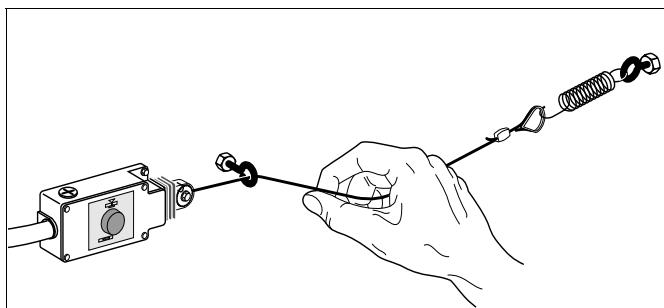


fig. 35 Emergency stop cord

7.2 Setting the adjustable infeed block

Viscera pack unloading station Nuova disconnectable

The unloading station has one adjustable infeed block 1.

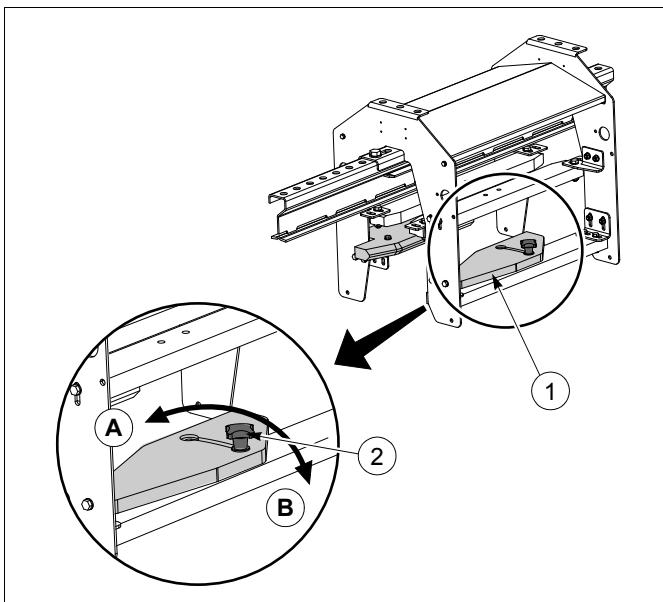


fig. 36 Setting the infeed block

Set the infeed block as follows:

1. Loosen knob 2 a few turns.
2. Put the guide in:
position A for unloading the products.
position B for not unloading the products.
3. Fasten the knob again.

See fig. 36.

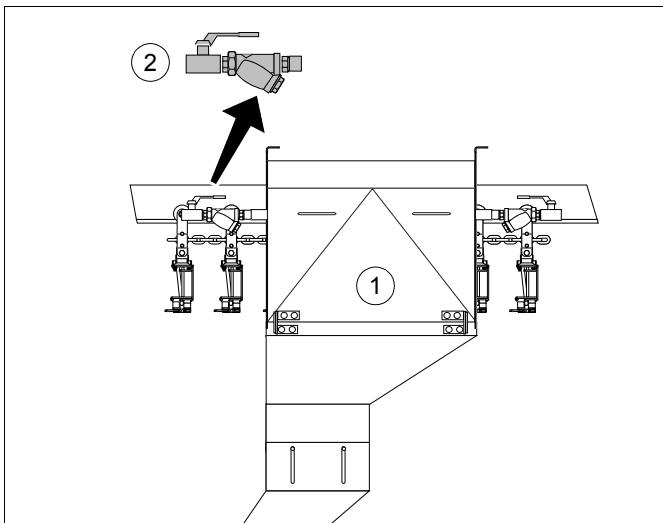


fig. 37 Unloading the viscera pack

7.3 Opening/closing the water supply

Viscera pack unloading station with washer

The unloading spray nozzles:

- unloading the viscera pack from the viscera shackles
- cleaning the viscera shackles.

Proceed as follows:

1. Close safeguard 1.
2. Open/close the water supply with valve 2.

See fig. 37.

7.4 Switching the product distributor on and off

Viscera pack unloading station with double product distributor

Product distributor 1 distributes **the products over:**

- two gizzard harvesters.
- two heart/lung separators.
- one gizzard harvester or heart/lung separator and one collecting bin.

Put switch **2** on the switch box in the “ON” (“1”) position to switch on the product distributor.

Put switch **2** on the switch box in the “OFF” (“0”) position to switch off the product distributor.

See fig. 38.

7.5 Starting and stopping the machine

See User's Manual Overhead conveyor on starting and stopping the machine.

See fig. 38.

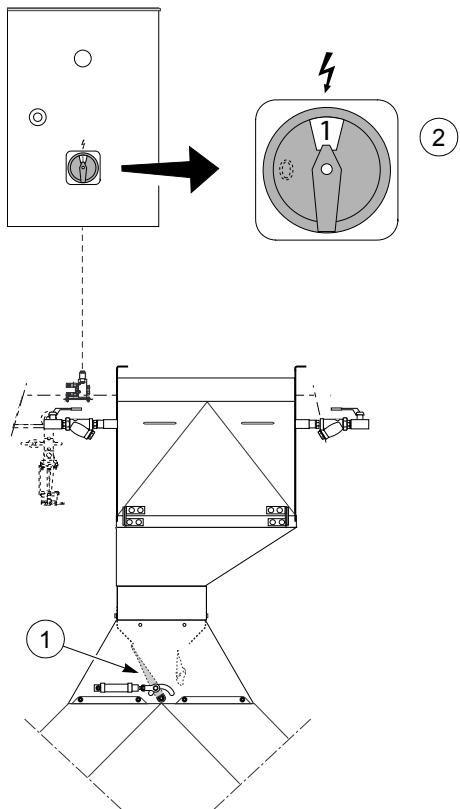


fig. 38 Switching the product distributor on and off.

8 CLEANING

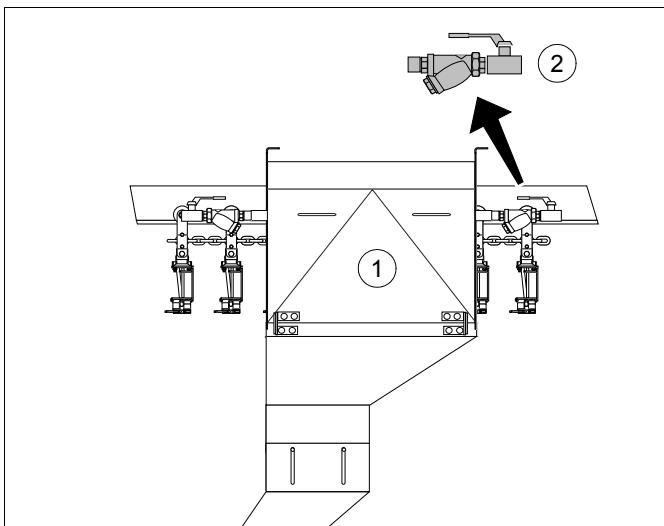


fig. 39 Cleaning after production

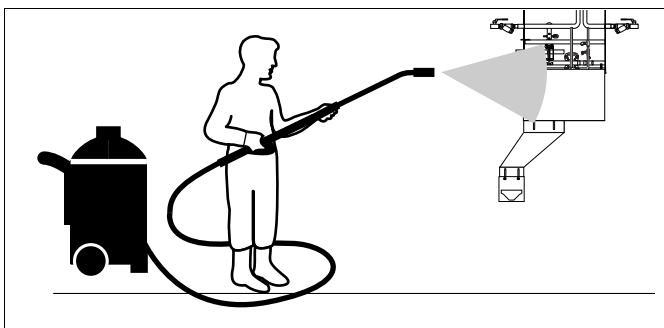


fig. 40 Cleaning the machine



MORTAL DANGER

Activities described in this chapter must be carried out by competent, professional and trained personnel.



MORTAL DANGER

Activities described in this chapter must only be carried out if the power supply to the machine and/or control panel is switched off.

1. Switch off main switch(es) of the control panel(s)
or
remove all machine plugs from the wall sockets.
2. Lock the main switch(es) with a padlock.
3. Take all measures to prevent unintentional recovery of the power supply.
4. Proceed carefully during carrying out the work.



NOTE

Consult the User's Manual "Cleaning and Disinfection" (90811).



TAKE CARE

Take measures to prevent the machine from being started.



NOTE

Open the machine safeguard for cleaning.

8.1 Cleaning after production

Viscera pack unloading station with washer

The viscera shackles can be cleaned after production.
Proceed as follows:

1. Close safeguard 1.
2. Open valve 2.
3. Start the cleaning system.
4. Start the overhead conveyor, see User's Manual Overhead conveyor.

See fig. 39.

Clean the machine on a daily basis, both inside and out.
Also see the User's Manual "Cleaning and Disinfection" (90811).

See fig. 40.

9 MAINTENANCE



MORTAL DANGER

Activities described in this chapter must be carried out by competent, professional and trained personnel.



MORTAL DANGER

Activities described in this chapter must only be carried out if the power supply to the machine and/or control panel is switched off.

1. Switch off main switch(es) of the control panel(s)
or
remove all machine plugs from the wall sockets.
2. Lock the main switch(es) with a padlock.
3. Take all measures to prevent unintentional recovery of the power supply.
4. Proceed carefully during carrying out the work.

9.1 Maintenance schedule

The schedule includes a list of all the maintenance activities which must be carried out. Good, regular maintenance increase the life span of the machine, improves safety and decreases the chance of faults.

Cleaning	Checking	Setting or replacing	Lubrication
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tab. 4 Maintenance schedule

Frequency	Component	Activity	Maintenance	Chapter
Daily	Safety provisions		Check the functioning of the safety provisions and the availability of the pictographs.	4.5
Weekly	Spray nozzles		Check all spray nozzles for blockage.	-
Monthly	Filter		Check the filter in the water supply.	9.2
Monthly	Entire machine		Check for wear, fractures and smooth running of the moving parts.	-

9.2 Cleaning the water filter

Clean the filter as follows:

1. Close the valve in the water supply line before the filter.
2. Loosen nut **1** of filter housing **2**.
3. Remove the filter from the filter housing.
4. Clean the filter.
5. Mount the filter in the filter housing.

See fig. 41.

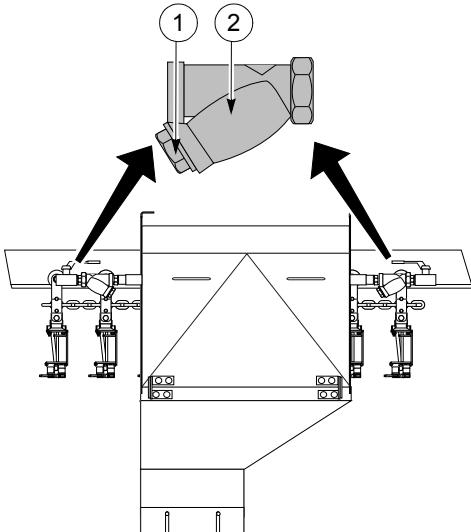


fig. 41 Cleaning the filter

10 FAULTS

**MORTAL DANGER**

Activities described in this chapter must be carried out by competent, professional and trained personnel.

**MORTAL DANGER**

Activities described in this chapter must only be carried out if the power supply to the machine and/or control panel is switched off.

1. Switch off main switch(es) of the control panel(s)
or
remove all machine plugs from the wall sockets.
2. Lock the main switch(es) with a padlock.
3. Take all measures to prevent unintentional recovery of the power supply.
4. Proceed carefully during carrying out the work.

10.1 Failure list

The following failure list includes the most usual failures, their possible cause and solution. Always fix failures as quickly as possible.

tab. 5 List of failures

Failure	Possible cause	Possible remedy	Chapter
Products are not unloaded properly.	Infeed blocks have not been set correctly.	Set the infeed blocks correctly.	6.2

Appendix 1: LOGBOOK

You can use the logbook to maintain a record of production, maintenance, cleaning, checks, faults, repairs, overhauls, modifications and other measures.

Appendix 2: SETTINGS

Note here the settings for the components for various products.