

# INSTRUCTION MANUAL

Bagging Machine type AM322-2/ AM422-2



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**Attention!** By " not approved " models, every weighing has to be checked on a separate weight.

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## 1.0 The use of the machine.

The use of the machine is for filling potatoes, onions, carrots or similar products.

By weighing products that without any further treatment, can be used for foodstuffs. The contact surfaces must be in stainless steel and the belt in white foodstuff quality 2T 24WA.

By weighing granulated products of min. approx. 3 mm, the elevator belt must be with vulcanised flexible sides.

By weighing frozen french-fries, berries etc, the contact surfaces must be in stainless steel and the belt in white foodstuff quality 2T 24WA.

Operation temperature range for the machine:  $-10^{\circ}$  to  $+40^{\circ}$  C.

## 2.0 Installation

It is most important to have a secure and effective support for the four wheels/mounts on a level base, in order to obtain a smooth operation and accurate weighing.

Turn the transport bracket over weighing hopper counter clockwise (fig. 1).

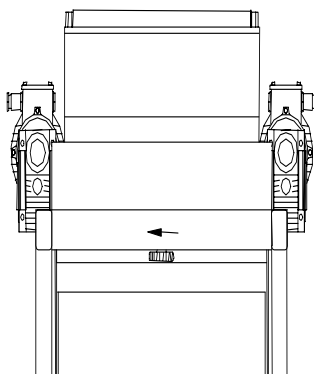


Fig. 1

Connect power supply to the machine by the cable with a connections plug (The machine use 1-phase 240volt). A good ground connection is important.

During transport the machine can be exposed to extreme temperature and therefore it is most important that it is acclimatised before starting, as the electronic components must have room temperature in order to weigh accurate.

Same procedure must be followed, if the machine is moved from another room with extreme temperature.

### 3.0 General

Both machines can be supplied with 25 kg or 50 kg weighing hopper.

Type AM322-2 is for weighing from 2,5 to 25 kg or from 5 to 50 kg.

Type AM422-2 is for weighing from 1 to 25 kg or from 2,5 to 50 kg.

If type AM422-2 is wanted to weigh carrots the machine must be reconfigured only to drive with the wide belt. (See section of configuration).

**As standard** the 25 kg machine is supplied with 1-coned outlet. Extra for 50 kg is 1 outlet covering weighing from 25 to 50 kg.

The bagging machines can be supplied with connections for following optional extras:  
(\* = Connections are optional extras).

- 1 Vibrator for 1 to 5 kg. \*
- 2 Automatic bag holder for 10 to 50 kg.
- 3 Compressor for automatic bag holder. \*  
(Read: Jun-Air compressor, directions for use, and spare parts).
- 4 Conveyor for transport of weighed quantity.
- 5 Stitcher.
- 6 Net closer.
- 7 Printer. (Interface module is required in computer).
- 8 Controlling of related machines by extra in- and outlets at terminal in relay box.  
(Programme according to desired specifications).

The machines are supplied with power up zero setting. This means, that when you depress "on", the machine will always start from zero independent of accumulation of soil in weighing hopper.

By start after change in amount of weighing the machine can be inaccurate. This will automatically be adjusted after a few weightings by means of an automatic correction factor for after run.

The motorised opening- and closing functions of weighing hopper are according to chosen programme controlled either fully automatically, or by means of touching capacitive sensor on flexible cord.

To keep the warranty, any repair must only be carried out by authorised personal.

### 3.1 Pictogram

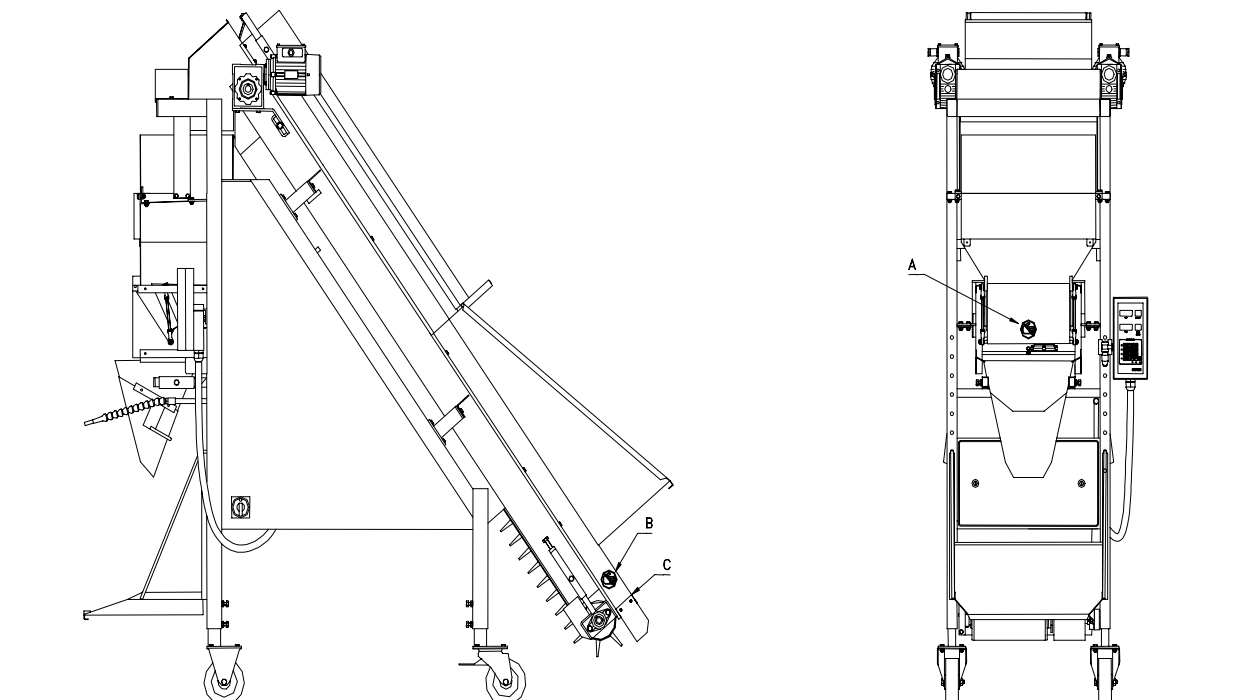


Fig. 2



A, B, C

- A) The motorised opening- and closing functions of the weighing hopper. Keep distance.
- B, C) Moving parts on the elevator. Keep distance.

## 4.0 Operation

- 1 Connect power supply to the machine by the cable with a connections plug (The machine use 1-phase 240volt). (fig. 2). Indication light for "off" on keyboard is on.
- 2 Depress "on". Indication light for "off" is off, indication light for "stand by" is on and the light in the four display is on. The machine is now in "stand by" position and ready for programming.
- 3 Depress "no". Indication light is on. Set desired number of weightings. When the set numbers of weightings are obtained the weighing stops automatically and the machine returns to "stand by". If the same number of weightings is desired again, depress "go". If a continuous number of weightings is desired, set 0000.
- 4 Depress "kg". Indication light is on. Set the desired number of kg.
- 5 Depress "progr". Indication light is on.  
Set the desired programme from 01 to 08:
  - 01 Weighing - activate sensor: emptying
  - 02 Weighing - auto emptying
  - 03 Weighing - activate sensor: emptying - vibrator starts
  - 04 Weighing - auto emptying - vibrator starts
  - 05 Weighing - activate sensor first time: bag on  
activate sensor second time: emptying  
activate sensor third time: bag off
  - 06 Weighing - activate sensor first time: bag on - auto emptying  
activate sensor second time: bag off
  - 07 Weighing - activate sensor first time: bag on  
activate sensor second time: emptying - bag off auto
  - 08 Weighing - activate sensor: bag on - auto emptying - bag off auto
- 6 Depress "sec". Indication light is on. Set number of seconds conveyor is desired to drive. If bagging machine is not supplied with conveyor, set 00.
- 7 Depress "stand by". Indication light is on.
- 8 The machines are supplied with a frequency inverter to control the speed of the belts.  
For the AM322-2 the high speed can be adjusted on the potentiometer on the top (use 80% as a starting position) For the AM322-2 the low speed can be adjusted on the potentiometer at the bottom (use 40% as a starting position).  
For a AM422-2 there are 2 potentiometers for the main belt and 2 for the dosing belt. Adjust like on AM322-2. Adjust to the best results according to your own compromise.
- 9 Depress "go". Indication light is on. The machine is now running according to preset data.
- 10 Empty the machine by detecting the sensor on the flexible arm. The machine empties now according to the "prog" you choose.

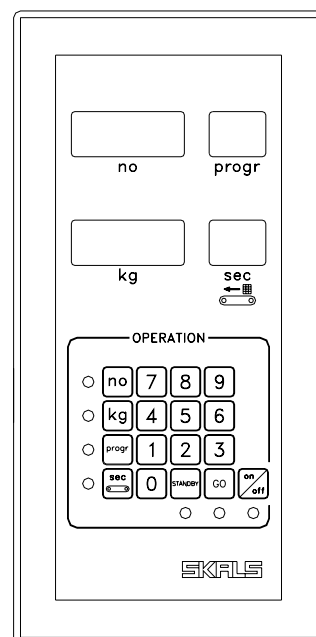


Fig. 3

If in example 100 bags of each 50 kg must be weighed on a bagging machine with 25 kg weighing hopper, following data must be set:

- 1 Depress "no" and set 100.
- 2 Depress "no" again and set 02 (part-portion).

- 3 Depress "kg" and set 25.00.
- 4 Depress "stand by".
- 5 Depress "go".

Part-portions can be pre-set from 01 to 99. Return to normal programme by setting 01 under point 2.  
 Note: In order to obtain high capacity, the first part-portion is inaccurate. The last part-portion will compensate for this.

## 4.1 Optimise the weighing-results by adjustable parameters

No.	Default value	Parameter
1	(0.01)	Select-set. (1-2-3)
2	(0.00)	Unit-no. (0-31) 0 -> No printer connected. 1-31 -> Unit-no. for printing.
3	(0.40)	Step-time in sec. for AM422-2
4	(0.64)	Pause-time in sec. between steps for AM422-2
5	(0.08)	Step-time in sec. for AM322-2
6	(1.20)	Pause-time in sec. between steps for AM322-2
7	(0.20)	Time-delay for cap. sensor (Emptying/start).
15	(0.24)	Time open by configuration 0040 + 0041 – big products.
16	(1.24)	Time delay by configuration 0040 + 0041 – big products.
17-18		Not used.
19	(0.00)	0-1 (1 = Test print on).

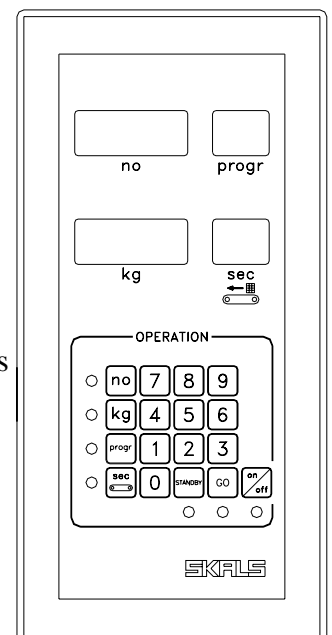
It is possible to choose 3 different set up.

Weight	Set1	Set2	Set3	Parameter
AM422-2	20 (4.00)	30 (3.00)	40 (4.50)	Main belt: fast-slow
AM422-2	21 (2.00)	31 (1.50)	41 (2.50)	Main belt: slow-stop
AM422-2	22 (1.00)	32 (0.50)	42 (1.50)	Doc.belt : fast-slow
AM322-2	23 (2.00)	33 (1.50)	43 (2.50)	Main belt: fast-slow
AM...	24 (1.90)	34 (1.70)	44 (2.00)	Stop time part portions
	25-29	35-39	45-49	Not used

(...) = Factory default values.

### Change the set-up value:

- 1 Depress "off".
- 2 Depress "no" and keep it in.
- 3 Depress "on".
- 4 Release "no" after 10 sec. and the set-up-mode is displayed.
- 5 Again depress "no" - Then depress the wanted set-up number - depress "stand by".  
(Instead of depress "no" use "kg" as an up-arrow or "progr" as a down-arrow).
- 6 Depress "sec" and the wanted set-up-number value can be changed, (displayed in "kg"-display) depress "stand by". The new value is flashing in "kg" display and stored in memory.



- 7 Depress "stand by" for returning to weighing-mode.

Return to factory-default value in set-up-mode:

Select set-up-no = 99

Select set-up-value = 9999

Depress "stand by" and 99 is flashing in "progr"-display.

## 4.2 Printing

(Interface module in computer is optional extras).

- 1 Depress "stand by".
- 2 Depress "3"  
(33 in "no" display)
- 3 Depress "3" and the machine will start printing.  
(88 will be seen in "no" display, which is code for cancelling data). In "stand by" code 88 can be called by depressing 8.
- 4 Depress "8" for cancelling.  
By depressing any other button, data will be stored in memory.

By data overload of memory, 3388 will be seen in "no" display. Then depress "3" for printing and "8" for cancelling.

## 4.3 Adjustment of vibrating time

(vibrator is optional extra)

The vibrator has a preset vibrating time for 0,00-1,50 kg on 2,00 sec, for 1,51-3,50 kg on 3,00 sec and for 3,51-5,00 kg on 4,52 sec.

The preset times can be changed by following settings:

- 1 Set desired number of kg.
- 2 Set program 3 or 4.
- 3 Again depress "progr" and the preset time can be read in "kg" display.
- 4 Set desired time.

Above adjustments can be done in all three weighing ranges. (Frequency 4/100 sec).



## 4.4 Codes of error

The electronics is designed to read out different codes of error indicated by the last two numbers in "no" display. Is indication light in "stand by" flashing simultaneously, reset by depressing "stand by".

- 1 Fault in software (internal fault in programme): Depress "off" and hereafter "on". If fault is still not relieved, contact factory or supplier and state code of error.
  
- 11 Fault in electronics (loss of data):  
Perform resetting in "no", "kg", "progr" and "sec". In case of repeatedly loss of data, contact factory or supplier and state code of error.
  
- 21-28 Mechanical faults.
  
- 21 No signal indicating weighing hopper is closed. Possible faults:  
Object stuck in outlet.  
Thermo relay e4 in relay box interrupted.  
Sensor at motor out of adjustment or defective.
  
- 22 Scale do not return to 0 at emptying. Possible faults:  
Objects blocked in weighing hopper or between weighing hopper and frame.
  
- 23 (Not approved model). Auto Tara-range is over 13 kg positive. The machine will not continue when this fault is present. Possible fault:  
Weighing cell can have changed load value.
  
- 23 (Approved model). Auto Tara-range is over 1.1 kg. Possible fault:  
Weighing cell can have changed load value.
  
- 24 (Not approved model). Zero setting-range is over 13 kg negative. Possible fault:  
Turn the transport bracket over weighing hopper counter clockwise.  
Weighing cell can have changed load value.
  
- 24 (Approved model). Zero setting-range is over 1.1 kg negative. Possible fault:  
A blocking between weighing hopper and frame.
  
- 25 Weighing hopper not empty after previous weighing. Empty weighing hopper by activating sensor.
  
- 27 (Approved model). Initial zero-range is over 5,5 kg positive. The machine will not continue when this fault is present. Possible fault:  
A blocking between belt and weighing hopper.  
Weighing cell can have changed load value.
  
- 28 (Approved model). Initial zero-range is over 5,5 kg negative. The machine will not continue when this fault present. Possible fault:  
A blocking between weighing hopper and frame.  
Turn the transport bracket over weighing hopper counter clockwise.  
Weighing cell can have changed load value.

31-34 Setting faults.

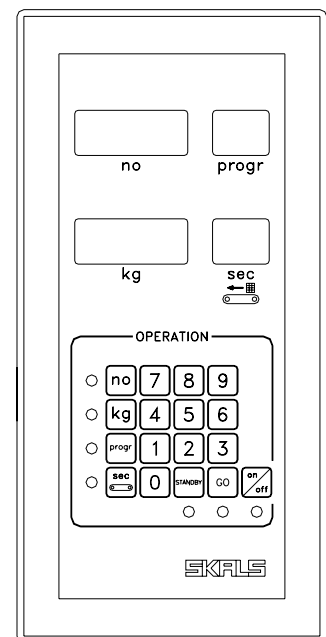
- 31 (Not approved model). The fault is present when adjusting the accuracy of the weight, if the calibration value is too low. Use min. 10 kg.
- 32 The preset configuration number does not exist
- 33 (Not approved model). Calibration is not possible, because the difference between the preset data and the weight is too much
- 34 The preset amount of kg exceeds the maximum allowed 55.00 kg.
- 51 After-run correction outside spectrum. This fault will correct itself, if you simply allow the belt to run
- 80 Set-up-Checksum is bad (During power up).
- 81 Illegal Set-up-No.
- 82 Illegal Set-up-Value.
- 91 Configuration missing.

## 4.5 Configuration

As the electronic control box is designed for different machines, a certain code is present in "no" display to fit the current machine.

If the purpose of the machine must be changed or if the electronic control box is replaced with a box having the wrong configuration, a reconfiguration is required:

- 1 Depress "progr" and keep it in.
- 2 Depress "on".
- 3 Release "progr" after 10 sec. and the last set configuration code is shown in "no" display.
- 4 If new configuration code is wanted this is set directly.
- 5 Depress "stand by" and the machine return to normal operation.



## 4.6 Configuration codes

- 0008 Bagging machine with weighing hopper and two belts (type AM422-2).
- 0040 Bagging machine with weighing hopper and two belts (type AM422-2) - Big products.
- 0009 Bagging machine with weighing hopper and one belt (type AM322-2).
- 0041 Bagging machine with weighing hopper and one belt (type AM322-2) - Big products.

**By changing the configurations code always end with depressing key 1 for 10 seconds during a new start-up – 99 will flash in “progr” display and the value are stored.**

## 4.7 Calibration of

**Not approved model\_** (Adjustment of weighing accuracy).

- 1 Depress "on".
- 2 Depress 9.
- 3 Place 10 kg weight in weighing hopper.
- 4 Depress 10.00.
- 5 Depress "standby".
- 6 Remove weight in weighing hopper.
- 7 Depress "standby" again.
- 8 Place 10 kg weight in weighing hopper again and check kg-display is showing 10.00.

### **Approved model**

(Adjustment of weighing accuracy).

- 1 Open front of computer.
- 2 Set dill switch no. 1 and 2 in position "on" = test position
- 3 Depress "on".
- 4 Depress "go".
- 5 Adjust value in "kg" display to 0.00 on potentiometer in mountings block behind computer.
- 6 Place 40 kg weight in weighing hopper.
- 7 Adjust value in "kg" display to 40.00 on potentiometer R40 in computer. (Gain)
- 8 Remove weight in weighing hopper.
- 9 If the value in "kg" display does not show 0.00. Repeat from 5 to 8.
- 10 Depress "off".
- 11 Set dill switch no. 1 and 2 in position "of" = normal position
- 12 Close front of computer.

**After the recalibration is carried out, the machine must be verified by authorised personnel.**

## 4.8 E-Prom

(program base)

The built-in E-Prom can be replaced. This can be done, if the purpose of the machine must be changed, or if a later updated E-Prom is desired. The E-Prom is numbered and the number can be read in "kg" display:

- 1 Depress "on".
- 2 Depress 1.

## 4.9 Service programme

- 99 Depress "progr". Indication light is on. Set 99.

Depress "stand by"

Depress "go"

This programme shows the direct outlet signal from weighing amplifier in "kg" display.

Depress "stand by" for return to normal operation.

## 5.0 Connections for optional extras

### 1 VIBRATOR

Vibrator must be placed on the mounting brackets.  
Connect plug to S9. ( Connections are optional extras )

### 2 AUTOMATIC BAGHOLDER

Bag holder must be placed on mounting brackets.  
Connect plug to S10.

Connect compressed air to quick coupling. (Min 4-6 atm). The bag holder has a built-in water separator and pressure gauge.

### 3 COMPRESSOR

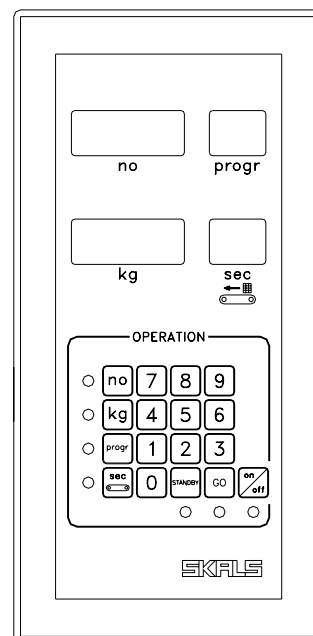
Mount compressor on brackets under belt and connect plug to S11.  
( Brackets and connections are optional extras ).

### 4 CONVEYOR FOR TRANSPORT OF WEIGHED QUANTITY

Connect plug to S2 for power supply and to S6 for pilot currency: terminal 8 and 9.  
( Connection S2 is optional extras ).

### 5 STITCHER

Connect plug to S2 for power supply and to S6 for pilot currency: terminal 8 and 9.  
( Connection S2 is optional extras ). Adjust the value in "sec" to 1 second and when the machines empty it send a signal to the Stitcher.



Connect a closing-signal from the stitcher to terminal 4 and 5 in S6 (Stitcher ready for a new portion).

6 NETCLOSER

Connect plug to S2 for power supply and to S6 for pilot currency:  
Terminal 4 and 5.  
( Connection S2 is optional extras ).

7 PRINTER

Connect plug to S6: Terminal 1 = grd. 2 = RXD/A. 3 = TXD/B.  
(Terminals in S6: 10 and 11 = 24Vac, 4 = -24Vdc, 7 = +24Vdc).

## 6.0 Electronic control box (computer)

In case of fault in electronic control box this can be replaced by unscrewing the two screws and pull box out of multi plug. Mount replacement box.

Make a new calibration with a following verification.

## 7.0 Lubrication and maintenance

All bearings, worm reduction gear, motors and drum are lubricated for life and require no maintenance.

In case of malfunction in motor or drum they must be dismantled and returned to factory for repair.

The conveyor belt (one or two) must be kept sufficiently tight and drive straight by adjusting tension bolts on elevator.

**The reduction gear for opening- and closing functions of the weighing hopper, the reduction gear for main belt and the reduction gear dosing belt (only type AM422)** are lubricated for life with synthetic grease for drive in the temperature range (-10° C to 40° C).

IP            TELESIA COMPOUND B  
SHELL      TIVELA COMPOUND A

By high pressure cleaning it is most important to cover drum, geared motor, relay box, electronic control box, weighing cell, plugs and if mounted motor on vibrator, pneumatic cylinders on automatic bag holder and compressor.

A careful maintenance and cleaning is extremely important in order to obtain reliability and low maintenance costs.

## 7.1 Cleaning of the machine.

Cleaning of the machine after use with different products must be done according to the **National Requirements**.

With reference to the Danish Plant Directorate's Order No. 965 of 13 December 1993 (p. 6).

- 2.3.3. Seed potato growers with contained propagation must clean and disinfect all sorting and ancillary equipment after each new variety. Disinfecting should be carried out using a product approved by The Danish Institute of Plant and Soil Science.
- 2.3.4. Companies authorized to sort potatoes and who also have the authorization to propagate potatoes, must clean and disinfect sorting machinery etc. which is under the control of The Danish Plant Directorate before the sorting of own propagation is commenced. Disinfecting should be carried out using a product approved by The Danish Institute of Plant and Soil Science.
- 2.3.5 Premises and machinery etc. must be cleaned and disinfected each year before 30 June. Disinfecting must be carried out using a product approved by The Danish Institute of Plant and Soil Science.

In other countries, customers must conform to relevant, local food and hygiene regulations..

## 8.0 Packing/transport instructions.

### No of collies:

The machine is in 1 collie as standard.

### Weight:

AM322 275 kg

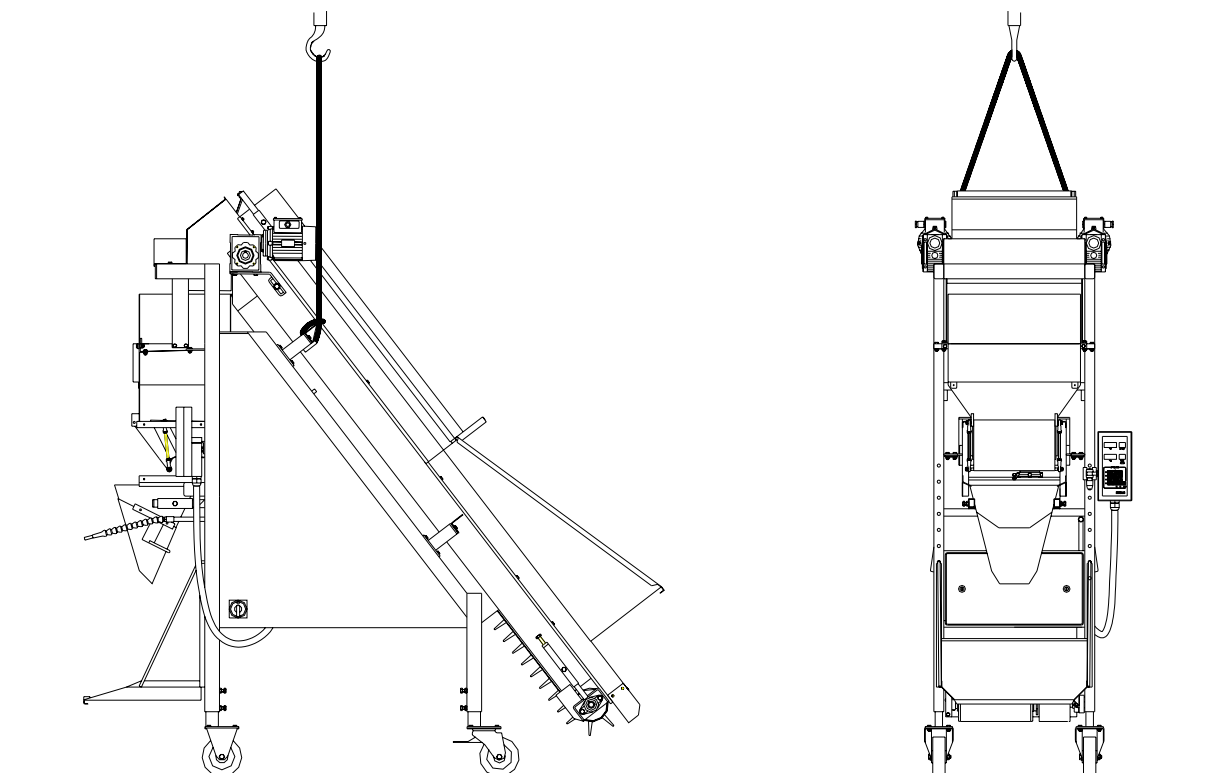
AM422 325 kg

### Dimension:

		<u>Length</u>	<u>Wide</u>	<u>Height</u>
AM322	:	2450 mm,	850 mm,	2300 mm.
AM422	:	2450 mm,	850 mm,	2300 mm.

### Transport/lifting instructions:

By lifting, nylon straps must be used, fitted on to the upper mounting brackets. (See illustration).



## 9.0 Input/output

Connections at the 37 pin SUB-D Plug S5:

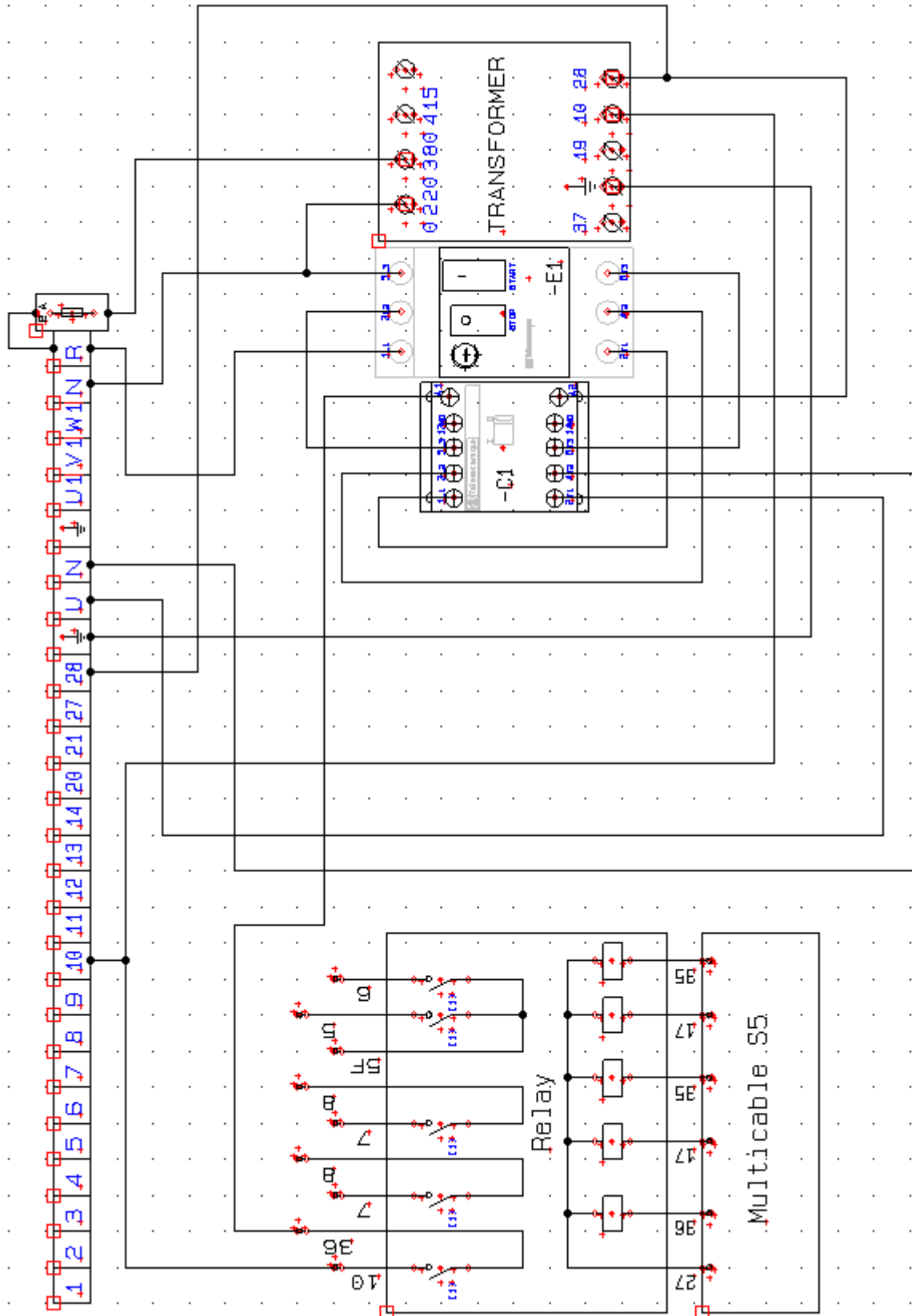
Nr.	Description.
1.	Printer ground.
2.	Printer RX.
3.	Transducer cabel. Red.
4.	Transducer cabel. Green.
5.	Transducer shield.
6.	Out extra 1.
7.	(21.2) -24Vac signal out when weigh hopper empty
8.	Extra.
9.	Ground -24V DC
10.	24Vac. 2.5A
11.	In flow bottom
12.	In flow top.
13.	In Inductive sensor.
14.	In Capacativesensor.
15.	Fast outlet 1.
16.	Fast outlet 2.
17.	Out main belt Fast.
18.	Out vibrator.
19.	14Vac.
20.	Printer TXD or B.
21.	Transducer cabel white.
22.	Transducer cabel blue.
23.	Transducer cabel black.
24.	Transducer cabel grey.
25.	Out flow start/stop.
26.	Ground 14-0-14Vac.
27.	+24Vdc.
28.	24Vac.
29.	Conveyor. (Timer).
30.	Optocobler in 7(extra).
31.	Optocobler in 8(extra).
32.	Out solenoid valve. Open close for automatic bag holder.
33.	Out dosing belt slow.
34.	Out dosing belt fast.
35.	Out main belt slow.
36.	Out outlet.
37.	14Vac



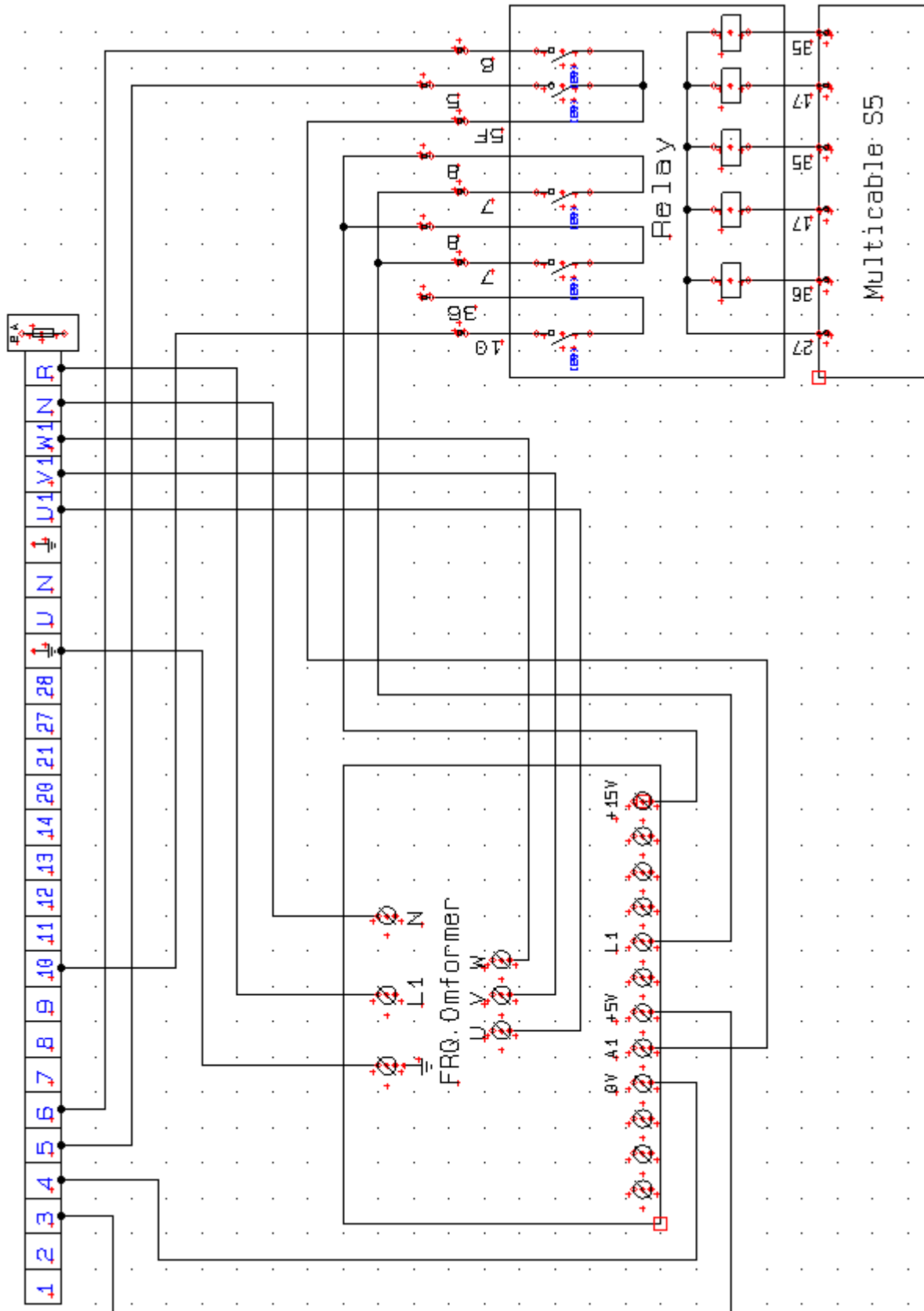
Controller cable 30x0,5mm

<b>S4 37 Pol Cabel</b>		<b>Cabel Nr.</b>
1	To	1
2	To	2
7	To	21.1
9	To	9
10	To	10
11	To	11
12	To	12
13	To	13
14	To	14
15	To	15
16	To	16
17	To	17
18	To	18
19	To	19
20	To	20
25	To	25
26	To	PE.Grnd
27	To	27
28	To	28
29	To	29
32	To	8
33	To	3
34	To	4
35	To	5
36	To	6
37	To	7

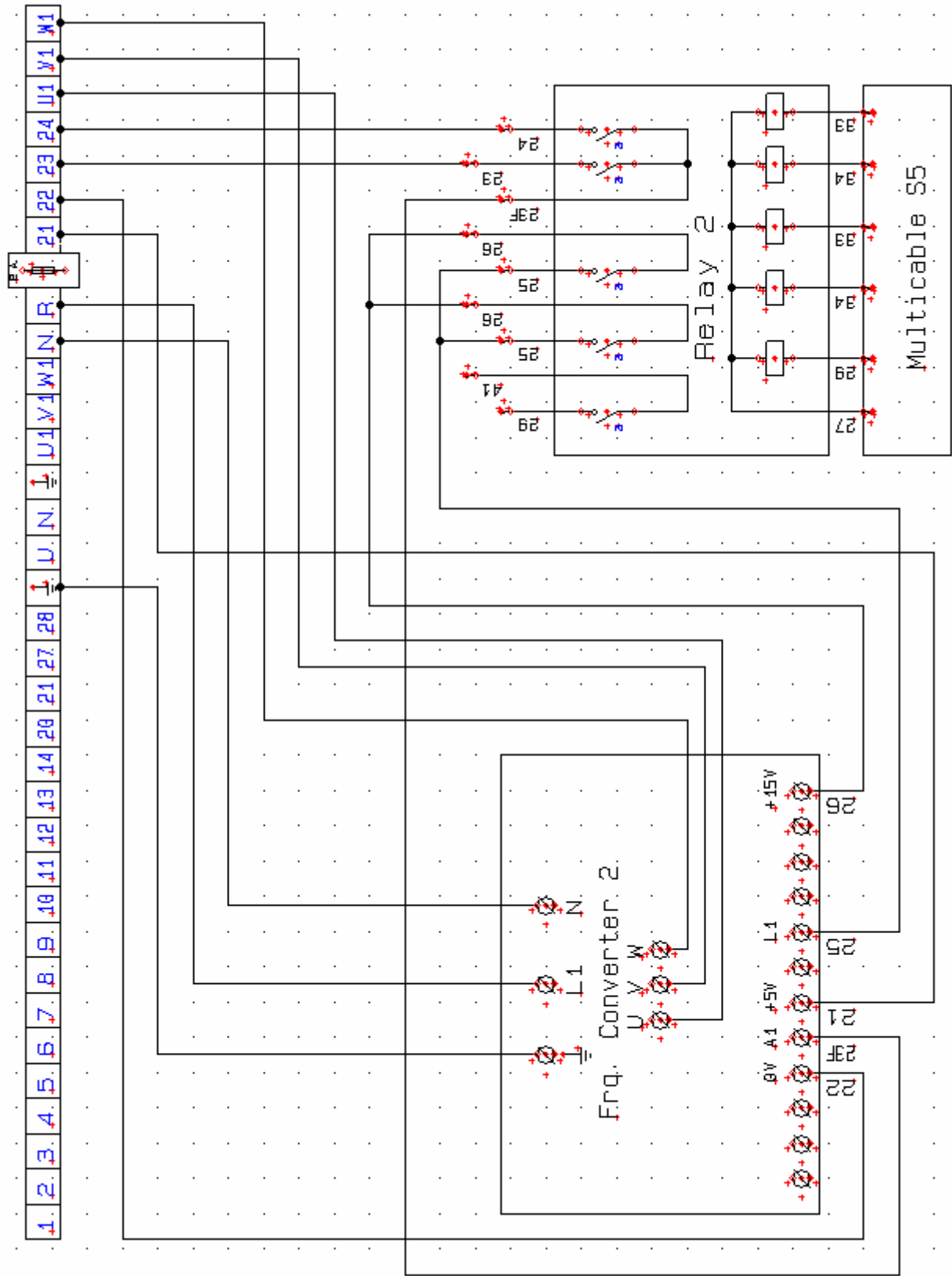
## 10.0 Eletrical charts AM322 & AM 422



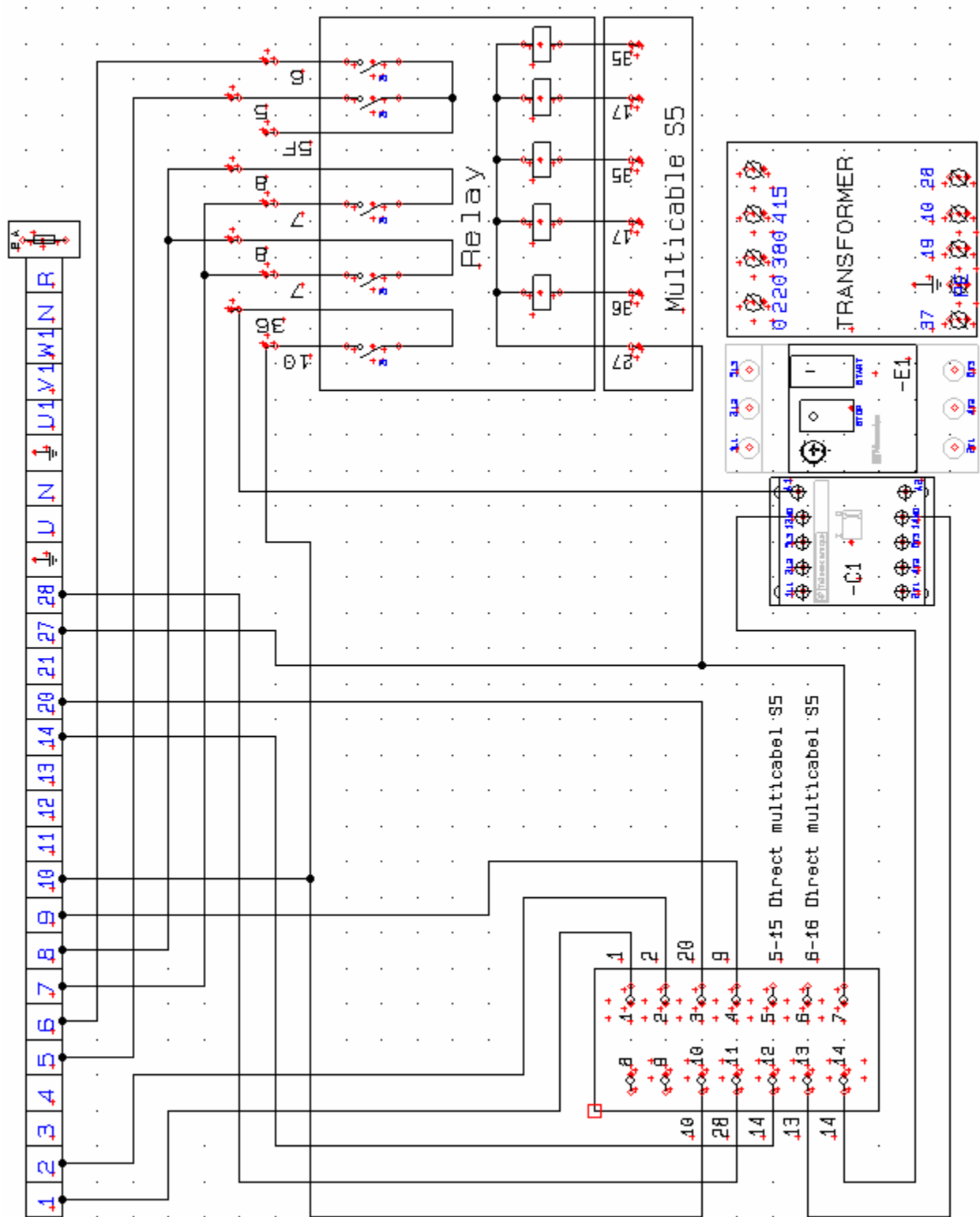
# AM322 & AM 422



# Frequency converter AM422

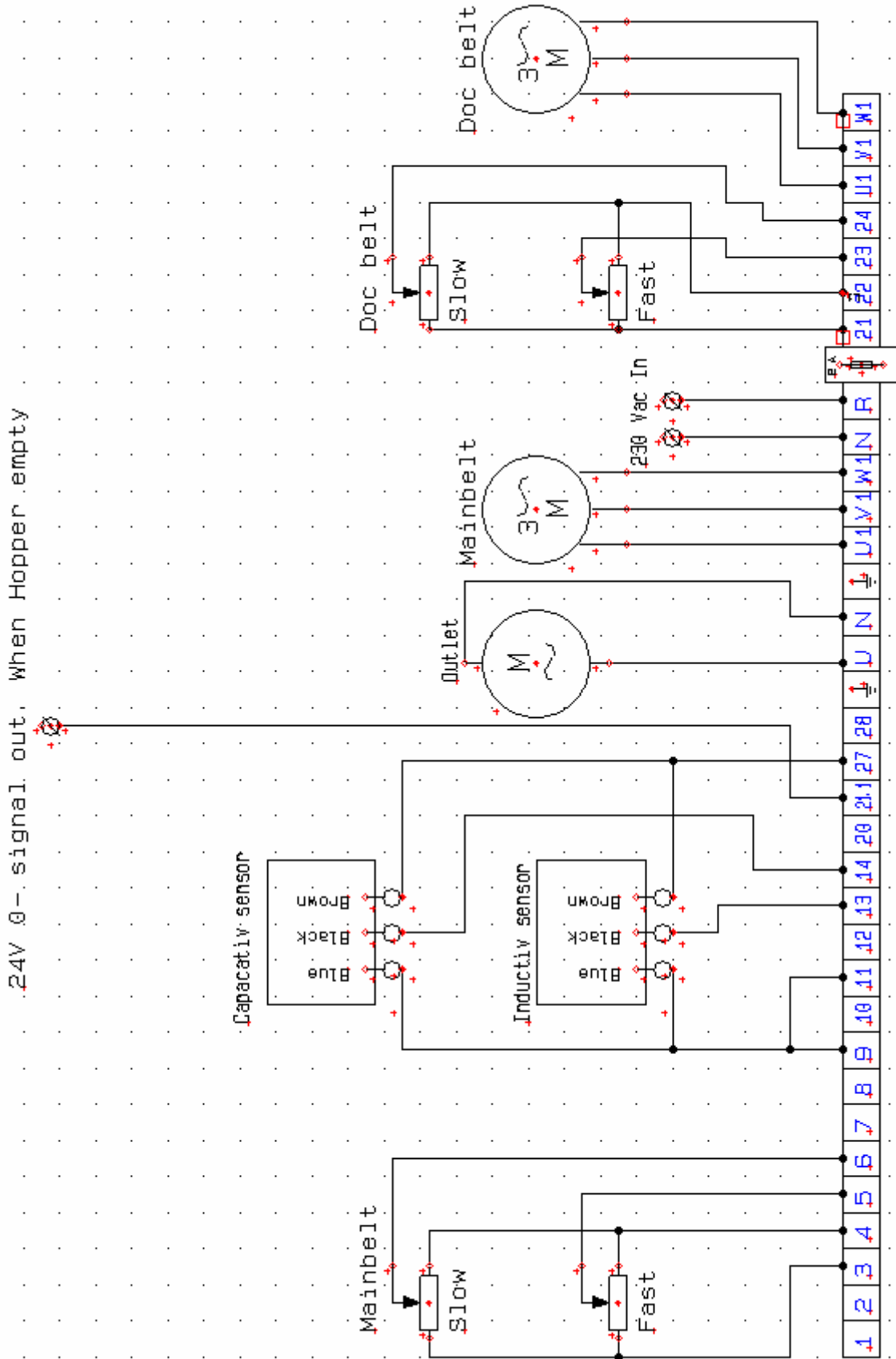


# Transformer AM422

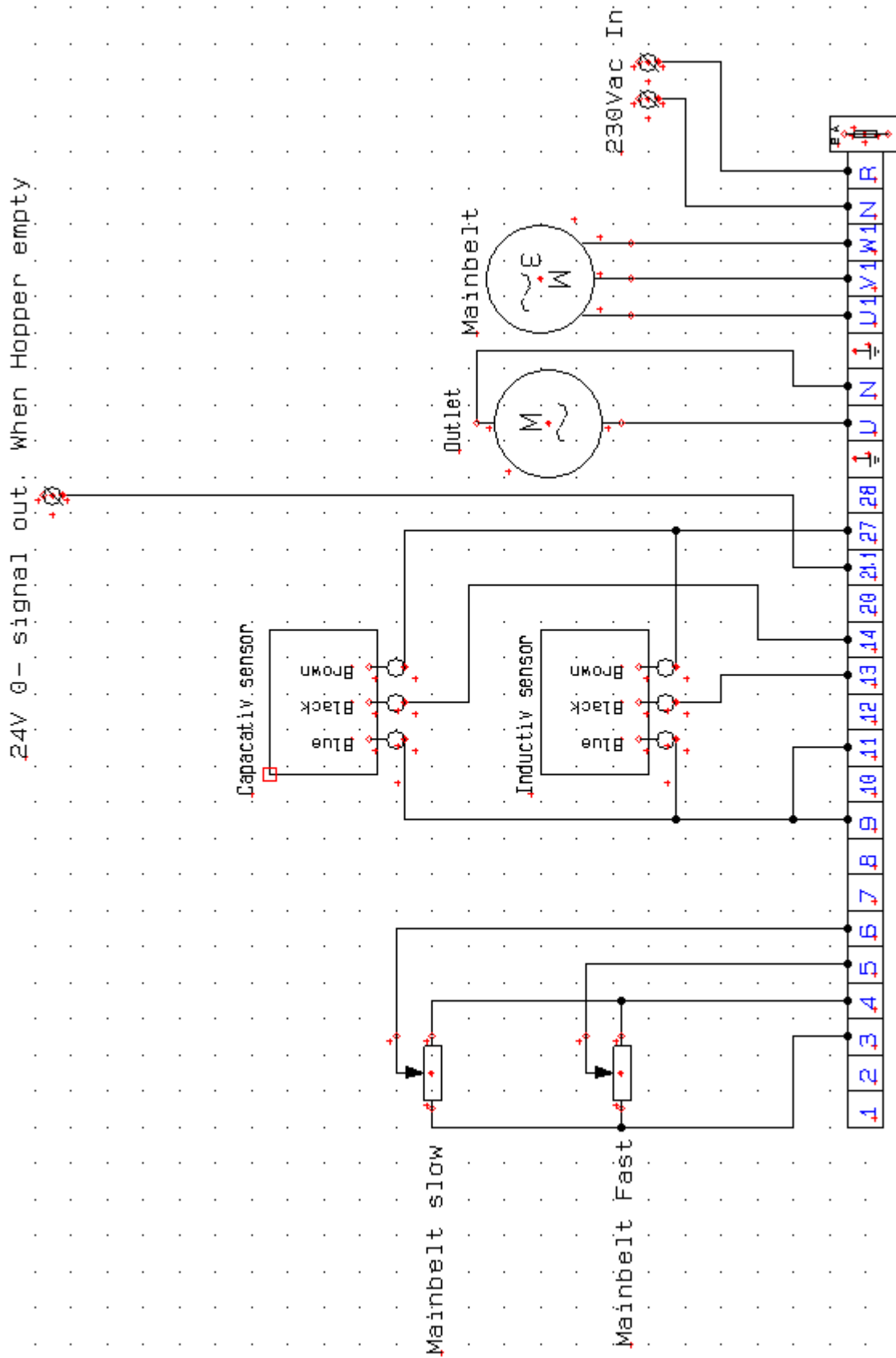




# Conveyer drive AM 422



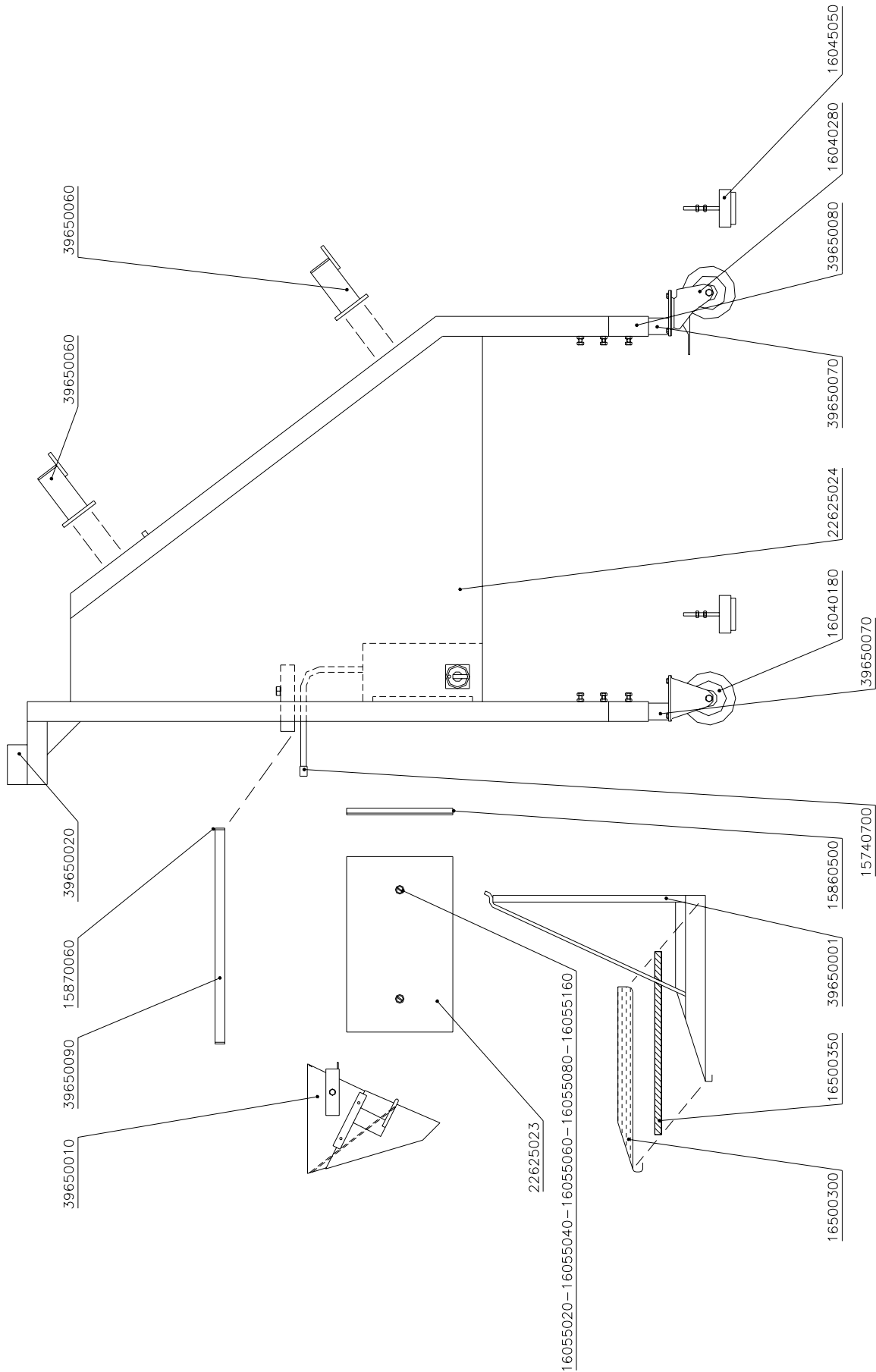
# Conveyer drive AM 322



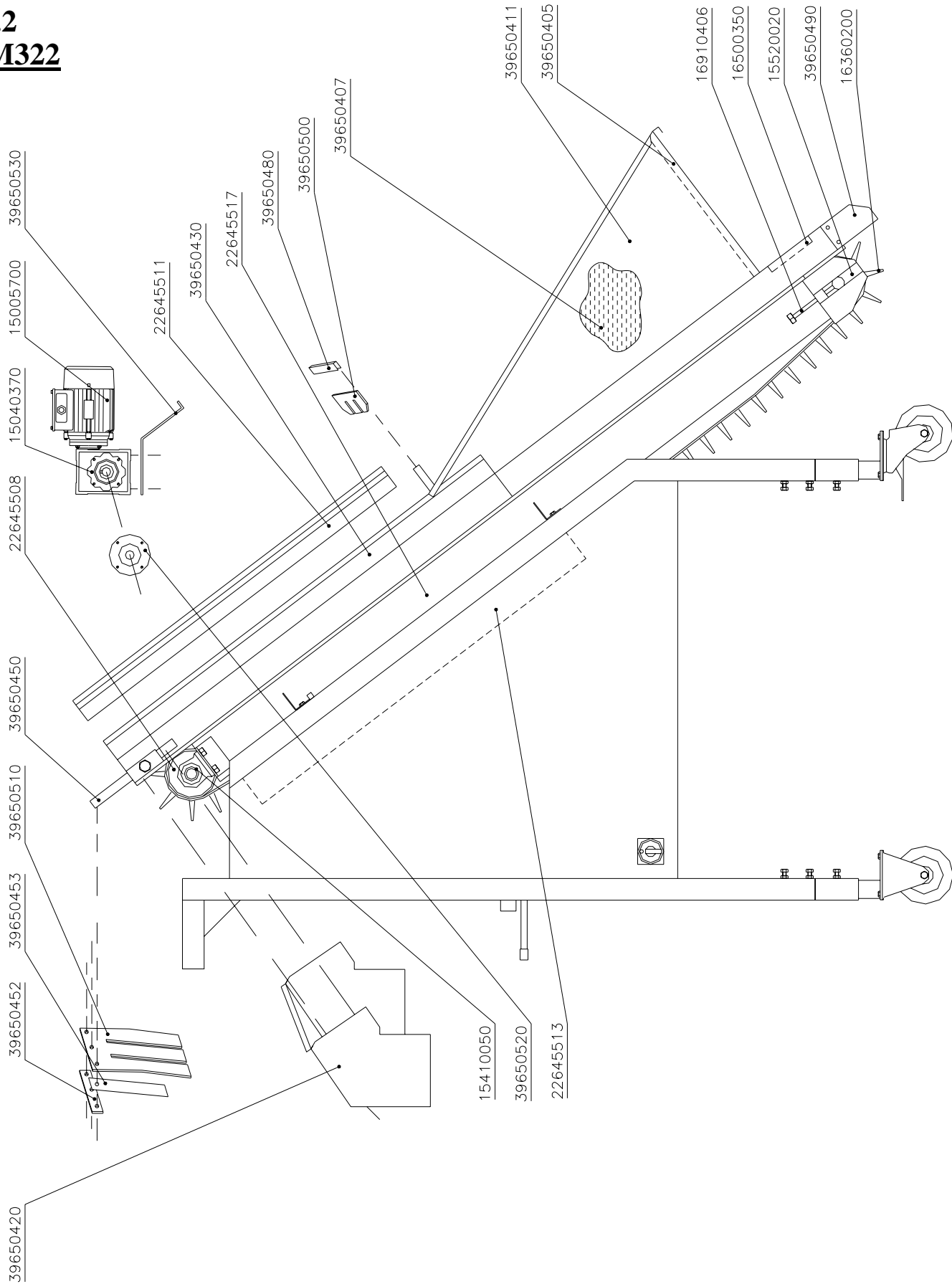


### 11.1 Spare parts

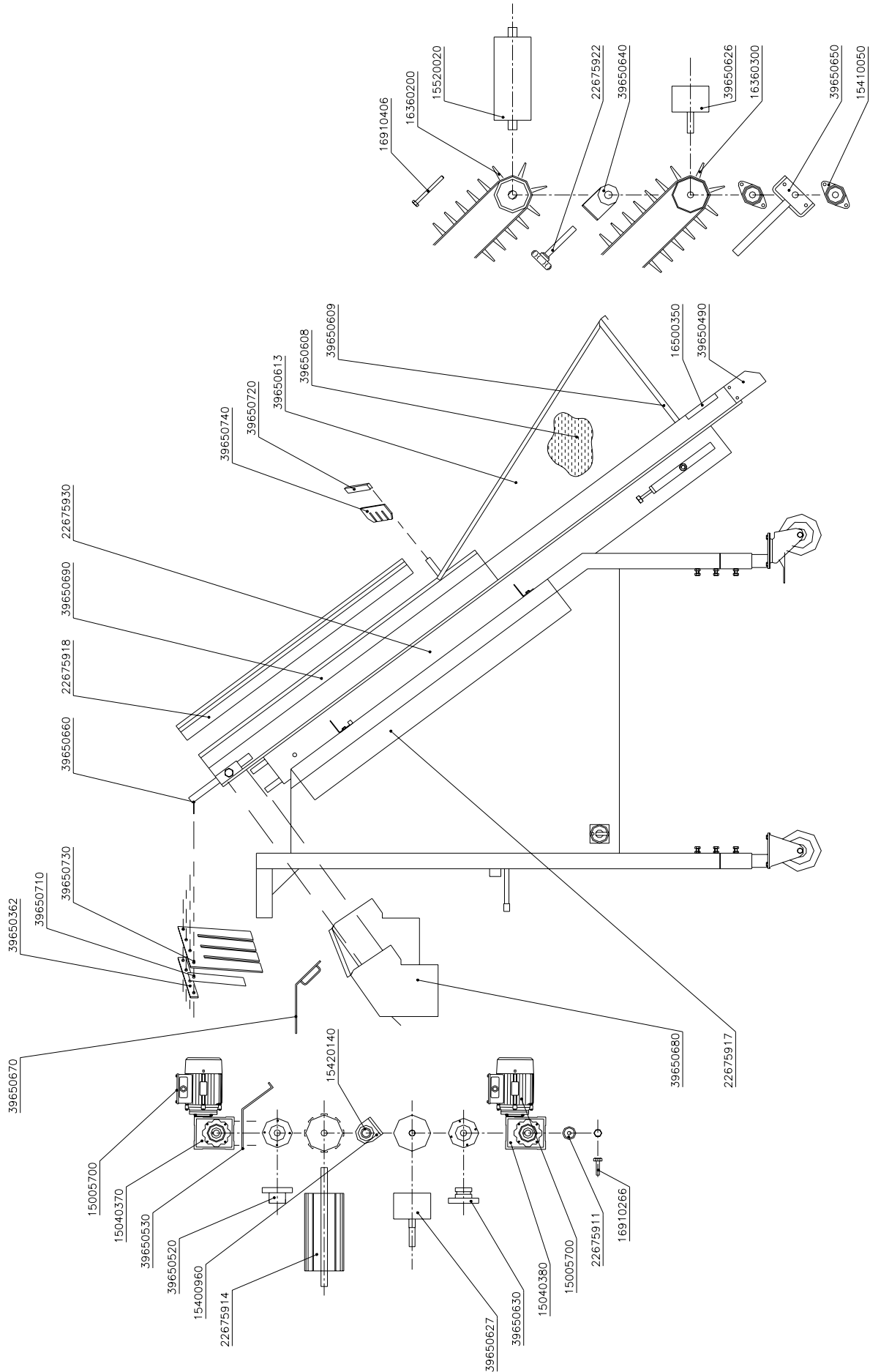
When ordering spares state machine type, serial no. and, if possible, position no.



**11.2**  
**AM322**

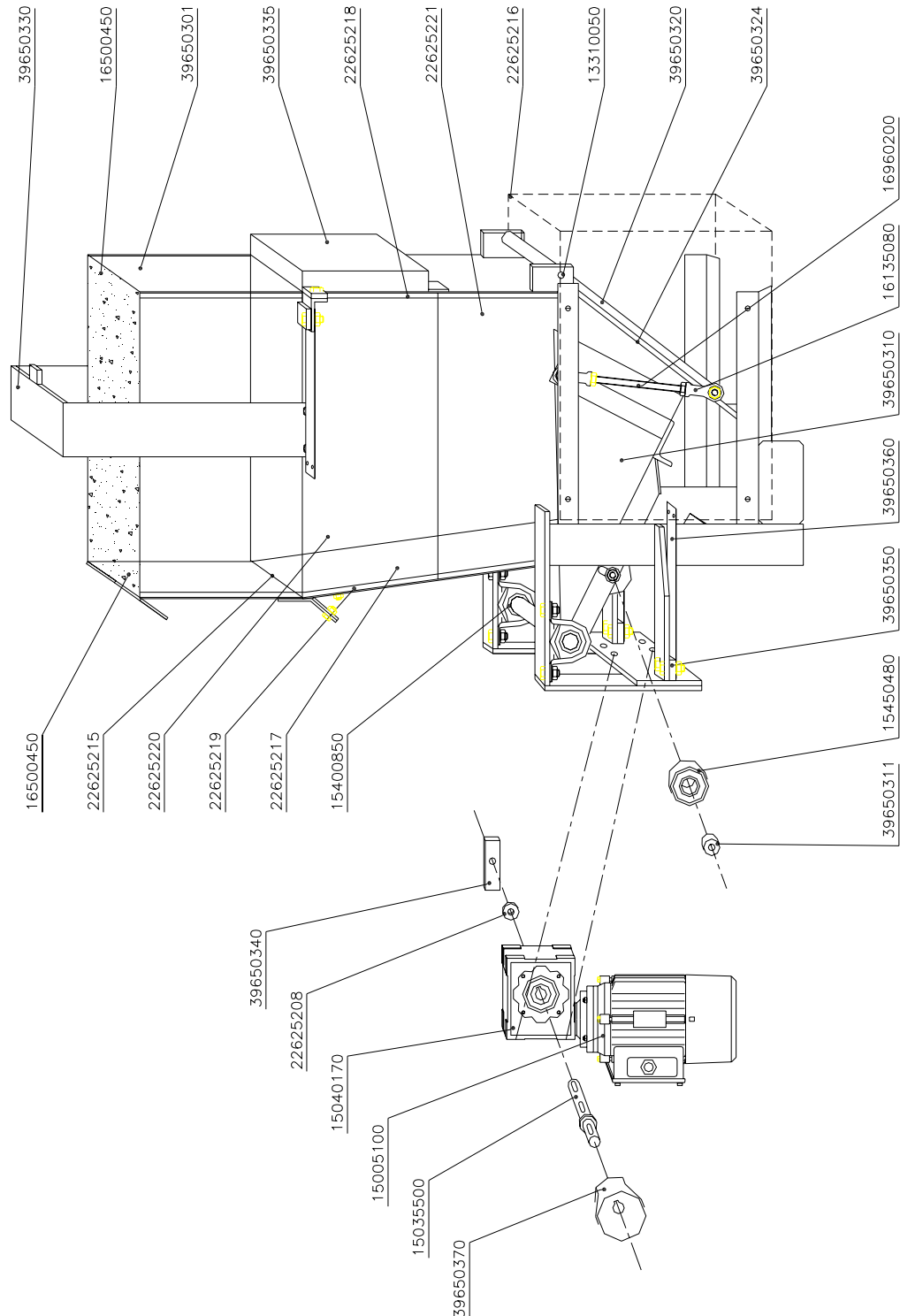


### 11.3 AM422



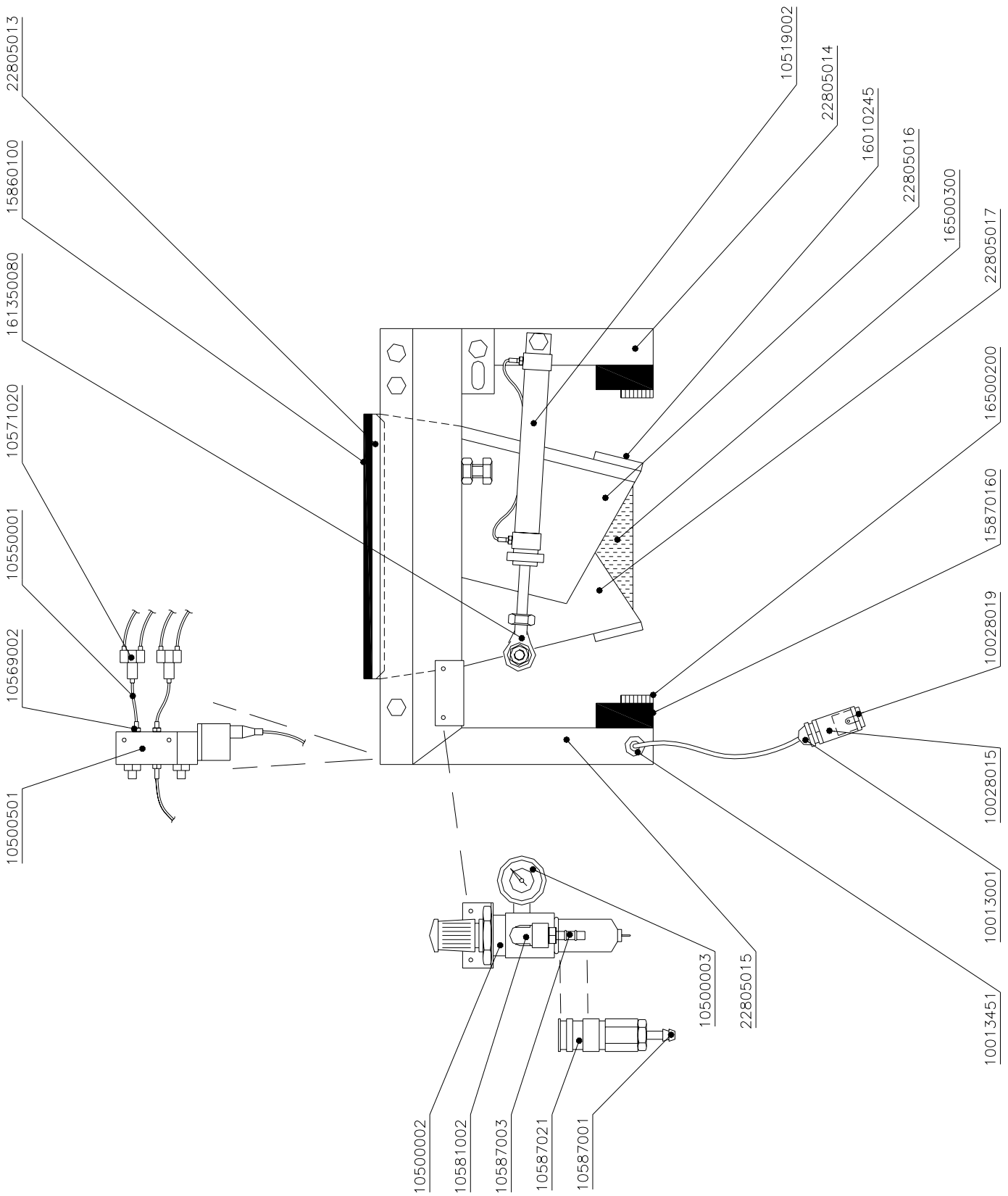
# 11.4

## AM322 & AM422

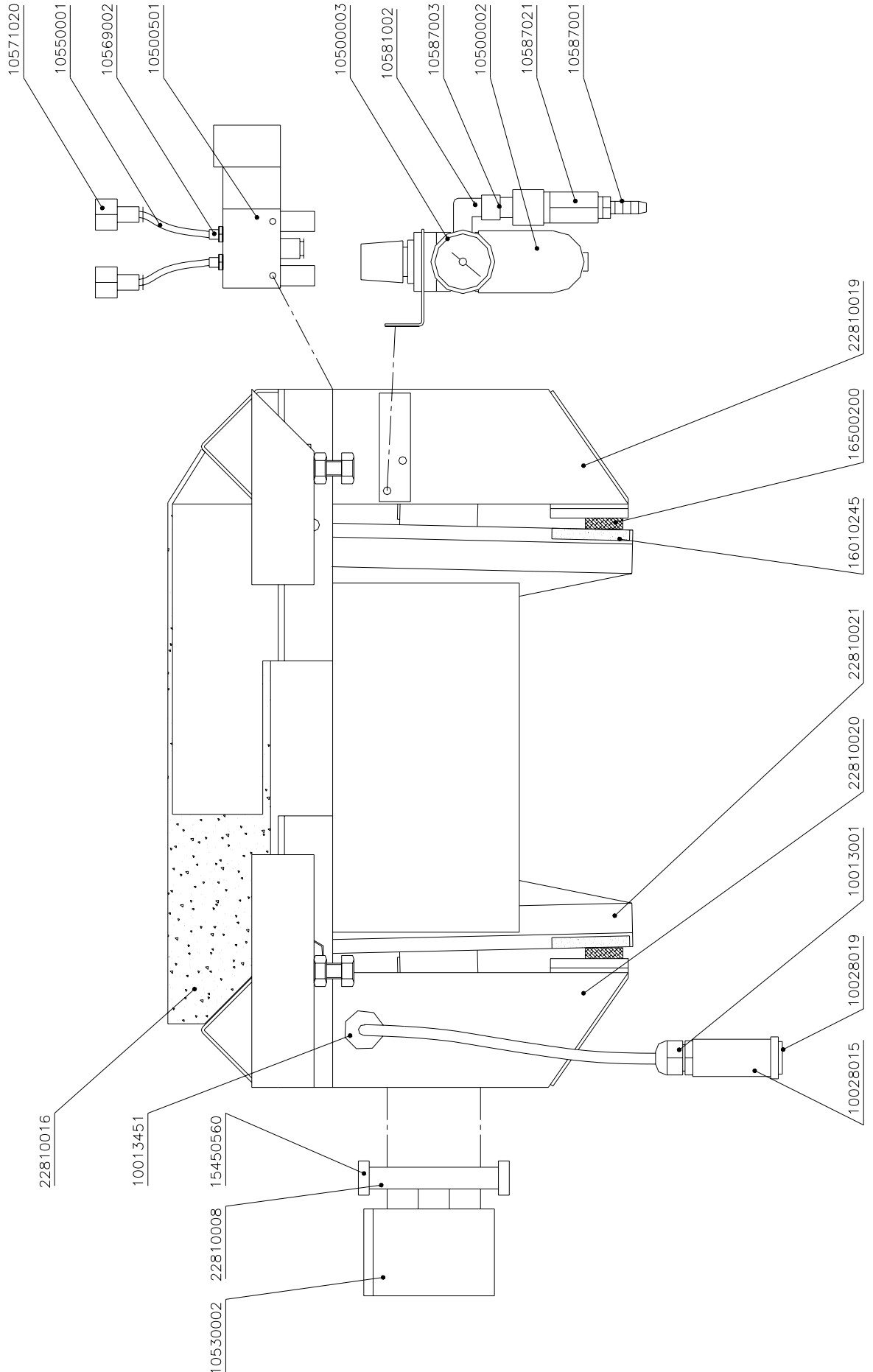


# 11.5

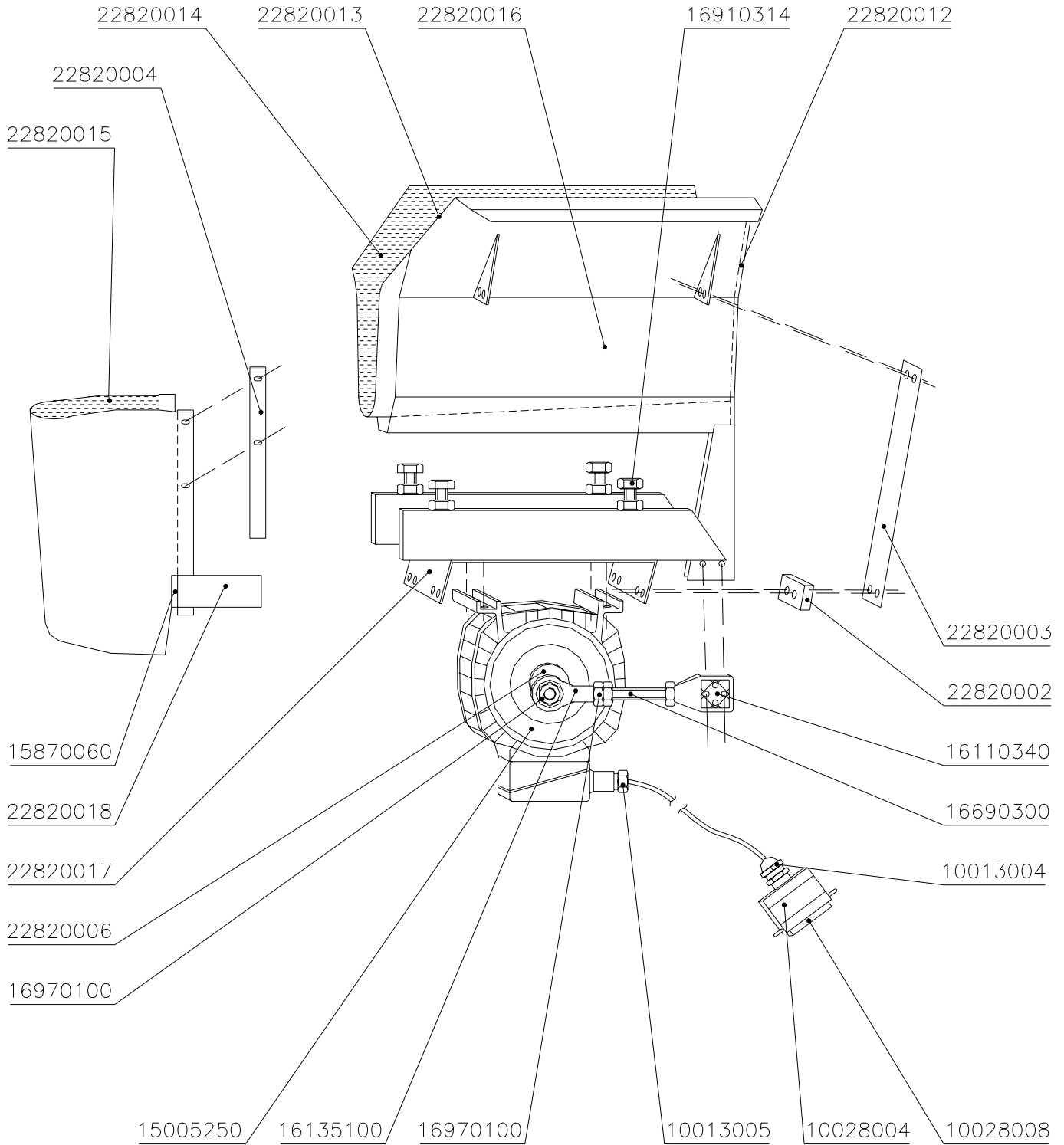
## AM322 & AM422



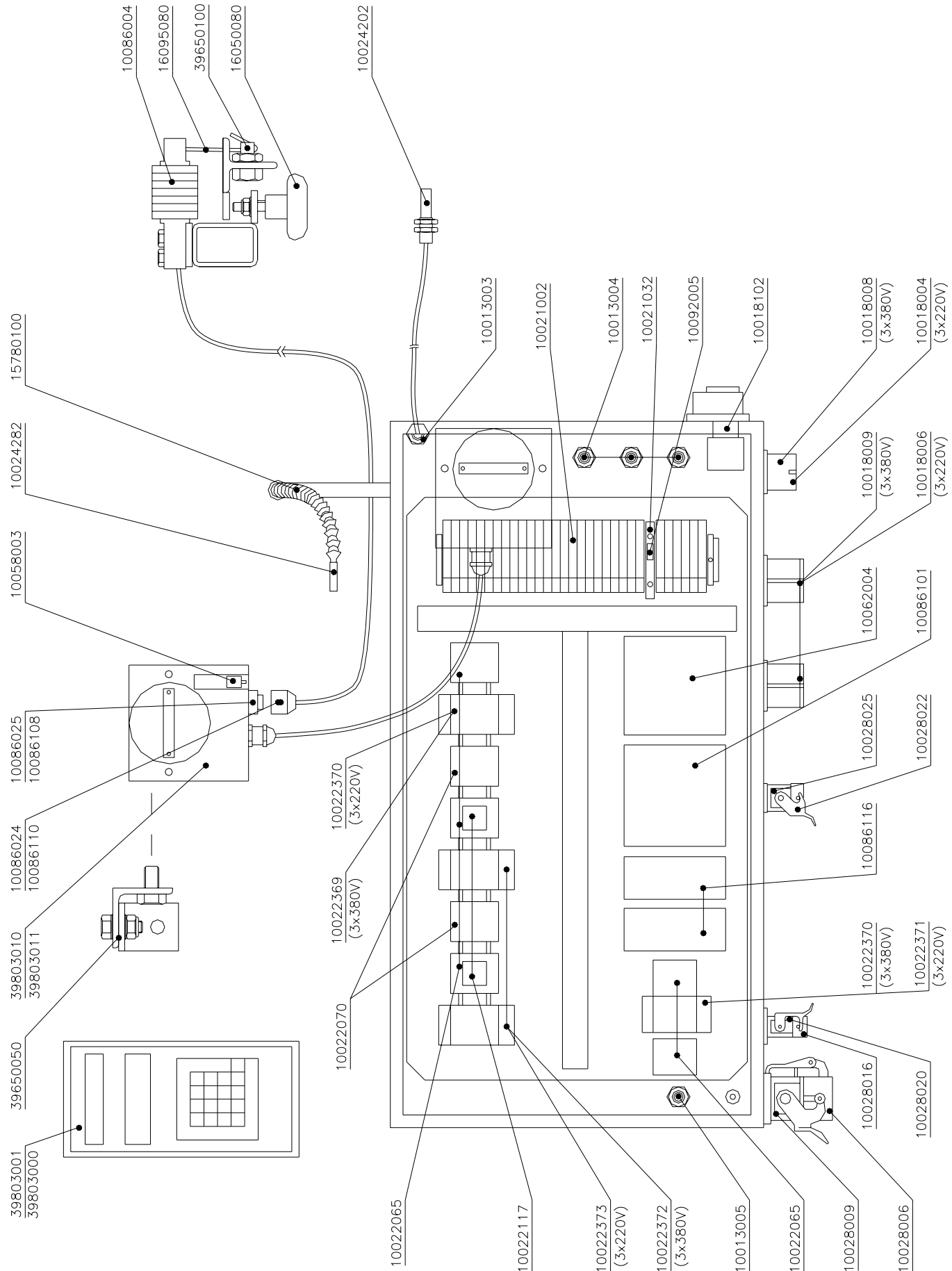
**11.6**  
**AM322 & AM422**



**11.7**  
**AM322 & AM422**



# 11.8 AM322 & AM422





## 12.0 Sparepartlist

Pos nr Item pos nr	Betegnels Denomination Bezeichnung	Type Type Typ	Antal No off Anzahl	side side seite
10013001	Forskruning Gland connector Verschraubung	FG11 WJ-top El nr. 09.13.022.476 Jacob	1	28
10013001	Forskruning Gland connector Verschraubung	FG11 WJ-top El nr. 09.13.022.476 Jacob	1	29
10013003	Forskruning Gland connection Verschraubung	Perfect PG9 poly	1	31
10013004	Forskruning Gland connection Verschraubung	Perfect PG13,5 poly	1	31
10013004	Forskruning Gland connection Verschraubung	PG13,5 WJ-top El nr. 09.13.022.489 jacob	1	20
10013005	Forskruning Gland connection Verschraubung	Perfect PG16 poly	1	31
10013005	Forskruning Gland connector Verschraubung	PG16 WJ-top El nr. 09.13.022.492 Jacob	1	20
10013451	Pakdåse Lead-in bush Durchführung	TET 7-10 El nr. 96.23.110.187 Thorsman	2	29
10013451	Pakdåse Lead-in bush Durchführung		1	29
10018004	Vægindtag Flanged plug Anbaugerätestecker	CEE 514-9 16A El nr. 17.18.421.239	1	31
10018006	Vægudtag Flanged socket Anbaudose	CEE 114-9 16A	2	31
10018008	Vægindtag Flanged plug Anbaugerätestecker	CEE 615-6 16A	1	31
10018009	Vægudtag Flanged socket Anbaudose	CEE 315-6 16A	2	31
10018102	Afbryder Plug Buchsenleisten	Bremas CP0160004KL2	1	31
10021002	Klemrække Tag block klemreihe	Wago grå 3P 2,5Q 280681	35	31
10021032	Sikringsklemme Fuse holder Sicherrungshalter	ASK1/35 PA	1	31
10022065	Kontaktor Relay Relais	9A LC1K0910B7 24AC	5	31
10022070	Kontaktor Relay Relais	9A LC1K0901B7 24AC	2	31

Pos nr Item pos nr	Betegnelse Denomination Bezeichnung	Type Type Typ	Antal No off Anzahl	side side seite
10022117	Hjælpeblock Relay Relais	3SL+1BR LA1KN31	1	31
10022369	Motorværn Relay Relais	0.4-0.63 GV2M04	1	31
10022370	Motorværn Relay Relais	0.63-1 GV2M05	1	31
10022371	Motorværn Relay Relais	1-1.6 GV2M06	1	31
10022372	Motorværn Relay Relais	1.6-2.5 GV2M07	2	31
10022373	Motorværn Relay Relais	2.5-4 GV2M08	2	31
10024282	Aftaster Sensor Taster	Kapacitiv DR 3E	1	31
10024202	Aftaster Sensor Taster	Induktiv EI1204 NPOS	1	31
10028004	Stik Plug Buchsenleisten	09.30.006.1440 El nr. 79.28.620.125 Harting	1	30
10028006	Chassisarmatur chassis connector Anbaugehäuse	09 30 006 0302 El nr. 79.28.620.183	1	31
10028008	Indsats Insert Einsatz	El nr. 79.28.620.293 Harting	1	30
10028009	Indsats Insert Einsatz	6ES FA 09 33 006 2716 El nr. 79.28.620.303	1	31
10028015	Stik Plug Buchsenleisten	El nr. 79.28.622.220 Harting	1	28
10028015	Stik Plug Buchenleisten	El nr. 79.28.622.220 Harting	1	29
10028016	Chassisarmatur Chasis connector Anbaugehäuse	09 20 003 0301	1	31
10028019	Indsats Insert Einsatz	El nr. 79.28.622.437 Harting	1	28
10028019	Indsats Insert Einsatz	El nr. 79.28.622.437 Harting	1	29
10028020	Indsats Insert Einsatz	3A FAT 09 20 003 2711	1	31

Pos nr Item pos nr	Betegnelse Denomination Bezeichnung	Type Type Typ	Antal No off Anzahl	side side seite
10028022	Chassisarmatur Chasis connector Anbauehäuse	09 20 010 0301	1	31
10028025	Indsats Insert Einsatz	09 70 014 2613	1	31
10058003	Potmeter Potentiometer Spannungsteiler	3590S104 Bourns	1	31
10062004	Transformator Converter Wandler	DT1830	1	31
10086003	Vejecelle Weighing cell Weigezell	STS-CE 200kg Ikke godk. Not approved model Nicht geeichte model	1	31
10086003	Vejecelle Weighing cell Weigezell	STS-CE 200kg Ikke godk. Not approved model Nicht geeichte model	1	31
10086024	Stik Plug Buchsenleisten	Kabelstik ITT410004 Godk. Approved model Geeichte model	1	31
10086025	Sokkel Socket Anbauehause	Apparatbøsning ITT410001 Approved model Geeichte model	1	31
10086101	Relæmodul Relay Relais	R5 1100-0202020	1	31
10086108	Sokkel Socket Anbauehause	Chassiskabel m. fatning 35 cm Not approved model Nicht geeichte model	1	31
10086110	Stik Plug Buchsenleisten	Kabelstik S6937P Plas Not approved model Nicht geeichte model	1	31
10086116	Relæmodul Relay Relais	R2	2	31
10092005	Sikring Fuse Sicherung	5x20 2,0A Flink	1	31
10500002	Filterregulator Filter regulator Filter-Regler		1	28
10500002	Fitterregulator Fitterregulator Fitter-Regler		1	29
10500003	Manometer Manometer Manometer		1	28
10500003	Manometer Manometer Manometer		1	29
10500501	Magnetventil Solenoid valve Magnetventil	5-2 24V ac. 1/8"	1	28

Pos nr Item pos nr	Betegnelse Denomination Bezeichnung	Type Type Typ	Antal No off Anzahl	side side seite
10500501	Magnet ventil Solenoid valve Magnet Ventil		1	29
10519002	Cylinder Cylinder Zylinder	20-100 CETOP RP 52P	2	28
10530002	Cylinder Cylinder Zylinder	SMC Ø 63-20	2	29
10550001	Slange Hose Rohr	super soft 4 mm		28
10550001	Slange Hose Rohr	super soft 4 mm		29
10569002	Enkelt union Union Union	1/8" - 4 mm	8	28
10569002	Enkelt union Union Union	1/8" - 4 MM	8	29
10571020	T-stykke T-peice T-Stück	4 mm	2	28
10571020	T-stykke T-peice T-Stück	4 mm	2	29
10581002	Vinkel Angle Winkel	1/4"	1	28
10581002	Vinkel fitting Angle fitting Winkel	1/4"	1	29
10587001	Slangenippel Nipple Hahn	1/4" - Ø 6 mm	1	28
10587001	Slangenippel Nipple Hahn	1/4" - Ø 6 mm	1	29
10587003	Koblingsnippel Coupling nipple Kupplungshahn	1/4" - Ø 12 mm	1	28
10587003	Kobling han Coupling Kupplung	1/4" Ø 12 mm	1	29
10587021	Kobling Coupling Kupplung	Ø 12 mm	1	28
10587021	Kobling hun Coupling Kupplung	1/4" Ø 12 mm	1	29
13310050	Messing aksel Brass bar Messing Stange		1	28

Pos nr Item pos nr	Betegnelse Denomination Bezeichnung	Type Type Typ	Antal No off Anzahl	side side seite
15005100	Motor Motor Motor	0,09 kW 1410 o/min	1	27
15005250	Motor Motor Motor	0,12 kW 690 o/min	1	30
15005700	Motor Motor Motor	0,3/0,43 kW 1400/2800 o/min	1	26
15005700	Motor Motor Motor	0,3/0,43 kW. 1400/2800 o/min	1	26
15005700	Motor Motor Motor	0,3/0,43 kW 1400/2800 o/min	1	25
15035500	Aksel Shaft Welle		1	27
15040170	Gear Gear Getriebe	MRV/30 50:1	1	27
15040370	Gear Gear Getriebe	MRV/50 40:1	1	26
15040370	Gear Gear Getriebe	MRV/50 40:1	1	25
15040380	Gear Gear Getriebe	MRV/50 50:1	1	26
15400850	Kugleleje Ball bearing Kugellager	UCPP204	2	27
15400960	Lejehus Bearing housing Lagergehäuse	UP205	1	26
15410050	Flangeleje Bearing housing Lagergehäuse	UCFL204	2	25
15420140	Kugleleje Ball bearing Kugellager	UC205	1	26
15450480	Kugleleje Ball bearing Kugellager	6204	1	27
15450560	Kugleleje Ball bearing Kugellager	608D	4	29
15520020	Tromle Roller Trommel	D135 B300 JOKI	1	26
15520020	Tromle Roller Trommel	D135 B300 Joki	1	25

Pos nr Item pos nr	Betegnelse Denomination Bezeichnung	Type Type Typ	Antal No off Anzahl	side side seite
15740700	Muffe Coupling Muffe	3/8"	1	24
15780100	Kølerør Holder Halter	Lockline 1/2S komplet	1	31
15860100	PVC-holder PVC-mountings PVC-Spannstück		2	28
15860500	Gummiprofilkantliste Rubber seal Gummileiste	nr. 1011-05 Scandi Loc	1	24
15870060	Rørben Plug Pfropfen	30 x 20	4	24
15870060	Rørben Plug Pfropfen	30 x 20	2	30
15870160	Rørben Plug Pfropfen	50 x 20	4	28
16010245	Anti slip tape Anti slip tape Anti slip tape		2	28
16010245	Anti slip tape Anti slip tape Anti slip tape		2	29
16040180	Hjul Wheel Rad	Blickle hjul L-POEV 160 RST KS	2	24
16040280	Hjul Wheel Rad	Blickle hjul L-POEV 160 R KS	2	24
16045050	Maskinsko Mount Maschinenschuhe	Sunnex nr. 1	4	24
16055020	Låsehus Lock casing Verschlussgehäuse	nr. 1000-U45 Scandi Loc	2	24
16055040	Indsats med kærvt Mortise lock Einsteckschloss	nr. 1000-U142 Scandi Loc	2	24
16055060	Pakning Packing Packung	nr. 1000-23 Scandi Loc	2	24
16055080	O-ring O-ring O-ring	nr. 1000-24 Scandi Loc	2	24
16055160	Tunge Fung Sperrhagen	nr. 1000-26 Scandi Lo	2	24
16110340	Svingelement Swingelement Schwingelement	Rosta ST18	1	30

Pos nr Item pos nr	Betegnelse Denomination Bezeichnung	Type Type Typ	Antal No off Anzahl	side side seite
16135080	Kugleled Ball joint Kugelgelenk	BRF8R Renold	4	27
16135080	Kugleled Ball joint Kugelgelenk	BRF8R Renold	4	28
16135100	Kugleled Ball joint Kugelgelenk	BRF12R Renold	1	30
16360200	Transportbånd Main belt Hauptriemen	Polymax 300 x 5000 CW60B/78 del:60/3 Forskudt	1	26
16360200	Transportbånd Elevator belt Elevatorband	Polymax 300 x 5000 CW60B/78 del:60/3 Forskudt	1	25
16360300	Doserbånd Dosing belt Dosierband	Polymax 125 x 5000 CW60B/90 del:100	1	26
16500200	Supergrib Supergrib Supergrib	EP 250/2 3+0.	2	28
16500200	Supergrib Supergrib Supergrib	EP 250/2 3+0.	2	29
16500300	PVC PVC PVC		1	24
16500300	PVC PVC PVC		2	28
16500350	Gummiplade Rubber sheet Gummiplatte		1	24
16500350	Gummiklap Rubber falp Gummiklappe		3	26
16500350	Gummiplade Rubber sheet Gummiplatte		1	25
16500450	Gummiplade Rubber sheet Gummiplatte	515 x 197	2	27
16500450	Gummiplade Rubber sheet Gummiplatte	367 x 197	2	27
16690300	Plejlstang Connecting rod Pleuelstange	M12	1	30
16910266	Skrue Screw Schraube	M8 x 40	1	26
16910314	Skrue Screw Schraube	M10 x 25	2	30

Pos nr Item pos nr	Betegnelse Denomination Bezeichnung	Type Type Typ	Antal No off Anzahl	side side seite
16910406	Skrue Screw Schraube	M12 x 140	1	26
16910406	Skrue Screw Schraube	M12x130	2	25
16960200	Gevindestykke Threaded rod Gewinde Stange	M8	2	27
16970100	Møtrik Nut Mutter	M12	1	30
16970100	Møtrik Nut Mutter	M12	2	30
22625216	Skærm Protection shield Schute platte		1	27
22625218	Gummiplade Gummiplade Gummiplade		1	27
22625221	Vejebeholder Weighing hopper Weigevorrichtung	25 kg	1	27
22625023	Låg Protection shield Schutzplatte		1	24
22625024	Understel Frame Untergestell		1	24
22625208	Spændering Mounting ring Spannring		1	27
22625215	Gummiplade Rubber sheet Gummiplatte		1	27
22625217	Gummiplade Rubber sheet Gummiplatte		1	27
22625219	Gummiplade Rubber sheet Gummiplatte		1	27
22625220	Gummiplade Rubber sheet Gummiplatte		1	27
22645508	Træktromle Roller Trommel		1	25
22645511	Dækplade Cover plate Deckplatte		1	25
22645513	Underskærm Cover plate Deckplatte		1	25



Pos nr Item pos nr	Betegnelse Denomination Bezeichnung	Type Type Typ	Antal No off Anzahl	side side seite
22645517	Stel Frame Rahmen		1	25
22675911	Spændestykke Mountings Spannstück		1	26
22675914	Træktromle Roller Trommel		1	26
22675917	Skærm Protection shield Schutzplatte		1	26
22675918	Dækplade Cover plate Deckplatte		1	26
22675922	Justerskrue Adjusting screw Justierschraube	M12 x 150 Ganter	1	26
22675930	Stel Frame Rahmen		1	26
22805013	Gummiplade Rubber sheet Gummiplatte		2	28
22805014	Kæbe Cheek Klemmbacke		1	28
22805015	Kæbe Cheek Klemmbacke		1	28
22805016	Kæbe Cheek Klemmbacke		1	28
22805017	Kæbe Cheek Klemmbacke		1	28
22810008	Beslag Mounting Beschlag		2	29
22810016	Gummiplade Rubber sheet Gummiplatte		2	29
22810019	Kæbe Cheek Klemmbacke		1	29
22810020	Kæbe Cheek Klemmbacke		1	29
22810021	Kæbe Cheek Klemmbacke		2	29
22820002	Spændestykke Mountings Spannstück		4	30

Pos nr Item pos nr	Betegnelse Denomination Bezeichnung	Type Type Typ	Antal No off Anzahl	side side seite
22820003	Bladfjeder Leaf spring Blattfeder		4	30
22820004	Spændestykke Mountings Spannstück		1	30
22820006	Exentrik Eccentric Exenter		1	30
22820012	Gummiplade Rubber sheet Gummi platte		1	30
22820013	Gummiplade Rubber sheet Gummiplatte		1	30
22820014	PVC PVC PVC		1	30
22820015	PVC PVC PVC		1	30
22820016	Udløbstud Outlet Auslauf		1	30
22820017	Beslag Mountings Beschlag		1	30
22820018	Bøjle Clamp Bügel		1	30
39650001	Sækkeplatform Platform Plattform		1	24
39650010	Udløbstud Outlet Auslauf		1	24
39650020	Skærm Protection shield Schutz Platte		1	24
39650050	Beslag Mounting Beschlag	Galv.	1	31
39650060	Beslag Mounting Beschlag		4	31
39650070	Justerbare ben Adjustable leg Justierbar bein		2	31
39650080	Forlænger ben Extended leg Verlängerungsbein		4	31
39650090	Ophæng Suspension Aufhängung		2	31

Pos nr Item pos nr	Betegnelse Denomination Bezeichnung	Type Type Typ	Antal No off Anzahl	side side seite
39650301	Vejebeholder Weighing hopper Weigevorrichtung	50 kg	1	27
39650310	Lukkeplade Dosing plate Schliessen Platte		1	27
39650311	Bøsning Bush Buchse		1	27
39650320	Lukkeplade Closing plate Schliessen platte		1	27
39650324	Gummiplade Gummiplade Gummiplade		1	27
39650330	Ophæng Suspension Aufhängung		1	27
39650335	Forvægt Counterweight Gegengewicht		1	27
39650340	Spændestykke Mounting Spannstück		1	27
39650350	Spændestykke Mounting Spannstück		2	27
39650360	Bladfjeder Leaf spring Blattfeder		4	27
39650370	Excentrik Eccentric Exenter		1	27
39650405	Gummiplade Rubber sheet Gummiplatte		1	25
39650407	Gummiplade Rubber sheet Gummiplatte		1	25
39650411	Tragt Hopper Trichter		1	25
39650420	Skærm Protection Shield Schutz platte		1	25
39650430	Sideplade Sideplate Seitenplatte		1	25
39650450	Bøjle Clamp Bügel		1	25
39650452	Spændestykke Mounting Spannstück		1	25

Pos nr Item pos nr	Betegnelse Denomination Bezeichnung	Type Type Typ	Antal No off Anzahl	side side seite
39650453	Bladfjeder Leaf spring Blattfeder		3	25
39650480	Spændestykke Mounting Spannstück		1	25
39650490	Gummiplade Rubber sheet Gummiplatte		2	25
39650500	Gummiklap Rubber Flap Gummiklappe		1	25
39650510	Gummiklap Rubberflap Gummiklappe		1	25
39650520	Beslag Mountings Beschlag		1	26
39650520	Beslag Mounting Beschlag		1	25
39650530	Beslag Mountings Beschlag		1	26
39650530	Beslag Mounting Beschlag		1	25
39650608	Gummiplade Rubber sheet Gummiplatte		2	26
39650609	Gummiplade Rubber sheet Gummiplatte		1	26
39650613	Tragt Hopper Trichter		1	26
39650626	Dosertrømler Dosing roller Dosiertrommel		1	26
39650627	Dosertrømler Dosing roller Dosiertrommel		1	26
39650630	Beslag Mountings Beschlag		1	26
39650640	Justerring Adjusting ring Justierring		1	26
39650650	Beslag Mountings Beschlag		1	26
39650660	Bøjle Clamp Bügel		1	26

Pos nr Item pos nr	Betegnelse Denomination Bezeichnung	Type Type Typ	Antal No off Anzahl	side side seite
39650362	Spændestykke Mountings Spannstück		1	26
39650670	Beslag Mountings Beschlag		1	26
39650680	Skærm Protection shield Schutzplatte		1	26
39650690	Sideplade Side plate Seitenplatte		1	26
39650710	Bladfjeder Leaf spring Blattfeder		4	26
39650720	Spændestykke Mountings Spannstück		1	26
39650730	Gummiklap Rubber flap Gummiklappe		1	26
39650740	Gummiklap Rubber flap Gummiklappe		1	26
39803000	Computer Computer Computer	SM02 Ikke godkendt Not approved Nicht geeichte model	1	31
39803001	Computer Computer Computer	SM03 Godkendt Approved Geeichte model	1	31
39803010	Computerbeslag Mounting Beschlag	Mellemkabel alu. Godk. Approved Geeichte model	1	31
39803011	Computerbeslag Mounting Beschlag	Mellemkabel PVC Ej godk. Not approved Nicht geeichte model	1	31



### 13.0 Declaration of conformity with EU.

<b>Manufacturer</b>	
Firm:	A/S Skals Maskinfabrik
Address:	Hovedgaden 56 8832 Skals, Denmark
Telephone:	87 25 62 00

declares herewith, that

<b>Machine:</b>	<b>Bagging Machine type AM322-2 Am422-2</b>
Brand:	
Type, serial no., year:	

Is manufactured in accordance with the decisions of the Councils Directives:

- 1 Machinery Safety – Directive 98/37/EC
- 2 Low Voltage Equipment Directive (LVD) 2006/95/EEC
- 3 Electromagnetic Compatibility (EMC) Directive 89/336/EEC and 93/68/EEC as amended.

<b>Title:</b>	Productions Manager
Name:	Søren Lund Madsen
Firm:	A/S Skals Maskinfabrik

Date: \_\_\_\_\_

Signed: \_\_\_\_\_

