

Operation and Setup Manual for Xpect Solutions Inc Lid Press Machinery





LID PRESS MACHINERY

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Operation and Setup Manual for Xpect Solutions Inc Lid Press Machinery

Includes instructions for:

Small Pail Tabletop Lid Press

Tabletop Lid Press

Stand Up Lid Press



(5-Gallon Bucket Stand up Fixed Stainless-Steel model)



***TO THE OWNERS, MANAGERS, AND OPERATORS OF LID PRESS MACHINES
EQUIPPED BY XPECT SOLUTIONS INC.***

Safety is the most important issue in the workplace. Observing safety guidelines, equipment capacities and using common sense will provide a work environment that is safe and efficient for employees, management, and customers. This operator manual has been assembled and sent to help you and your operators move products quickly and safely. It is important that you and your operators read and understand the information included here in.

A key element in safely lidding buckets and pails is that all necessary people are trained, including:

- >Machine Operators.
- >Personnel working in the area of the operation of the machine.
- >Other individuals, Owners or Management of your company feel need to be trained.

Prior to using the Lid Press Machine, ensure that all personnel that will use/or work in the area of the machine read the following:

- >Operation Manual and Setup Manual for Xpect Solutions Inc Lid Press Machinery. (*This Manual*) <

We recommend that Management complete the following items prior to using Xpect Solutions Inc Lid Press Machinery:

- >Conduct a meeting with all personnel to review, discuss and answer questions regarding safety, capacities, limitations, and proper operational procedures.

Daily workplace and operational safety is the responsibility of the **Owners, Managers, and Operators**.

- >Knowledge & routine supervisory duties to ensure that safe operating practices are followed.
- >Regular maintenance and inspection of the equipment, with documentation of such.
- >Periodic meetings, reviewing operating guidelines, signed by all of the attending personnel.

The proceeding outline, and the following information laid out in this Operational Manual for Xpect Solutions Inc is intended to be a guide only, and is not meant to encompass all issues that may need to be addressed for your particular type of business operation.

Lid Press Machinery Precautions

Secure the Machine

Assure the Lid Press Machine is in a secure level position for operation. Movement of the machine during operation could result in injury.

Put on appropriate Personal Protective Equipment (PPE)

At minimum, wear safety glasses. Your worksite may require additional PPE, such as steel toe shoes, gloves, etc., observe your workplace rules.

Lid Press Operation Requirements

Air Requirements

Each Press is required to have an air supply connected to the Quick Connect Fitting located on the back of the Lid Press.

CAUTION: When air is applied to the regulator the Press Disk could potentially MOVE from the down position to the raised position. Additionally, when air is REMOVED the Disk could potentially lower from the raised position to the lower position. Be sure not to place any arms or fingers in the area of the Lid Press, Press Disk. Failure to do so could result in severe/crushing injury.

80 PSI, Clean and Dry Air

The Regulator should be set to 80 PSI minimum



(Air Regulator)

Lid Press Operation

Operation of the Press is simple in nature.

Each Lid Press Machine is equipped with a 2-Hand Control.

In order to actuate the Press, BOTH buttons MUST be pressed at the EXACT same time to lower the Press Head. Buttons are located on each side of the 2-hand control in the center of the yellow ends.

The Press Head will stay lowered until the buttons are released at which point the Press Head will raise automatically. It is recommended to press and hold the button for 3 seconds while the press head is in the extended position to assure a complete tight lid.



(2 Hand Control)

Lid Press Operational Safety

Pinch Points

There are a number of potential pinch points at different areas;

Pinch Point Stickers have been placed at areas around the machine to indicate the hazard area.

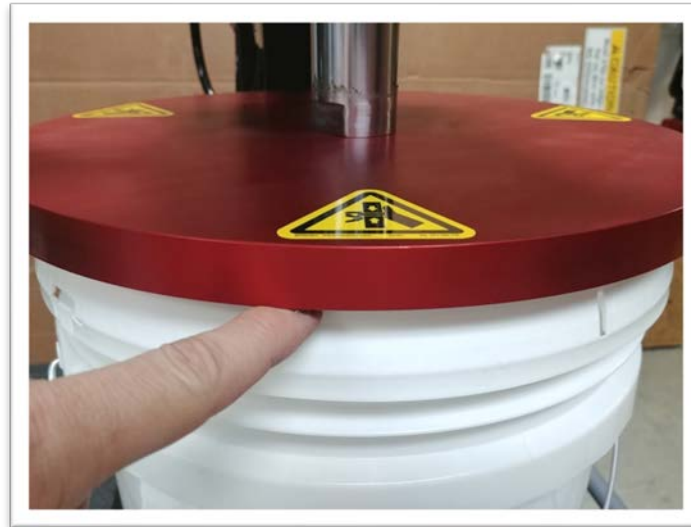
Correct 2-Hand Operation of the Machine will assure hands are in the proper place during operation of the press.



(Press Disk with Pinch Point Stickers)

CAUTION: Potential Pinch Points Areas are

Between the Press Plate and the Bucket Lid.



(Potential Pinch Point)

Between the Press Plate and the Cylinder Body.



(Potential Pinch Point)



Lid Press Setup

The Lid Press should be set up for your Bucket size when it ships from Xpect Solutions Inc, but from time-to-time adjustments are required to be made to assure the proper closure of Lid to Pail.

Pail Stop

The Pail Stop is the location at the base or midpoint of the vertical I-beam. Its purpose is to act as a backstop and positioning guide for the bucket to keep it centered under the press head.



(Pail Stop)

Pail Stop Adjustment

Loosen the two Hex Head Cap Screws and slide the White UHMW Bracket forward or back until your Bucket position had the pail centered under the press disk. Re-tighten the screws.

Press Head Adjustment

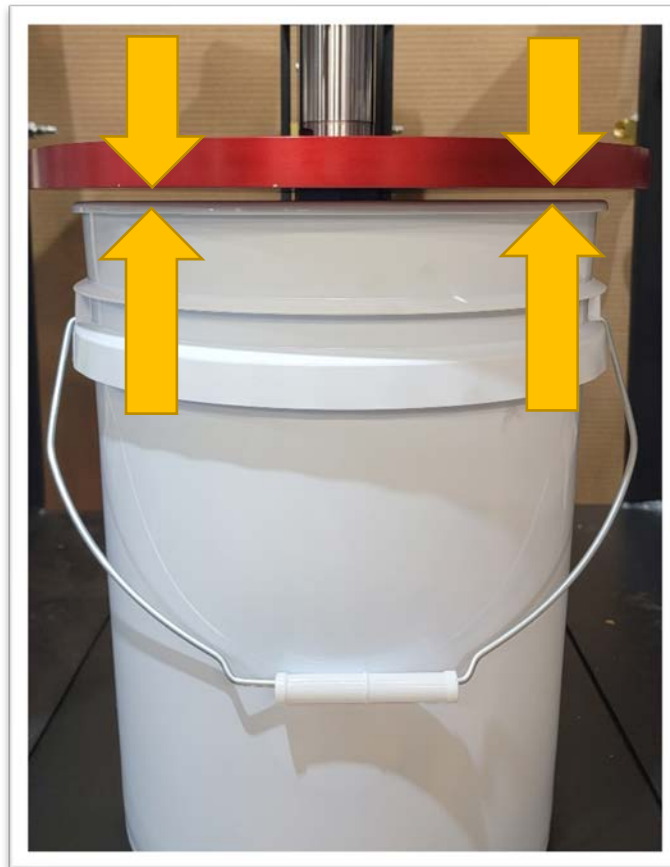
With air connected to the Press and the Press Plate retracted, place an empty bucket with NO LID under the Press Head.

Press and hold the 2-Hand Control. The Press Disk should lower while the 2-hand control is pressed.

While in this position, visually inspect the top edge of the pail on the lower edge of the Press Disk. There should be 1/8" clearance between the circumference of the pail and Press Disk.

View this clearance from multiple angles to assure the clearance is equal.

Some Lid and Pail combinations require a bit more clearance and some require a bit less than 1/8" clearance. View your pails final seal to determine your fine-tuned requirements.



To Adjust the Press Head for a NEW Pail Closure Position:

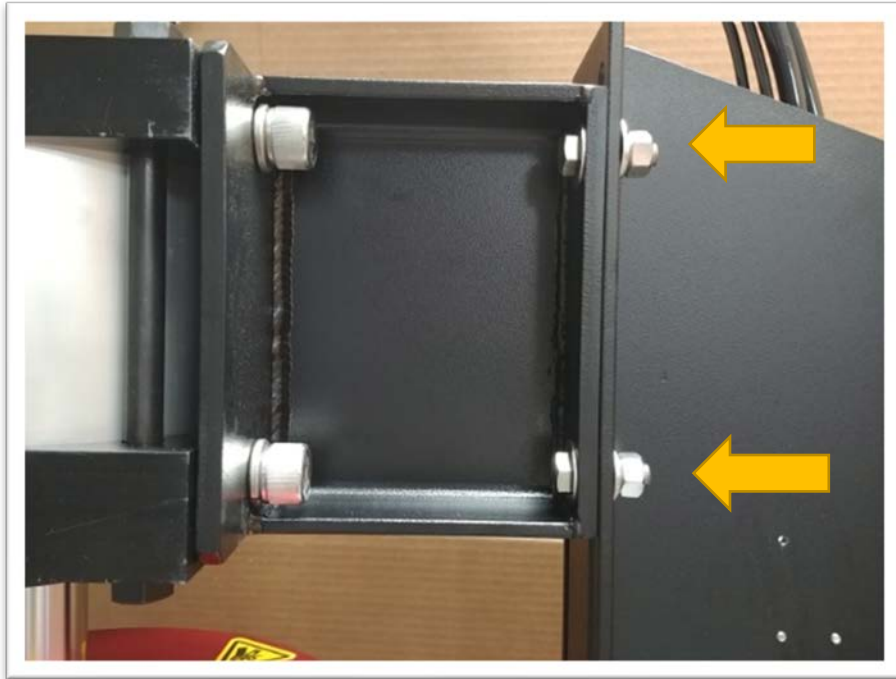
CAUTION: Only qualified service or maintenance personnel should attempt this adjustment.

With AIR connected to the Press, place an empty bucket with A FULLY PRESSED LID under the Press Head. Remove the Main Air Line from the Air Regulator from the back of the machine.

Locate the Control Valve, which is located on the side of the vertical I-Beam. With air removed from the press, swap tubes A and B so you have inserted Tube A into Port B and Tube B into Port A.



(Control Valve)



(Press Head Support Beam)

Do Not remove or loosen the bolts attached to the Air Cylinder as shown on the left (above).

Using the proper size, open end wrench or socket combination, loosen the 4 ½-13 bolts that support the Press Head as shown on the right as indicated in the photo above.

CAUTION must be used to only **loosen these bolts**, as the Press Head is HEAVY and could slide to the bottom of the slots.

Reconnect the Air Supply. Once the Air Supply is reconnected the Press Disk should **immediately** extend – extending the Press Plate down onto the closed pail and pushing the entire Press head assembly up in the slots. (If the Head does not move up the bolts, they are too snug. You will need to loosen them more).

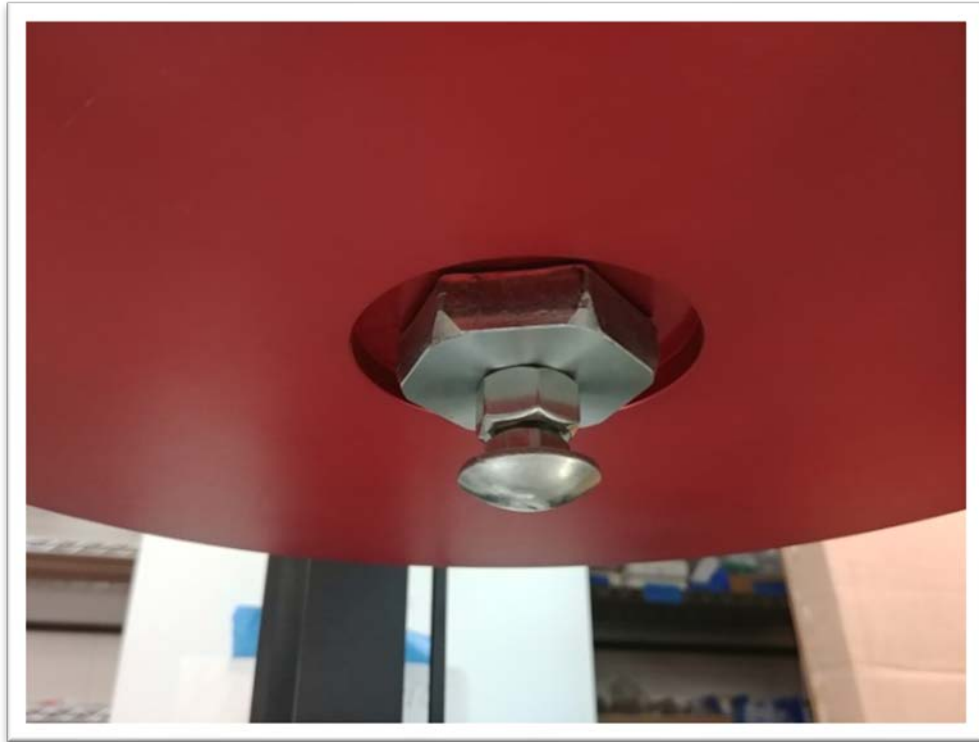
View the gap between the Press Head and the top of the pail. If required, use a plastic mallet to adjust the Press Head bracket up, down, left or right, to position the Press Head parallel with the top surface of the CLOSED pail.

Once you are satisfied with the alignment, tighten all 4 of the ½ - 13 bolts and remove the main air supply.

Swap the Air Lines back on the valve to Tube A to Port A, Tube B to Port B. Re-apply Main Air and test.

Burper

Each Press has the option for a Burper to be installed. Installation and adjustment are as easy as threading a bolt into the provided threads and setting the height to allow the Burper to NOT puncture the Bucket Lid while pressing the lid on.



(Burper as seen from below)

Quick Exhaust

The main Air Cylinder is equipped with a quick exhaust fitting and a check valve to allow for the fast release of air from the Air Cylinder during the closure cycle. No adjustments are typically necessary. The check valve will open when air is applied to the machine and close when air is removed from the machine. This prevents movement of the air cylinder when NO air is applied to the press.

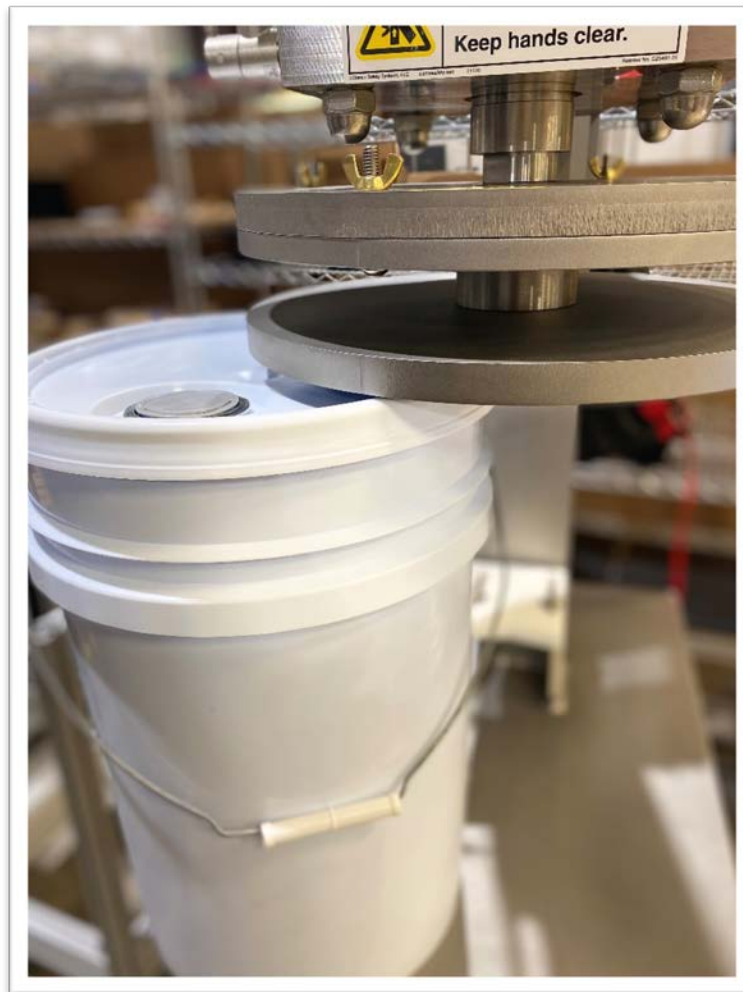


(Quick Exhaust and Check Valve)

Pail / Bucket Adapter

Pail adapters are used when multiple size pails are run on one machine and size conversion is required from the larger pails size to the smaller pail size.

Pail Adapters are equipped with 4 threaded bolts which are inserted up through 4 holes in the Press Plate. They are then fastened with wing nuts for operation.



(Pail Adapter)

For Service or Operation Questions

