



OPERATING & MAINTENANCE INSTRUCTIONS
FOR
BULK BAG FILLING STATION

BULK HANDLING SPECIALISTS
www.ROTOLOK.com



BULK BAG FILLING STATION



OPERATING & MAINTENANCE **INSTRUCTIONS:**

For

Bulk Bag Filling Station

ONLY QUALIFIED AND/OR APPROVED PERSONNEL SHOULD UNDERTAKE THE INSTALLATION, START UP, PUTTING INTO SERVICE AND PERIODIC MAINTENANCE OF THE BULK FILLING STATION, SAFETY ASPECTS CANNOT BE OVEREMPHASISED.

THE PNEUMATIC CYLINDER, SLIDE GATE, AND FILLING SEAL ARE ALL POINTS WHICH EXTREME CAUTION MUST BE USED. THE MACHINE MUST BE FULLY ISOLATED WITH ELECTRICAL POWER AND COMPRESSED AIR LOCKED OUT PRIOR TO WORKING ON THE MACHINE

Health and Safety at Work

In the interest of health and safety at work, it is essential that before installation such matters as application, mounting position, support and other similar matters should be thoroughly investigated.

Technical details relating to this equipment are shown in our relevant catalogues, which are available on line at www.rotolok.co.uk or on demand from our sales office. In the event that any further advice is required please do not hesitate to contact Rotolok Ltd.

Installation and start-up

DISCONNECT ALL POWER AND PNEUMATICS BEFORE UNDERTAKING ANY WORK ON THE BULK BAG FILLING STATION AND/OR CONTROL PANEL.

Assembly

All units are of modular construction for ease in assembly and adding/removing components. Most units are shipped in sections:

- Upright Supports (Legs) Section with optional control panel assembly.
- Bag Support Frame
- Filling Head Assembly with any combination of slide gate, bag spout seal, or filling cone.

The leg sections bolt to the bag support frame. All necessary bolts, nuts and washers are supplied with the unit. The filling head assembly in turn bolts in place to the upper framework. Mount pneumatic controls in location of your choice, and bolt in place on the framework. Run the pneumatic air line from the filling head to the control panel. A dust extraction spigot is located on the filling head assembly. This spigot may be used with a dust sock filter or vacuum collection system.

Group Accounts/Sales/Purchasing:

Rotolok Ltd. 1 Millennium Place, Tiverton Business Park, Tiverton, Devon. EX16 6SB.
Telephone: Central Switchboard: 01884 232232 Fax: 01884 232200.
Email: sales@rotolok.co.uk Web: www.rotolok.co.uk
Registered in England No. 2050400
Registered Office 1 Millennium Place, Tiverton Business Park, Tiverton, Devon. EX16 6SB





Air supply to the inflatable seal must be clean and dry. Minimal air is required to inflate the seal, typically only 4 – 5 psi. Excessive pressure will cause the seal to rupture. To set the air pressure, start at 0 psi and slowly increase air pressure until the seal makes contact with the seal retaining ring. Once the correct pressure has been achieved, lock out.

If there are any questions or concerns during assembly of the unit, please do not hesitate to contact our engineering staff.

Operation

WARNING: THE BAG WEIGHT MUST REST FULLY ON THE FLOOR OR A PALLET. DO NOT ALLOW THE BAG TO HANG FROM THE BAG SUPPORT HOOKS. THE SUPPORT HOOKS ARE DESIGNED TO SUPPORT ONLY THE EMPTY BAG AND TO HOLD IT IN THE PROPER POSITION FOR FILLING.

Place a pallet at the centre of the station on the floor and hang an empty bag from the support hooks. Place the bag spout around the filling head inflatable seal. Inflate the bag spout seal. Do not inflate the spout seal without a bag spout around it.

The unit is now ready to be filled with material.

When the bag is full, deflate the seal and pull the bag spout down below the filling head. Tie the bag spout and remove the bag from the filling station by lifting the pallet and backing away with a hand or fork truck.

Maintenance

Disconnect power and 'lock out' prior to performing any maintenance on the Bulk Bag Filling Station. Only qualified personnel should service the unit.

Regular inspection of the spout seal, tubing, and air cylinder is recommended. Intervals between inspections will vary with the application and service, but as a minimum a monthly inspection is recommended.

All pneumatic connections are with quick connect fittings. Most air leaks can be stopped by firmly pressing the tubing into the fitting.

All bolts, flanged connections, and hitch pins should be periodically checked to insure they are tight and secure. Again, inspections will vary with application and service, but as a minimum a monthly inspection is recommended.

Check the main air filter periodically and clean or replace the filter element as required.

Problem Awareness

DISCONNECT ALL POWER BEFORE UNDERTAKING ANY WORK ON THE BULK BAG FILLING STATION.

Material Flow Problems

If product fails to flow into the bulk bag, please check the following:

- Product is being delivered to the filling station.

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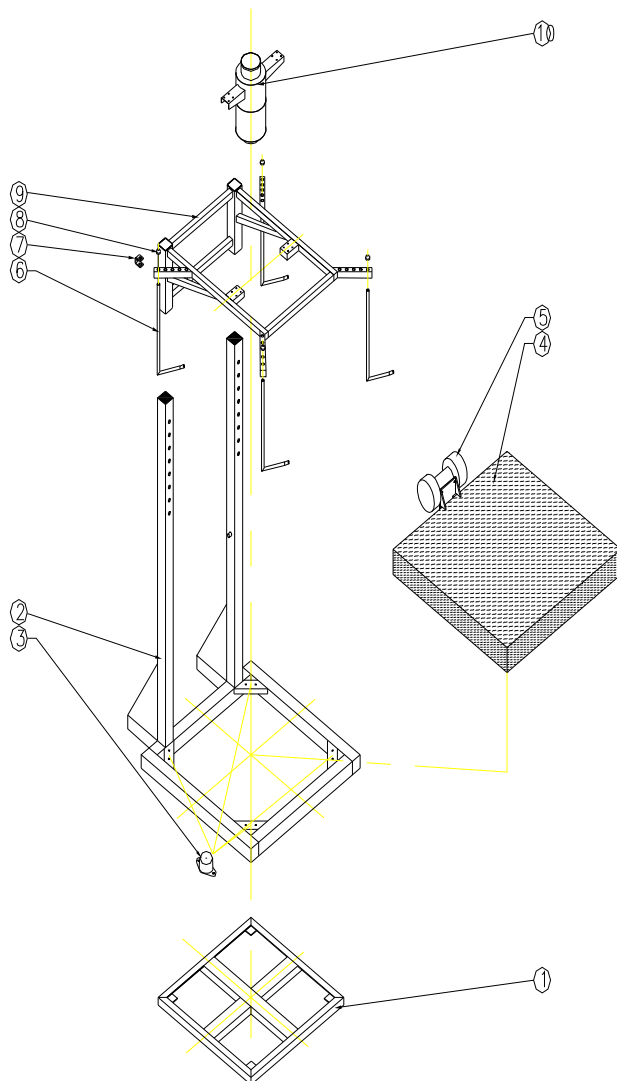
- Is the product is flowing properly without bridging in the filling head tube.

Air Leakage Problems

Most air connections utilize quick connect fittings. Most leaks can be stopped by firmly pressing the air tubing into the fitting. Other connections are threaded and sealed with Teflon pipe thread tape.

Long Term Storage

The bulk bag filling station must be stored in a dry area out of the elements. The shipping crate is not designed to support any weight, nor is it designed to be stacked on top of other equipment.



	ITEM	QTY
1	LOAD CELL PLATFORM	1
2	FILLING STATION FRAME	1
3	ANTI-VIBRATION MOUNTS	4
4	WEIGH PLATFORM	1
5	VIBRATOR MOTOR	1
6	BAG LOOP SUPPORT ARM	4
7	'C' CLAMP	4
8	SUPPORT ARM STOP	4
9	SUPPORT ARM FRAME	1
10	FILLING HEAD	1

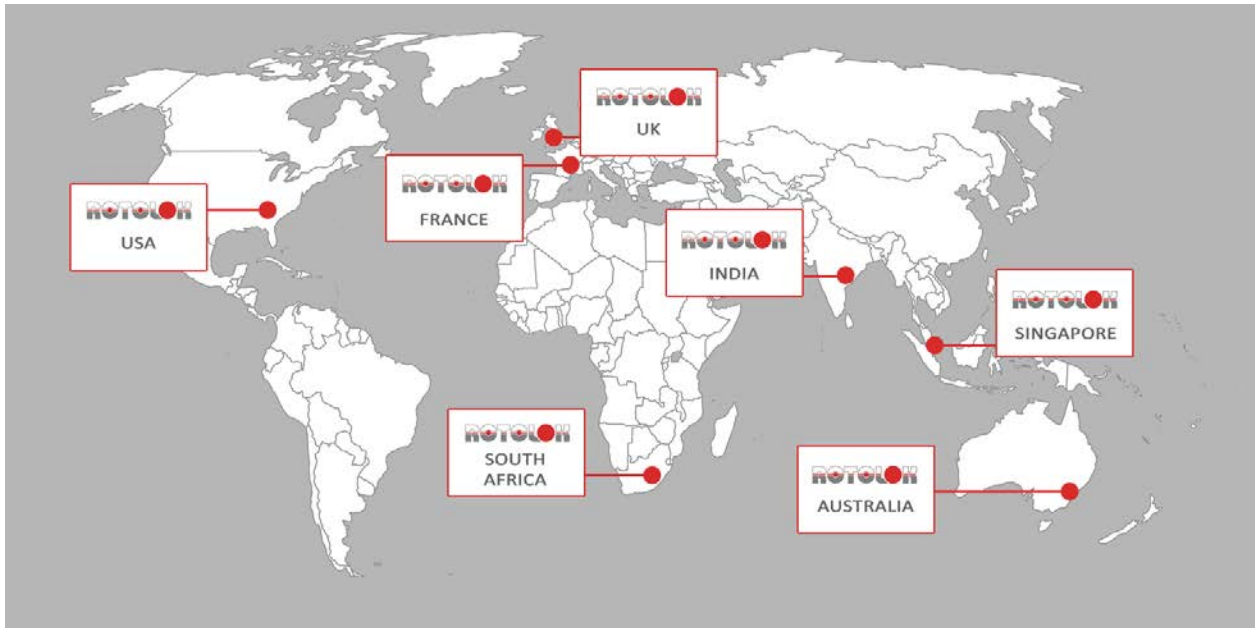
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