Grupo Giró

GirBagger PACKAGERS

Models: UB50, GB50, GB50S, GB55, GB55S, UB60, UB60S , UB65

User Manual

Manual 328-999996-07 (ENG) Revision: 3 (03/12)

GENERAL CONSIDERATIONS

Please read this User Manual carefully before proceeding with maintenance, placement into service, utilization, and before any use of the machine in general.

This User Manual has been drafted with the idea of serving as an aid and guide in the operations of the machine itself, with the security that by correctly following the explanation and advice detailed within it, the machine will obtain its maximum yield in accordance to how it has been designed and created.

ATTENTION: This certification sign (as seen to the left of the text) will be found throughout the manual in order to highlight the most important aspects necessary to properly operate the machine.

This manual describes the manner in which the machine must be used and lists a number of risks that can arise through its improper use. **Giró** bears no responsibility for the consequences resulting from any type of improper utilization of the machine.

WARNING: This warning sign (as seen to the left of the text) is found throughout the manual in order to highlight the most important aspects in respect to worker safety and health.

Information pertaining to maintenance operations, as well as a list of replacement parts is found in the Maintenance and Replacement Parts Manual.

Giró reserves the right, without previous notice and at any time, to make modifications or improvements it deems necessary to the design of its previously manufactured machines, while maintaining, however, its essential characteristics described in this manual.

Giró GH, S.A.
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Declaramos, bajo nuestra responsabilidad, que la máquina
We declare, under our own responsibility, that the machine / Nous déclarons, sous notre responsabilité, que la machine
Wir erklären auf unsere eigene Verantwortung, dass die Maschine / Dichiariamo, sotto nostra responsabilità, che la macchina.

MARCA **GIRÓ**
TRADEMARK / MARQUE / MARKE / MARCA

TIPO **GB / UB**
TYPE / TYPE / TYP / TIPO

Nº DE SERIE **.328 . .**
SERIAL NUMBER / Nº DE SÉRIE / SERIE NNR. / Nº DI SERIE /

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I. GENERAL CHARACTERISTICS

1.- GENERAL DESCRIPTION OF THE GIRBAGGER PACKAGER

1.1.- GB-UB Packager Characteristics

GB/ UB is a machine line used for packaging fruit and vegetables using a thermo-sealing system to form, fill and close bags starting from a continuous reels of mesh and other consumable products. A SOFT machine version is also available which enables soft or delicate products to be packed such as apples and tomatoes, etc.

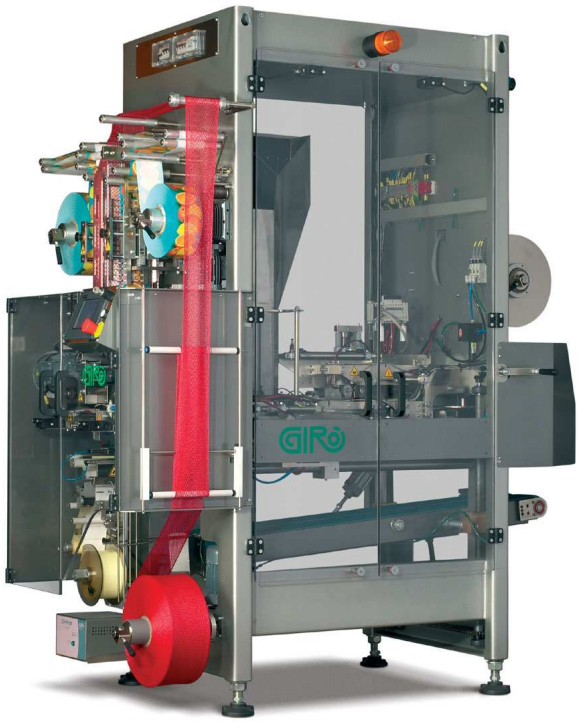


FIG. 1.1. GIRBAGGER

1.1.1.- General Information

- Automatic packaging of bags weighing up to 5 Kg according to format (up to 4 kg in the SOFT packing version according to format).
- It operates with a continuous reel of mesh, which drastically reduces stoppage for changing consumable products.
- Recommended mesh widths range from a 40 to 49 cm according to format.
- Film widths: from 75 to 145 mm according to format.
- It can use registered film on both right and left sides (to be ordered).
- It can be integrated in to a GIRPRINT labeller to adhere labels to the left side. Also a thermotransfer labeller to print directly on the left of the film.
- It can adapt to all types of weighing machines.
- The machine can pack up to 32 packages per minute in function of the format, product type, caliber, ...

1.1.2.- Electrical System

- Voltage [1] ..... [400 Vac ± 5%, III + N + T] or [230 Vac ± 5%, III + T]
- Frequency ..... 50 / 60 Hz
- Average Power ..... 3.5 Kw.

1.1.3.- Pneumatic System

- Operating pressure ..... 6 bar
- Average air consumption ..... 1000 l/min

1.1.4.- Dimensions and weight[2]

- Length (closed doors) ..... 1770 mm
- Depth (with doors closed and without hopper) ..... 820 mm (+250mm)
- Height ..... 2185 mm
- Weight ..... 780 Kg.

1.1.5.- Environmental conditions of utilization

- Operating temperature range ..... 0ºC ÷ +40ºC (32ºF - 104ºF).
- Storage temperature range ..... -10ºC ÷ +65ºC (14ºF - 149ºF).
- Ambient humidity tolerated ..... 0% ÷ 90% HR (non-condensing humidity).

1.1.6.- Protection machine during long periods of inactivity.

- A preventive maintenance will ensure the correct operation of the machine after a long period of inactivity. Before a long period of inactivity is recommended:
    - Make an exhaustive cleaning of the machine to remove any remaining of residues.
    - Check all the mobile parts. Proceed according the maintenance manual of the machine.
    - To prevent rust in some parts is recommended use a preventive spray with FDA approved food grade. **Giró recommends use protective spray LOCTITE 8021**.

[1] Each machine leaves the factory outfitted for **only one** of the two possible electrical voltages, according to the order.

[2] These values can be different according model and accessories.

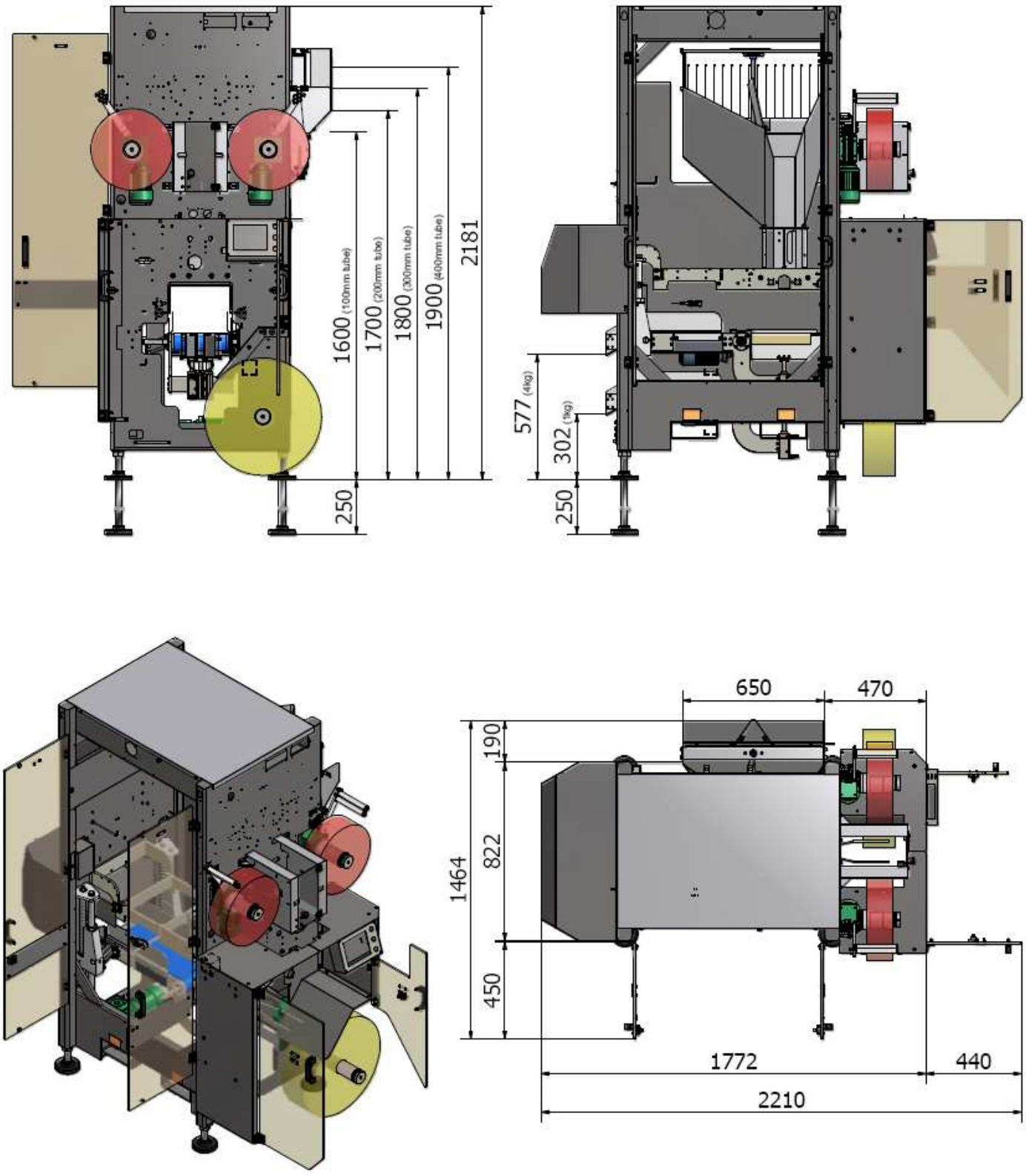


Fig 1.2 GIRBAGGER Machine lay-out

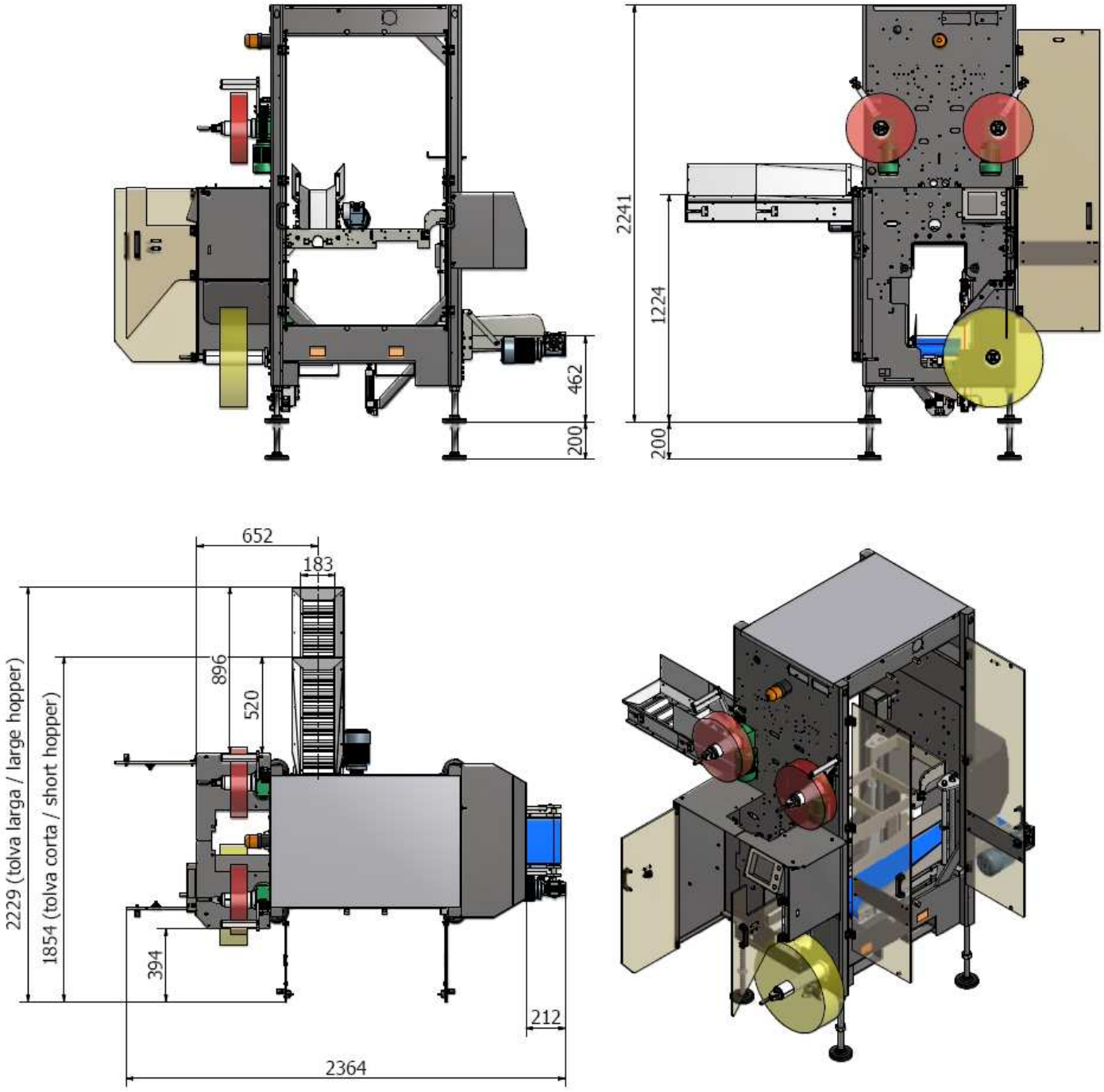


Fig 1.2 GIRBAGGER SOFT Machine lay-out

1.1.7.- Bag format according to machine model

UB 50 / UB50 A

Bag type ULTRABAG with or without HANDLE:

Film width from 75 to 145 mm

GB 50 / GB 50S

Bag type GIRSAC

Film width from 75 to 120 mm

GB 50 A / GB 50S A

Bag type GIRSAC with or without HANDLE

Film width from 75 to 120 mm

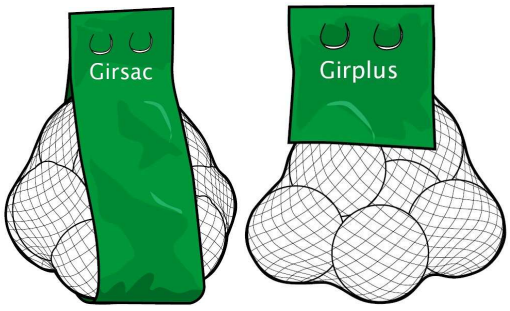
GB 55 / GB 55S

Bag type GIRSAC and GIRPLUS

Film widths:

for GS fr 75 to 120 mm

for GP fr 90 to 120 mm



GB 55A / GB 55S A

Bag type GIRSAC and GIRPLUS with or without ASA

Films widths:

for GS fr 75 to 120 mm

for GP from 90 to 120 mm

UB 60 /UB 60 S

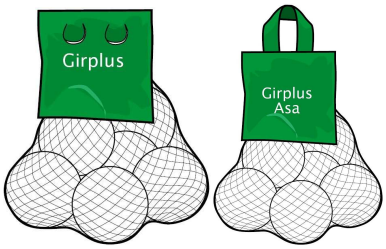
Bag type GIRSAC and ULTRABAG
Film widths:
for GS from 75 to 120 mm
for UB from 75 to 145 mm

UB 60 A / UB 60 S A

Bag type GIRSAC and ULTRABAG
with or without HANDLE
Film widths:
for GS from 75 to 120 mm
for UB from 75 to 145 mm

UB 65 / UB65 A

Bag type GIRSAC,GIRPLUS and ULTRABAG with or without HANDLE
Film widths:
for GS from 75 to 120 mm
for UB from 75 to 145 mm



1.1.8.- Functional explanation of the machine

From a functional point of view, the GIRBAGGER machine can be considered to have two main areas joined by a transfer mechanical system:

I. BAG FORMATION AREA is essentially composed by:

- The reels for the mesh (A) and film (B) and their reserve areas (C) for storing material.
- Bag formation area. The bag is shaped by passing the mesh and the film through a mould (spreader) (D for GIRSAC and E for ULTRABAG) and using pre-sealers (F for GIRSAC and G for ULTRABAG) and a bag bottom sealer (H), all the while being driven by motorized rollers (I).
- Labeller: A GIRPRINT Labeller (J) prints a label and adheres it to the film on the left side.
- GIRPLUS feeders (K)

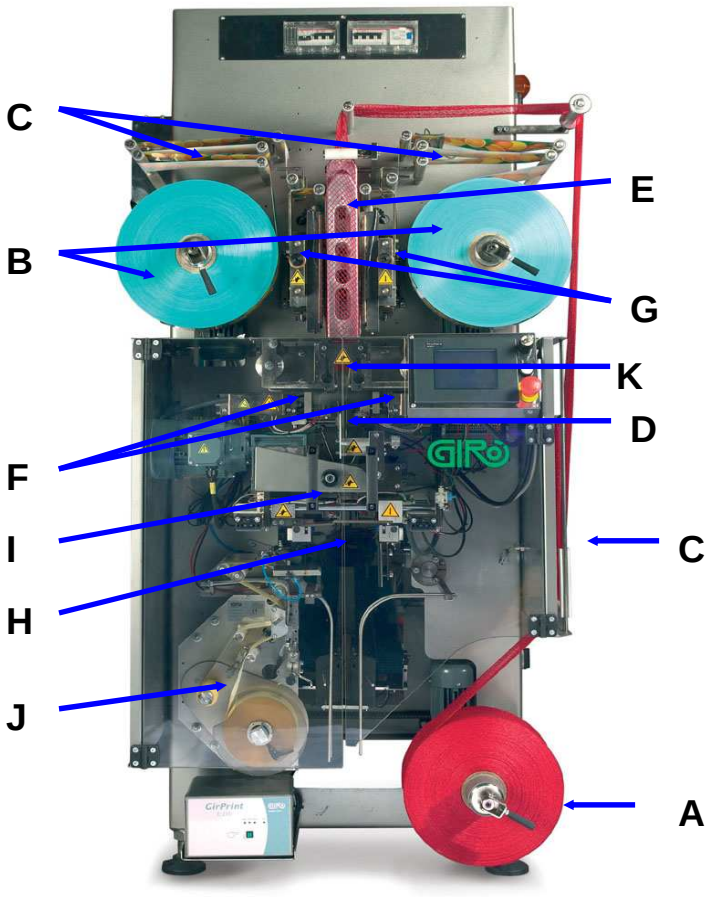


FIG 1.2. GIRBAGGER FRONT VIEW

II. FILLING AREA AND BAG CLOSING AREA essentially composed by:

- A station for product loading and folding mesh on a header (L).
- A station for the sealer header and handle introduction (M) with handle band reel holder (N) used to make the handle.
- Elevator (R) (only on the SOFT version)

III. LINEAR TRANSPORTER essentially composed by:

- 2 solidary carts (O, right and left) that slide along the linear guides on which they are mounted, a vacuum gripper that collects the shaped bag from ZONE I and brings it to the loading station in ZONE II and a clamp which picks up the bag in the loading station and brings it to the sealer header station.
- A conveyor belt (P) taking the bag from ZONE I, bag formation, through the stations in ZONE II, to the machine outlet (Q).

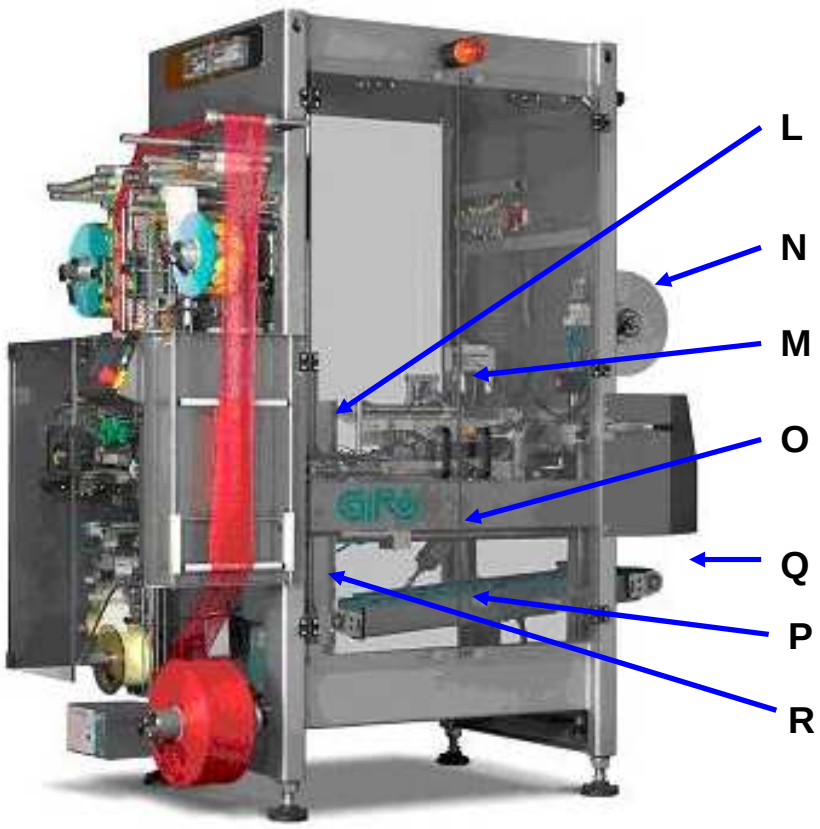


FIG 1.3. GIRBAGGER SIDE VIEW

This manual explains the operation of the UB 65 A machine, as the lesser models do not have functions which are different from this machine.

II. INSTRUCTIONS RELATED TO TRANSPORT, MAINTENANCE, AND STORAGE

2.- UNLOADING, TRANSPORT, PLACEMENT AND LEVELLING

Both the unloading and transport of the machine is to be done from its left or right sides using a forklift by inserting its blades (at least 100 cm long) into the areas on the crossbar marked in the figure.

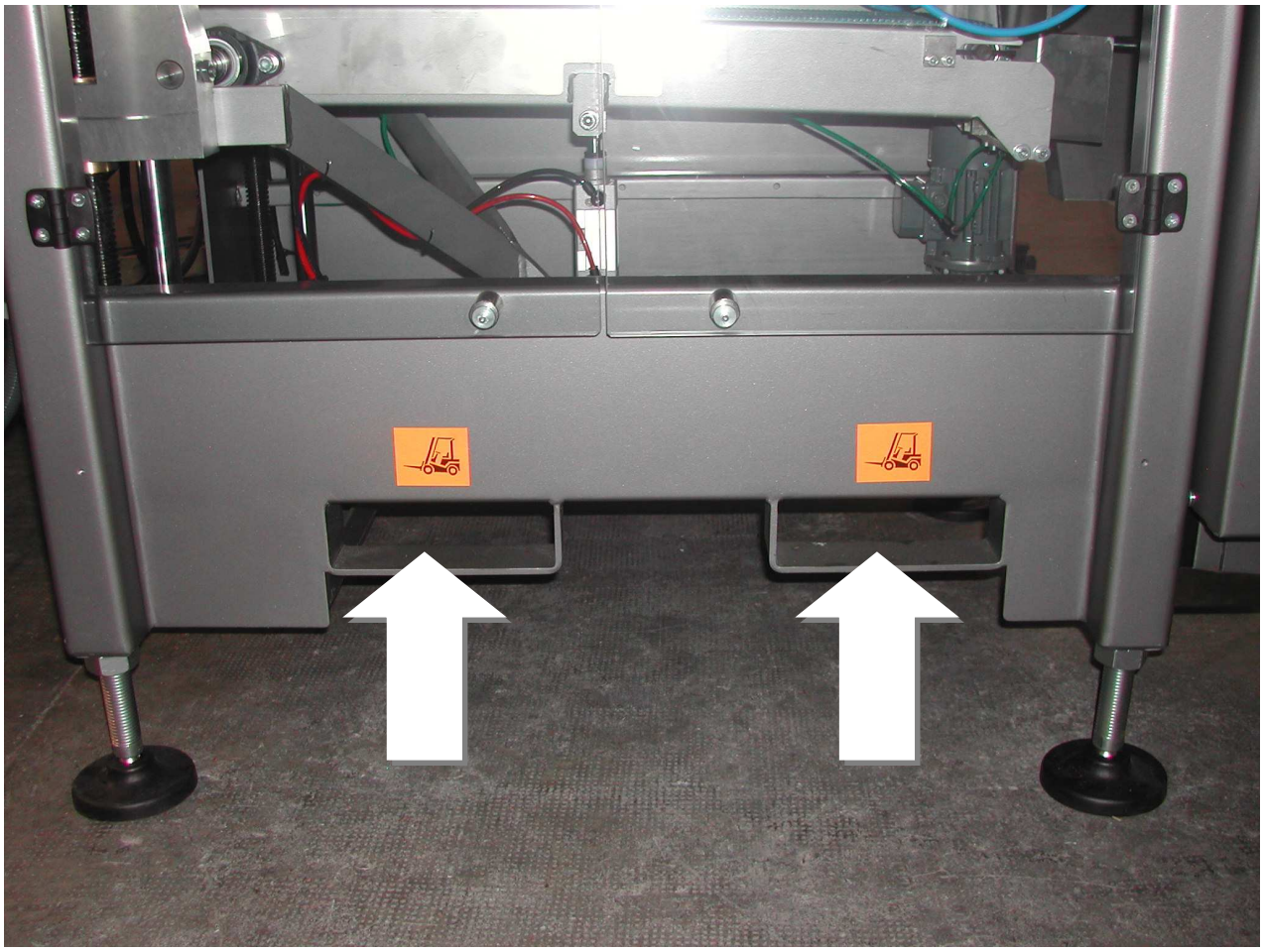


FIG 2.1.. AREAS FOR PLACING THE FORK LIFT BLADES

The GB-50 has four adjustable feet with fixed positioning locknuts on its base to level and position the packaging machine in respect to the weighing or counting machine used to feed it.

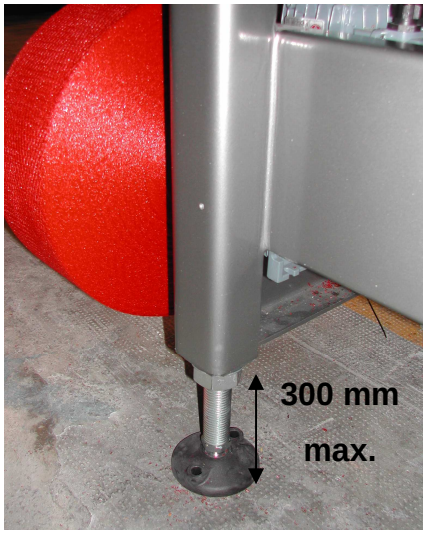


Fig. 2.2. Adjustable foot for leveling and positioning

ATTENTION: The machine leveling must be done by placing a level (A) on the interior crossbar and checking that the GIRSAC spreader is centered in respect to the mesh folders in the bag formation station.

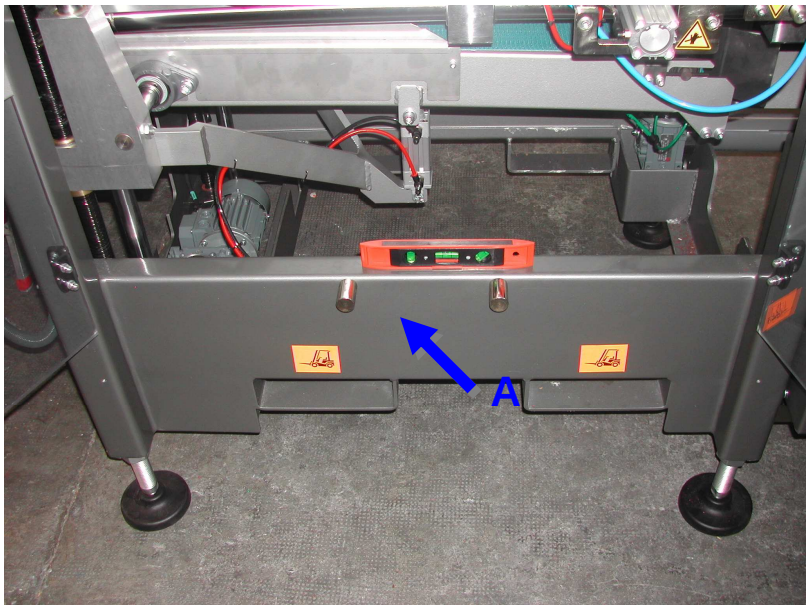


Fig. 2.3. Using a level for levelling the machine

III. INSTRUCTIONS RELATED TO PUTTING INTO SERVICE

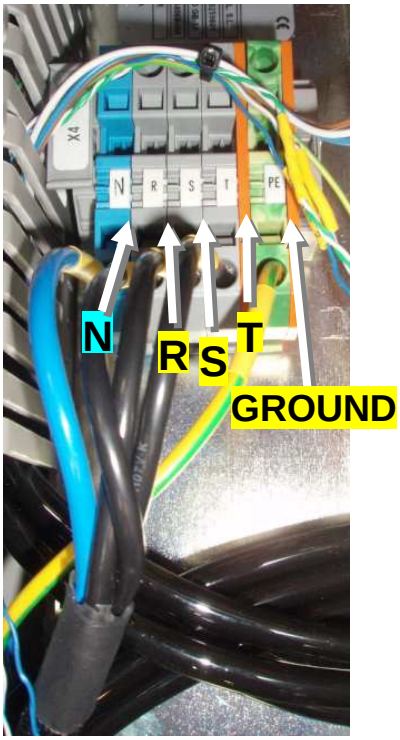
3.- ELECTRICAL CONNECTION

3.1.- Connecting to the power supply

First, check if the power voltage of the three-phase supply coincides with what is showed in the machine's electrical closet.

Connect a three-phase cable tubing with a neutral and ground (in 230 Vac connect a three-phase cable tubing with ground without neutral) to the X4 terminal located inside the main electrical closet, as indicated in the figure.

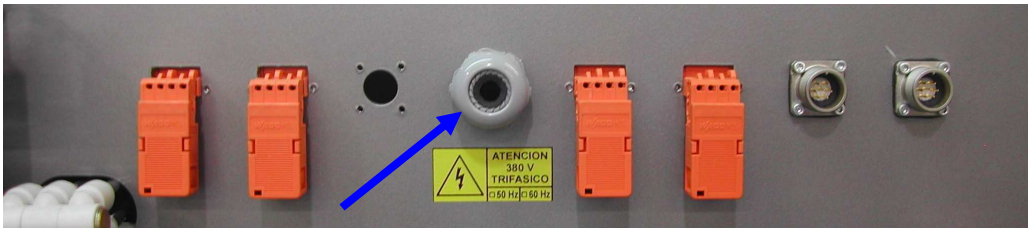
400 Vac ± 5%, III + N + GROUND



230 Vac ± 5%, III + GROUND

Fig. 3.1. Connecting to the power supply

Finally, pass the cable sleeve through the cable gland and connect it to the power supply using the appropriate connector.



CABLE GLAND FOR

POWER SUPPLY CABLE

3.2.- Checking the rotation direction of the motors

All the motors in the machine leave the factory rotating in the correct direction.

Nevertheless, it is possible that during the installation the power supply's phases have been wrongly connected causing some of the motors to rotate in the opposite direction. If the mesh-unwinding reel is seen to be turning in an anticlockwise direction (seen from the front of the machine), it will necessary to interchange two of the three input phases (R.S.T.) on the power supply connection.

Fig. 3.2. Check the direction of the mesh unwinding reels

4.- PNEUMATIC CONNECTION

4.1.- Connecting to the pneumatic supply

Connection to the pneumatic power supply (**A**) is carried out using a hose with a *nominal diameter of 5/8 (16mm).* The hose should be connected to the *hose shank supplied with the air treatment equipment.* Inserting a high pressure hose right to the back of the shank until it touches the flat part of the hexagon.

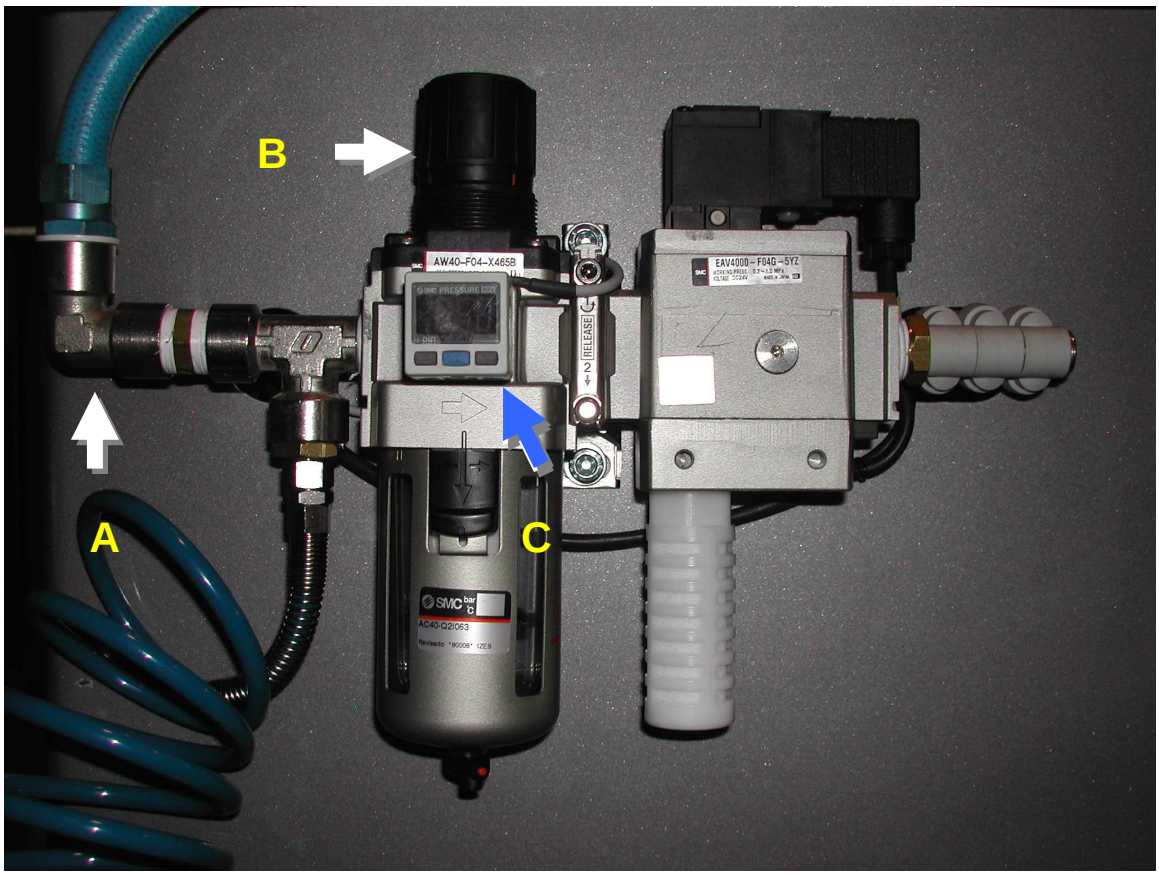


Fig. 4.1. Connecting to the pneumatic supply

ATTENTION: Do not use a tube to supply the machine with an inside diameter less than 15 mm throughout the line. Carefully check the airflow diameters when attaching quick adaptors.

4.2.- Adjusting the air pressure

The air pressure comes adjusted from the factory at 6 bars, which is the operating pressure. The pressure can be checked with the pressure gauge (**C**). A pressure between 6 and 7 bars is essential for the proper operation of the machine.

Use the knob (**B**) accordingly to adjust the air pressure.

5.- WEIGHING MACHINE CONNECTION

The product to be packaged is normally supplied from another machine, a weighing or counting machine, according to the necessary requirements.

To do this, communication or synchronization with electrical signals is made between the weighing machine and the packager.

5.1.- Synchronization Logic

Synchronism is the name given to the communication between the packager and the weighing machine. Synchronism ensures that the weighing machine does not send the product until the packager asks for it.

The synchronization cycle is the following:

1. The packager asks for the product from the weighing machine.
2. When the weighing machine receives the signal, it sends the product to the packager at the moment when it has the product available;
3. When the weighing machine sends the product, it transmits a signal to the packager so that it can initiate its work cycle.

5.2.- Packager-weighing machine synchronized connection

The attached graph lists the different types of synchronisms between the GIRBAGGER and the weighing machine, selected on the machine's maintenance screen.

Option 1 in Fig. 5.1., the graph for GIRBAGGER with weighing machine synchronism options, corresponds to the selection chosen at the factory. If the synchronism required by the weighing machine is different from this, the GIRÓ Technical Service must be advised.

The signal provided by both the packager and the weighing machine corresponds to free power contacts. The electrical charge which these contacts must not surpass 100 mA 24v DC or AC.

GB variable	Machine	Diagram	Dialogue
1	GB	CLOSED	GB asks for packet and maintains signal until the weighing machine sends packet and closes contact 1-2
	weighing machine	CLOSED	
2	GB	CLOSED	GB asks for packet and maintains signal until the weighing machine sends packet and opens contact 1-2
	weighing machine	OPEN	
3	GB	CLOSED	GB asks for packet and does not maintain signal until the weighing machine sends packet and closes contact 1-2
	weighing machine	CLOSED	
4	GB	CLOSED	GB asks for packet and does not maintain signal until the weighing machine sends packet and opens contact 1-2
	weighing machine	OPEN	

Fig. 5.1. Graph for GIRBAGGER with weighing machine synchronism options

PIN	COLOR	DIALOGO
1	BLACK	Confirmation weighing machine to GB
2	BLUE	
3	BROWN	Confirmation GB to weighing machine
4	RED	

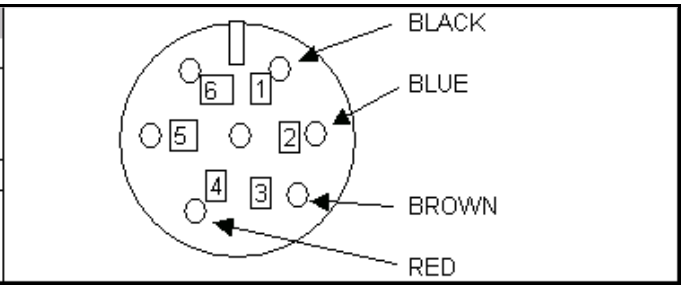


Fig. 5.2. Connection of GIRBAGGER with weighing machine synchronism connectors

5.3.- Packager synchronism input connection

The synchronism input for the packager corresponds to the pin numbers 1 and 2 on the synchronism connector.

This signal will be activated from the weighing machine with a free power contact for default with the standard NO level. (If needing to change to NC level, contact the GIRÓ Technical Service).

5.4.- Packager synchronism output connection

The synchronism output for the packager corresponds to the pin numbers 3 and 4 on the synchronism connector.

The signal provided is a free power contact for default with a standard NO level. (If needing to change to NC level, contact the GIRÓ Technical Service).

Fig. 5.1. Electrical connections

A double wand hopper connected to a weighing machine with two output belts requires two synchronisms (1 and 2) as if using two packagers, while a double wand hopper or single wand connected to a weighing machine with an output belt requires just a single synchronism (1).

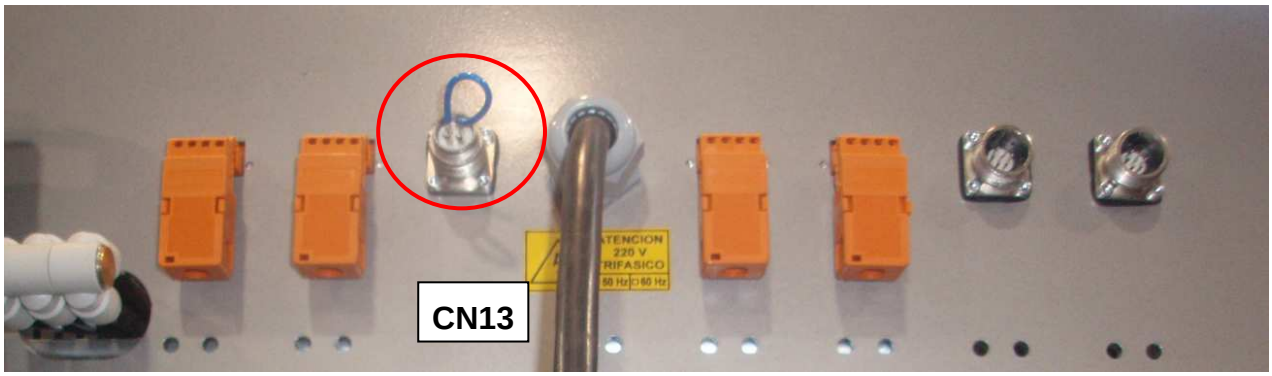
6.- External security system "Emergency STOP" (Optional)

External security system E-STOP allows the stoppage of several machines in line at the same time when.

- The emergency stop button of the GB machine acts over others machines of the line.
- The emergency stop button of the other machines on the installation line acts over the emergency stop of the GB machine.

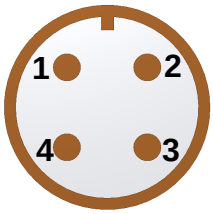
6.1.- E-STOP connection

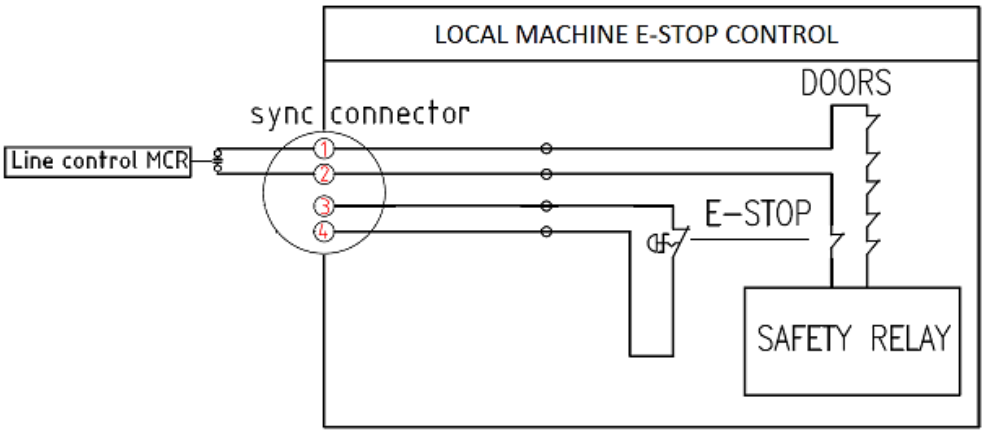
E-Stop connection between the GB machine and others machines of the line is carried out by means of a sync connector (CN13).



Important: The GB machine needs the union of the pins 1 and 2 to operate (see wiring diagram on spare parts manual).

CN13 Connector

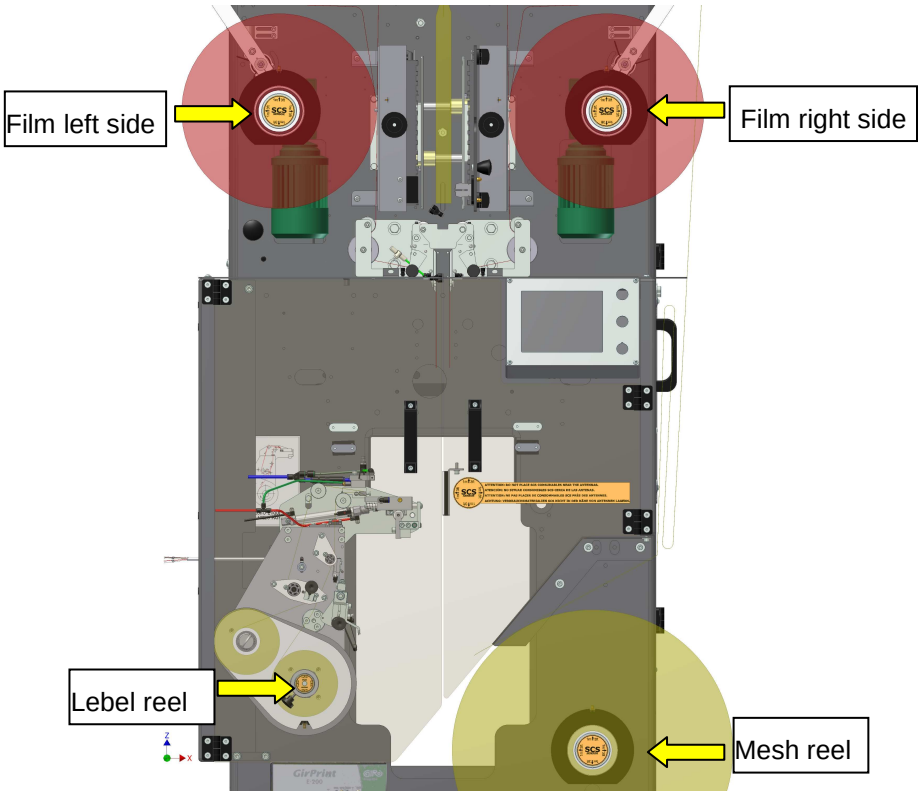




7.- SMART CONSUMABLES SYSTEM "SCS" (Optional)

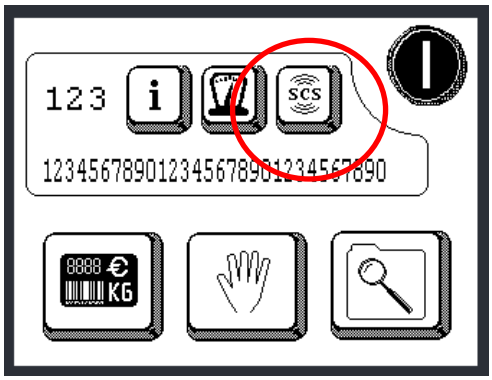
- Smart Consumables System (SCS): the intelligent management of consumables is the incorporation of radio tags (RFID) in consumables from Giró (net, film and labels) so that the packaging machine, equipped with an antenna, identifies those supplies to avoid errors.
- The verification (matching) of each consumable can be enabled separately and can also disable for specific confections.
- A "package code" has been associated to each client and consists on the group of: number of label, paper label, number of confection, left film coil, right film coil and net coil.
- The codes that compose a package are received by the "Gircontrol system". This is permanently connected.

SCS antennas position on GB/UB machine



7.1.- SCS activation screen

From the main menu, press the SCS button. This option only is available when the machine is equipped with the optional kit SCS



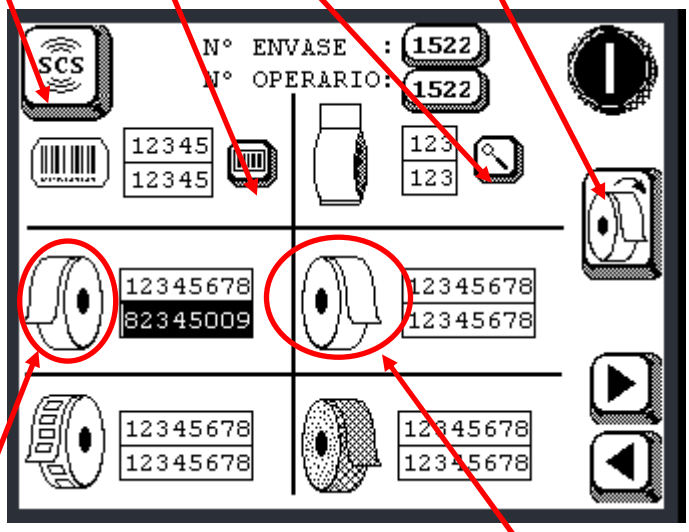
MATCHING SCREEN

Press to disable the SCS system

Access to the label screen

Access to the confections screen

Little rotation of reels

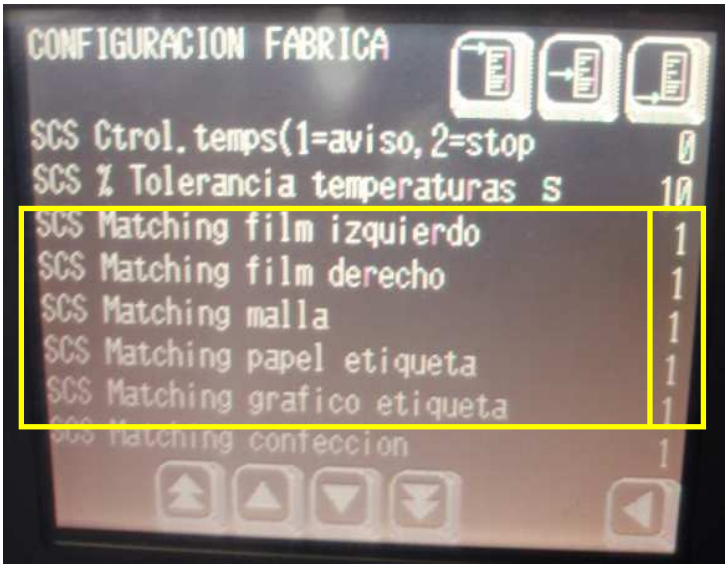


Press to omit the consumable

press to intensive sampling

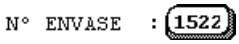
This screen shows in the down boxes the reference of consumables detected and shows in the top boxes the reference of the adequate consumable. If a consumable is inadequate, the reference is shown in reverse color. If the number of label or confection is not appropriate, it shows in reverse color.

Attention: If one or more of the antennas are not installed, is necessary turn off the corresponding SCS consumable from the variables screen. This option must be only performed by the TSS personnel. Failure to observe this warning carries a premature aging of the system due to excessive power not consumed

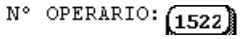


7.2.- "MATCHING" screen settings

- Enter the “package number”, that define a set of consumables



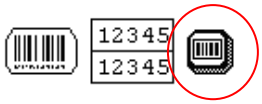
- Enter the “operator number”



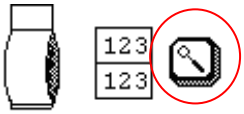
From this point, the machine communicates with the "Gircontrol" system and shows the adequate values on the top of the squares.

Then:

- Press the small button located in the right side of the number of the label so it will jump to the labeler screen.



- Press the small button located in the right side of the number of confection so it will show the confections list screen.



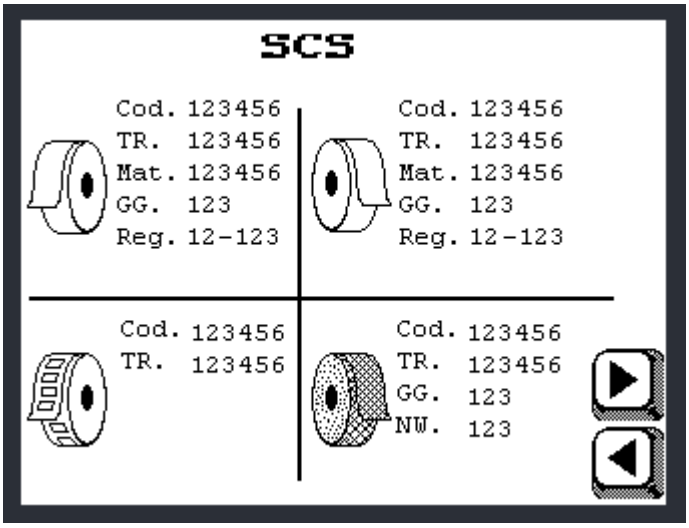
- Place the consumables –Film, net and label reels - in the machine. The SCS system will detect the identification of each consumable and the screen shows the reference. If Gircontrol sends any of the six set values at zero, it means this consumable is not to be matched, so the upper box shows empty and its icon crossed. . If the operator tries to enable the antenna, the message “CONSUMABLE DISABLED BY GIRCONTROL PACKAGE” will show.

- It is possible to ignore the matching of a consumable by clicking the corresponding icon, the icon shows crossed and the code is hidden. This option only is available using the access password. This option allows running the machine with consumables that are not detected. The top left button "*SCS*" allows disabling the full SCS system. If the confection does not have label or the label is disabled, both label number and label paper icons are crossed. If sacked mesh is being used, the mesh icon will show crossed. If the operator tries to enable the antenna, the message “SACKED MESH ACTIVE” will show.
- It could happen that when you insert the new consumable, its antenna does not detect the reel because the RFID tag is located in a "shadow zone" of the hub -antennas do not read 360 degrees in all the hub-. If it is the case, slightly turn the reel until it overcomes the "shadow zone" and the antenna detects the reel. Instead of manually rotating the reel, you can also press the touch button on the right of the screen to rotate automatically the reels actually undetected. Every time you press this button, only undetected reels rotate. You can also force the reading of a single consumable to accelerate the detection process by clicking on the corresponding box, and the system only will read these consumable
- When all the consumables are detected and make "matching", the machine may be run. If any component is not detected, the machine can run, but if after five bags some consumable is still undetected, the system stops and show the message "Gircontrol matching error". This short period of operation of five bags allows reel motors to turn and the consumables change their position, and then is it possible to detect and verify the matching.
- If any antenna had detected an incorrect consumable, the machine cannot be started, even that this consumable is not being actually detected, giving an immediate warning. The associated code from 1 to 6 indicates which of the consumables is the incorrect one.

7.3.- Access “CONSUMABLES” screen

- From the matching screen, push the right arrow icon to access the consumables screen descriptions.

SCREEN CONSUMABLES

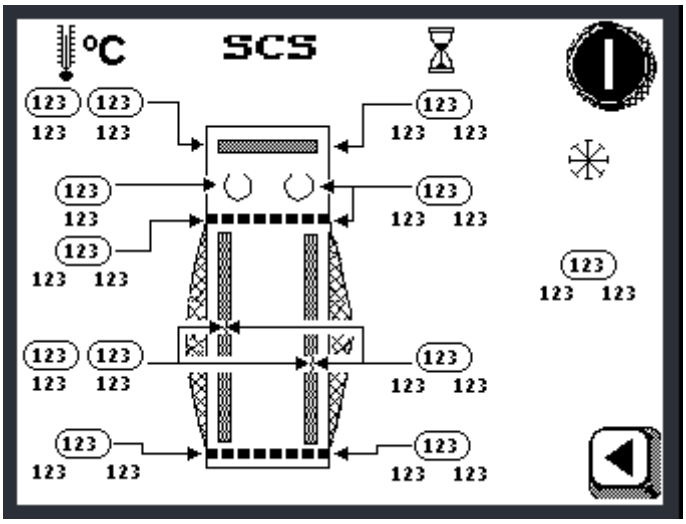


- This screen shows the description from each consumable, the code number, traceability, material length of the bag, gauge, etc

7.4.- "TEMPERATURES" SCRREN ACCESS

- From the descriptions screen, push the right arrow icon to access temperatures screen.

TEMPERATURES SCREEN



Every SCS consumable contains a TAG with the ideal values of temperatures and welding times. This screen shows recommended temperatures and shows in reverse video the values with a wide difference of temperature. Depending on the confection used, some values appear empty because they do not exist for this format.

Technical service staff can turn off the matching temperatures mode for the confections if the machine does not use these settings. Warning mode is also possible, and allows the machine running while the screen shows the message that the temperatures do no match

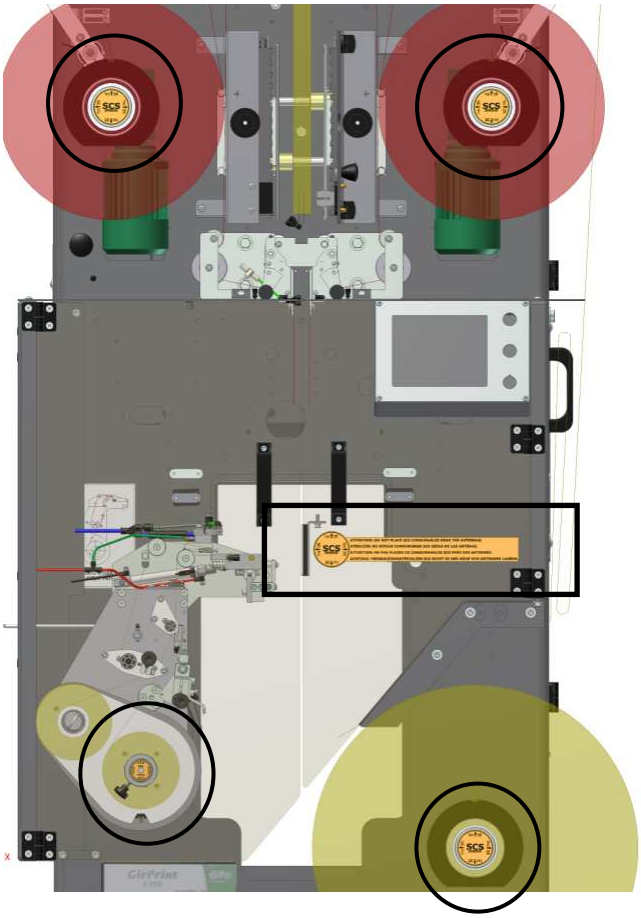
7.5.- Reading ratio area of SCS consumables

SCS Antennas have a reading area of approximately 3 feet (1-meter radius). The location of any consumable or empty tube with SCS tag within the reading area of the antennas can cause read errors. Place the stickers attached in the kit as shown the drawing.

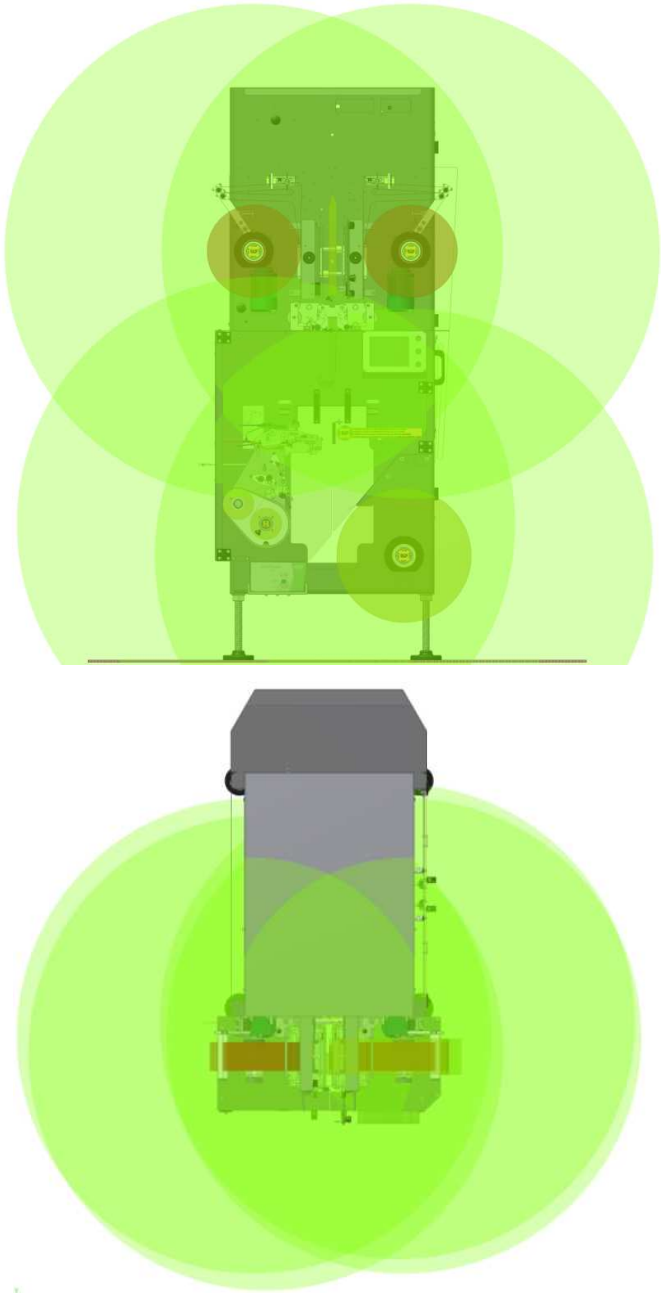
Some stickers have been added on machine to mark the position of the antennas.

Attention: Do not place SCS consumables within reading area of the antennas.

Stickers position on machine.



Reading area of the antennas.



- To check the sensibility of the antennas and so fine-tune its power according to the machine environment, if accessed with the SAT password, when selecting *intensive search* of an antenna, intermittent zeros will show, and if the *little rotation of reels* button is pressed, its axis start turning while a good/bad reading ratio is being calculated, showing at the top of the SCS screen. The bigger the value, the better is the antenna sensibility for its consumable placed in the axis.

7.6.- SCS "Gircontrol" configuration

- Select the SCS tab.

- The screen shows a packaging editor at the bottom of the screen.

 Add package

 Edit package

 Delete package

 Reload list

 Go to the home page

 Next page

 Previous page

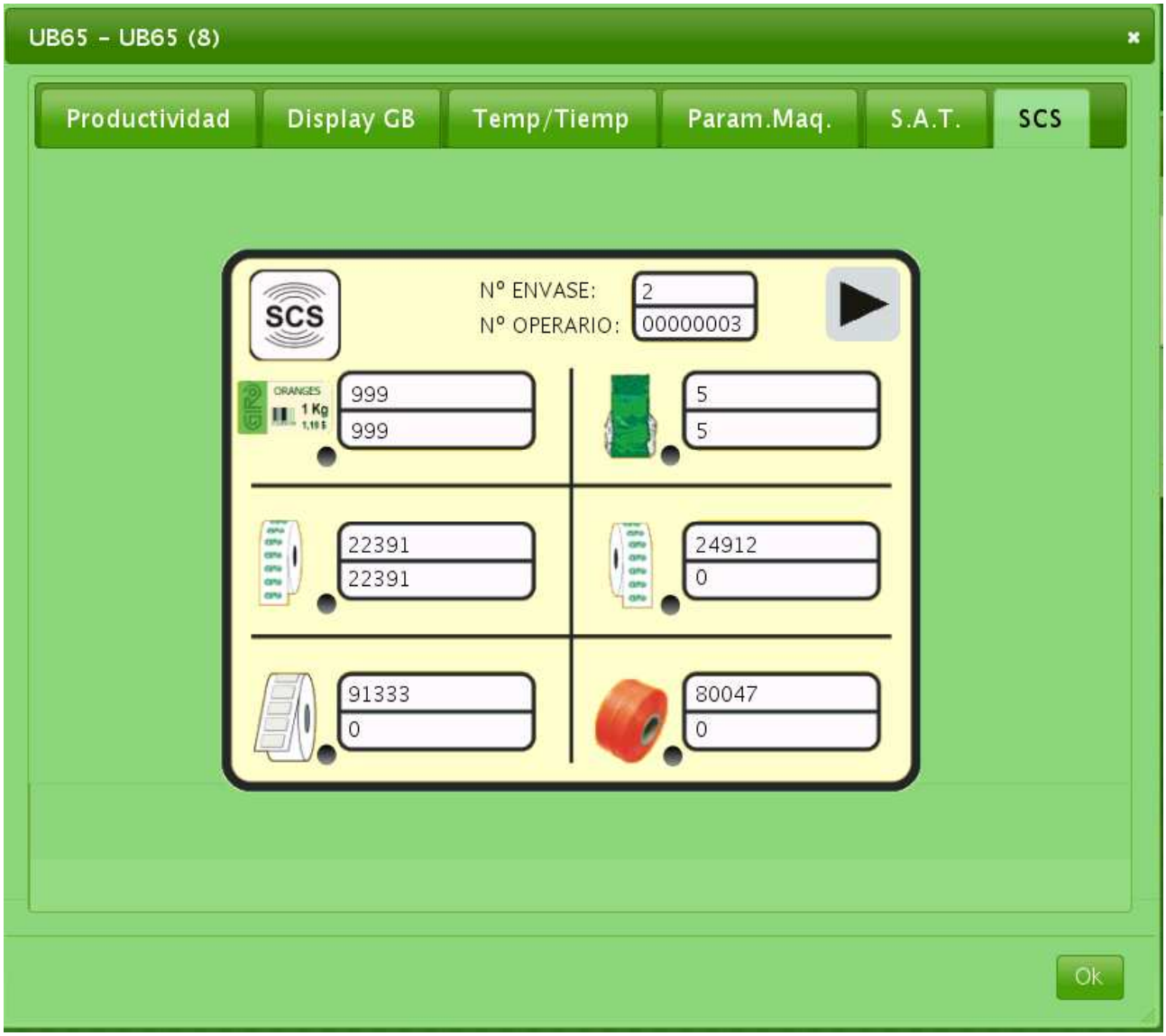
 Go to the last page

 Page counter

 Page lines

 Counter by number of items listed.

- From the screen of the edition of machines , is possible access at the SCS screen. This screen shows the status of the consumables like the GB screen.



8.- CONNECTION TO THE LABELLING NETWORK

The GIRBAGGER can incorporate a *GirPrint* labeller design to be connected with the rest of the labellers in the warehouse and the computer installed with the *GirLabel* software for label production, with all of this enlaced with the RS-485 communication terminal used by this labelling system. The packaging machines can be interconnected in the same way for updating software.

For this, the machine has two different communications connectors, two incoming and two outgoing. The bus cables from the previous labeller and packer are connected to the incoming connectors and the bus cables connected to the next packaging machine and labeller will then be connected to the outgoing connectors.

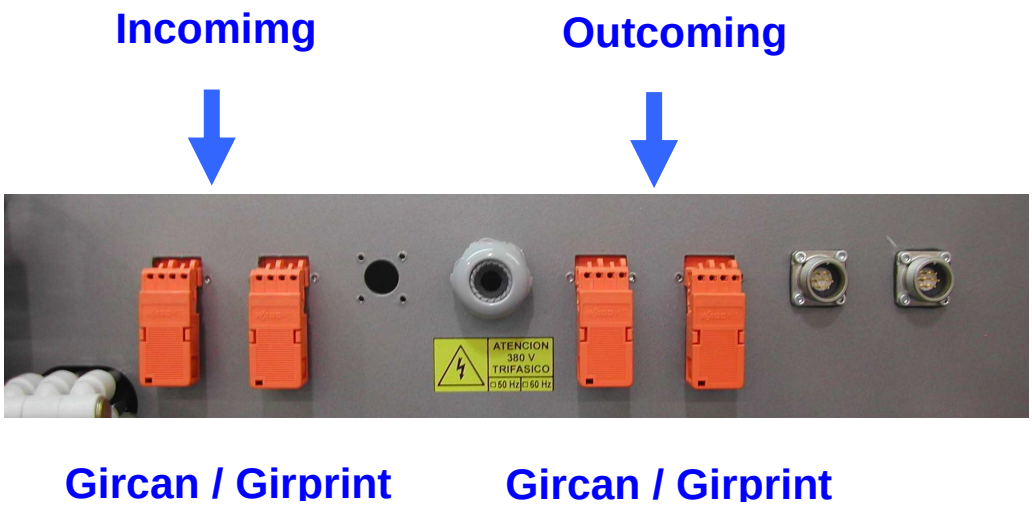


Fig. 8.1. Labelling network communication connector

ATTENTION: The installation of the labeller communication network has to strictly follow specifications which are not included in this manual. This installation should be made exclusively by personnel authorized by GIRÓ.

IV. INSTRUCTIONS RELATED TO SAFETY AND HEALTH

9.- EXPECTED USE OF THE MACHINE

GIRBAGGER is automatic sealer for tubular mesh bags used for packaging fruit and vegetables. During the formation of the bags, film bands are added to provide better resistance to the bag and improve its aspect. A label can be added to the bag.

The product to be packaged can be received from a weighing or counting machine. The removal of the bags can be done by a conveyor belt.

Its uses are limited to the interior spaces with normal environmental conditions.

WARNING: Under no conditions should the machine, machine parts or attached equipment be used for a use other that what has been defined.

10.- OPERATION POST

GIRBAGGER has no defined operation post. The GIRBAGGER operator handle can do other tasks and control various machines, as long as the required attention is paid to the operations of each machine.

The GIRBAGGER operator must only take control of those machine operations, which are shown as follows:

The GIRBAGGER operator must not handle the machine in areas other than those designed for this purpose, which are:

- The general on/off switch.
- The control panel, which includes touch screen, the emergency stop and reset buttons, and, if so authorized, a key to disable the mobile safeguards (reduced safety mode).
- The parts which the mesh, film, label, and handle reels should be placed and threaded, along with their respective opening, closing, and adjustment mechanisms, **exactly in the way described in this manual**, when it is necessary to replace or adjust the corresponding consumable product.
- Accessing to the areas necessary to remove defective bags or unacceptable products, **exactly in the way described in this manual.**

WARNING: Any other type of intervention different that what is defined in this chapter requires the disconnection of the power and pneumatic supply and the intervention of qualified personnel.

11.- GENERAL SAFETY INSTRUCTIONS

- Completely read this instruction manual before operating the machine and follow the instructions established for accident prevention.
- Do not modify the machine in any way, nor disable or block the safety mechanisms.
- Never operate the machine if it does not have all its mobile safeguards available.
- Always remove the keys from the electrical panels.
- This manual must be available to all personnel who operate the machine.
- If the machine is sold to a third party, this manual must be delivered along with the machine.
- If any interference occurs, stop the machine and consult the instructions manual or, if needed, the Technical Assistance Service or your distributor.
- Maintain the work area clean and orderly, and provide sufficient lighting.
- Carry out the appropriate maintenance of the machine according to what is described in the Maintenance and Replacement Parts Manual.
- Disconnect the power and pneumatic supply during any maintenance and/or operations of the machine.
- Only use original replacement parts found in the Maintenance and Replacement Parts Manual.

9.1. Machinery noise

The machine in operation generates a noise above the 70dB and **operators must therefore wear the corresponding hearing protection.**

Sound level equivalent energy value (Leq Value) = 81.5 dB

Protocol carried in accordance with:

- Machinery Directive 2006/42/CEE.

- UNE-EN 415-3 Packaging machine safety requirements.

- RD 286/2006 "Workers health and safety protection against noise".

12.- HYGIENE PRACTICES

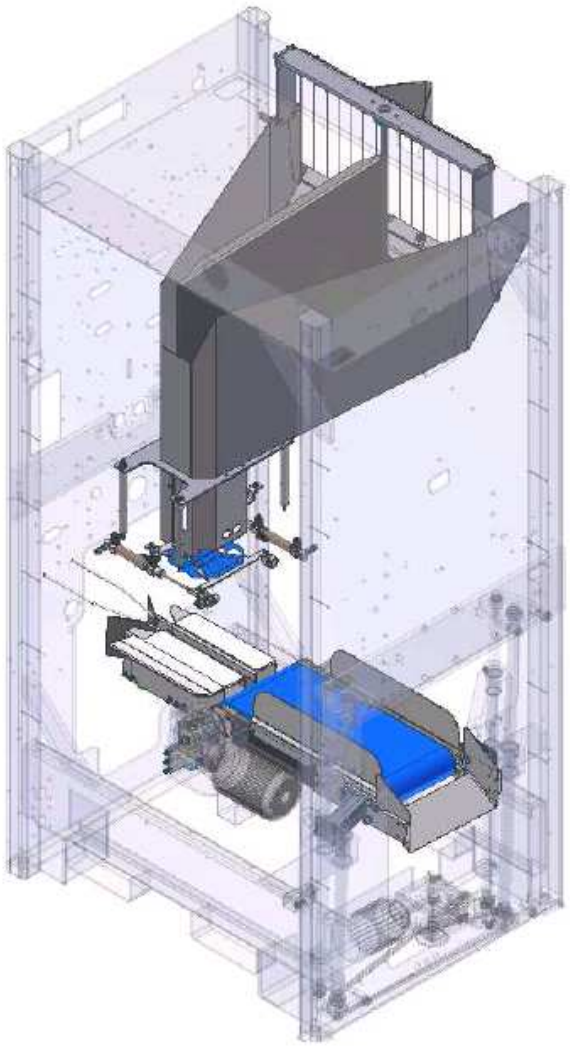
The machine has been purposely designed to satisfy all the hygiene related properties needed to make this a machine, which is easy to clean, to prevent the accumulation of any dirt and to allow the necessary maintenance to be carried out.

Here are some appropriate measures and recommendations for use, which have been outlined with the purpose of keeping the machine free from sources of contamination and to prevent any unsanitary conditions, which might affect the product to be processed.

- The main purpose of cleaning is for hygiene but the appearance is also a relevant factor, to leave all in order.
- Both the materials used and the coverings are hard-wearing, can be cleaned and disinfected as and when required and are also scratch resistant to prevent the absorption of any unwanted matter under the established conditions for use.
- The surfaces which come into contact with the food are corrosion free, non toxic, non absorbent, do not transmit any undesired odors, colors or flavors to the foodstuffs and neither do they cause any contamination nor have any adverse affect on the foodstuffs.
- The surfaces that are exposed to the foodstuffs can be cleaned and disinfected as required. Special care has to be taken of these surfaces for them to remain in a perfectly hygienic state. Before carrying out these processes the machine must be fully disconnected, following the safety measures indicated in the current manual.
- The frequency with which the machine has to be cleaned will depend on the type of workplace and the use of the machine, at the very least observing the instructions specified in the cleaning and maintenance section.
- The design and finish prevents, as far as possible, that the product is separated from the food area and then returns to this area, if this return is likely to present a risk to the food being processed.
- Recommendations are to put together and carry out a cleaning plan.
- The operator responsible for cleaning the machine has to be competent and sufficiently knowledgeable on any hazards which might arise during the various stages of the life of the machine. The operator has to follow the recommended hygiene practices for the use of the machine and for the use of the personal protection equipment necessary for all circumstances.
- All the products used for cleaning the machine must be products suitable for the food industry.
- Cleaning is carried out manually or by mechanized means depending on each situation.
- The machine must be installed in a place with sufficient space to allow for the machine to be correctly used and for maintenance to be carried out. Sufficient access for maintenance and cleaning systems, as well as to the adjacent areas, must be guaranteed in order to maintain the level of hygiene required.
- The surrounding conditions (air currents, dust or liquids...) must be acceptable levels to ensure there is no adverse affects on the food products.
- The machine is designed to be a suitable distance from the floor to allow the area to be properly cleaned and disinfected. It is important to be able to access the entire floor surface and to use products suitable for the food industry to avoid the possible risk of any cross-contamination.

- The machine is recommended to be well sealed to the floor on installation.
- The machine comes supplied with suitable grease for the food industry and recommendations are therefore to grease the machine with this same type of grease (**LGFP GREASE)**.

GIRBAGGER MODEL



GIRBAGGER SOFT MODEL

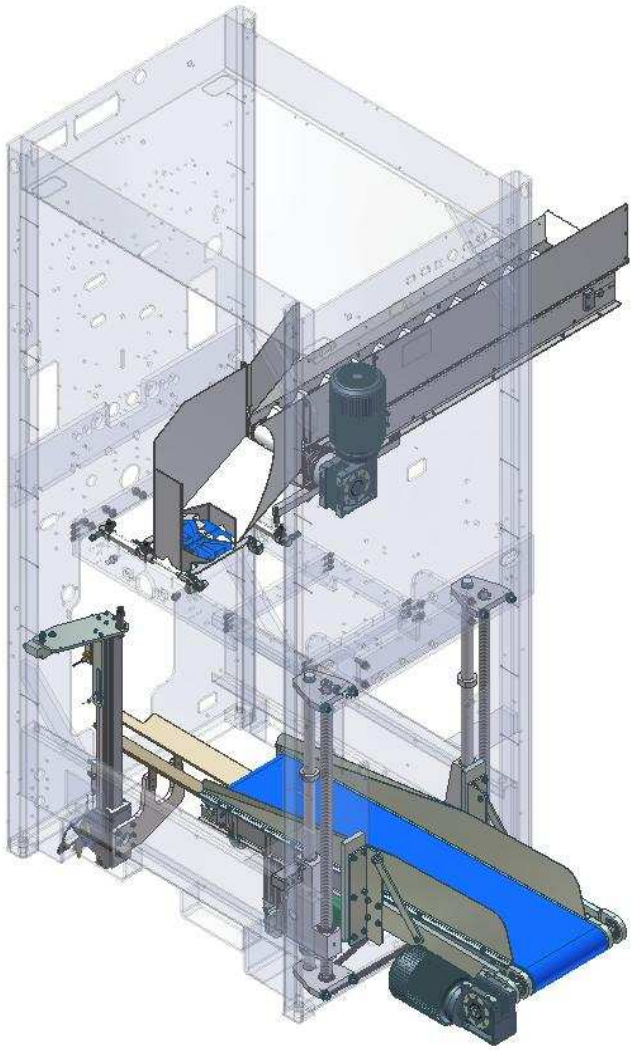
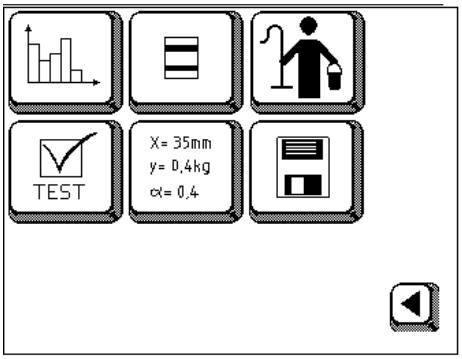


Illustration of GB/UB machine showing the surface that is exposed to the product.

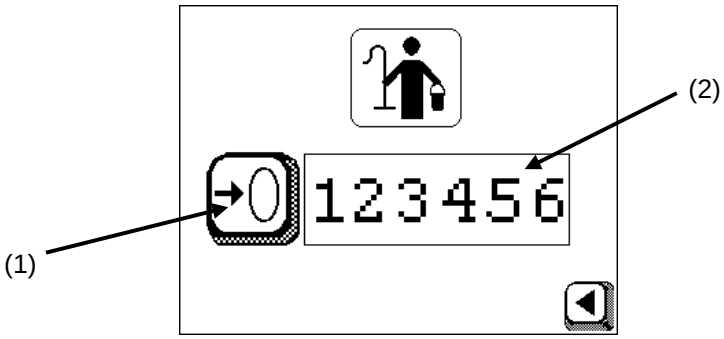
12.1.- Machine clean.

Machine has a clean warning system. It is programmed in order to advise (see alarm chapter) about the needed to clean the machine every 100000 bags. Is possible to configuration this parameter.

When  is pushed the next screen is the maintenance screen:



Only  button is accessible for the users. When is pushed appears a numeric virtual keyboard where is necessary to put 123 password. On the next screen we can reset the counter for the next clean (1) or is possible to see the number of bags since the last clean (2). If the counter flicks it means that machine needs a clean.



13.- SAFETY ELEMENTS

13.1.- Emergency stop

The emergency stop is a function designed to avoid hazards or reduce apparent risk that can harm the personnel or damage to the machines or work in progress.

In following, the effects caused by this stop will be examined, as well as the activated parts that can trigger a stop, and how to reset the machine to keep working.

13.1.1.- Effects of an emergency stop

When the emergency stop function is activated, the machine energy sources that can cause physical harm to the personnel are physically disconnected:

- Compressed air
- Motors
- Heating of the sealer resistors

WARNING: The emergency stop **does not disconnect** all the power inside the main electrical panel, the low voltage power still remains active (24 V). If it is necessary to work within the main electrical panel, first disconnect it from the electrical power supply and disable it to avoid an unintentional start-up.

WARNING: Due to thermal inertia, the sealing resistors can maintain high temperature even several minutes after being disconnected.

With the machine in emergency stop status, all the moving parts of the packager can be moved manually and effortlessly without danger of entrapment due to the activation of elements of the machine.

13.1.2.- Activation modes of the emergency stop

13.1.2.1.- *Emergency stop button*

The machine has an emergency stop button (A) on the front control panel.

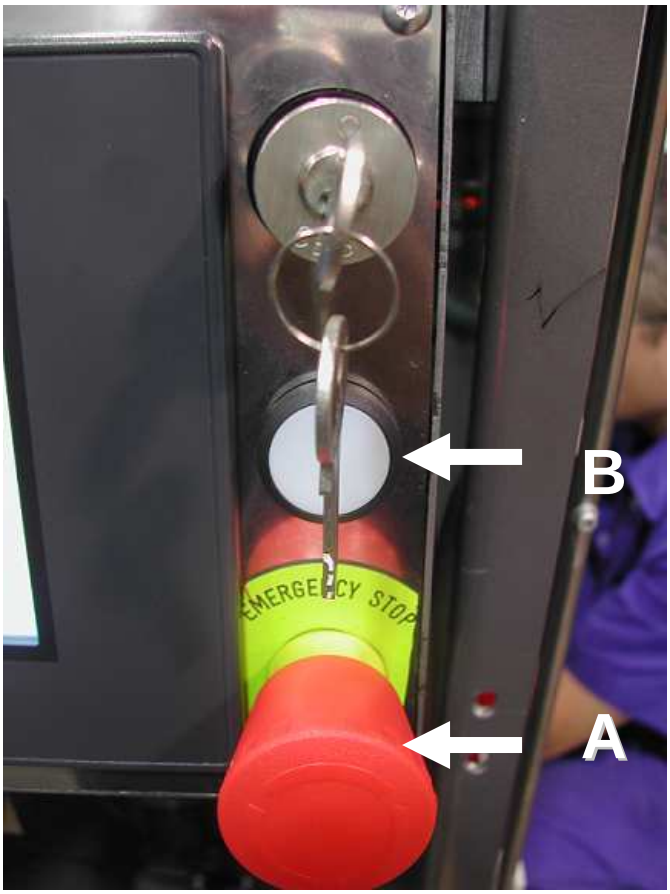


Fig. 13.1. Safety buttons on the control panel

This is a “mushroom” type button which is lockable, which means then when one’s hand is removed, the internal mechanism of the button maintains locked, and it is only unlocked with a twisting or pulling motion on the button itself, although by doing so will not cause the machine’s energy sources to be restored until the reset button is pressed.. Consult section 10.1.3

13.1.2.2.- *Opening the mobile safeguards*

The opening of any of the mobile safeguards on the machine will cause an emergency stop in exactly the same way as if having pressed the emergency stop button.

Closing all the doors will not restore the energy sources to the machine until the reset button is pressed.

Consult section *13.2*

WARNING: The opening of the mobile safeguards **will not cause an emergency stop** if using the key to disable these mobile safeguards (reduced safety mode). Consult section *13.2*

Key in position 0 = Mobile safeguards active
Key in position I = Mobile safeguards disabled

13.1.2.3.- *Resumption of the electrical supply to the machine*

When resuming the electrical supply to the machine after having been disconnected from the network, the machine must be reset so that the operational energy can be restored.

13.1.3.- Resetting the machine

For safety reasons, it is necessary to at least make the position action of resetting the machine when changing from emergency stop status to normal operation status.

To reset the machine, proceed in the following order:

a) Reset preparation:

- Remove any excess or badly inserted labels that could be remaining in the labelling dispenser.
- Remove any excess or badly shaped handles that could be remaining in the operation formation station.

b) *Reset operation:*

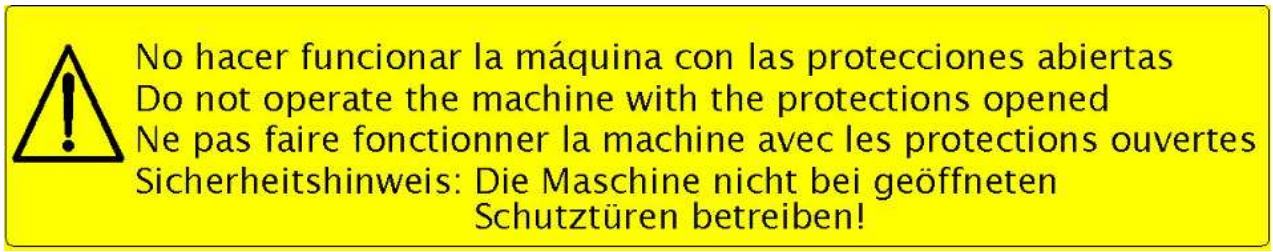
- Make sure that the machine is electrically supplied.
- Make sure that all the doors accessing the interior of the machine are completely closed.
- Make sure that the emergency stop button is unlocked. This is done by turning it in the direction indicated by the arrow marked on the button itself or pulling it depending on the model. .
- Press the white reset button (B). **This action is that which restores the energy sources to the machine.** When resetting the machine, this button light turns off.

14.- SECURITY SAFEGUARDS

14.1.- Mode with mobile safeguards enabled (normal mode)

This must be the normal working mode. The key disabling the mobile safeguard is not inserted in the machine and not within reach of any non-authorized personnel.

In this mode, any opening of the doors interrupts the safety circuit, which causes exactly the same effect as pressing the emergency stop button, as is described in *13.1.-Emergency stop*.



14.2.- Mode with mobile safeguards disabled (reduced safety mode)

Some machine preparation or maintenance tasks can be sped up if some machine elements are energized while the doors are opened. This is achieved by disabling the mobile safeguards, or *reduced safety mode*.

This mode is a status that is **clearly distinct from the emergency stop status**. In the reduced safety mode, the power supply is disconnected from all the valves by means of the control program but the compressed air will remain connected. These operations and their activation or deactivation is integrally related to the control program. Specifically:

- The electrical supply is disconnected **from all the motors and all the solenoids.**
- **The compressed air and heating remain active.**

The utility of this operational mode is for making specific maneuvers from the “MANUAL OPERATIONS” screen and other maintenance screens while some of the doors remain open in order to facilitate certain manual operations.

To disable the mobile safeguards, the following steps must be taken:

- Insert and turn the key for disabling the mobile safeguards in the way shown in the picture.

Fig.11.1 Mobile safeguards disabling key

- Open the doors required and carry out the operation in question.
- Close all the doors pull out the key and store it in a secure place.

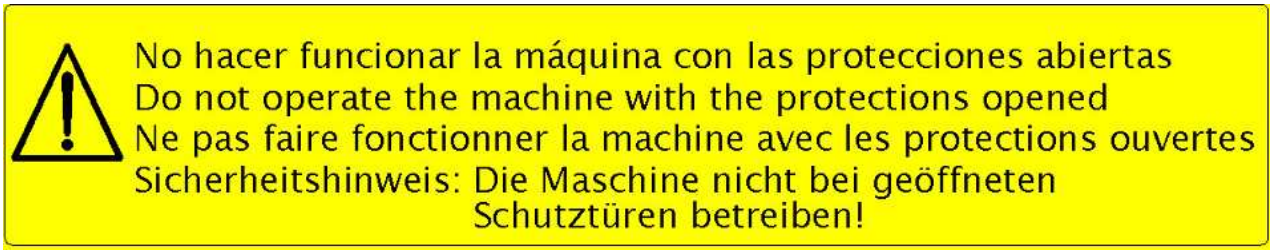
WARNING: This key must only be available to personnel who are fully aware of the safety limitations of this operating mode. Its use must be strictly limited to the operations outlined in this manual.

ATTENTION: The emergency stop button and the restoration of the electrical supply after its interruption still require the machine to be later reset, even when the mobile safeguard disabling mechanism is active.

14.3.- Fixed safeguards

The machine has various fixed safeguards built into its structure to protect those elements that are potentially dangerous. If one of these safeguards is disabled, the machine must not be operated under any circumstances.

WARNING: The safeguards must never be disabled or deactivated under any circumstance.



14.4.- Hazard signs

The machine has adhesive labels that indicate areas that especially present risks and show what type of risk they are.

You will find the following signs:

Entrapment hazard

Operations in this area have the risk of entrapping hands or objects, if the machine is not disconnected from the electrical supply or in emergency stop status.

Burning hazard

Operations in this area have a burning risk, if the sealers have not ceased working for sufficient time to cool down to a tolerable temperature, and if the machine is not disconnected from the electrical supply or in emergency stop status.

Electrical hazard

Operations inside this area can have a risk of electric shock or dangerous electrical currents, if the machine is not disconnected from the electrical supply.

14.5.- Electrical safety

WARNING: Do not handle the inside of the machine's electrical closet without having previously disconnected the power supply. IT IS NOT SUFFICIENT to set the machine to emergency stop status.

14.5.1.- Switch

Manually operated interrupter switch for starting which controls the supply of power to the machine. Is possible use a padlock (not included) to block the switch. For this press down on the flange and pass the padlock through the gap.

14.5.2.- Differential circuit breaker

Automatic circuit breaker designed to protect the user from any possible leakages of earth current.

14.5.3.- Thermal Magnetos

Automatic Interrupter that provides thermal magnetic protection for the user and the machine against short circuits and overloads.

14.5.4.- Ground

This machine should be fitted with a ground that complies with the regulations currently in force for the correct operating of the machine.

V. INSTRUCTIONS RELATED TO THE USE OF THE MACHINE

15.- CONTROL PANEL AND OPERATIONAL PARAMETERS

15.1.- Description of front panel

Fig. 12.1 The machine control panel

The front panel consists of the following elements:

15.1.1.- Touch screen

Its interactive function both display information to the user as well as enables order and parameter entry.

The visual elements of the touch screen can be divided in:

a) *Aesthetic elements*: These provide an agreeable and intuitive display. They consist of background screens and icons.

b) *Context elements*: These are fixed texts that display the significance of the alarms appearing on screen, (only if the alarm text option is activated).

c) *Value elements*: These are numerical values or texts which give information about the machine's status at all times.

The input elements on the touch screen are activated by pressing a finger on them and they can be divided into:

a) *Buttons*. Each button has one of the following functions: changing screens, running a movement sequence, or activating and deactivating a function option.

b) *Value fields*. As well as displaying the current value of a parameter, pressing on these fields opens an onscreen keyboard that can change the values at will. This keyboard includes, among others, the  key to erase individual digits, the  key to accept a recently input value, as well as keys to navigate through the digits within the value.

15.1.2.- Start cycle button

This button is shown as an icon onscreen in the upper right corner.

This is used to run packaging cycles, either uninterrupted ones if using the automatic mode, or one by one if using the manual mode. If there is no air pressure, or if one of the machine safeguards is open, this button cannot used.

15.1.3.- Stop cycle button

Once the machine is running, the “start cycle” icon will immediately be replaced by the “stop cycle” icon.

On pressing the button, the machine will continue to operate until the end of the current cycle is finished before stopping. Once the machine has stopped, the “stop cycle” icon is replaced by the “start cycle” icon.

15.1.4.- Emergency stop button

This is the large red lockable button.

Consult section *13.1.-Emergency stop*.

15.1.5.- Reset button

This is the white illuminated button.

Consult section 10.1.3.*Reset machine*

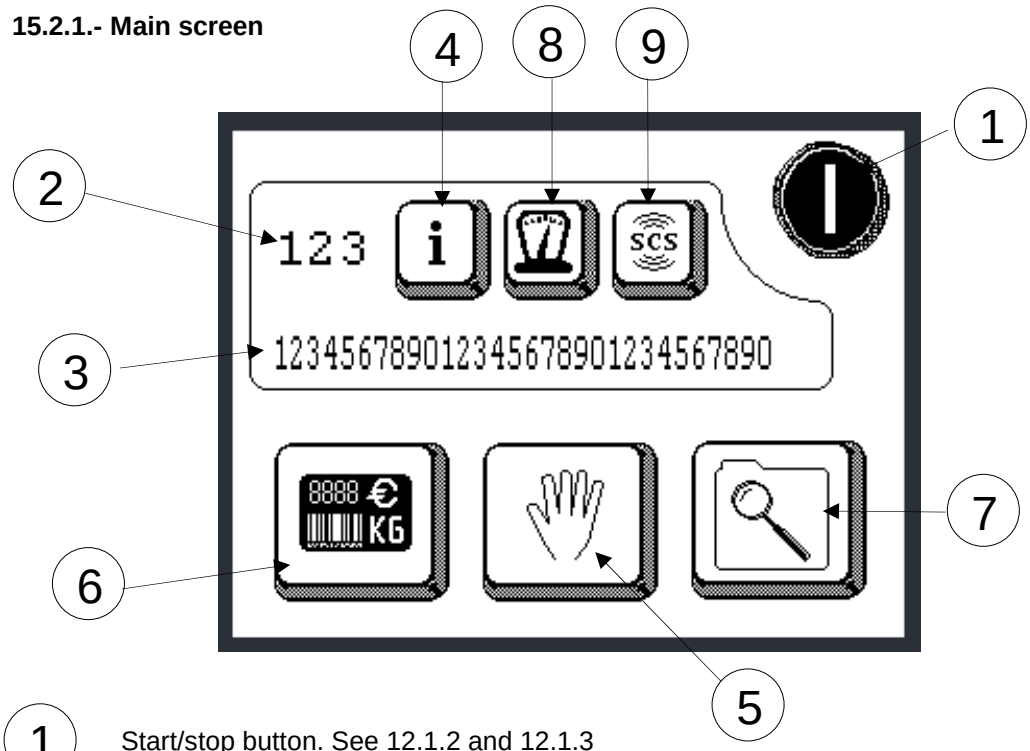
15.1.6.- Mobile safeguard disable key

Consult section 11.2. Disabled mobile safeguard mode

15.2.- Screen icon definitions

***NOTE:** Screen configuration and icons showed in this manual can be different the showed in the screen machine.

15.2.1.- Main screen

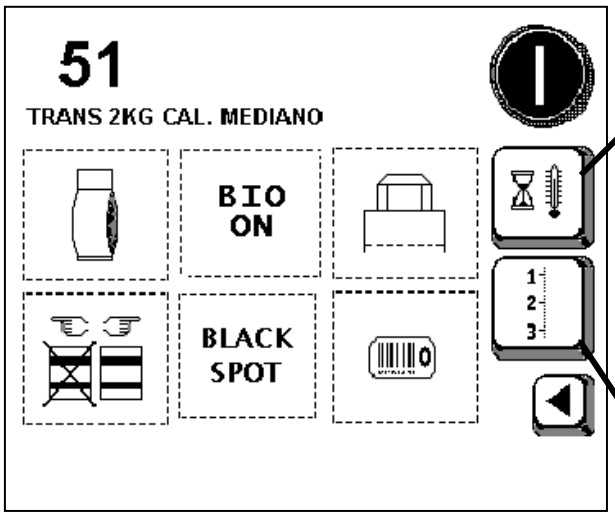


1. Start/stop button. See 12.1.2 and 12.1.3
2. Formation number in process. (Information on this screen)
3. Formation name in process. (Information on this screen)
4. Button opening the parameters of the formation in process
5. Button opening the manual operation screens.
6. Button opening the labeller screen
7. Button opening the formation list
8. Button opening checkweigher CHW-G30
9. Button opening SCS matching screen

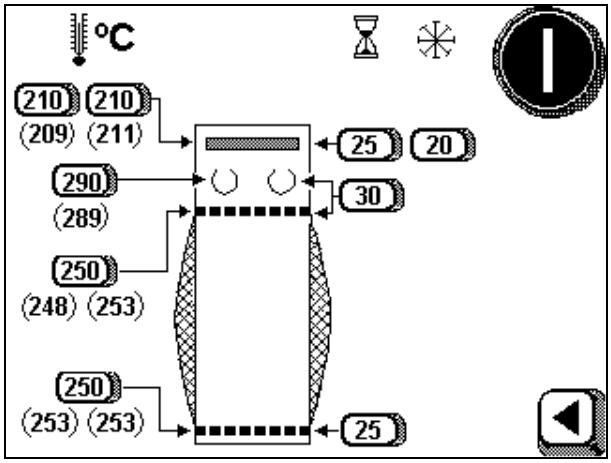
15.2.2.- Formation in process parameters.

Formation is understood as the set of parameters that defines what the machine has to make in order to form a determined type of bag.

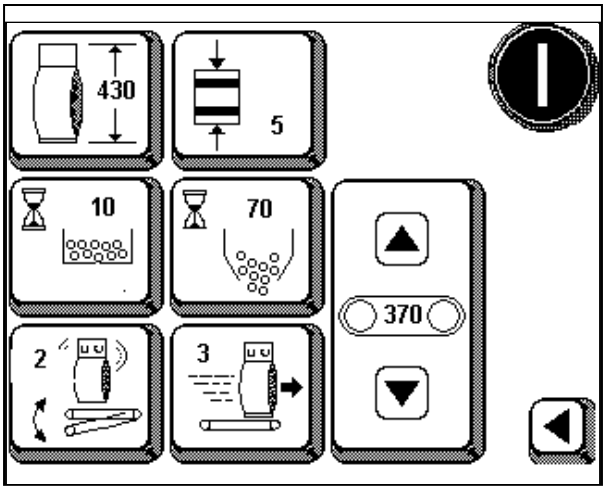
Pressing the  key on the main screen opens the screen displaying the format of the formation in process:



"Format of the formation in process" Screen

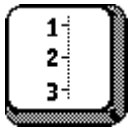


"Sealers of the formation in process (GIRSAC)" Screen

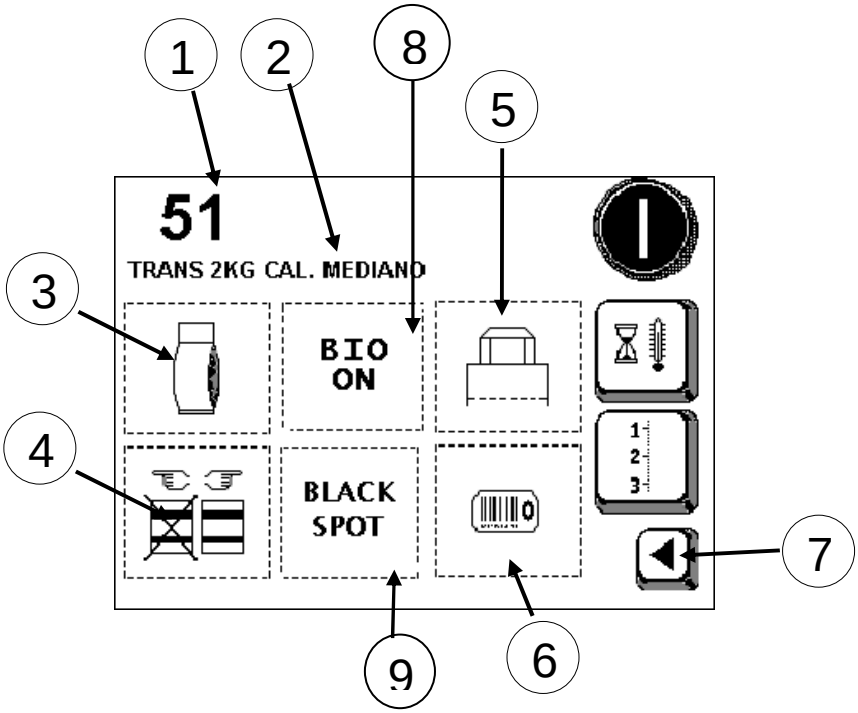


"Data of the formation in process" Screen

Pressing the  key opens the "sealers of the formation in process" screen

Pressing the  key opens the "data of the formation in process" screen

15.2.2.1.- *"Formation in process format" Screen*



1 Formation number in process. (Information on this screen)

2 Formation name in process. (Information on this screen)

3 Information field for bag type defined in formation in progress.

4 Information field for register type defined in formation in progress.

5 Information field for bag handle type defined in formation in progress.

6 Information field for label type defined in formation in progress.

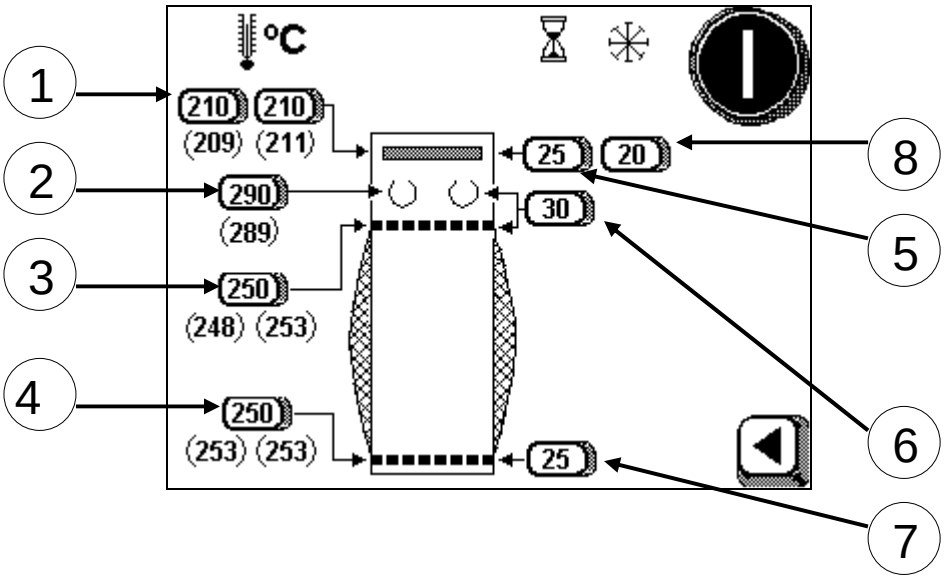
7 Key to return to previous screen.

8 Activate the making with material compostable.

9 Activate the invisible mark registration.

The format of the formation in progress cannot be modified from this screen.
To examine the different option in the information fields, see section 15.2.5.

15.2.2.2.- *"Formation in progress sealer parameter (GIRSAC)" Screen*



1 Left and right pre-sealer temperatures. The set temperature is displayed inside the key, while the values below in parenthesis show their related true thermocouple. All temperatures have a range from 0ºC to 240/300 ºC.

2 Die sealer temperature. In this case, there is only one sealer, so there is only one setting with its related thermocouple.

3 Header sealing temperature. In this case, there is only one setting for the right and left sealers, but there are two thermocouples listing the temperature.

4 Bag bottom-sealing temperature. In this case, there is only one setting for the right and left sealers, while there are two thermocouples listing the temperature.

5 Sealing time for the pre-sealers. All sealing times have a range from 20 to 100 csec.

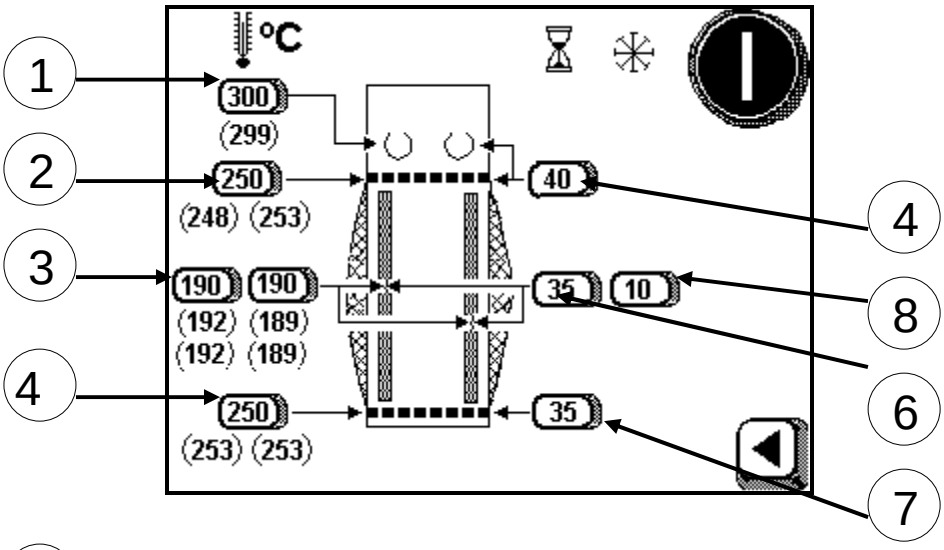
6 Header sealing time

7 Bag bottom sealing time

8 Cool down time for the pre-sealers. This has a range from 0 to 100 csec.

The ranges defined in this manual for the various data above correspond to those set at the factory and can be modified by the technical service.

15.2.2.3.- *"Formation in process sealing parameters (ULTRABAG)" Screen*



1 Mould sealing temperature. In this case, there is only one sealer, so there is only one setting with its related thermocouple. All temperatures have a range from 0ºC to 240/300 ºC.

2 Header sealing temperature. In this case, there is only one setting for the right and left sealers, but below in parenthesis there are two thermocouples listing the recorded temperature.

3 Vertical sealer temperature. There are 4 vertical sealers: BACK LEFT, FRONT LEFT, BACK RIGHT, and FRONT RIGHT. The field buttons refer to the left side sealer setting and the right side sealer settings, while the temperatures of the 4 thermocouples are shown below, with the thermocouples closest to the buttons corresponding to the back sealers.

4 Bag bottom-sealing temperature. In this case, there is only one setting for the left and the right sealers, while the recorded temperature of the 2 thermocouples is shown between parentheses.

5 Header sealing time. All sealing times have a range from 20 to 100 csec

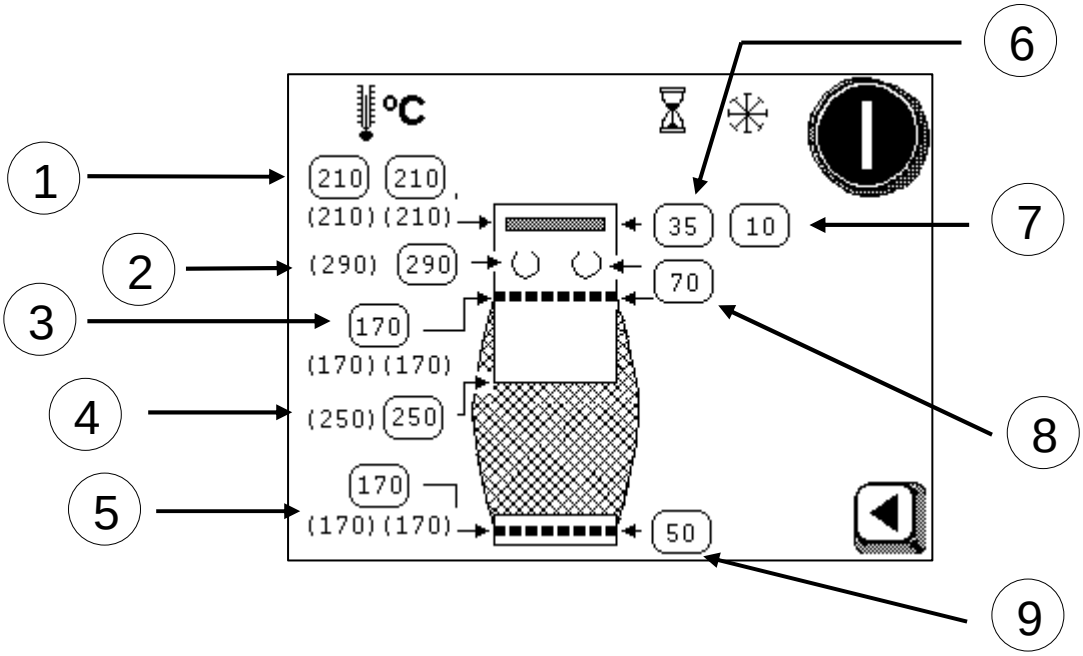
6 Vertical sealing time

7 Bag bottom sealing time

8 Vertical sealers cool down time. This has a range from 0 to 100 csec.

The ranges defined in this manual for the various data above correspond to those set at the factory and can be modified by the technical service.

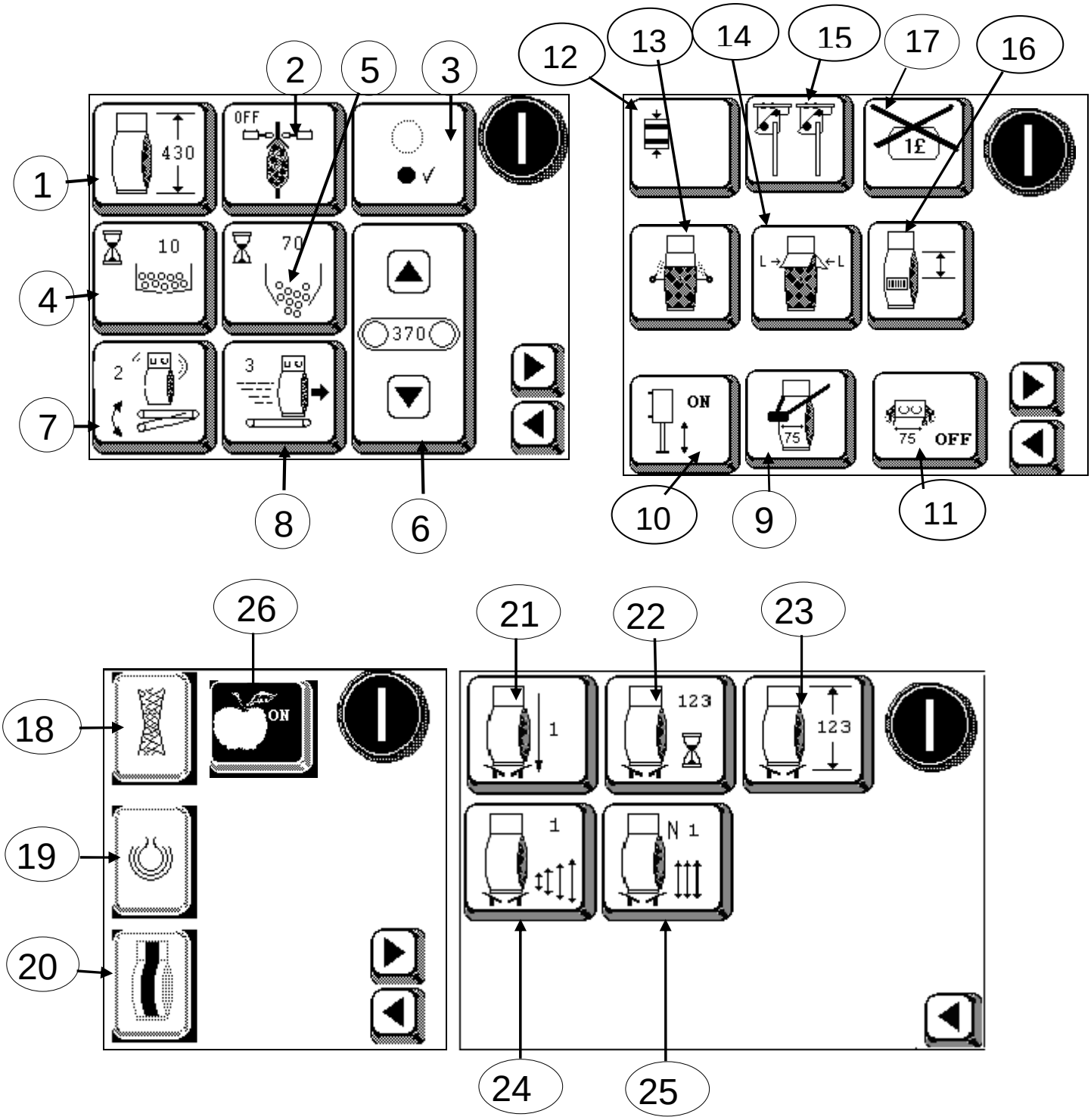
15.2.2.4.- *"Sealing parameters for the formation in progress" screen (GIRPLUS)*



1. Left and right side pre-seal temperature. The recorded temperature is indicated on the key whilst the associated true thermocouple value is shown below in brackets. All the temperatures range from 0ºC to 240º/300 ºC.
2. Die cutter sealer temperature. In this case, a single sealer and therefore a single register and associated thermocouple.
3. Header sealer temperature. In this case, a single register for left and right sealer whilst there are two temperature information thermocouples.
4. Temperature of Girplus cutting blade. In this case, a single register for the left and right sealer and only one thermocouple.
5. Bag bottom seal temperature. In this case a single register for the left and right seal whilst there are two temperature information thermocouples.
6. Seal temperature of pre-sealers. All sealing times range from 20 to 100 csec.
7. Pre-seal cooling time. Ranges from 0 to 100 csec.
8. Header sealing time
9. Bag bottom-sealing time.

The various data ranges specified in this manual are in relation to the factory output and can be modified by technical services.

15.2.2.5.- *"Formation in progress general parameters" Screen (GIRSAC, GIRPLUS and ULTRABAG)*



1 Bag length. This has a range from 265 mm to 700 mm

2 Activates or deactivates station 3 extractor gripper

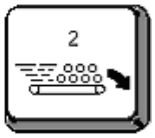
3 Button to select large/small size. Operates the hopper shovel without the product being retained, eliminating bridging

4 Time holding product in wands. This has a range from -30 csec to +100 csec.

5 Product loading time (wands open).This has a range from 40 csec to 250 csec.

6 Belt height. This range from 200 to 600 mm. Pressing the arrows adjusts the height of the belt.

7 Number of belt vibrations needed to settle product in bag. This can have the following values: 0 (no belt movement), 1 (one single movement of the belt at the end of the loading time) and 2 (as many vibrations allowed by the loading time).



In SOFT versions, button nº 7 has the function to change the in feed product belt speed. The possible values are 1 and 2.

8 Outgoing belt velocity. This has a range from 1 to 3

9 Belt wands. Only on models GB-55 / UB-65 /GB-55S / UB-65S. This button activates two wands at the S2 bag loading station with 75 film to avoid “stretch marks”. Accessible when the variable “existing belt wand” is activated.

10 Activates the hopper anti-bridging cylinder.

11 Activates the double prewelder.

12 Adjusts the position of the film register.

13 Adjusts the extra blower time on Girplus machines

14 Selects the length of Girplus flaps

15 Position of the film register readers.

16 Adjusts the height of the position of the label.

17 Activates right labeller.

18 Narrow mesh button. Pressing this button allows a narrower and tighter mesh than normal to be used.

19 Onion's button. The infeed product flaps are cancelled

20 Strengthening film button for Girplus. With this option and the 3rd reel set up, another film is in place to strengthen the mesh. Makes the bag stronger.

21 Lift descent speed. 2 speeds.

22 Lift descent delay. Ranges from 0 to 250 cseg.

23 Lift vibration intensity. 3 vibration intensities.

24 Number of lift vibrations. Ranges from 0 to 9.

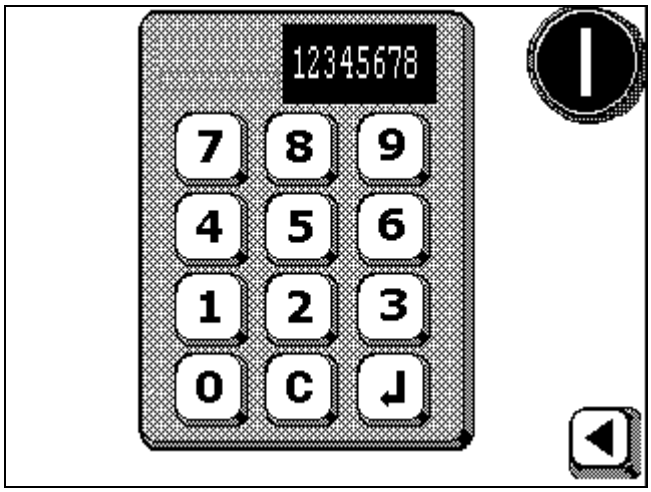
25 Height of the lift stop. Ranges from 300 mm to 700 mm.

26 OPTIONAL: Seletion SOFT / NO SOFT.
ON : Allows run machine with soft product.
OFF : Allows run machine with stonefruit.

Keys 21 to 25 only apply to the SOFT machine version. key 26 is optional.

The ranges defined in this manual for the various data above correspond to those set at the factory and can be modified by technical services.

When any of the keys containing values are pressed, a numeric keypad appears so that these numbers can be changed:



15.2.3.- "Labeller" Screen

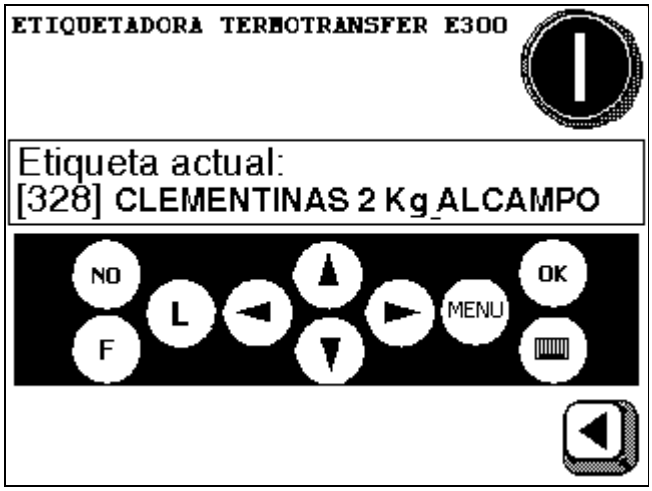
Pressing on the 

key from the main screen accesses the following screens,

according to the labeller selected or the two in the case that both have been selected.

15.2.3.1.- *Thermotransfer labeller screen.*

The front panel on the machine is displayed on the packaging machine's tactile screen and consists of a 2 line display with 20 alphanumeric characters and 8 keys:



The role of the keys is as follows:

'⇐' '⇒' Cursors to select certain parameters for modification.

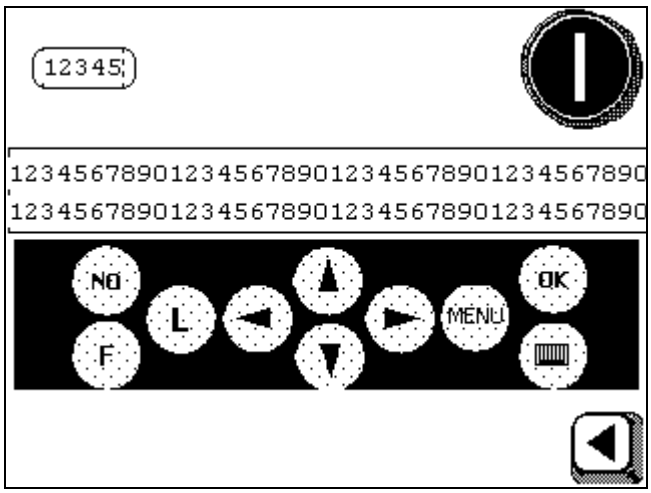
'⇑' '⇓' Make the modification to the selected parameter .

'OK' Confirm present or modified parameter values.

'L' Request label (Load label) by PC remote or reserved internal memory.

'NO' Cancel operations.

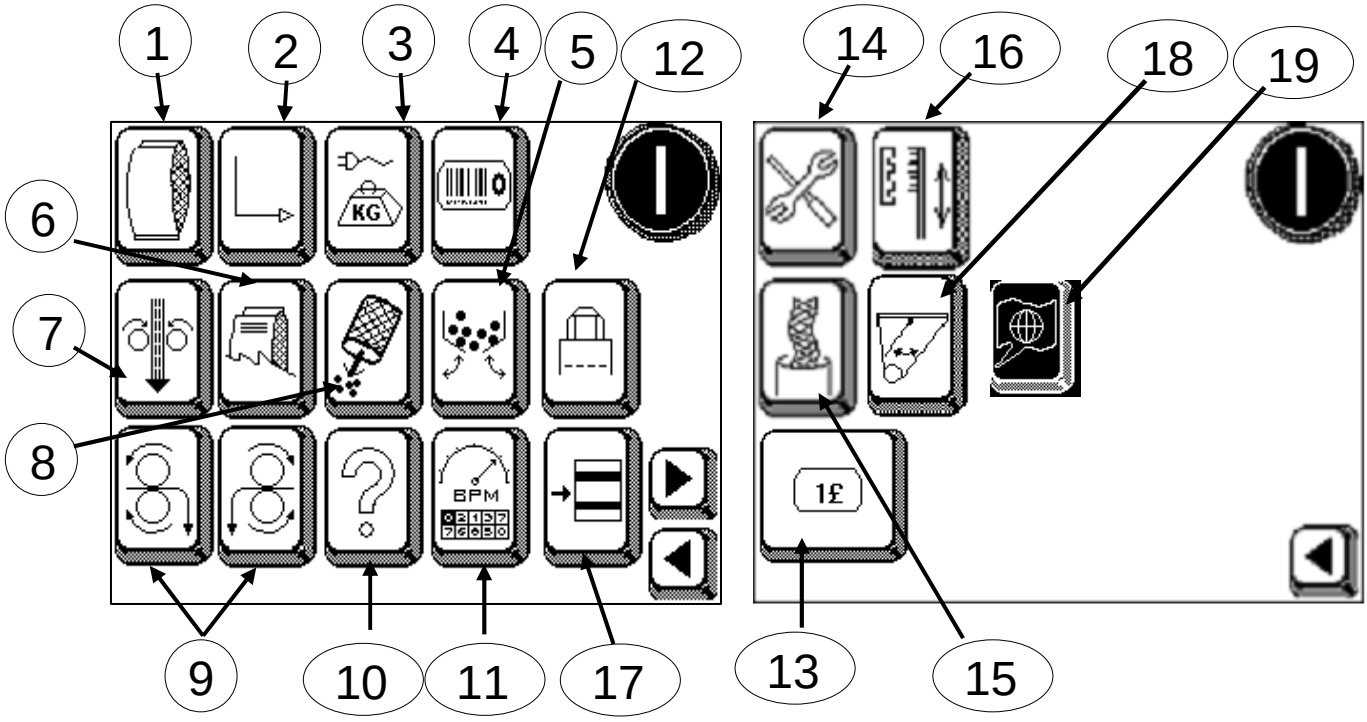
15.2.3.2.- *GIRPRINT 200 labeller screen:*



To use the labeller, see the GIRPRINT E200 labeller manual.

15.2.4.- "Manual operations" Screen

Pressing the  key on the main screen opens the manual operations screen.



1 Operates the machine for bags only. This is used to check the operation of the bag formation station.

2 Operates the machine from bag to bag, or 1 cycle only, (icon represented in the figure) or in automatic mode.

3 Activates sychronism with weighing machine. If operating w/ this button pressed (w/o weighing machine), bags will have no products inside.

4 Activates labeller. If operating with this button pressed, the labeller does not run and the bags come out unlabelled.

5 Activates manual wand opening. This is used if wanting to manually unload the product held by the wands.

6 Activates manual bag driver at the bag formation station.Used to load consumable products).

7 Manual activation of the pre-sealer and bag bottom cutter (only works with the doors closed)

8 Empties packager. It removes the 3 bags possibly in the packager.

9 Feeds the left and right folds according to the length specified for the production. (Buttons only in GIRPLUS versions)

10 Help button for bag format changes, where the mechanical elements are indicated in the submenu which have to be taken ito account for this to function correctly.

11 Button opening the screen displaying the machine's cadence and counters.

12 In machines with a HANDLE station, this deactivates the handle holder. This is used to extract the last unused handle.

13 Only machines with right labeller. The labeller gives a label

14 Button opening the maintenance screens. This area requires an access code to enter.

15 Activates operating with continual mesh supply.

16 Put together the counterplates in order to help the clean job of welding plates.

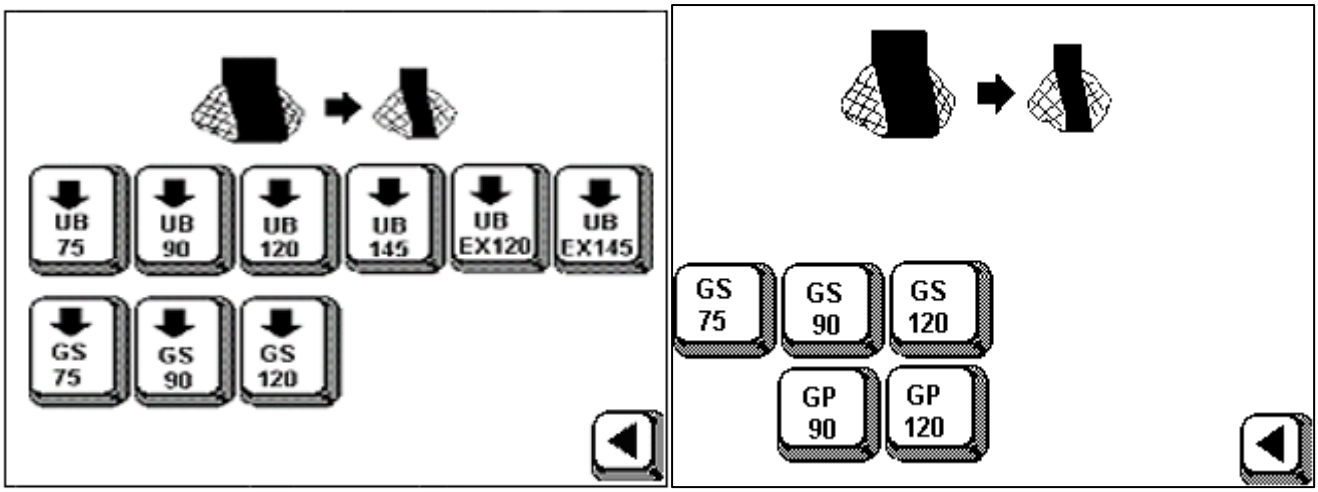
17 Automatic search button of registry for GIRSAC and ULTRABAG format

18 Change shovel position

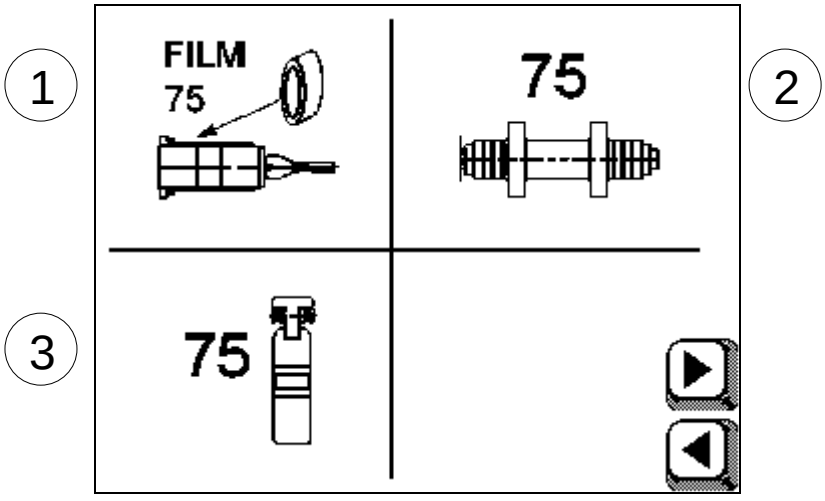
19 Acces to change language

15.2.4.1.- *Help Screens to change bag format.*

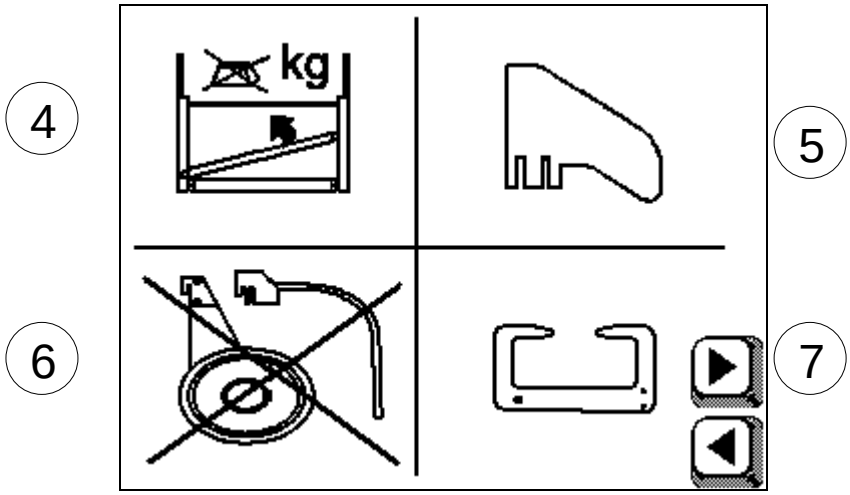
Pressing  on the “Manual Operations” screen provides access to the bag format change screen. The “Bag Formats” help screens will then be displayed corresponding to the UB60 machine (left format) and the GB55 machine (right format). The UB-65 machine displays all the help screen options:



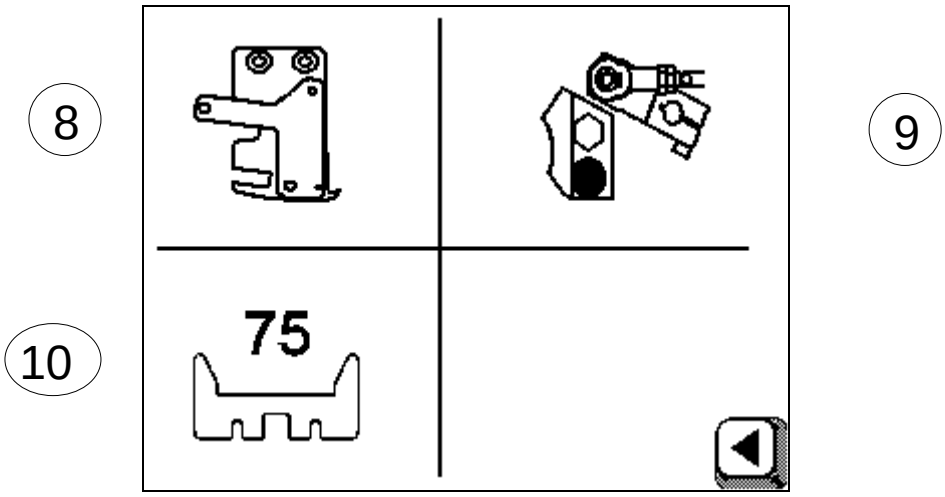
Pressing any of the buttons on the previous screen and a new screen will appear, in which the mechanical elements to be taken into account for any bag format change can be visualized on screen. As an example, on the GB60 machine, pushing the GS75 (Girsac 75) button activates the following screen which indicates that the separator (1) for the 75mm film has to be placed on the film reel, (2)) the film guide adjustment rings in the correct position for 75 mm film, (3) the GIRSAC torpedo for 75 mm film.



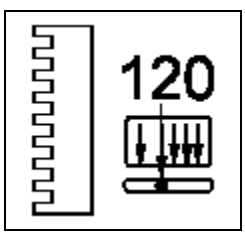
The following screen indicates when the counterweight for the mesh lung used in the ULTRABAG format has to be removed (4) the mesh feeder at the bag production station needs to be in place (5) the mesh feeder at the bag production station used for the ULTRABAG format has to be removed (6) and the mesh belt used in the GIRSAC format needs to be in place (7).



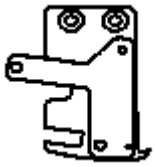
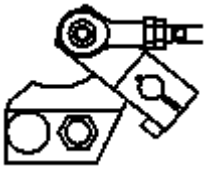
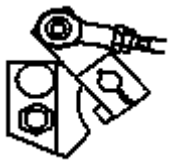
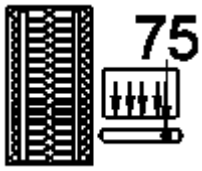
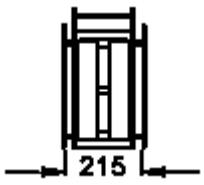
The following screen indicates that the rod protection covers on the mesh feed at the product loading station should be uncovered (8) the positioning block for the mesh feed at the product loading station should be placed in the position as indicated(9) and the film belt placed in the product loading station.(10)

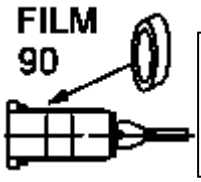


In addition to the previous icons another icon is used which identifies the opening position of the vertical welders in the ULTRABAG format.

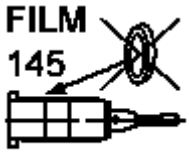


The various help icons are described as follows:

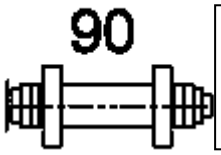
	To fit centring device for 75 or 90 film transfer grips		To remove centring device for film transfer grips
	To fit mesh lung counterweight used in el the ULTRABAG forma		To remove mesh lung counterweight used in the ULTRABAG format.
	To remove mesh lung counterweight used in the ULTRABAG format.		To close rod protectors to the E2 loading station (extruded mesh)
	To position E2 belt stops for 120.		To position E2 belt stops for 145.
	To position E2 belt stops for 75/90/120 (extruded mesh).		To position as indicated on the vertical UB sealers. 75/90/120/145
	To use the UB torpedo.		To place UB torpedo in the closed position. 170
	To place UB torpedo in the half-open position. 200		To place UB torpedo in the open position. 215



To fit film reel holder separator.



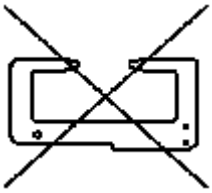
To remove the film reel holder separator.



To fit the slotted shaft guide stops in position. . 75/90/120/145.

To fit the Girsac torpedo 90 or 75.

To fit the mesh belt used for the GIRSAC format.

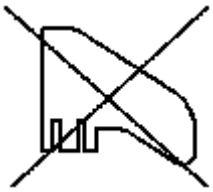


To remove mesh belt used for the GIRSAC format.

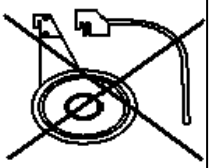
To fit the E1 belt discs.

To fit the E1 wand guides.

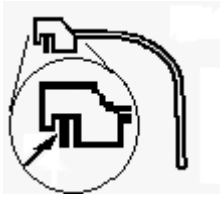
To fit mesh feeder on the bag formation station.



To remove mesh feeder from the bag formation station



To remove mesh feeders from the bag formation station.



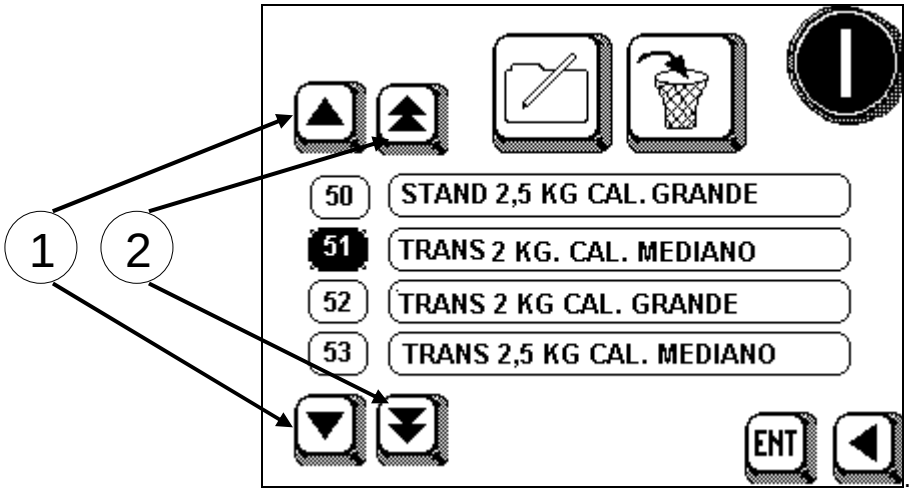
To place E1 wands in the position indicated.

15.2.5.- "Formation List" Screen

The machine's memory can store up to 100 different formations (codified from 1 to 100).

Creating formations is restricted to advanced users who know the password allowing entry to the formation creation screens. With the option described in section 12.2, the user could only modify the values related to the temperature and time of the formation in progress, whereas in this next section, the format of the formation can be modified.

Pressing the  key from the main screen opens the formation list screen (through the corresponding password screen):



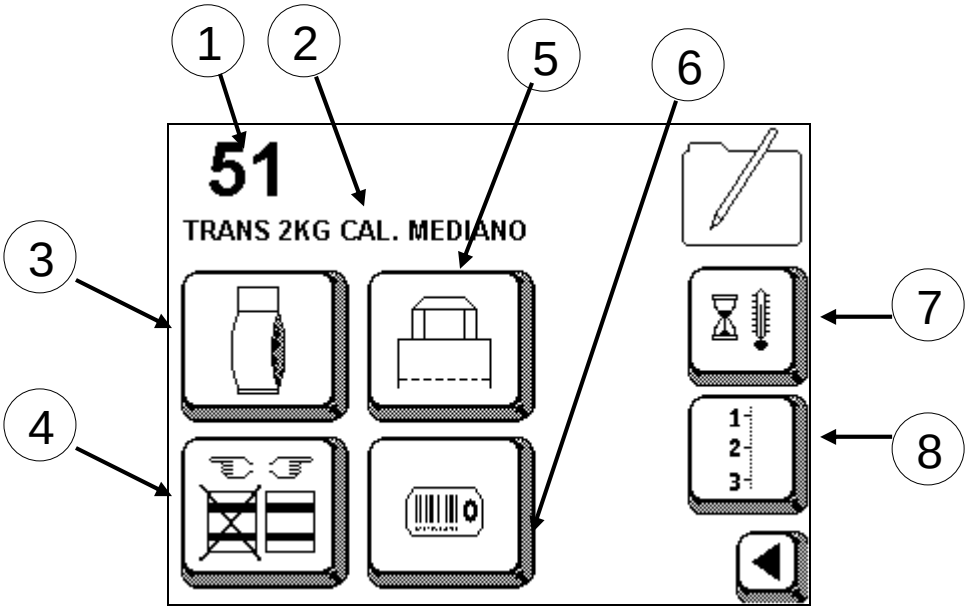
To navigate through the screen where the various formations are listed, use the line cursors to move up and down (1) and to skip pages forward and backward (2), and the formation selected will be shown in black. At this point, three actions can be taken:

1st- Activate the formation by pressing the 

button, which will make the formation selected become the formation in progress.

2nd- Press the  button and after a confirmation message, the formation selected will be eliminated from the formation memory.

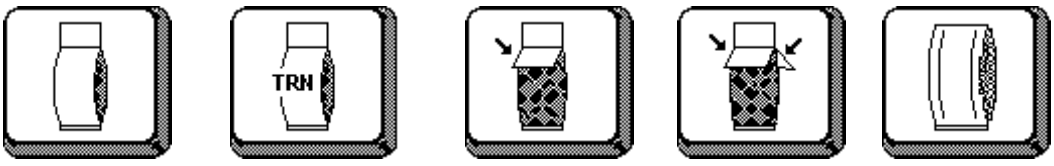
3rd- Press the  button and the “Formation parameters” screen will open for the formation selected. The first screen to appear will be the one called “Formation format”:



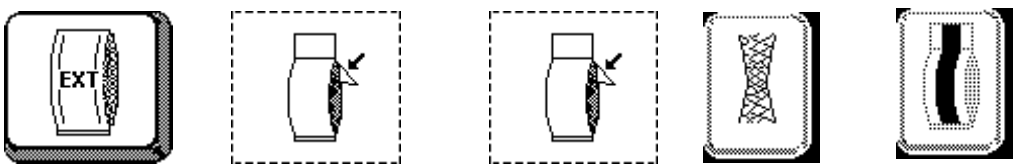
1 To modify the number of the formation, press the button to open a numeric keypad on which the desired number can be entered. This field has a range from 1 to 100.

2 To modify the name of the formation, press this button to open an alphanumeric keypad on which the desired name can be entered.

3 Pressing on the “bag type” button provides the choice, according to the machine model (see section 1.1.5) between the GIRSAC bag type shown in the figure or GIRSAC transparent type and the ULTRABAG woven mesh type or ULTRABAG extruded mesh, as shown below:



GIRSAC | GIRSAC Transparent | GIRPLUS 1 Flap | GIRPLUS 2 flap | ULTRABAG



ULTRABAG extruded | GIRSACPLUS RIGHT | GIRSACPLUS LEFT | NARROW MESH (optional kit) | 3rd band (optional kit)

To change from GIRSAC to ULTRABAG bag types and vice versa, it will be necessary to make changes and adjustments to certain areas on the machine. See section 15. BAG FORMAT CHANGE.

4 Pressing the “register type” button allows the choice between the following options

without register | Left film register 1 black bar | Left film register 2 black bars | Right film register 1 black bar | Right film register 2 black bars | Double film register 1 black bar | Double film register 2 black bar

5 Pressing the “bag handle type” button allows the choice between mould and handle (if the machine model has the HANDLE module), and the mould must be then brought in or separated with an appropriate wrench.

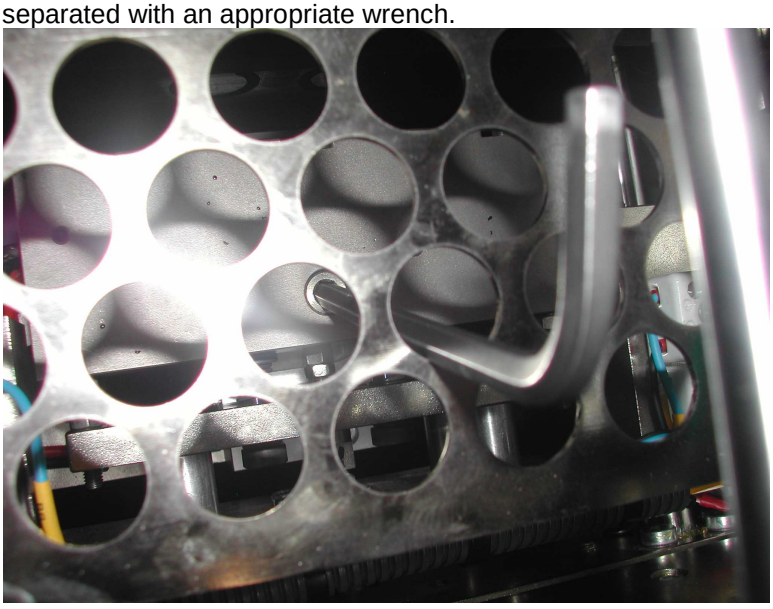
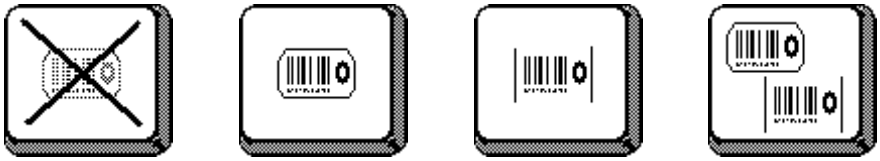


FIG. 12.2.5.

6 Pressing the “labelling type” allows the choice between the thermal labeller or the thermo-transfer (if the machine has this type of labeller) represented by the icon:



No thermal labeller | Thermal labeller | Thermo-transfer labeller | Termal & thermotransfer

7 Pushing this button accesses the “Formation sealers parameters” screen

8 Pushing this button accesses the “General formation parameters” screen

When returning to the formation list screen, the modified formation is recorded with its new data.

15.2.5.1.- *Creating a new formation*

To create a new formation, an existing formation is selected and modified with the corresponding data of the new formation, following the criteria given in the previous sections.

Given how important it is to organize the formations, when a formation is validated by pressing the  key, you will be asked onscreen whether you want to overwrite the formation, which has the chosen number, or create a space in the formation list by increasing by 1 the rest of the formations higher than the chosen formation.

15.2.5.2.- *Formation type*

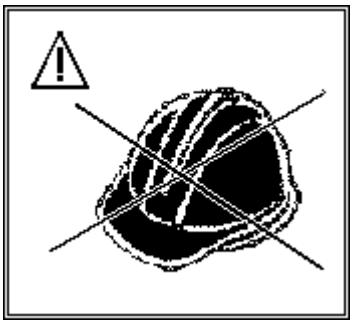
At the factory, various formations are recorded in the formation lists according to bag types, types of film material, bag weight, and product caliber, all numbered from 100.

15.3.- Alarms

During the normal operation of the equipment, various anomalies can arise, with the majority of them being inherent to the process and the supply of materials, and the users can easily resolve these. Some of them should never occur unless there is something wrong with one of the machine's components.

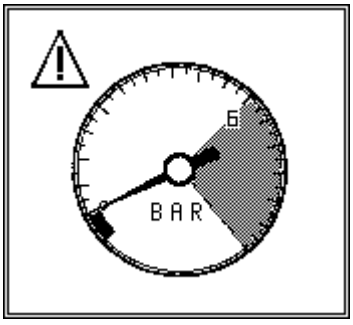
When an alarm occurs, the machine stops and the alarm light is activated, with an icon also appearing onscreen represented by an icon indicating the anomaly. This icon stays on the screen, as does the light, until the user becomes aware of them by pressing on the "Warning" key.

15.3.1.- Alarm list with user intervention



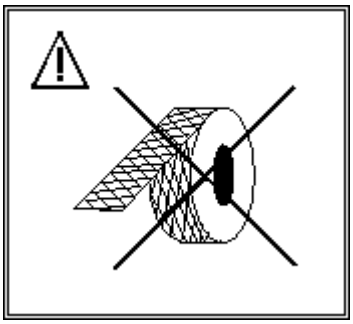
Security activated.

This indicates that the doors are open or the machine has not been reset.



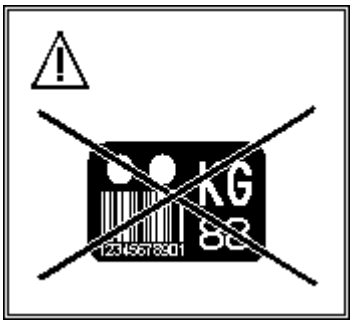
Lack of air pressure.

This indicates that the compressed air pressure reaching the machine is below the minimum required for its operation.



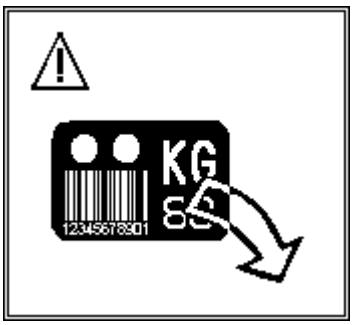
Mesh finished.

This indicates that the mesh reel has been used up. The alarm can also occur if the reel is not properly placed or the mesh has jammed up somewhere along its run through the machine. If the handle on the reel holder is open, the alarm can likewise occur as the reel will slip on the reel holder axis.



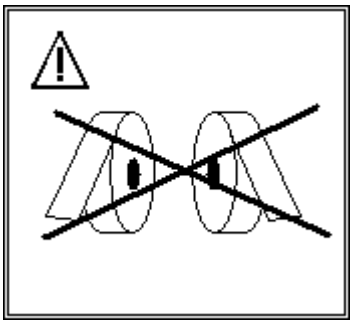
Labels finished.

This indicates that the label reel has been used up. The alarm can also be set off if the reel is not properly placed or the strip of labels has jammed up somewhere along its run through the labeller .



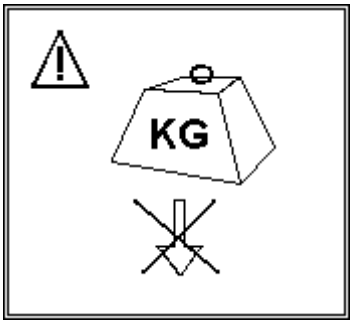
Remove label from donor

This indicates that the label on the label donor platform should be removed, if there is one. If this is not done, the labeller will dispense another label and cause jamming.



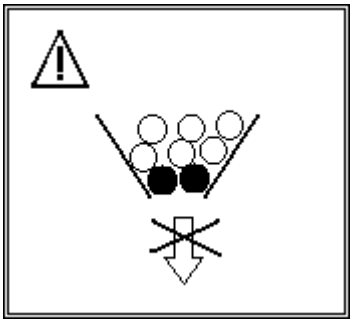
Film finished.

This indicates that the film reel has been used up. The alarm can also occur if the reel is not properly placed or the film has jammed up somewhere it its run through the machine. If the handle on the reel holder is open, the alarm can likewise occur as the reel will slip on the reel holder axis.



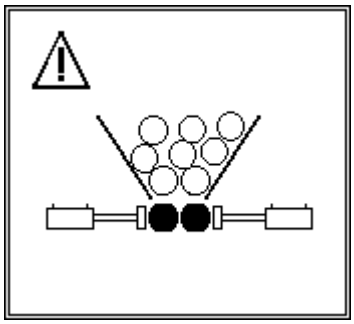
Waiting for weighing machine.

This indicates that the machine is waiting for the machine to deliver a packet. This alarm appears if the waiting time is higher than the preset time.



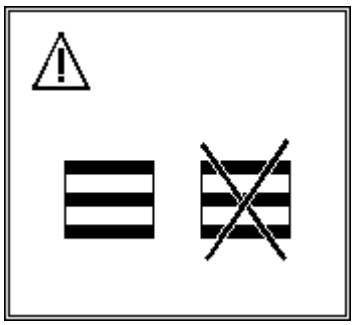
Hopper jam

This alarm appears when there is blockage in the hopper, the tube or between the loading wands. It can also appear if product stays on the wands once they are closed.



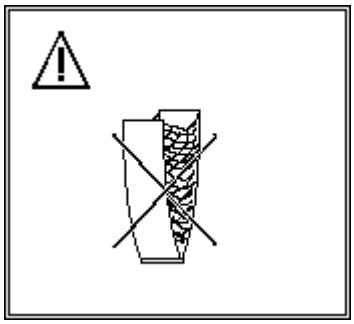
Transfer clamp jam

This alarm appears when the clamp carrying the bag from station 2 to 3 could not be closed due to being blocked by a piece of product, as it has not settled enough or there is too much product for the size of the bag.
The product should be settled manually or the excess should be removed before restarting the machine.



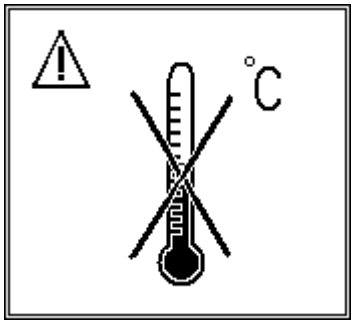
Lack of right register.

The machine can not find the right register. The film should be re-positioned correctly.
The same kind of alarm will occur if the error is on the left register or on both registers if the double register errs, provided that the machine has these options installed. In both cases, the left register or both registers will appear crossed out.



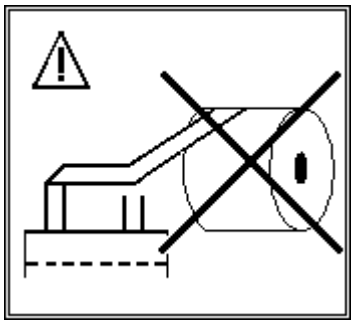
Bag lost between E1 and E2

This can occur when the bag formed in the bag forming area can not be picked up by the grippers that transfer it to the loading station, or they lose the bag while passing between both stations, which will set off the alarm mentioned.
The cause could be a jam in the consumable product in the bag forming area or the gripper can not open the bag, and in this case the technical service must be advised



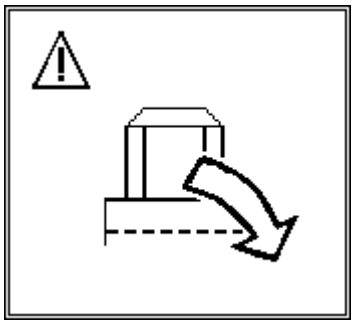
Sealer temperatures beyond tolerance level.

If the sealer temperatures are outside the accepted tolerance levels and the machine is in automatic mode, this alarm will appear.
The most likely cause is that the machine has just been connected or that one of the safeguards has been opened without the safeguard disabling key.



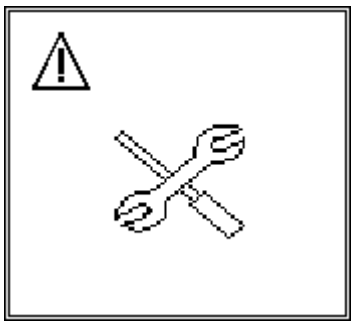
Handle finished.

This indicates that the handle reel has been used up. The alarm can also occur if the reel is not set properly or the handle band has jammed up somewhere along its run through the machine. If the handle on the reel holder is open, the alarm can likewise occur as the reel will slip on the reel holder axis.



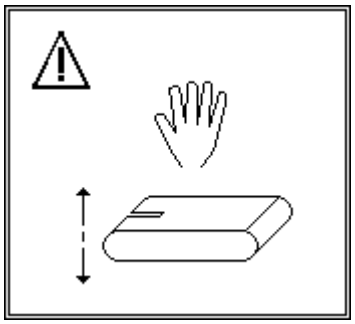
Remove handle

In some formation changes or after an alarm, the machine may require removal of a handle which may be incorrectly positioned in the handle station.



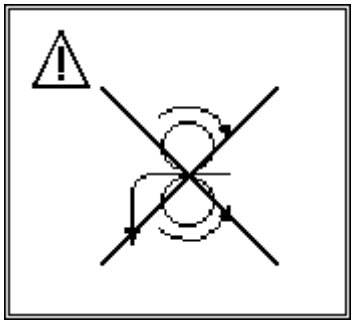
Advise maintenance service.

When this warning appears, the technical service must be advised, as this indicates an anomaly has occurred that the user can not resolve.



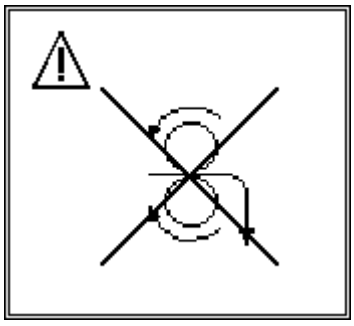
Machine positioning bag output belt.

When this warning appears, the machine has the touches screen blocked until bag output belt finish its movement.



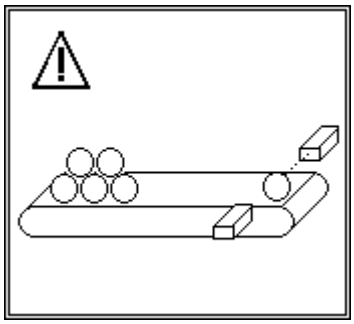
Right feed obstruction GIRPLUS

This warning appears when no changes have been detected in the right photocell register during the entire Girplus film feed .



Left feed obstruction GIRPLUS

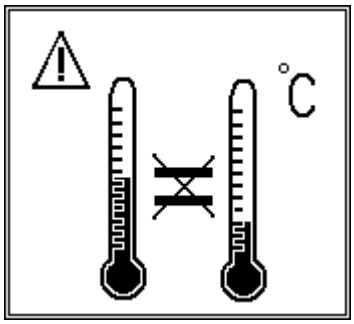
This warning appears when no changes have been detected in the left photocell register during the entire Girplus film feed .



Premature load detected.

Probably some of the previous load left behind .

This warning is only on the SOFT machine model

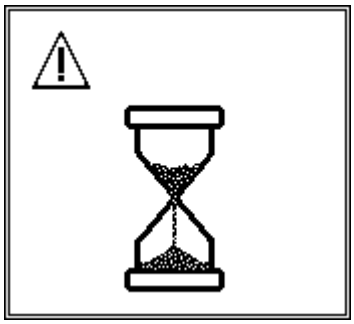


Excessive temperature difference.

After 40” the alarm activates and after 60” the electrical supply is switched off.

Clean the machine.

Every 100000 bags the machine has to be cleaned.

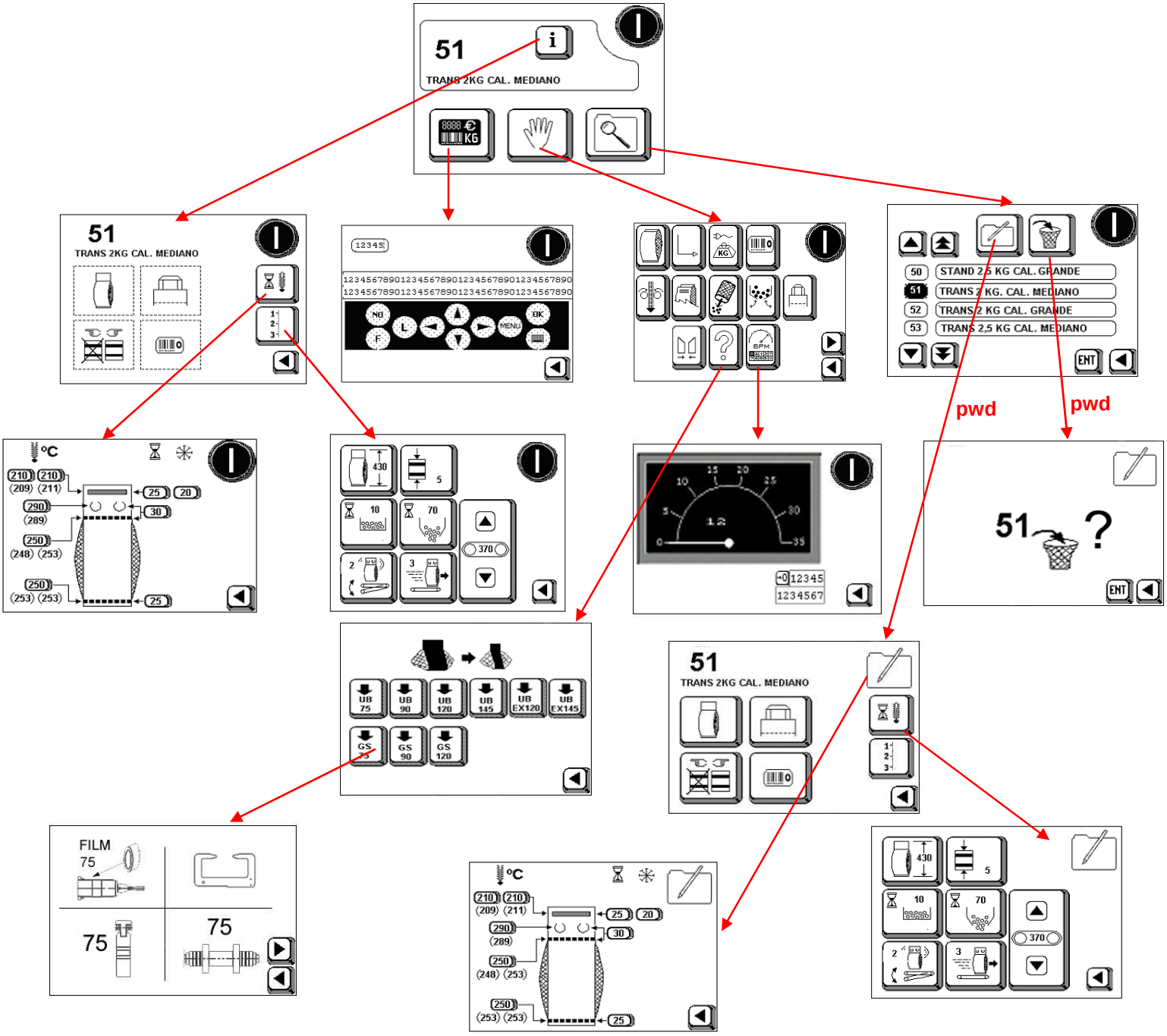


Wait, machine stopping.

Notice that the machine is been stopping.

15.4.- Screen hierarchy

A graph is shown below listing all the screens available on the touch screen, demonstrating as an example a formation with GIRSAC RIGHT REGISTER with HANDLE and ADHESIVE LABEL. The arrows indicate the screen changes that are made when the user presses the button indicated by the beginning of the arrow. The word 'pwd' means that to change screens it is necessary to introduce a password.



VI. INSTRUCTIONS RELATED TO ADJUSTING THE EQUIPMENT

16.- LOADING THE FILM

16.1.- General comments about film

ATTENTION: GIRÓ only guarantees the optimal operation of the GIRBAGGER machine if it is loaded with film designed specifically for the machine. Consult GIRÓ about the film models that are right for the type of bags needed to be formed in this packager.

The standard packager is prepared to work with film width between 75 and 145 mm.

The machine has two reel holders for film. Both must be loaded with reels of film.

When the film reel has been used up, the machine stops automatically and displays the “FILM FINISHED” alarm onscreen.

The reel must be placed in such a way that in its run toward the spreader, the film comes off the reel at the bottom.

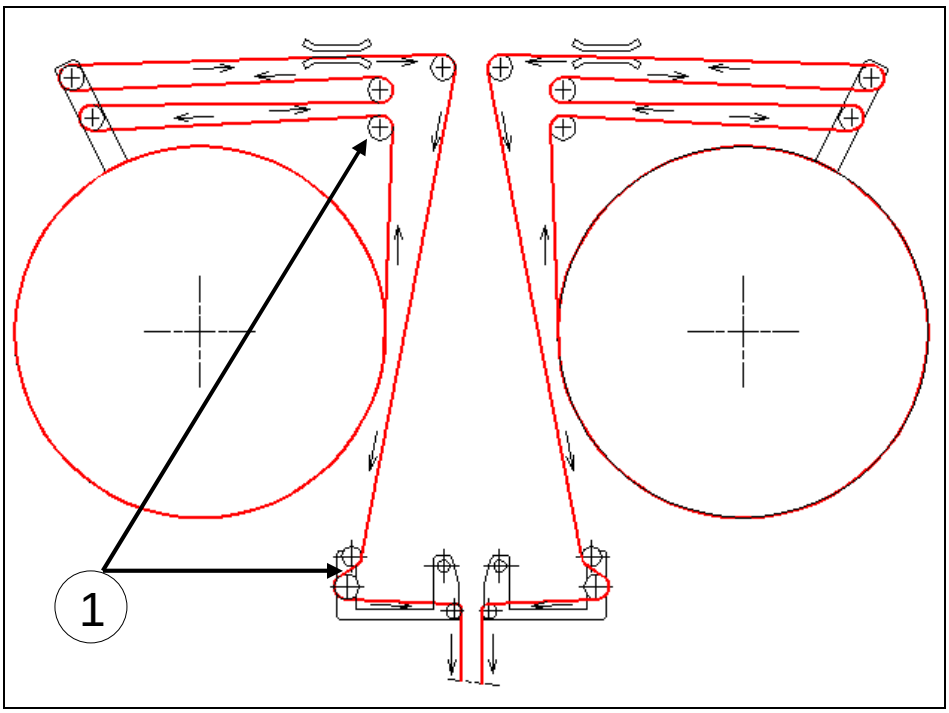
ATTENTION: The core of the reels must be in good condition and have standard measurements.

16.2.- Placing and threading the film

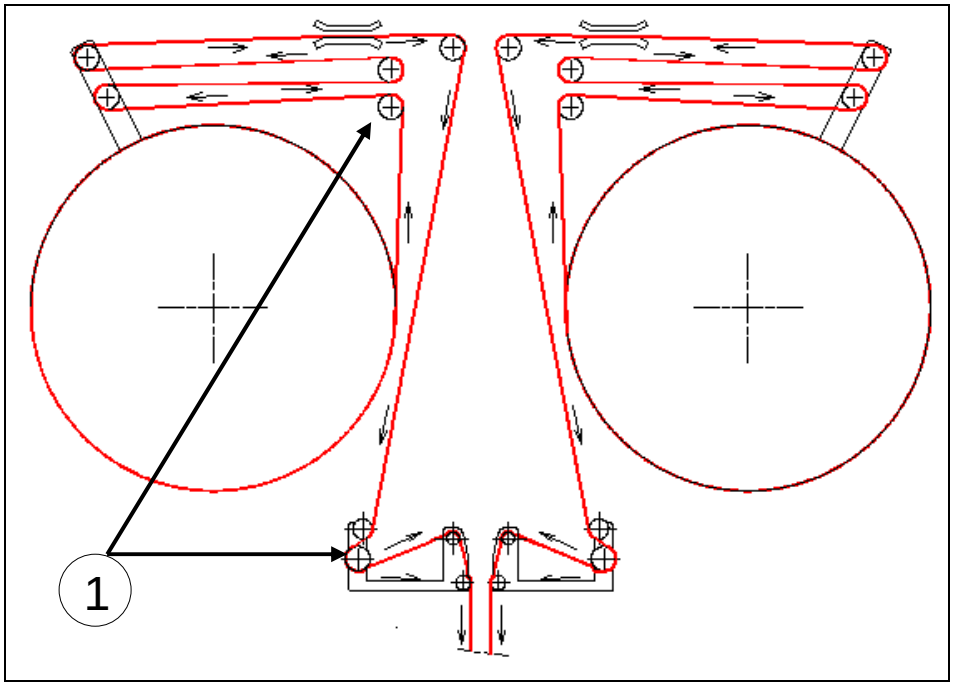
16.2.1.- Preparation

- First, always make sure that the machine is in the stopped position and then insert the mobile safeguard disabling key.

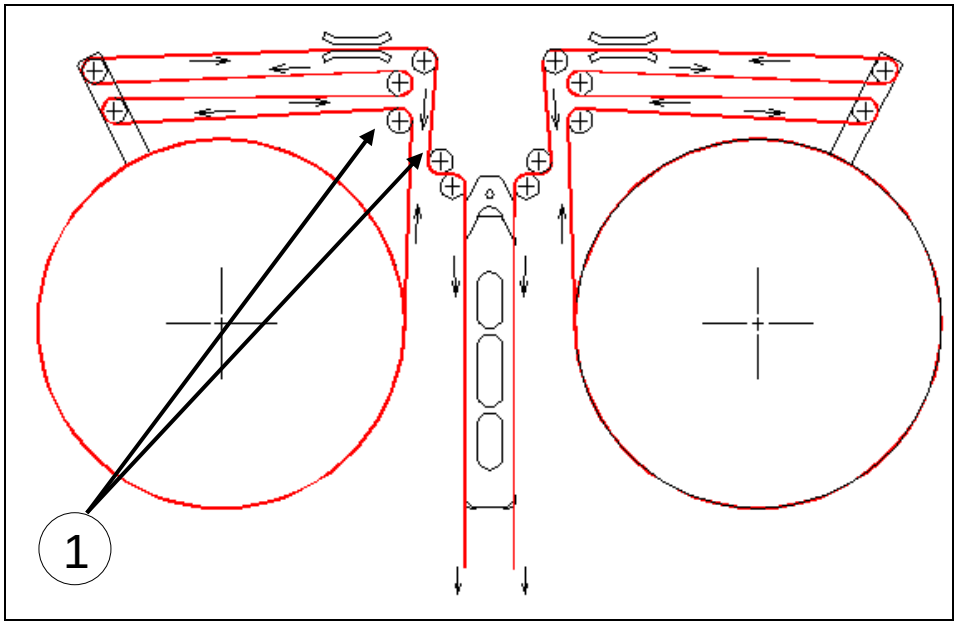
If there already is a film threaded, it is recommended to cut it at the point it leaves the reel and attach the end of a new film to the old with an adhesive label, thus saving time in passing the film through the spreader and the driving rollers. Make sure the film follows the path described in the scheme below:



13.1 Threading film for GIRSAC GB50 and UB60 bags



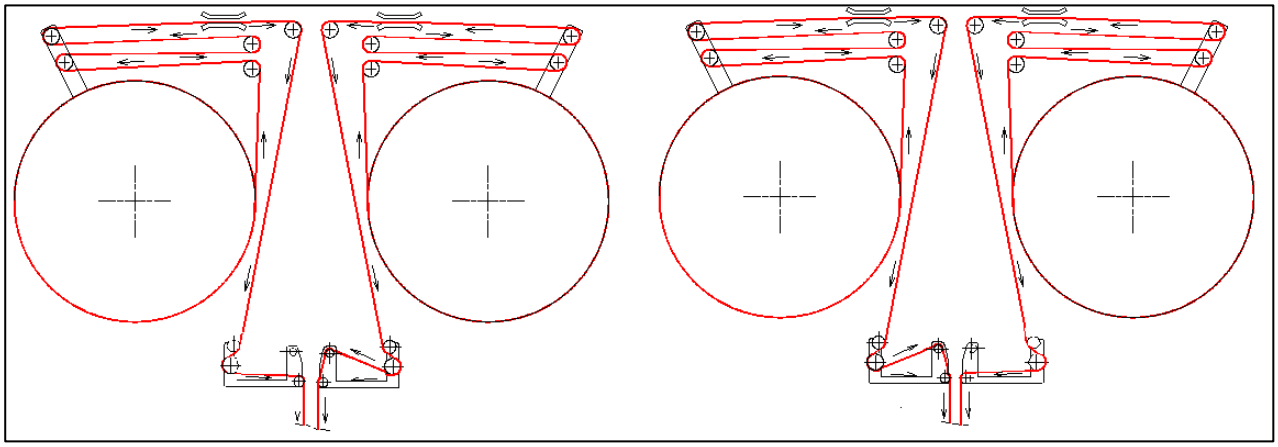
13.1b Threading film for GIRSAC GB55 bag



13.2 Threading film for ULTRABAG UB60 bag

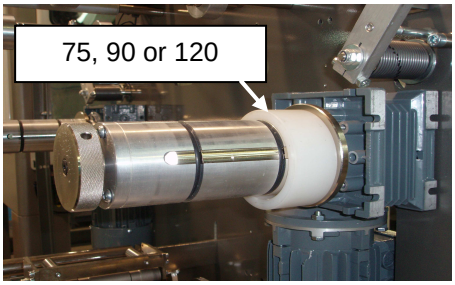
GIRSACPLUS LEFT

GIRSACPLUS RIGHT



13.3 tHREADING FILM FOR girsacplus GB55 and UB65

Make sure to locate the film guide discs in the proper position according to the film width



If there is no previously placed film, use the starting wrench marked in the figure to separate the driving rollers to pass the film through them.

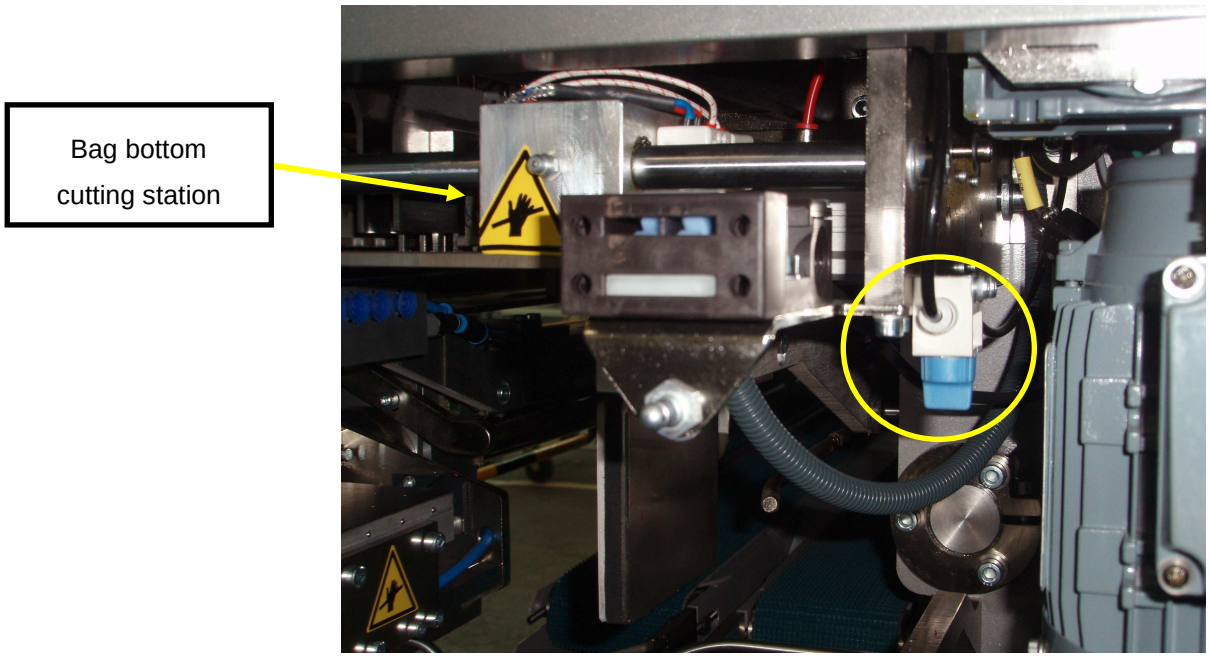


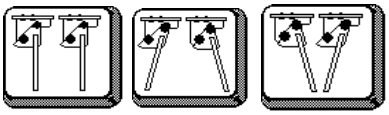
Fig.13.3 Bag bottom cutting station

Use step sequence 5 to 7 in section 14.2 to adjust the alignment between the films and the mesh.

Remember to deactivate the “Bags only” option and place the mobile safeguard disabling key into the deactivated position before reinitiating the operating cycle. Also, make sure that the “Automatic cycle” button is pushed, in this way the bags can be continually made.

16.2.2.- Method of register search:

It is necessary adjust the position of the readers when the mark stops and matches in the middle of the reader.



- GIRSAC and ULTRABAG:
  - Machines with >= V62:
    - 1 and 2 tokens:
      - Bring face to face the tokens of both films, if it applies.

Fig. 13.4a

      - Advance the film until the token is 50 mm before the reader. The distance can be bigger, provided there is not anything between the reader and the token that could confuse the readout.

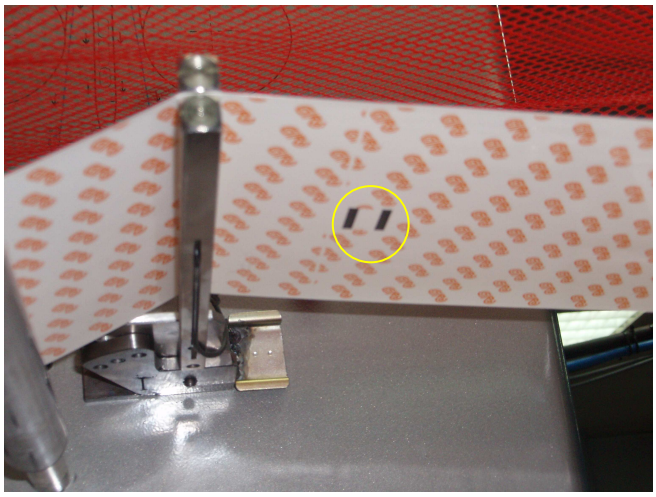


Fig. 13.4b

      - Push the automatic search button.(page 46 button 17))

- GIRPLUS:

It only works with 2 tokens register and the search is completely automatic.

- GIRSACPLUS:

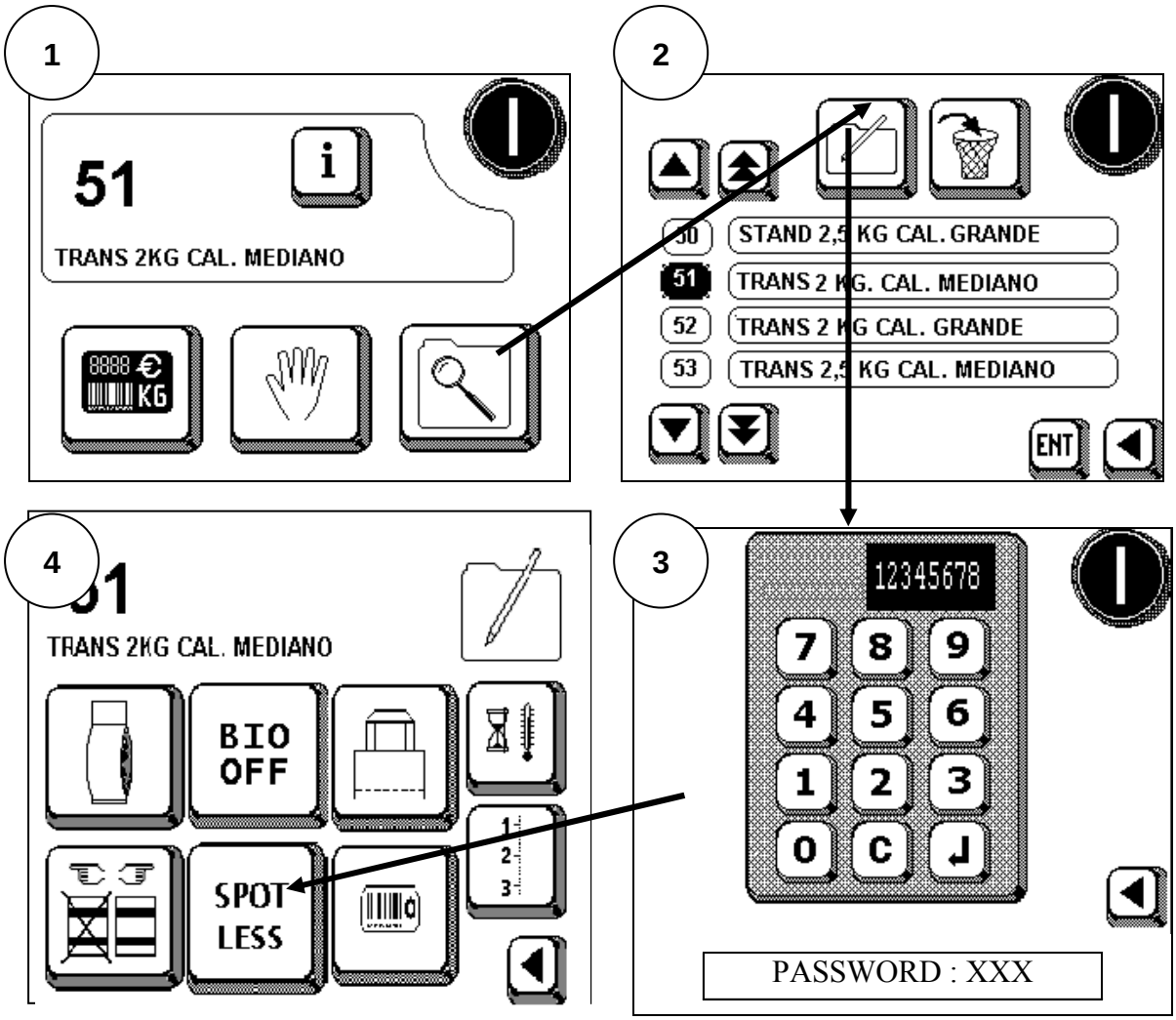
One side Grisac and the other side Girplus.

It will require manual search in the Girsac side and automatic search in the Girplus side. It will be also necessary adjust the following parameters:

GPL mm pres-cut side. PLUS Mix.
GPL mm pres-cut side . SAC Mix.

16.2.3.- Spot-less register (Optional)

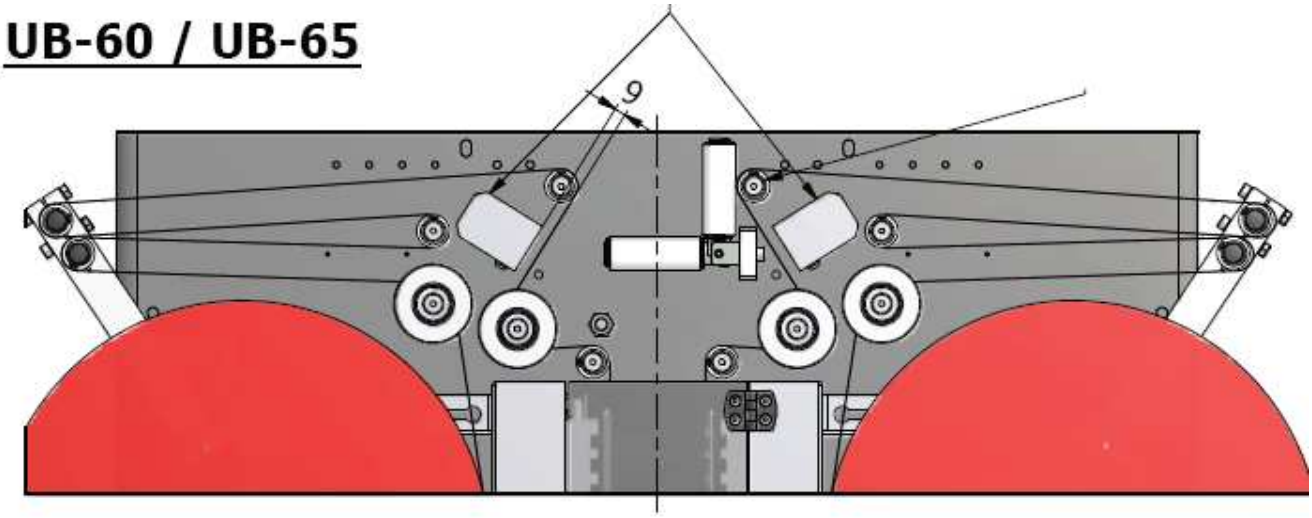
16.2.3.1.- *Activate Spot-less register.*



16.2.3.2.- *Threading film.*

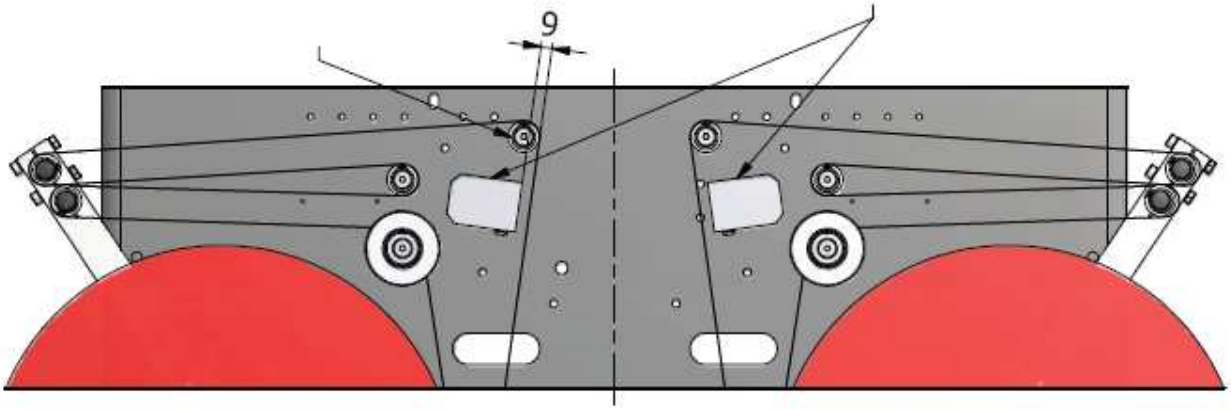
SL SENSORS

UB-60 / UB-65



GB-50 / GB-55

SL SENSORS



16.2.3.3.- *Sensor adjustment.*

IMPORTANT: Spot-Less sensor has a delay function. **For a correct operation is necessary turn off the delay function.**

Check status sensor: Press SET pushbutton and keep it pressed until the READY/ERROR LED turns off, blinking and turns off again, then release the SET pushbutton:

- If the delay function **IS NOT ACTIVE** the READY/ERROR LED blinks green with 2 quick pulses. Correct adjustment.

- If the delay function **IS NOT ACTIVE** the READY/ERROR LED blinks green with 4 quick pulses. Press and release immediately the SET push-button in order to change the function status.

To exit adjustment mode, wait a few seconds without press SET button.

Search mark:

Use 2 meters of Giró film ref.23968. If you don't have this film, Order code **328NT025-10** composed by 5 meters of Giró film ref.23968

- 1.- Put **NO mark** in front of the photocell, press length (more than 3 seconds) until it stops blinking.

- 2. -Put the **mark** in front of the photocell, press length (more than 3 seconds) until it stops blinking. **Important: Do not use the white line; use either of the 2 lines of transition points in the picture.**

16.2.3.4.- *Spot-Less adjustments*

1. Bring the mark near the reader, and make an automatic search. Cut the bag, advance with the manual drive until displaying the mark, cut the bag and measure the distance from the register to the bottom of the bag.

2. Go to the Variables screen, in the paragraph REG. Search the corresponding variable "mm. Photocell to cut ". For example: if the film have two marks and the confection is UB, we will go to variable "REG mm.left photo-cut 2 token" (or/and "REG mm.right photo-cut 2 token", right side in case of double register).

3. If we want to more down the trademark "X" mm. from the current position, we should INCREASE the value of the variable "X" mm.

4. If we want to more down the mark "X" mm. from the current position, we should SHORTEN the value of the variable "X" mm.

5. Get out from this screen, return to the manual operations screen and repeat the instructions from the point 1.

6. If the position is the correct (The mark is between 5 and 10 mm. from the bottom), we will proceed to adjust the other side (in case of double register). If the position is not correct, we will repeat the adjustments of variables.

7. Once agree with the adjustment, we will transmit these increments or decreases of value to the rest of variables REG. mm Photo-cut Girsac, if we work with Girsac confection and if it is being worked with the two types of marks, adjust the other mark that has not been adjusted.

16.3.- GIRPLUS threading film

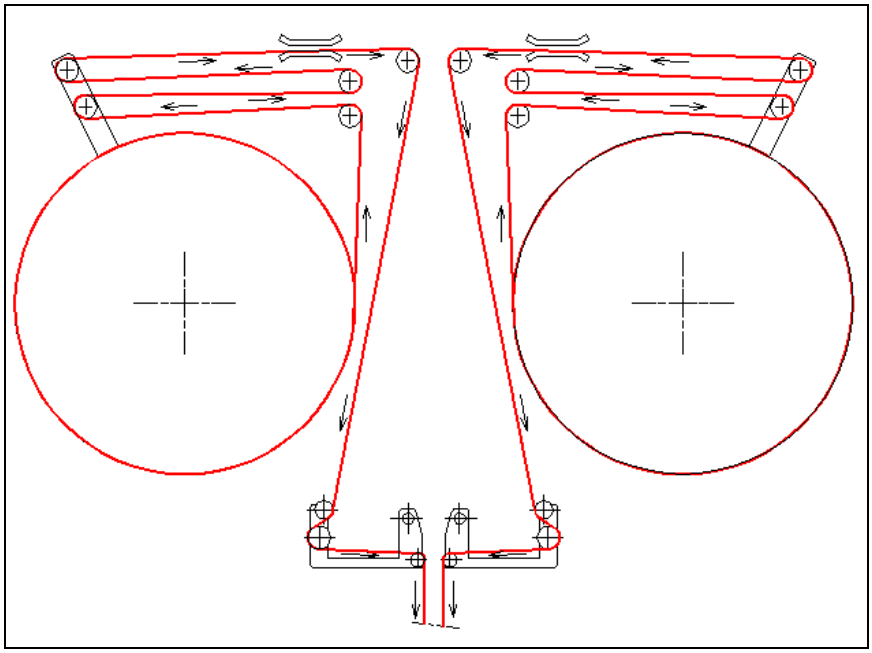


Fig 13.5

1. The reels are loaded with their corresponding separators.
2. The film is threaded through the entire pulmonary system.
3. The rollers are separated from the feeders by lever A. First pull outwards and then in the direction as indicated by the arrow. See Fig. 13.6

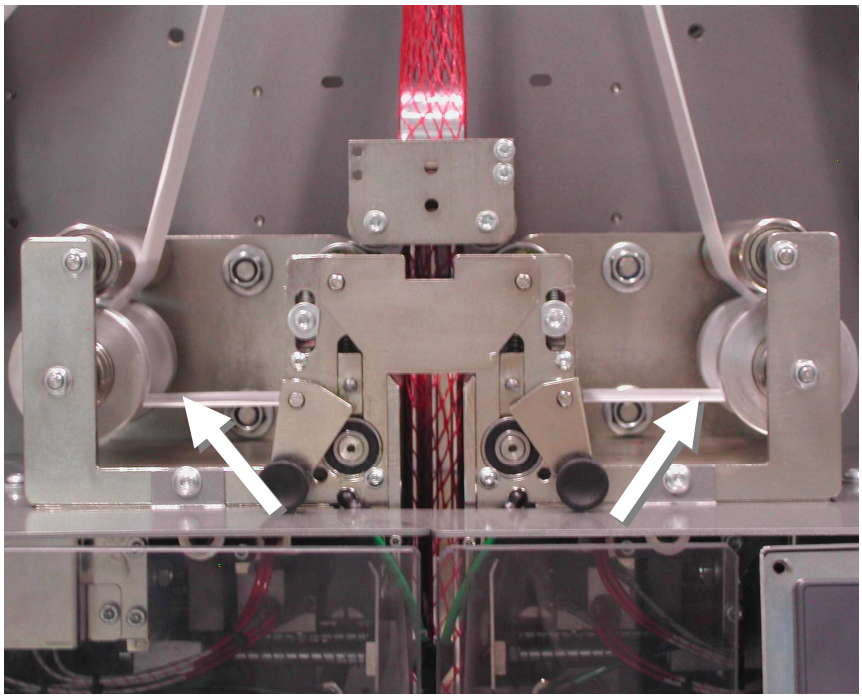
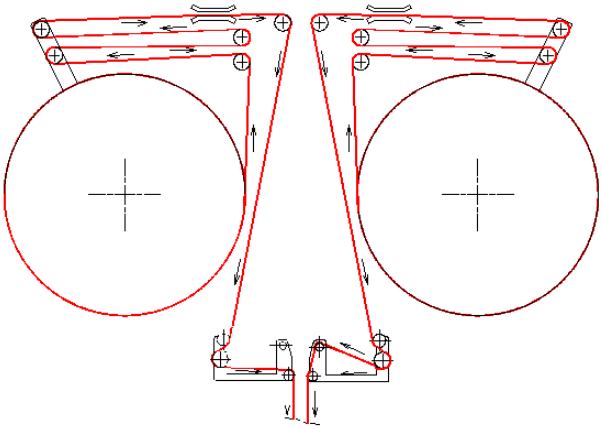


Fig. 13.6

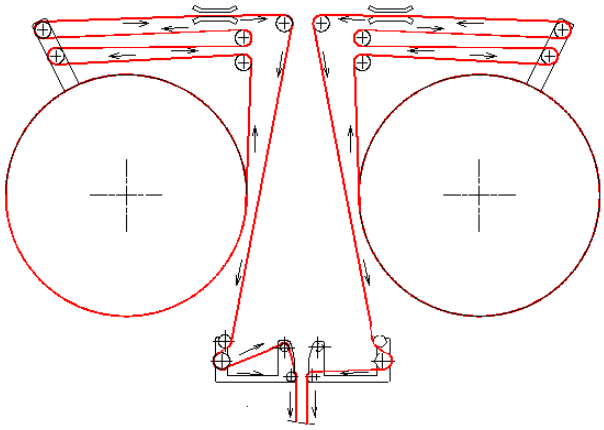
4. The film is threased through the feeder with 5cm left hanging in the location of the torpedo.
5. The feeder rollers are closed with lever A

16.4.- GIRSACPLUS threading film

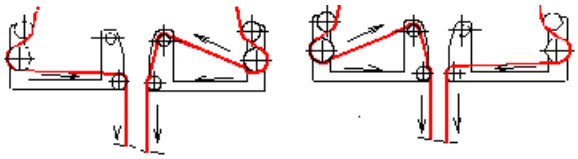
GIRSACPLUS LEFT SIDE



GIRSACPLUS RIGHT SIDE



1. The reels are loaded with their corresponding separators.
2. The film is threaded through the entire pulmonary system.
3. The rollers are separated from the feeders by lever A. First pull outwards and then in the direction as indicated by the arrow.



4. The film is threaded through the feeder with 5cm left hanging in the location of the torpedo.
5. The feeder rollers are closed with lever A

Note: Girsacplus confection is only possible with mesh width of 49 cm.

16.5.- Changing film width

16.5.1.- GIRSAC / GIRPLUS / GIRSACPLUS Format

When making a film width change for a machine prepared to form bags with the GIRSAC/GIRPLUS/GIRSACPLUS format, make sure to:

- Place separating rings on the film reel holders that are appropriate for each film width, (75, 90 or 120). See fig. 13.7

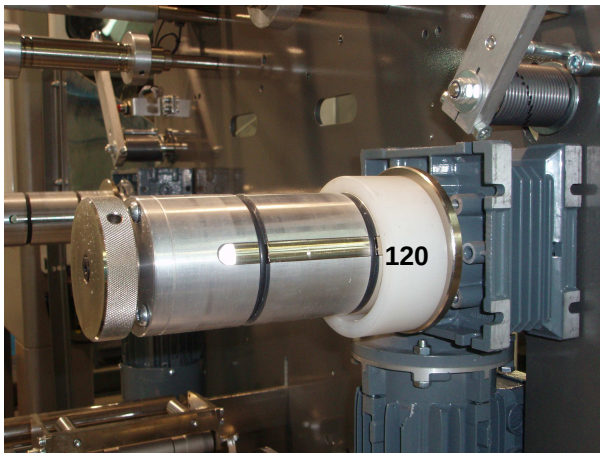


Fig. 13.7

- Place the film guide rings (1), see figure 13.1, in the appropriate position according to the film width. See fig. 13.8

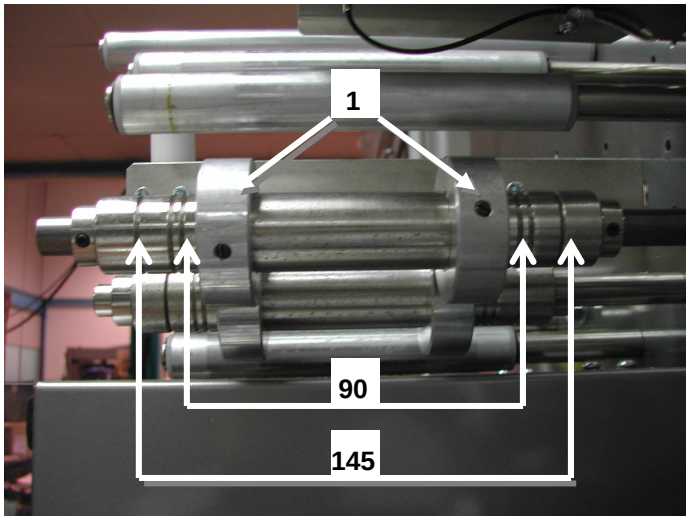


Fig 13.8

- Use a spreader type appropriate for the film width (75 for 75mm film or 90 for 90 mm and 120 mm films). See fig 13.9

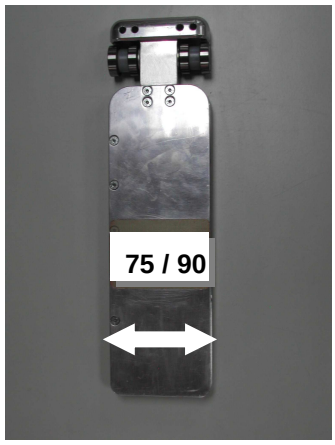


Fig 13.9

- When using a UB60 machine operating in GIRSAC format, the stops that position the mesh folders in the loading station should be set in the position in which the stops are not working.

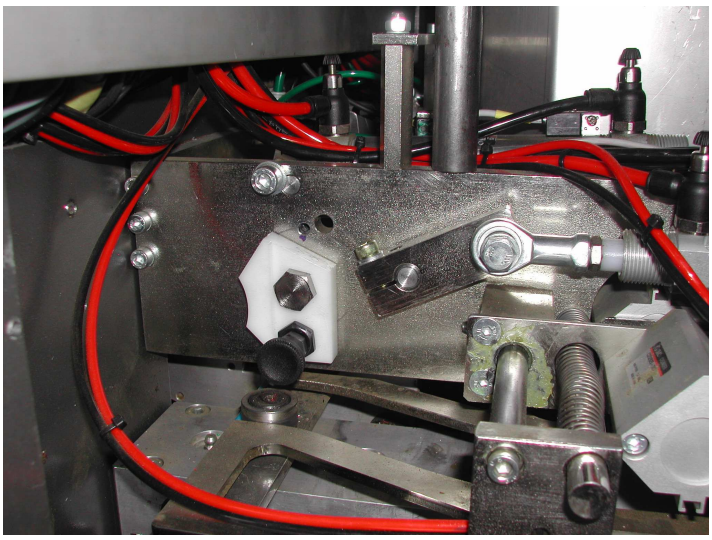


Fig 13.11

16.5.2.- ULTRABAG Format

When making a film width change for a machine prepared to form bags with the ULTRABAG format, make sure to:

- Place the film reel separating rings on the reel holder shaft. Each film width has its own corresponding ring (75, 90, 110, 120 or 145). See Fig 13.7.
- Place the film guide rings (1), see figure 13.2, in the appropriate position according to the film width. See Fig. 13.8
- Adjust the vertical sealers using the knobs located opposite the sealers, according graduated scale. See Fig. 13.12 & 13.13

Fig 13.12

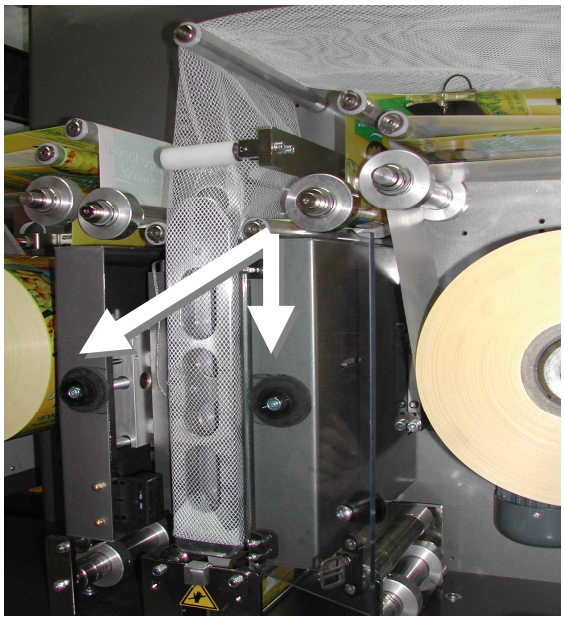


Fig 13.13

- With knitted mesh, place the guide rods in the closed position for 75 and 90 width films and open for 145 and 120 width films. With extruded mesh, place the guide discs in the closed position for 240 mesh and open for 270 mesh.

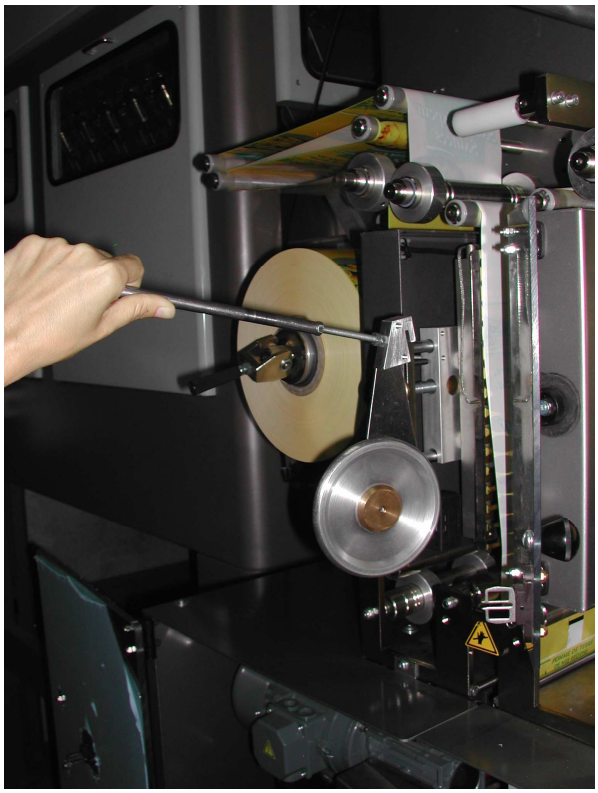


Fig 13.14

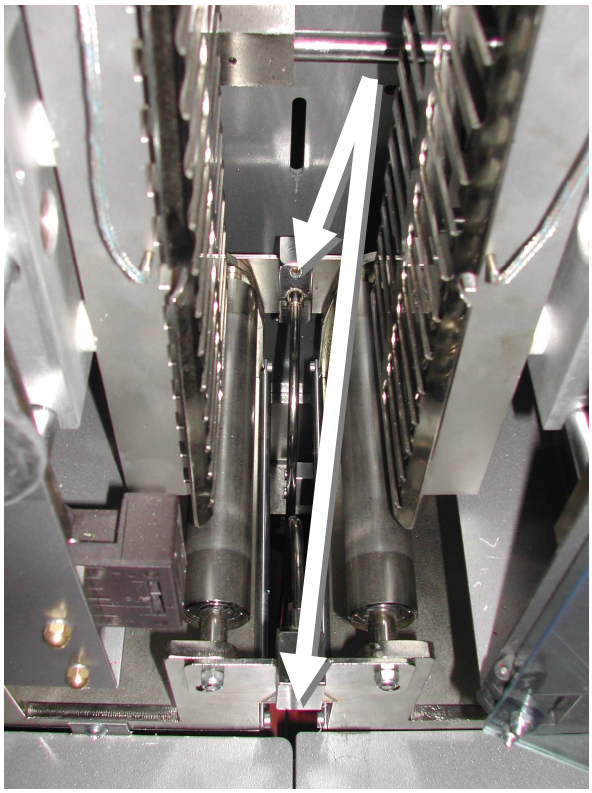


Fig 13.15

- Adjust the buffers that position the mesh folders in the loading station according to the width of the film, using the knob locating on both sides of the loading station. For all the GIRSAC and ULTRABAG formats, using 75 and 90 film the knobs must be set in the lowest position. For ULTRABAG using 120 film should be set in the middle position and on the highest for the 145 film. See fig. 13.11.

17.- LOADING THE MESH

17.1.- General comments about mesh

GIRBAGGER uses reels of tubular mesh, in some cases it is possible to work with bagged mesh.

The measurements of “GIRÓ” recommended mesh are between 40 and 49 cm according to the formation type.

ATTENTION: GIRÓ only guarantees the optimal operation of the GIRBAGGER machine if it is loaded with mesh designed specifically for the machine. Consult GIRÓ about the mesh models that are right for the type of bags needed to be formed in this packager.

When the mesh reel has been used up, the machine stops automatically and displays the “MESH FINISHED” alarm onscreen.

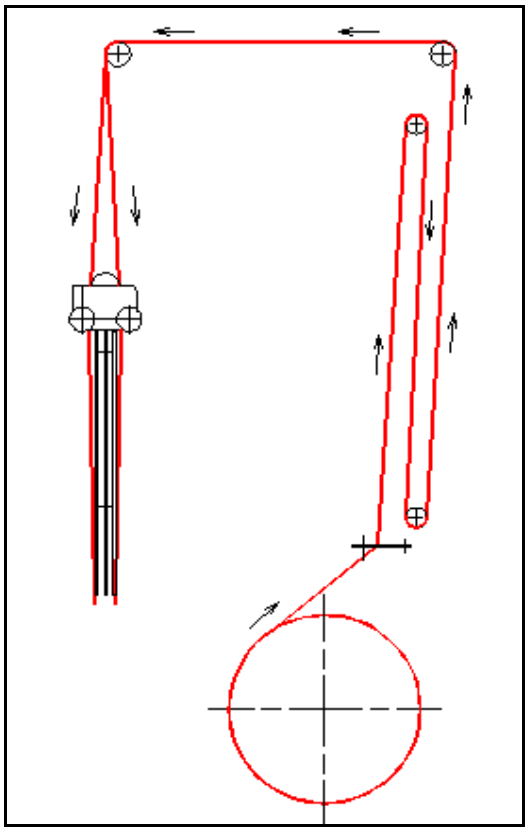
If using sacked mesh, the end of the sack should be knotted in the counterweight of the mesh reserve, so that the end of the mesh can be detected. The direction in which the mesh for GB is fed through is opposite to that of the label.

17.2.- Placing and threading mesh for GIRSAC and ULTRABAG

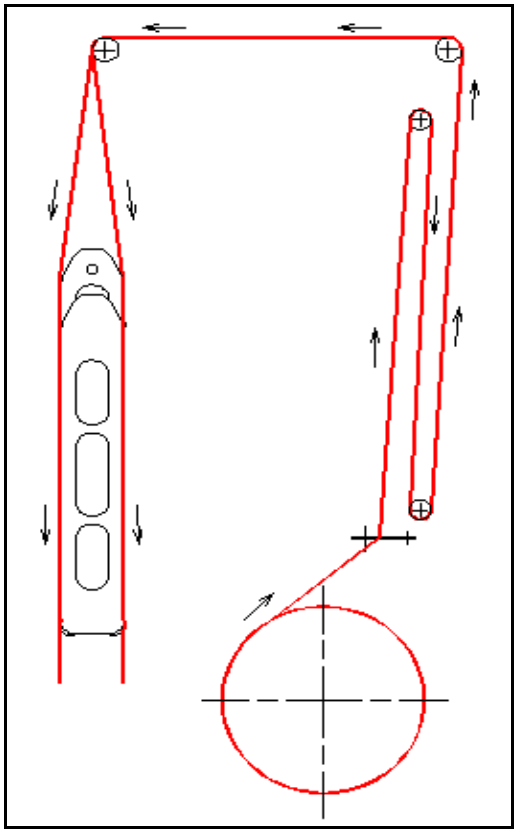
Before placing the mesh, check that both sides of film are loaded and are threaded to at least the cutting station (see section 13.2. for placing and threading film).

Load the mesh reel in such a manner that on its way to the spreader, the mesh comes out of the top of the reel (see Fig. 3.2.) following the route described in the diagram below.

A reel of tubular woven mesh must have a separating ring inserted in the mesh reel holder.



14.1. Threading mesh for GIRSAC bag types



14.2. Threading mesh for ULTRABAG bag types

Steps to follow to make a change for woven mesh:

1. Insert the appropriate spreader for the GIRSAC (75 or 90) or ULTRABAG formats into the mesh and place it into its corresponding housing

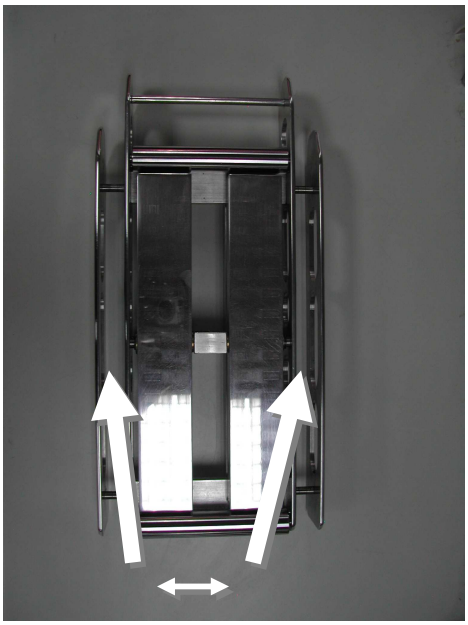


Fig 14.3

2. For the spreader used in GIRSAC machines, fold about 15 cm of the bottom end of the mesh over one side of the spreader.

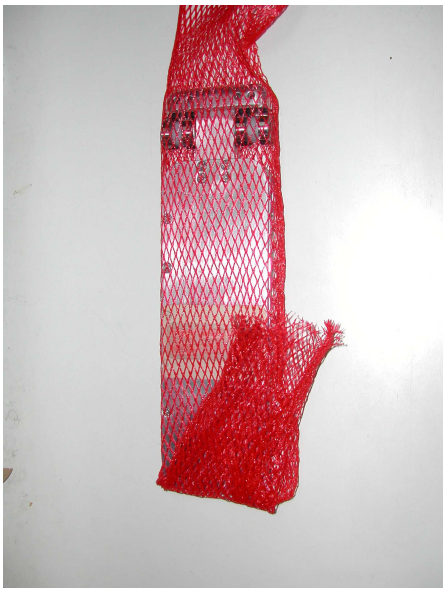
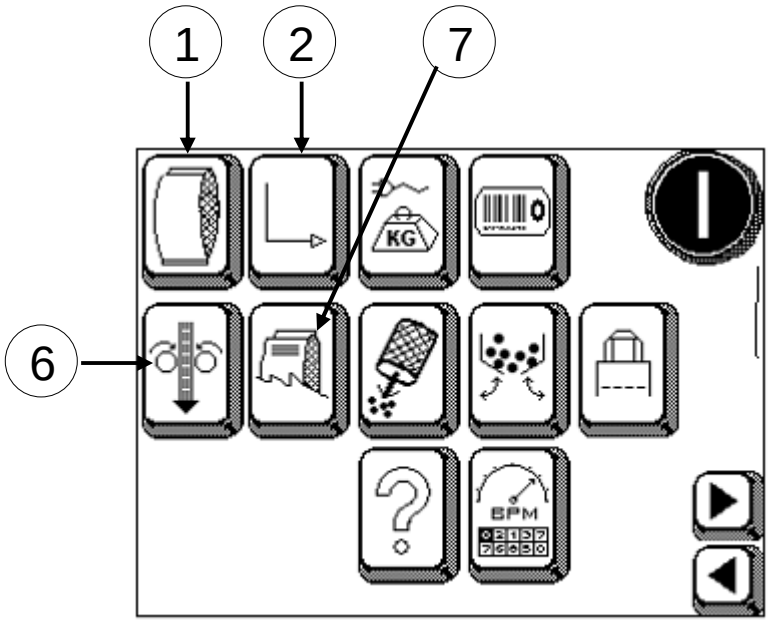


Fig 14.4

3. The ULTRABAG spreader should adjust in width (closed, half-opened and open positions) in accordance with the width of the woven mesh (closed or half-opened position) or 270 mm extruded mesh (open position).See Fig. 14.3

4. Make a pre-seal (or vertical seal in ULTRABAG format) through the “manual operation” screen with the pre-sealing button (7). By doing this, both film sides will be sealed to the mesh, which will allow the whole piece to be guided downward.



5. Press the “Bag driving” button (6) to continue lowering the film-mesh piece, once again activating the pre-sealer and turning the rollers as described, until the mesh passes cleanly through the machine without jamming either in the spreader area or the bag bottom cutting area.

6. Activate the “Bags only” button (1) and press the button to start the cycle. Form a few bags in this way and stop the cycle. Check that the bags have come out correctly made. Make any necessary corrections and adjustments. During this phase, it is advised to have the “automatic cycle” button (2) deactivated, because if the bags are made one by one using the start cycle button, the consequent problems with the consumable products are thus limited (breakage, jamming...)

Remember to deactivate the “Bags only” option to restore the normal operation mode before reinitiating the cycle. Also, make sure that the “Automatic cycle “button is pressed, so that the bags can be made uninterruptedly.

17.3.- Threading mesh for GIRPLUS

Threading the mesh is the same as for the GIRSAC format. With the exception of the 15cm, fold which is replaced by a knot and 10cm tail. See Fig. 14.6.

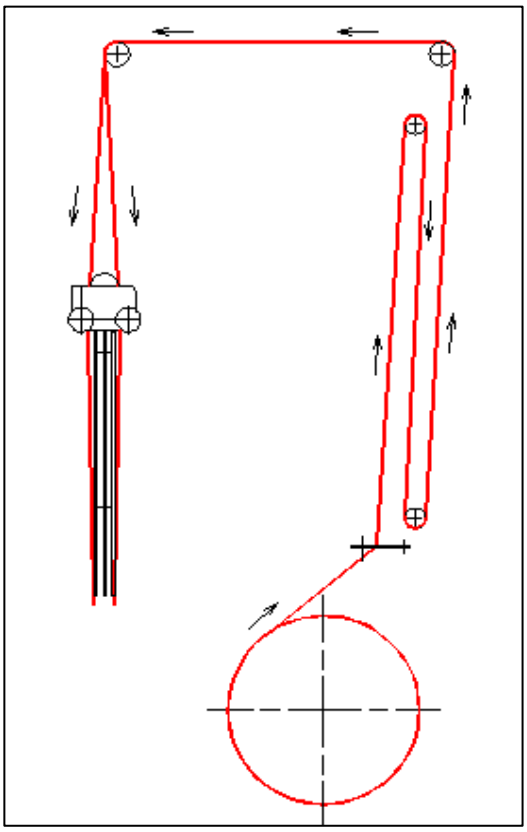


Fig. 14.5

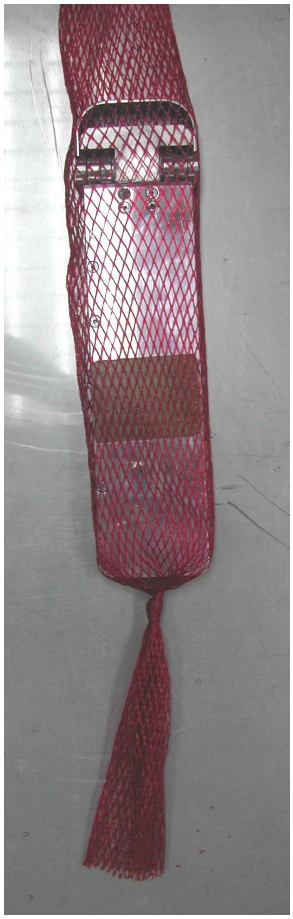


Fig. 14.6

18.- BAG FORMAT CHANGE

In addition to selecting the bag format to make from the “Formation format” screen, there are changes to make on the machine itself in order to change from one bag format to another, which are the following:

18.1.- GIRSAC to ULTRABAG woven mesh Format change

To change from GIRSAC to ULTRABAG format using woven mesh, one must proceed in the following manner:

- Change the GIRSAC spreader for that of ULTRABAG. See Fig. 13.6 and 14.3
- Remember to follow the steps for changing the film width, if necessary
- Add a counterweight to the buffer mesh.

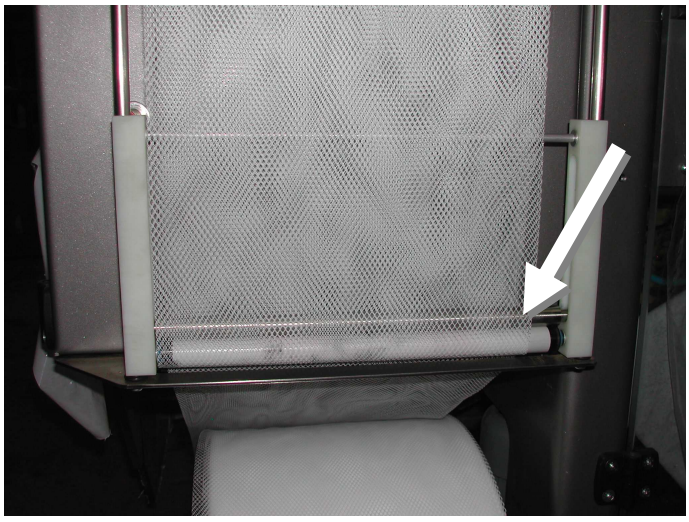


Fig 15.1

- Move back both mesh folders in the bag formation station.

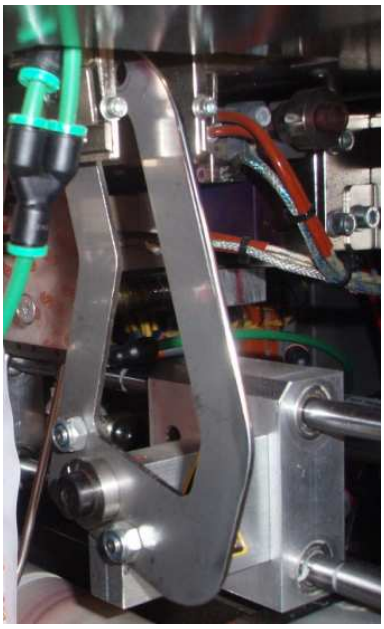


Fig 15.2

- Correctly place the mesh guide rods located below the ULTRABAG spreader. They have two positions, closed and open when using 145 mm film. See Fig. 13.14

Fig 15.3

- Adjust the vertical sealers with the knobs located opposite the sealers so that the seal is made about 10 mm from the edge of the film. See Fig. 13.11 and 13.12

- Adjust the buffers that position the mesh folders in the loading station to the width of the film using the knobs located at the sides of the loading station. See Fig 13.10

18.2.- Format change from ULTRABAG woven mesh to ULTRABAG extruded mesh

To change from woven to extruded mesh in the ULTRABAG format, proceed in the following way:

- Remember to follow the steps for changing the film width, if necessary
- Change lower for higher counterweight in the mesh reserve. See Fig 15.1
- Adjust the width of the spreader to the closed position if the extruded mesh is 240mm and to the open position if the extruded mesh is 270 mm. See Fig 14.3
- Replace the woven mesh guide rods located below the ULTRABAG spreader for extruded mesh guide discs, placing them in the same position. See Fig. 13.13 and 13.14
- Remove the mesh folders in the bag formation station. See Fig. 15.2
- Block the anchoring mechanism on the mesh folders in the loading station.

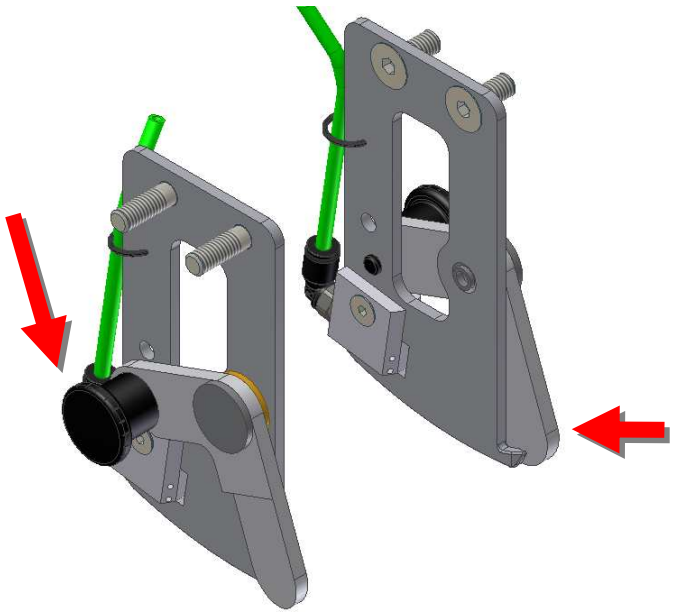


Fig 15.5

- Adjust the buffers that position the mesh folders in the loading station to the 75 mm position for any film width. See fig 13.10

18.3.- Changing to GIRPLUS format

- In the GIRPLUS format, always use the 90mm torpedo.
- Remember to follow the steps for changing the film width if necessary.
- Add the counterweight to the buffer mesh.
- Do not make any changes to the folders.
- Place the automatic folders in the location of the torpedo (see Fig. 15.2**)**.
- Make sure the loading station folding buffers are not working (knob down).

19.- LOADING THE HANDLE

19.1.- General comments on handles

The GIRBAGGER A models can create bags with a handle.

The handle used is a tubular type, which is to say a continual tube of plastic that later is laminated and wound on a reel.

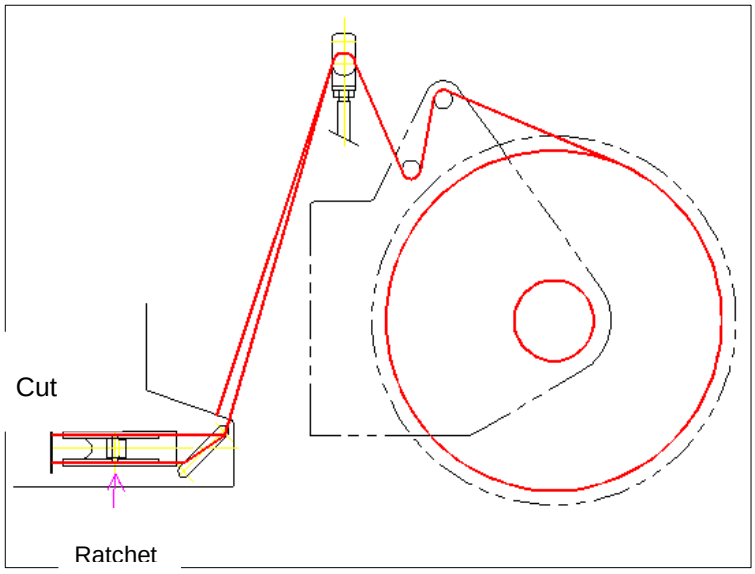
Bags with tubular handle have better resistance and are more comfortable to carry than conventional flat handles.

ATTENTION: GIRÓ only guarantees the optimal operation of the GIRBAGGER machine if it is loaded with handle types designed specifically for the machine. Consult GIRÓ about the handle models that are right for the type of bags needed to be formed in this packager.

When the handle reel has been used up, the machine stops automatically and displays the “HANDLE FINISHED” alarm onscreen.

19.2.- Placing and threading the handle reel

Place the reel on its reel holder. A correct orientation is one that supplies the handle with the reel spinning in the outgoing direction of the reel shown in the figure. Continue along the route drawn in the figure by manually feeding the handle and threading the machine through the opening in the chassis until reaching the retention area (lifting the catch hook) and ending just at the cutting area



15.1. Threading the handle band

20.- LOADING THE LABELS

GIRBAGGER can incorporate a GirPrint E-200 labeller that can print self-adhesive thermal labels from a roll of up to 4000 labels and adhere them to the left film once the bag is formed.

For the best printing quality and printer head durability, it is recommended to exclusively use labels supplied by GIRÓ.

For more information, consult the labeller information.

21.- SIGNIFICANT DEFECTS FROM IMPROPER ADJUSTMENTS OF THE MACHINE

Bags can leave the machine in poor quality due to either the improper placement of consumable products in the machine or the formation parameters having incorrect values. In following, some of the defects are linked to their probable causes:

21.1.- Vertical film overlap on bag bottom

The film reels must be on their reel holders in the position appropriate for each film width, using the corresponding ring, and the guide rings used in threading the film along its circuit through the rollers (shown in section 13) must be placed in their correct position according to the film width used.

An improper placement of these rings causes a vertical overlap on the bag bottom.

21.2.- Film overlap and/or header stretch marks

Whenever there is an overlap on the header, the problem will be from one of the following areas:

- The use of the film guide in the bag transport clamp from loading station to sealer header station is incorrect.
- The height of the bag exit belt is wrong.
- The loading time is too short which causes excessive vibration in the wands as they act as if there is a blockage in the product.
- The bag length is too short for the caliber / quantity of the packaging process.
- In ULTRABAG format, the buffers that position the mesh folders in the loading station are incorrectly placed.

In most of these cases, stretch marks can also appear.

21.3.- Blockage on the wands

Depending on the product caliber, a long wand holding time provokes blockage on top of the wands.

21.4.- Product falls out of the bag

If the mesh is not pre-sealed on the film, the product can fall out of the bag in the E2 loading station. The cause can be that the pre-sealing temperature / time are too low, or the mesh has rolled over the spreader in the shape of a corkscrew.

21.5.- Badly inserted handles

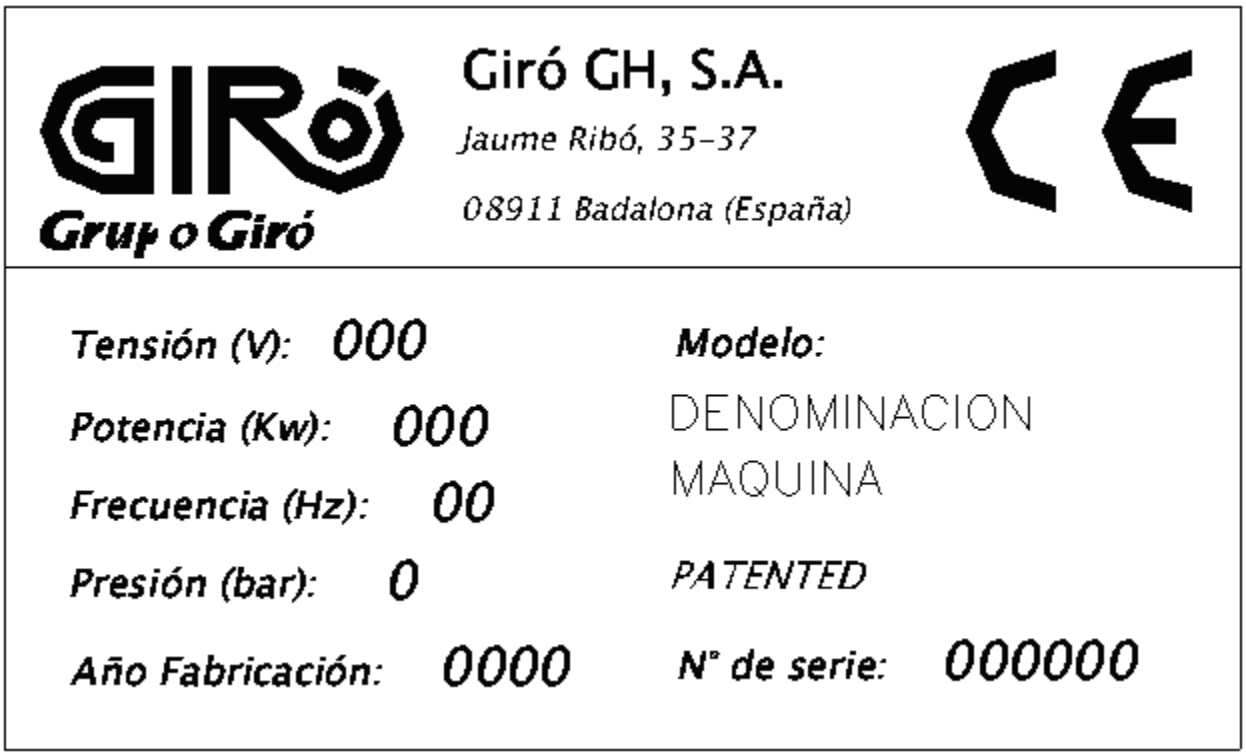
The placement of the handle reel in the direction opposite of what was indicated in section 15 can cause the handle to not be inserted properly in the bag.

21.6.- Defective sealers

Check that the temperatures used in the production run correspond to the film material being used. Also, ensure that the sealers are clean, without any build up or residues of plastic or any other foreign bodies. If the problem persists, advise Technical Services.

22.- CHARACTERISTICS PLATE

The indications noted on the identification plate are the same on every GIRBAGGER, varying only by the order number for each machine. The plates include the date of manufacture, power, voltage, and the “CE” mark.



USA machines also incorporate a special plate: