

INSTRUCTION MANUAL

Box/Bag Filler Type KSF640/650



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1.0 General information

The box/bag filler can be set to fill to a certain level or used in conjunction with scales where a signal from the weighing indicator stops filling.

Filling height can easily be set for both boxes or bags, and the selected filling height is stored in the PLC.

All unauthorized repairs of the machine will void the warranty.

2.0 The application of the machine

The box/bag filler can be used to fill root vegetables in wooden boxes or big bags.

The machine can be operated in a temperature range of -10 degrees to +40 degrees C.

3.0 Set-up

The machine is adjusted to the required filling height using the adjustable chassis. Lift up the machine with a forklift truck, and set the chassis with wheels to the required height. Adjust the chassis using the bearers lengthwise to ensure that it is vertical.

The shock absorber should be adjusted to horizontal position using the turnbuckles.

The machine is supplied with fixed wheels as standard. These can be turned to the required position. If the machine has been supplied with a turnplate, the wheels can be turned so that it is possible to move the machine manually between two boxes.

3.1 Operation

The operating panel looks like this:



The operational elements are defined as follows:

START	<p>When the control is powered and RESET has been pressed, the machine can be started by pressing START.</p> <p>If the START indicator is flashing, filling is complete, and the machine is ready for new filling by pressing START.</p> <p>The START indicator is continuously lit during operation.</p> <p>MANUAL OVERFILL is activated by holding down the START key for more than 1 second. MANUAL OVERFILL stops a filling sequence and when the key is released, the shock absorber stays at the current height.</p>
STOP	<p>Stops filling at any time.</p> <p>Leaves the shock absorber in the latest position.</p>
RESET	<p>When the blue indicator lights up, the safety circuit has been broken, and the RESET button must be pressed to reconnect the safety system.</p>
SAVE HEIGHT	<p>Is used to save a filling height for the settings of BOX or BAG.</p> <p>When pressing SAVE, the indicator in the key flashes to show that the value is being saved. When the indicator lights up continuously, the fall damper is at the set filling height.</p> <p>Values can only be saved when the STOP key is pressed or the MANUAL OVERFILL function has been used.</p>
BOX	<p>The switch is used to toggle between the two set filling heights for BOX/ BAG or if a scales indicator is connected which can stop WEIGHT fill on a set weight.</p>
FALL DAMPER UP/DOWN	<p>When the machine has stopped, FALL DAMPER UP/DOWN can be used to find the required filling height manually.</p>

3.2 Start-up and operation

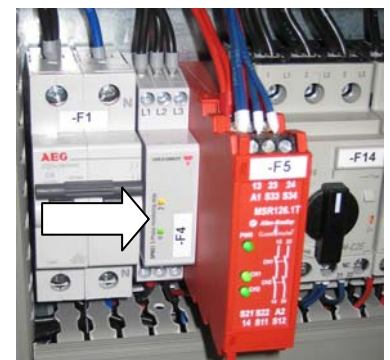
Connect the power supply and switch on the main switch on the left side of the board.

Is the blue indicator in the **RESET** key lit?

If yes – press **RESET**

If no – Open the control board and check that both indicators (yellow and green) are lit on the phase relay (F4). If not, change the two phases in the supply cable.

The emergency circuit can then be connected by pressing **RESET**, and the indicator goes out.



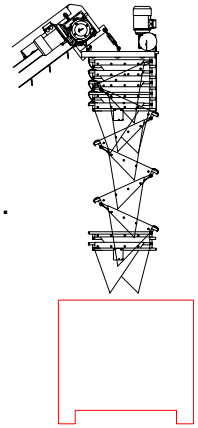
Set filling height:

Select BOX on the switch **BOX/BAG/WEIGHT**.

Activate the **FALL DAMPER UP/DOWN** until the required filling height is achieved.

Press **SAVE HEIGHT** > 1 sec. The indicator will flash and a height has now been saved for BOX.

Toggle to BAG and repeat the same setting for BAG.

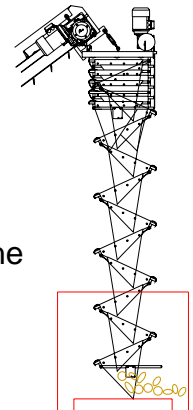


If the filling height needs to be more precise, this can be done during operation when the box or bag is nearly full. Use the **MANUAL OVERFILL** function for this by pressing **START** > 1 sec. Now filling will continue until the **START** key is pressed. When the required filling height has been achieved, release **START** and press **SAVE HEIGHT** for BOX or BAG.

START Automatic filling

When the required filling height has been set, the machine is ready for operation.

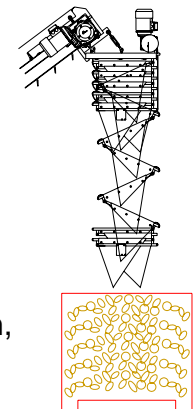
Press **START**. Now the shock absorber automatically runs down to the bottom of the box. The feed conveyor starts and begins to fill the box.



When automatic filling is complete, filling stops and the fall damper runs to a pre-set free height.

To change this free height change a parameter internally in the PLC. This is easily done by opening the control cupboard and operating the PLC on the display.

After the shock absorber has been run to free height, the **START** indicator will flash, and the machine is ready for the next filling.



4.0 Pictograms

Movable parts at the inlet to the conveyor and on both sides.
Keep your distance.



5.0 LUBRICATION AND MAINTENANCE

All bearings have been lubricated from the factory and require no maintenance.

The worm gear driving the main conveyor, the worm gear driving the absorber have been lubricated for their entire life with synthetic grease for operation in standard temperature range (-15 degrees C to 40 degrees C).

IP	TELESIA COMPOUND B
SHELL	TIVELA COMPOUND A

The conveyor belt must be kept suitably taut and run straight. This is ensured by adjusting the conveyor's adjustment bolts.

For high-pressure cleaning the following areas must be carefully covered: gear motors, electronic control boxes, weighing indicator and weighing cells on weighing platform.
To achieve optimum operating reliability and low maintenance costs thorough maintenance and cleaning are **very important**.

6.0 CLEANING THE MACHINE

Reference is made to the Danish Plant Directorate's Order no. 965 of 13 December 1993 (p. 6):

- 2.3.3 Seed potato farmers with closed crops must clean and disinfect sorting machinery, etc. for each part of a different type. Disinfection must take place using an agent certified as efficient by the Danish State Plant Trials.
- 2.3.4 Authorised sorting companies that are also authorised to grow potatoes must clean and disinfect sorting facilities, etc. under the control of the Danish Plant Directorate prior to commencement of sorting of own produce. Disinfection must take place using an agent certified as efficient by the Danish State Plant Trials.
- 2.3.5 Premises and machinery, etc. must be cleaned and disinfected annually prior to 30 June. Disinfection must take place using an agent certified as efficient by the Danish State Plant Trials.

7.0 PACKAGING/TRANSPORT GUIDE

PACKING/PACKAGING:

KSF650/640 : no packaging.
VP : no packaging.

NUMBER OF PIECES:

The machine must be packed in one piece.

WEIGHT:

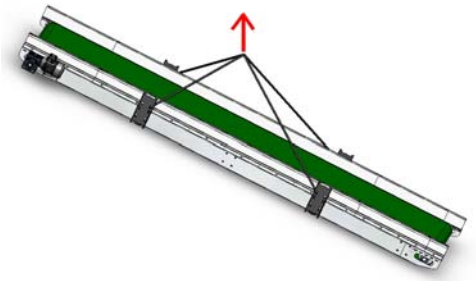
KSF640 : 355 kg
KSF650 : 395 kg
VP : 90 kg

DIMENSION:

	Length	Width	Height
KSF640	4,400 mm,	1,200 mm,	3,000 mm.
KSF650	5,200 mm,	1,300 mm,	3,400 mm.
VP	1,800 mm,	1,400 mm,	200 mm.

TRANSPORT AND LIFTING INSTRUCTIONS:

VP : To be transported on a pallet.
KSF640/650 : If the box/sack filler is to be lifted, this must be done using the nylon straps mounted on the conveyor's brackets.



8.0 Connection of accessories:

Weighing platform.

A weighing platform with the dimensions 1400x1400mm or 1400x1800mm is available. A forklift truck must be used. A U pallet is also available for handtruck.

Frame for bags.

The frame can be installed on the vertical chassis of the machine. The frame has been installed with a compressed air cylinder which is adjustable using a pressure regulator to ensure that the sack will be lowered at a required weight. The frame can also be lowered for easier operation during bag changes.

If a weighing platform was included, the frame should be installed on the bracket on the weighing frame to avoid incorrect weighing.

Suspension on horizontal bearers for straps in big bags should be set according to size used.

8.1 Operation of platform scales reinforcer with WE1208:

SETTING OF KILO VOLUME

- 1 Press ENTER and UP simultaneously (INFO is shown on the display).
 - 2 Press NEXT once (SET PT is shown on the display).
 - 3 Press ENTER once (P1 FU is shown on the display).
 - 4 Press NEXT once (P1 LO is shown on the display).
 - 5 Press NEXT once (P1 ON is shown on the display).
 - 6 Press NEXT once (P1 PFF is shown on the display).
 - 7 Press ENTER once
 - 8 The UP and PT keys will flash on the left side of the display
 - 9 Press NEXT once
 - 10 The first number will flash. If kilo volume requires changing, press UP
 - 11 Press NEXT once
 - 12 The next number will flash. If kilo volume requires changing, press UP, etc.
- Press ENTER once to accept the selected kilo volume.
- 14 Press CE three times to complete the entry.



8.2 Calibration of scales reinforcer type WE1208:

- 1 Start: Press using a thin implement and activate the hidden **MENU** key
- 2 Press **ENTER** and **UP** simultaneously. (**INFO** is shown on the display).
Now you are ready to carry out a calibration:
- 3 Press **NEXT five times** (**CAL** is shown on the display).
- 4 Press **ENTER** (**Lin** is shown on the display (set-up)).
- 5 Press **ENTER** (This should be set to 0).
- 6 Press **ENTER**
- 7 Press **NEXT once** (**CAL-0** is shown on the display).
- 8 Press **ENTER** (Zero point is shown on the display).
- 9 Press **ENTER** (In the display= **buSY**. Wait until this signal is still, then:)
- 10 Press **ENTER** (**DONE** is shown and the zero point is saved).
- 11 Press **NEXT once**. (**LOAD1** is shown on the display).

- | | | |
|----|---|--|
| 12 | Press ENTER | (Set the calibration weight to 920 KG (Skals Maskinfabrik)) |
| 13 | Press ENTER | (In the display = buSY . Wait until this signal is still, then:) |
| 14 | Press ENTER | (DONE is shown. The calibration weight has been saved. – (Min. 20%)) |
| 15 | Press NEXT once | (CAL-1 is shown on the display). |
| 16 | Set the calibration weight here and wait until the weight is still. | |
| 17 | Press ENTER | (Current mV/V is shown on display). |
| 18 | Press ENTER | (In the display= buSY . Wait until this signal is still, then:) |
| 19 | Press ENTER | (DONE is saved). |
| 20 | Press CE twice | (The weight has now been calibrated and is ready for use). |

9.0 List of spare parts

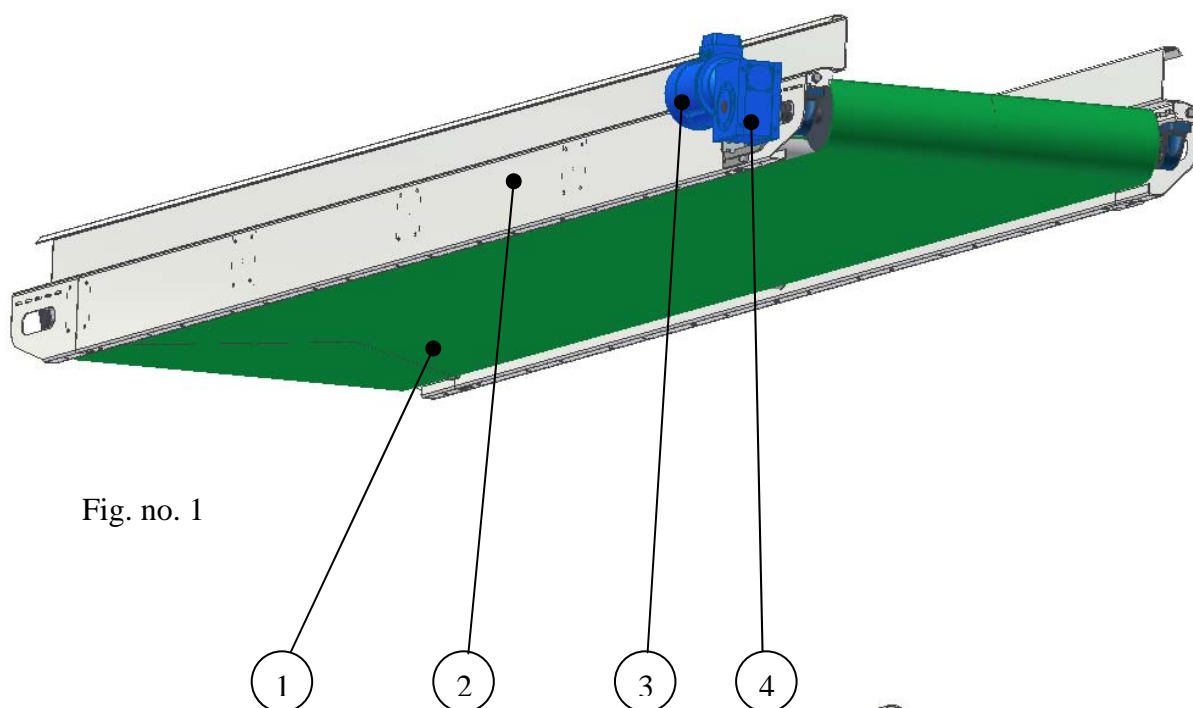


Fig. no. 1

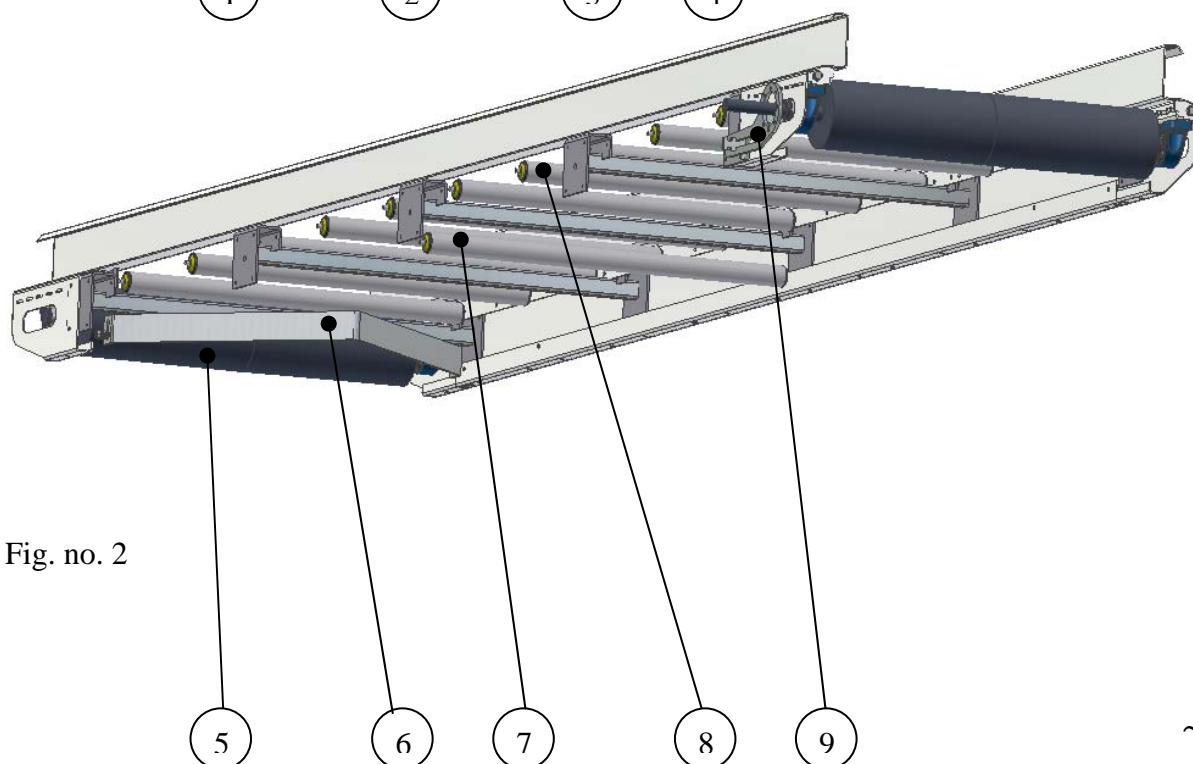


Fig. no. 2

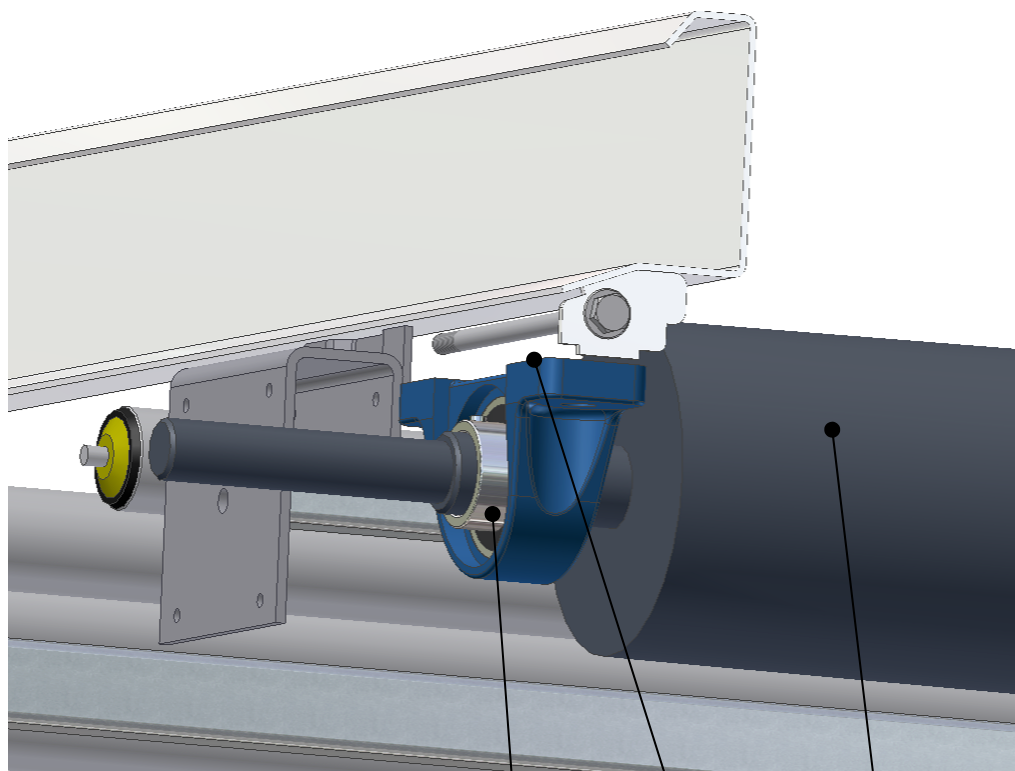


Fig. no. 3

10 11 12

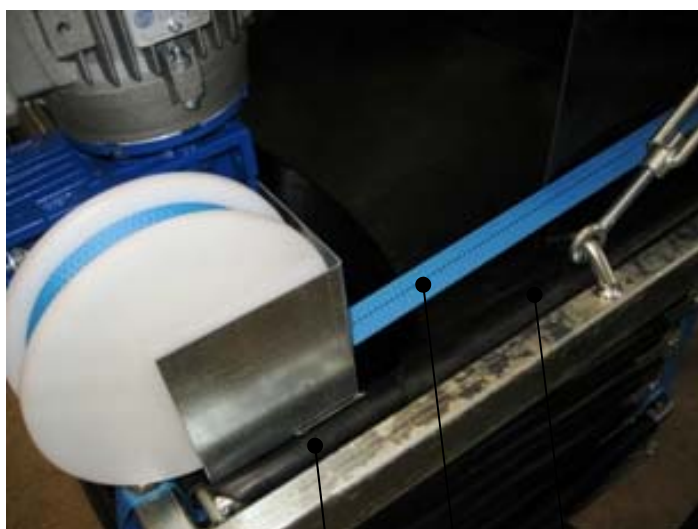


Fig. no. 4

13 14 15



Fig. no. 5

16

17



Fig. no. 6

18

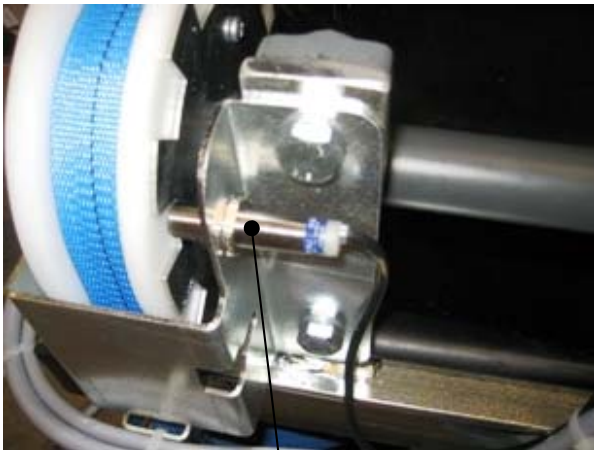


Fig. no. 7

19

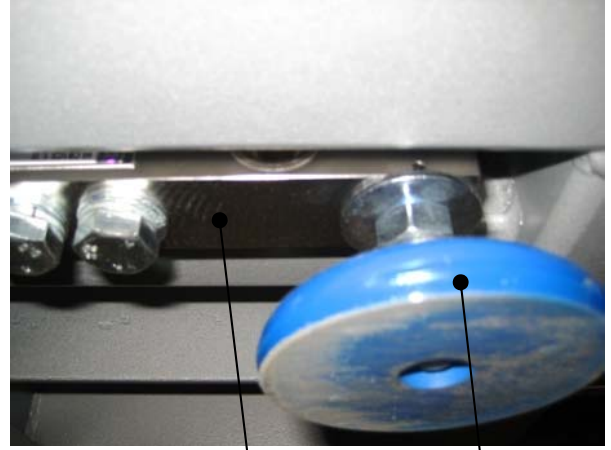


Fig. no. 8

20

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Page	Fig. no.	Pos. no	Description
8	1	1	Conveyor belt
8	1	2	Side plate
8	1	3	Motor
8	1	4	Gear
8	2	5	Loose roller
8	2	6	Conveyor scraper
8	2	7	Return roller
8	2	8	Bearing roller
8	2	9	Lever arm for motor and gear
9	3	10	Bearing
9	3	11	Adjustment screw
9	3	12	Drawing roller
9	4	13	Damper canvas 1 FDA small
9	4	14	Lashing bands 25 mm
9	4	15	Damper canvas 2 FDA large
10	5	16	Damper canvas 3 FDA
10	5	17	Photo sensor
10	6	18	Micro switch
10	7	19	Inductive sensor
10	8	20	Weighing cell
10	8	21	Foot

10.0 EU - Declaration of Conformity

Manufacturer	
Company name:	A/S Skals Maskinfabrik
Address:	Hovedgaden 56
	8832 Skals, Denmark
Telephone:	87 25 62 00

hereby declares that

Machine:	Box/Bag Filler KSF 640/650
Brand:	
Type, serial no., year:	

Has been manufactured in conformity with the COUNCIL'S DIRECTIVE:

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

Title:	Production Manager
Name:	Søren Lund Madsen
Company:	A/S Skals Maskinfabrik

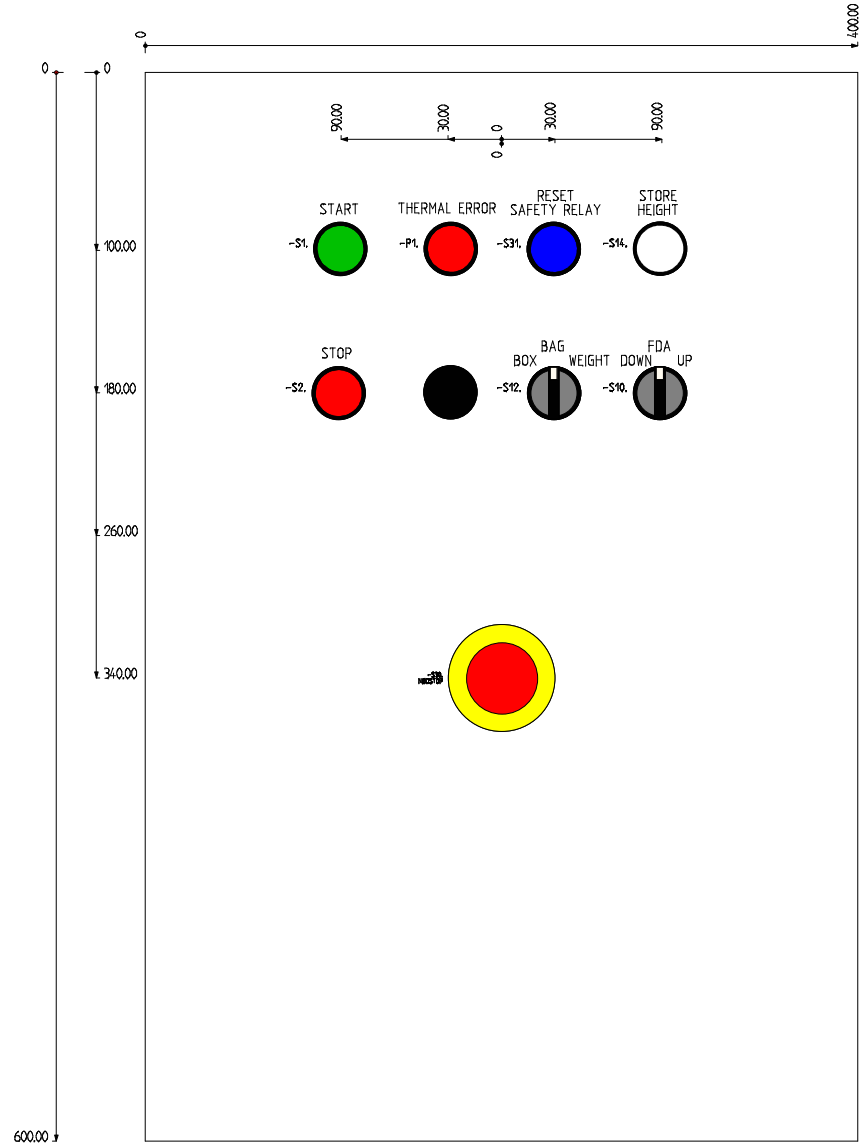
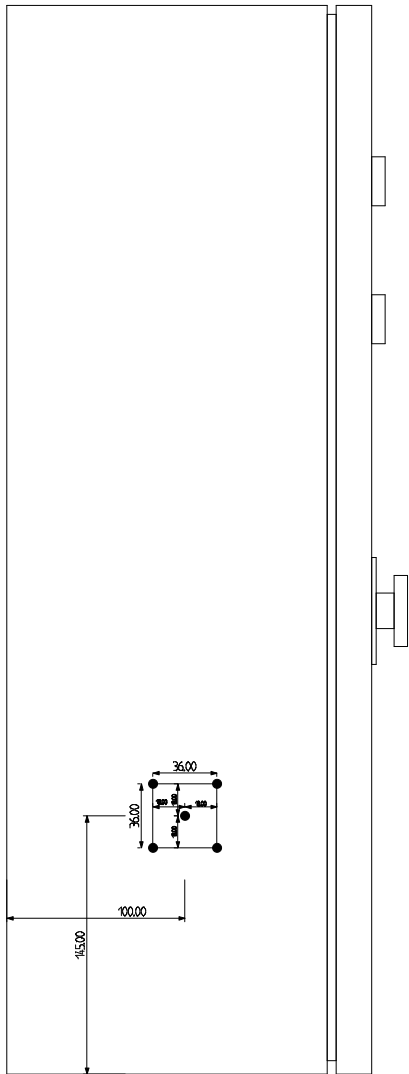
Date: _____

Signature: _____

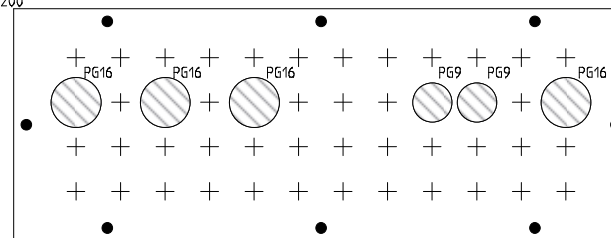


Document list

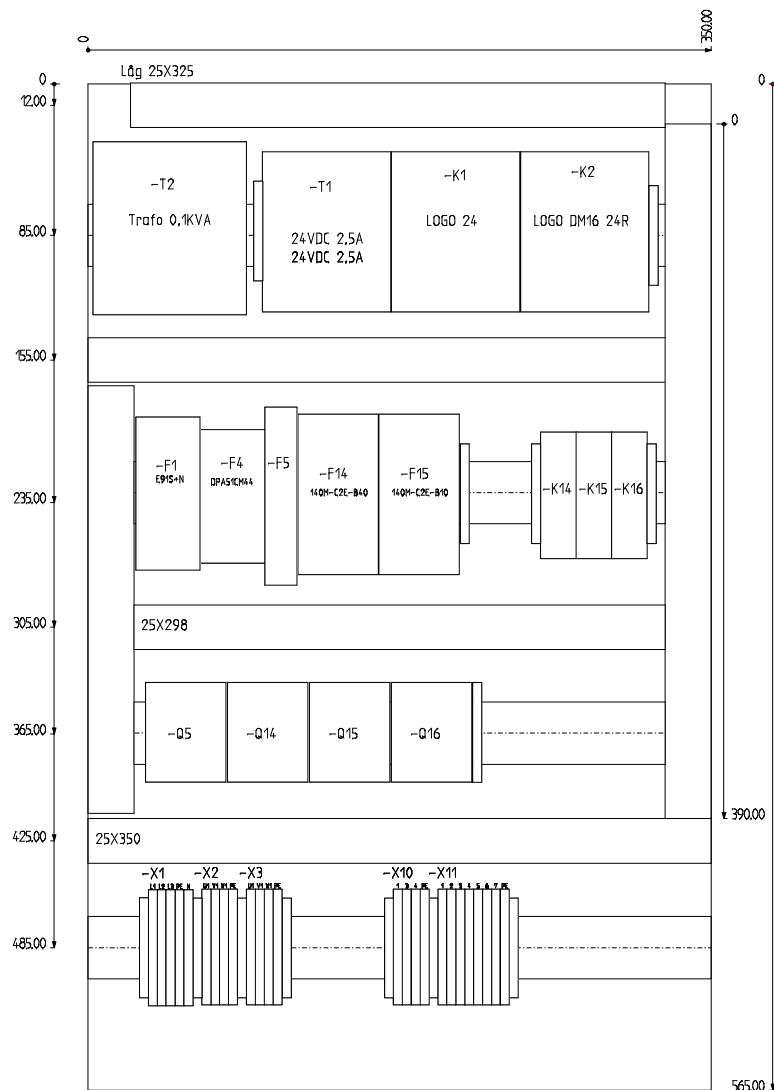
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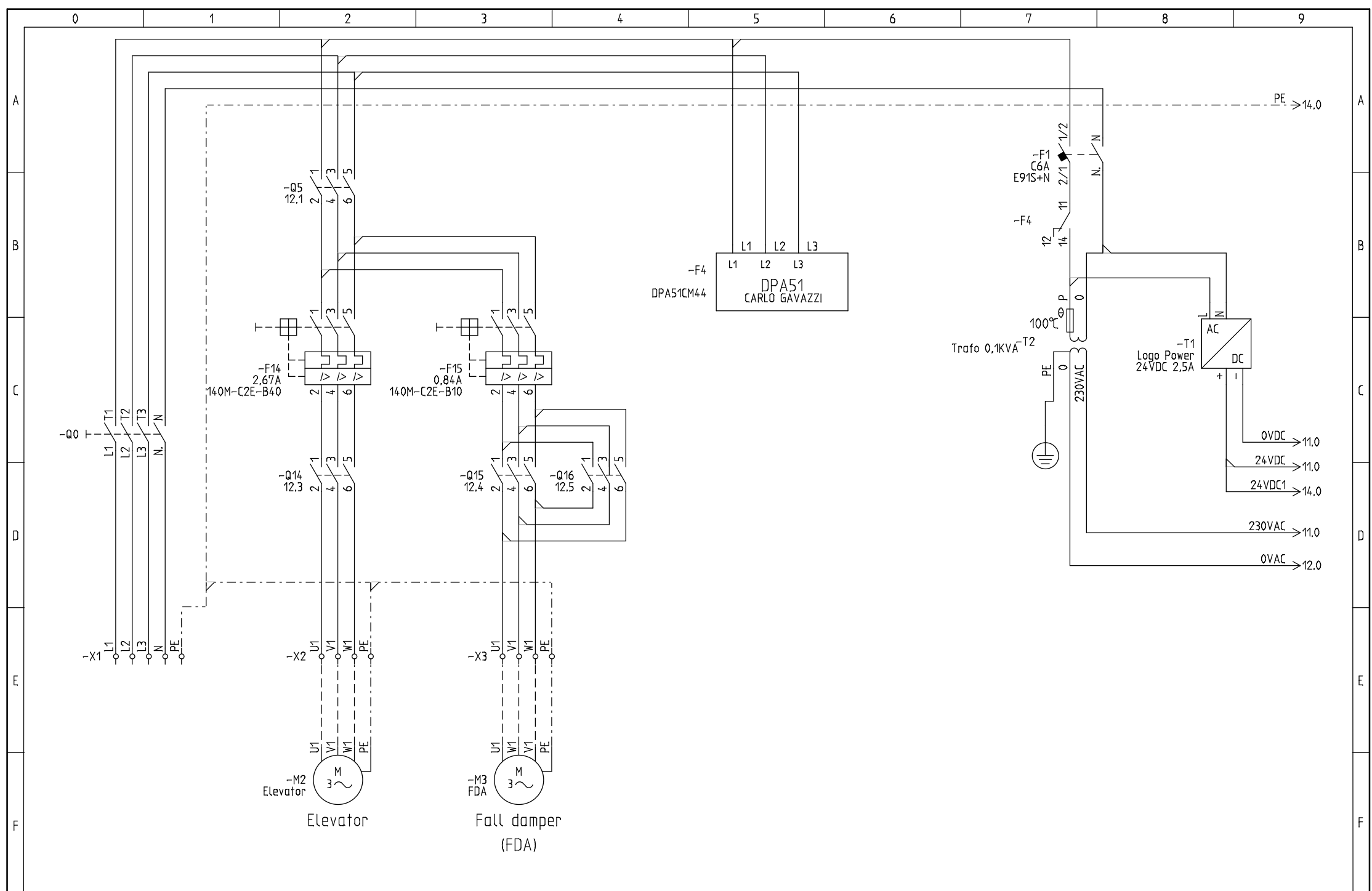
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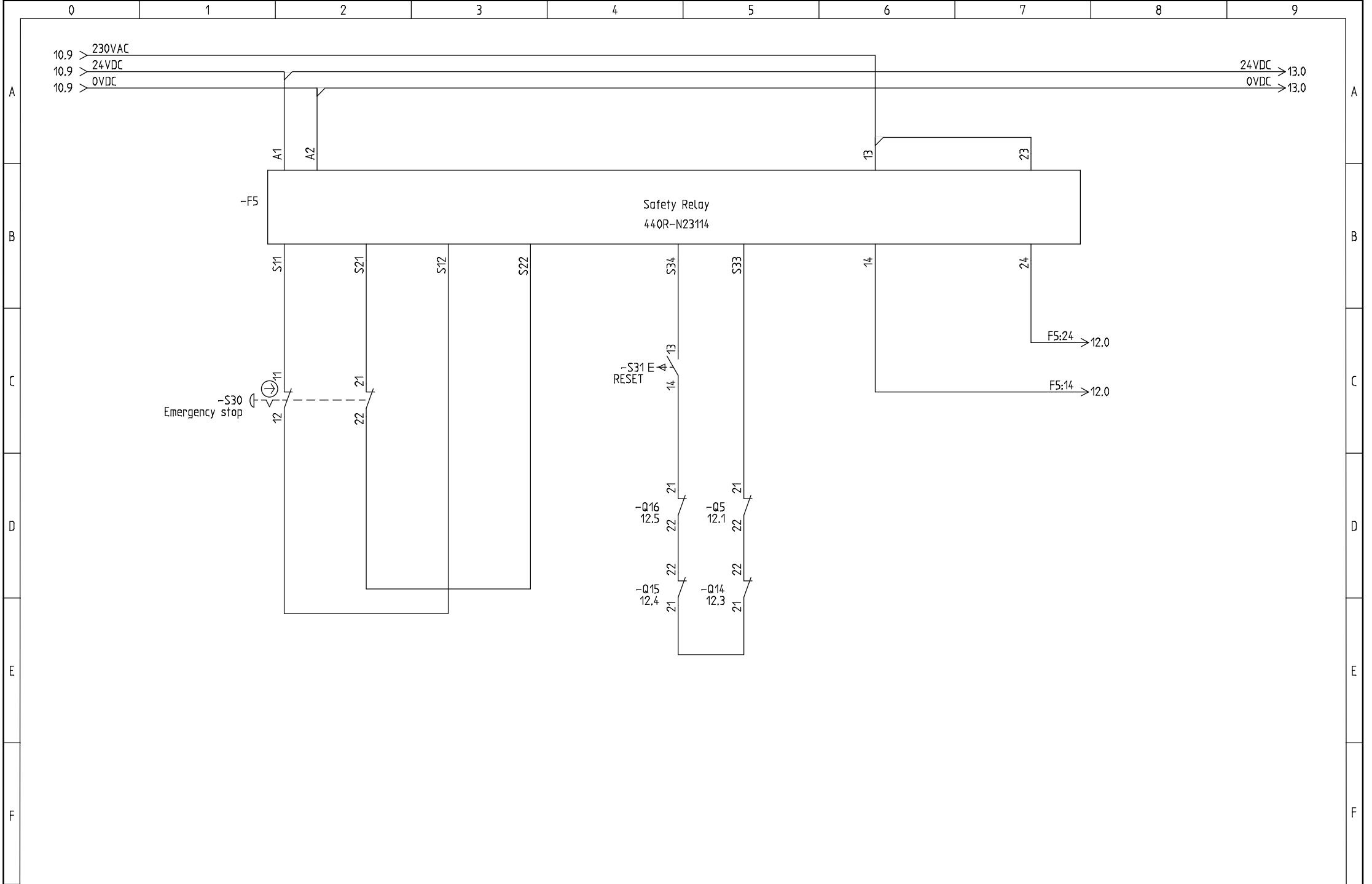


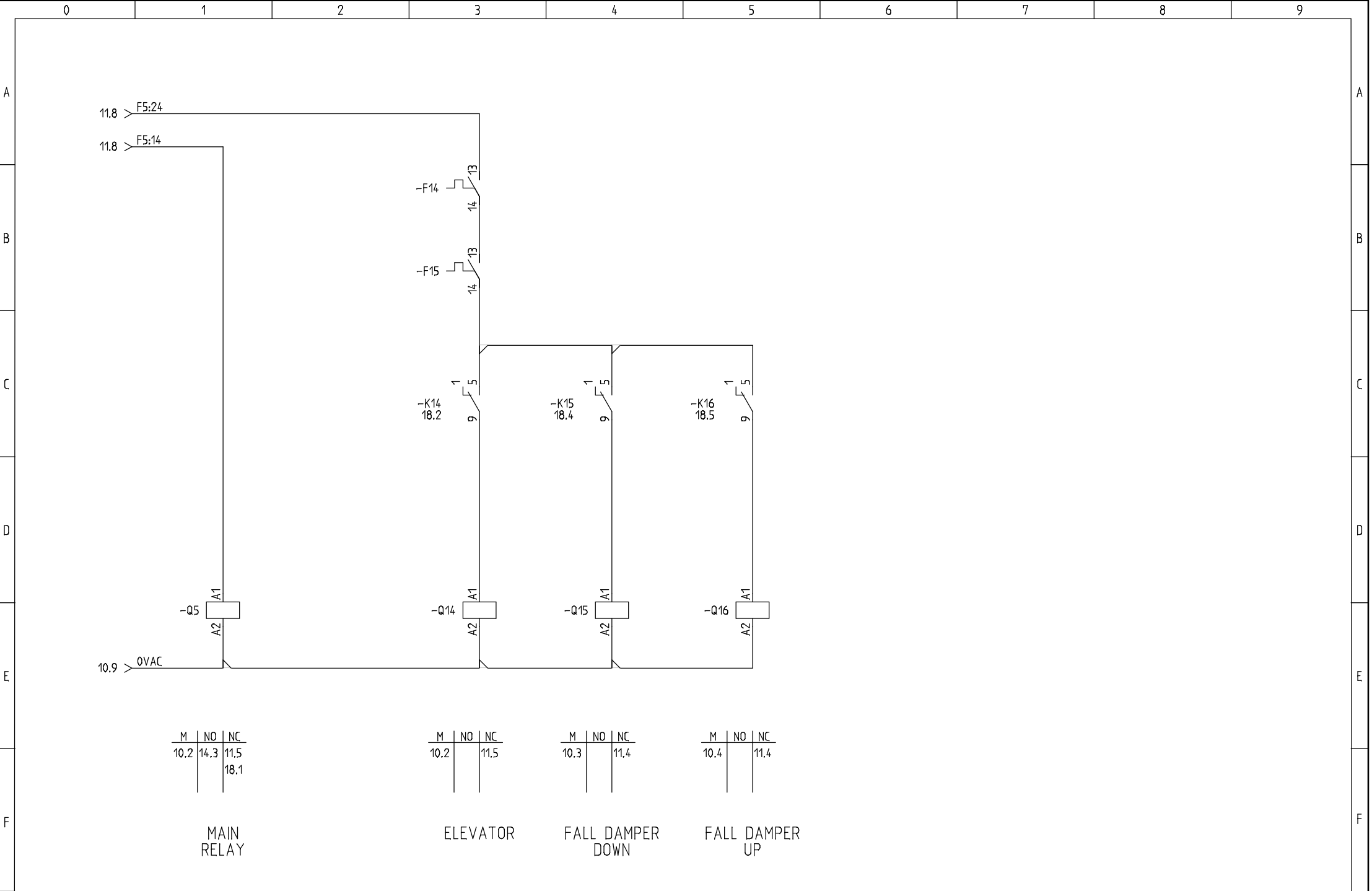
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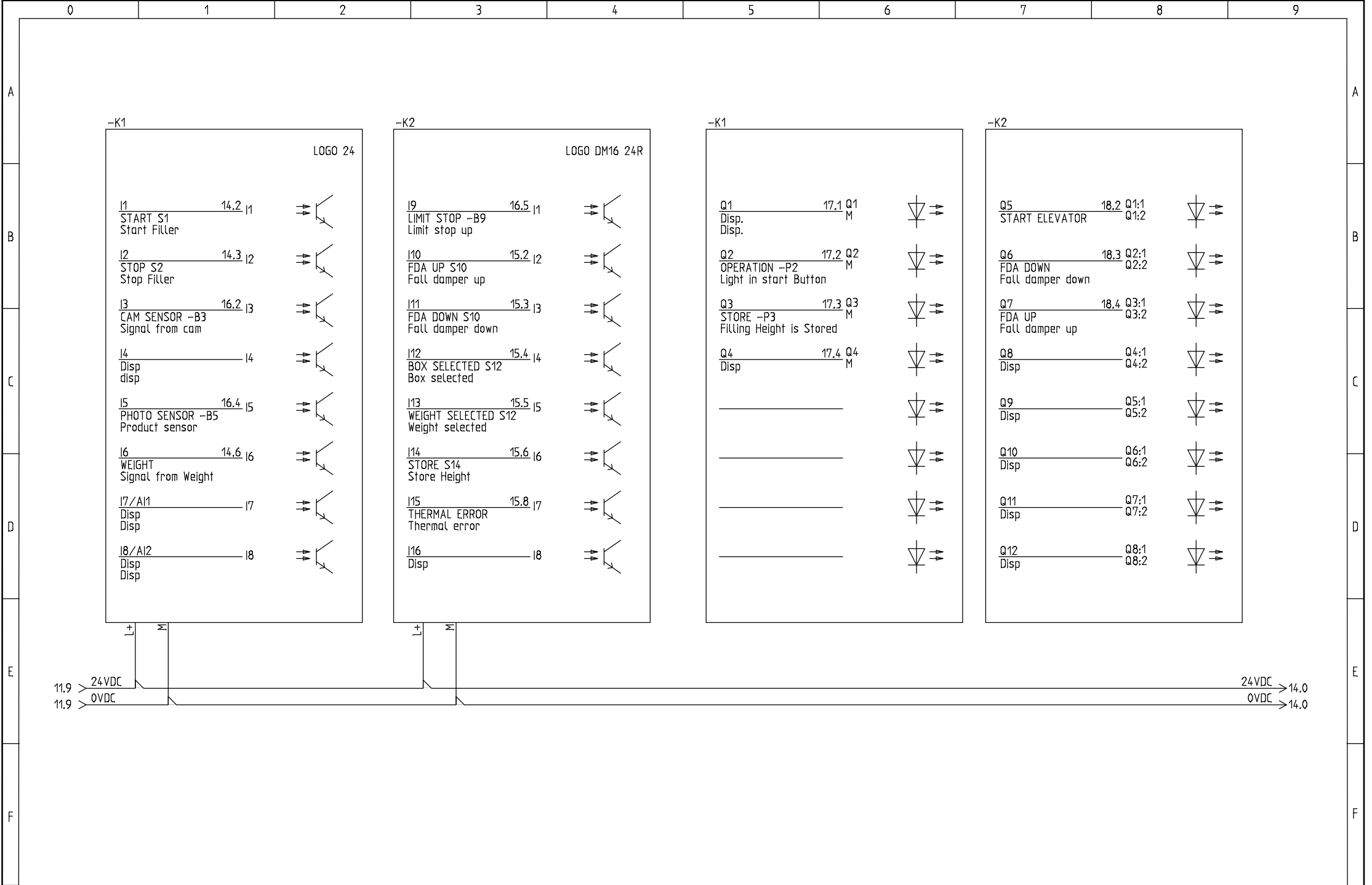


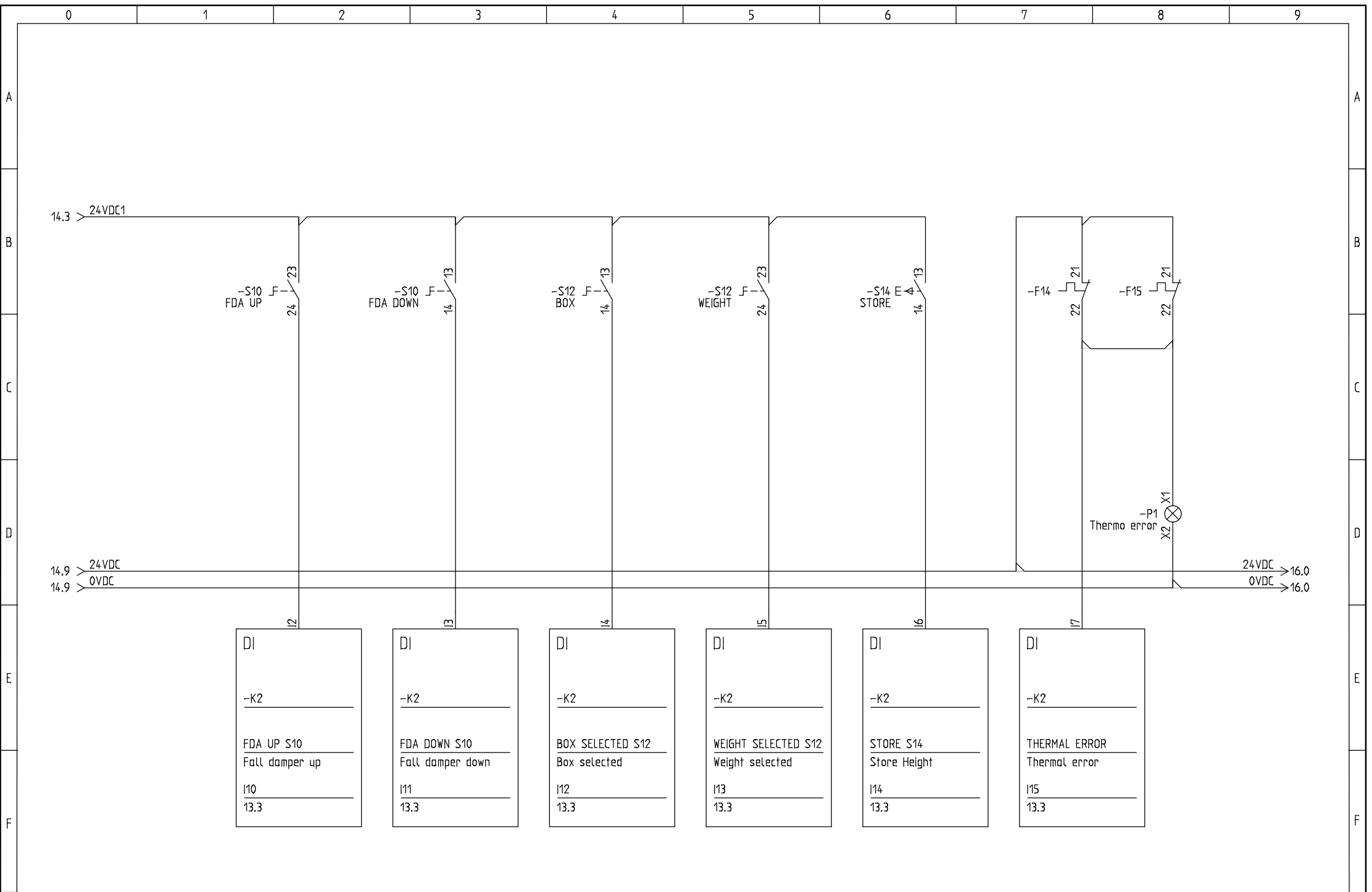
FDA = Faldtæpper
ELE = Elevator
SOP = Selvejre omgang

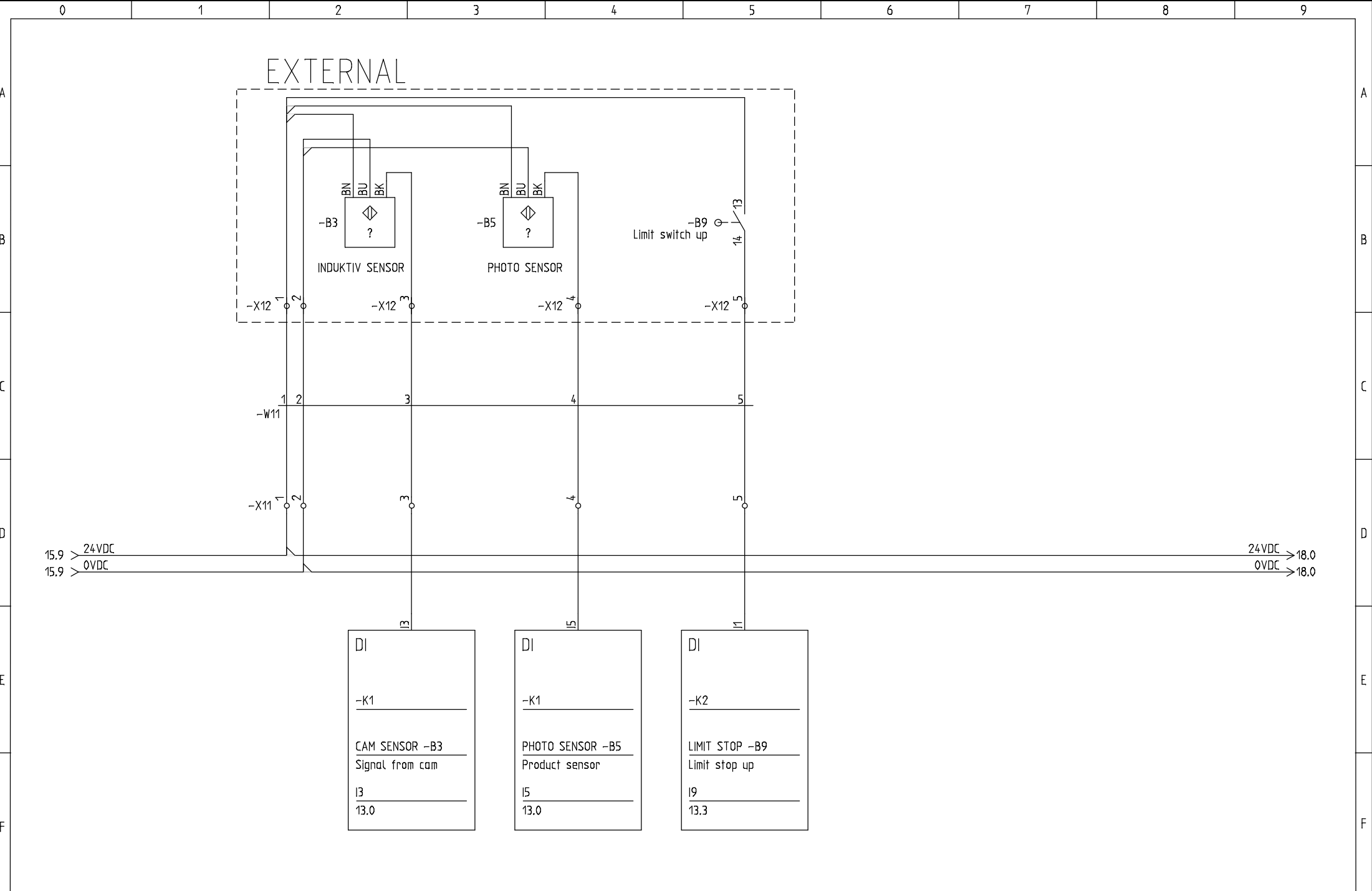


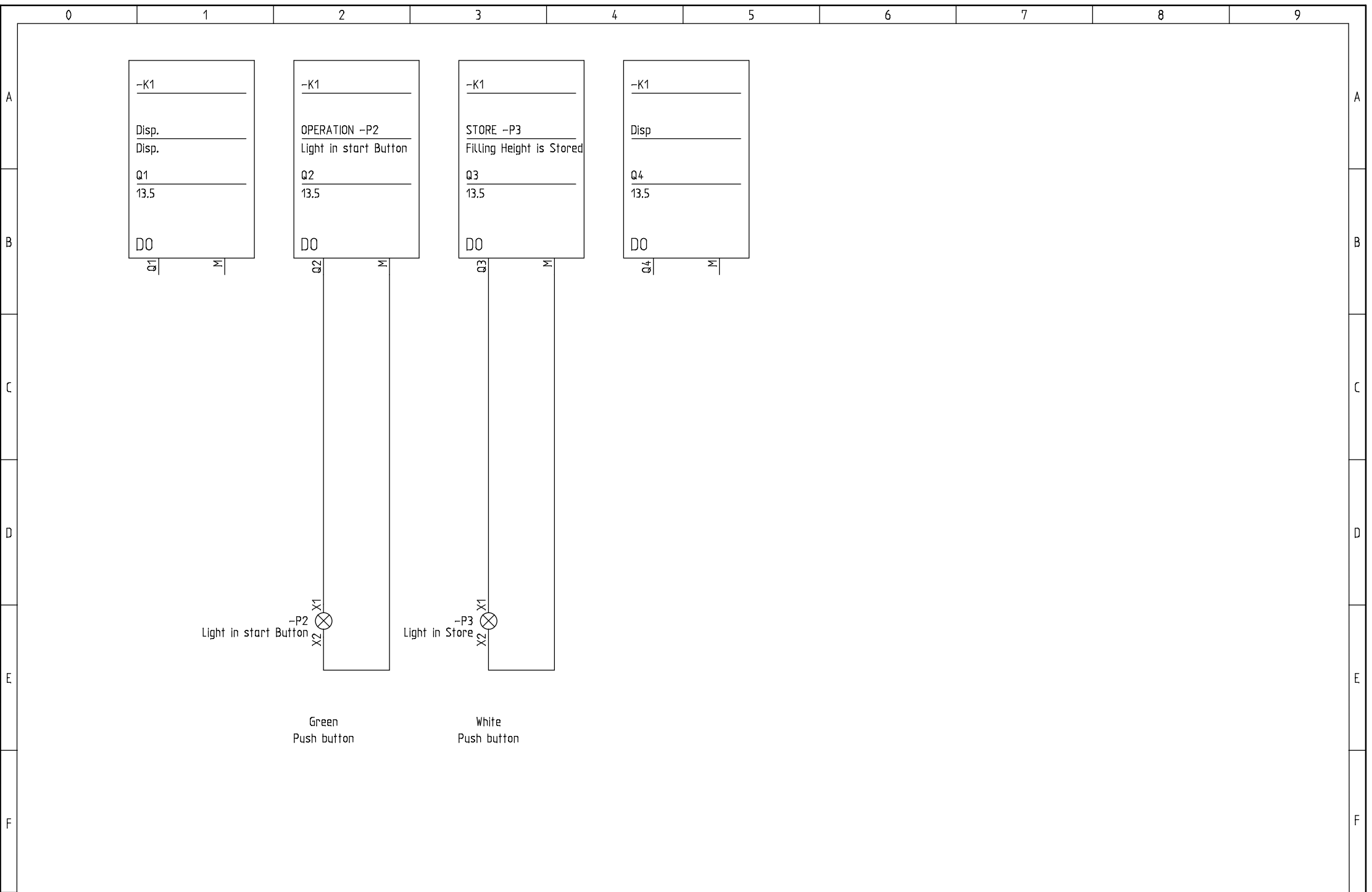


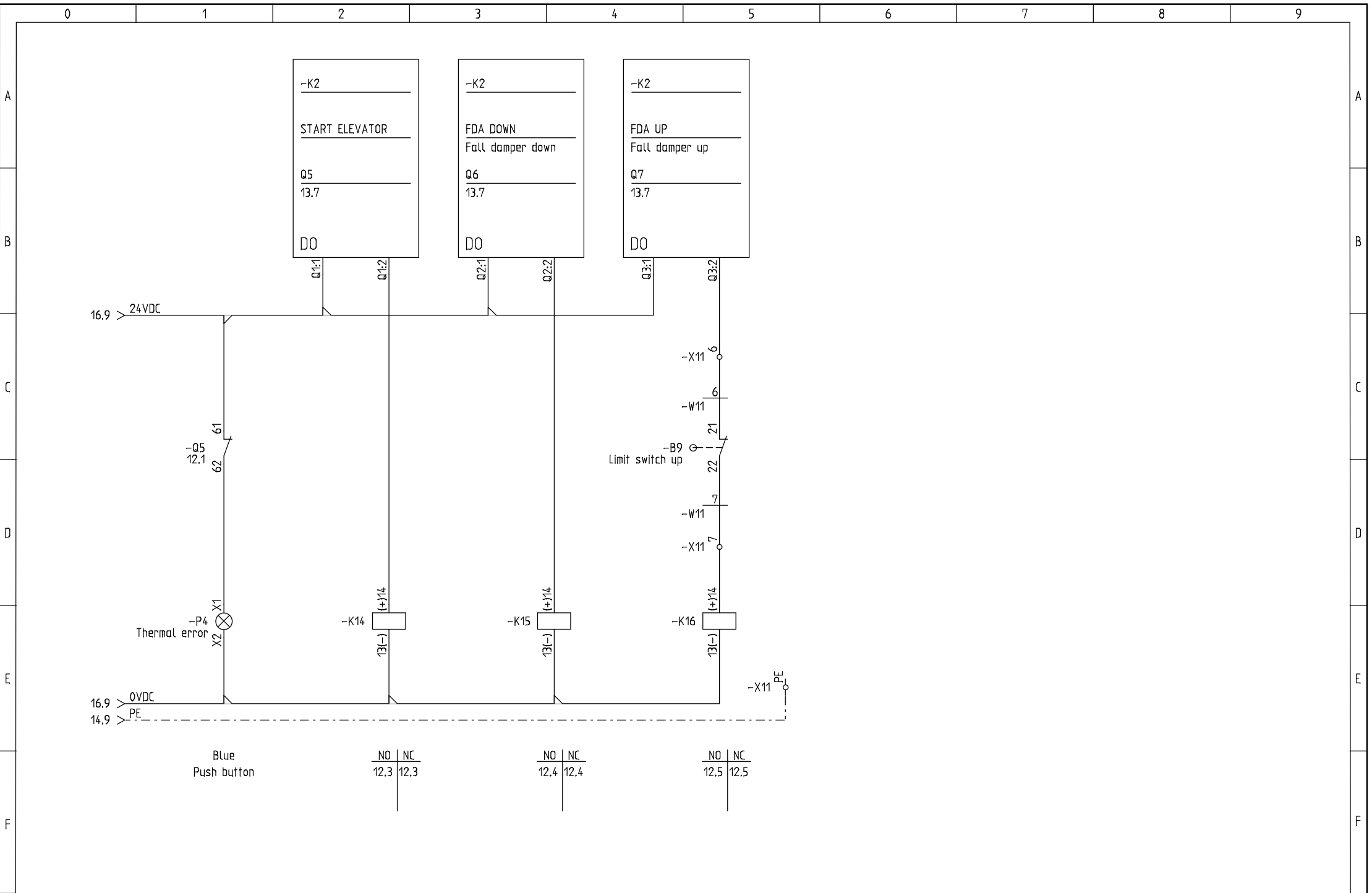













Spare part list

Function (=)	Place (+)	Product (-)	Type	Number	Deliver	Brand	EAN 13						
		-B3	INDUKTIV	1.00	Skals MaskinFabrik								
		-B5	Photo Sensor	1.00	Skals MaskinFabrik								
		-B9	Limit switch	1.00	Skals MaskinFabrik								
		-F1	E91S+N	1.00	AEG	AEG	5413656810698						
		-F4	DPA51CM44	1.00	Carlo Gavazzi	Carlo Gavazzi	8030956000566						
		-F5	440R-N23114	1.00	Solar	GUARDMARSTER	5703847851983						
		-F14	140M-C2E-B40	1.00	Allan bradley	Allen Bradley	5703847303574						
		-F15	140M-C2E-B10	1.00	Allan bradley	Allen Bradley	5703847303543						
		-K1	LOGO 24	1.00	Solar	Siemens	6940408100978						
		-K2	LOGO DM16 24R	1.00	Solar	Siemens	4025515071372						
		-K14	SH1B-05C	1.00	Solar	IDEC	57003436004257						
		-K14	RH1B-UL 24VDC	1.00	Solar	IDEC	57003436000471						
		-K15	SH1B-05C	1.00	Solar	IDEC	57003436004257						
		-K15	RH1B-UL 24VDC	1.00	Solar	IDEC	57003436000471						
		-K16	SH1B-05C	1.00	Solar	IDEC	57003436004257						
		-K16	RH1B-UL 24VDC	1.00	Solar	IDEC	57003436000471						
		-K100	RH1B-UL 24VDC	1.00	Solar	IDEC	57003436000471						
		-K100	SH1B-05C	1.00	Solar	IDEC	57003436004257						
		-M2	M1	1.00	Skals MaskinFabrik	DR Drives							
		-M3	M2	1.00	Skals MaskinFabrik	DR Drives							
		-P1	800F-N3W	1.00	Allan bradley	Allen Bradley	5703847848471						
		-P1.	800FP-P4	1.00	Allan bradley	Allen-Bradley	5703847848136						
		-P2	800F-N3W	1.00	Allan bradley	Allen Bradley	5703847848471						
		-P3	800F-N3W	1.00	Allan bradley	Allen Bradley	5703847848471						
		-P4	800F-N3W	1.00	Allan bradley	Allen Bradley	5703847848471						
		-Q0	194E-A25-NP	1.00	Allan bradley	Allen Bradley	5703847167183						
		-Q0	194E-E25-1753	1.00	Allan bradley	Allen Bradley	5703847167145						
		-Q5	100-K09KF01	1.00	Allan bradley	Allen bradley	5703847895369						
		-Q14	100-K09KF01	1.00	Allan bradley	Allen bradley	5703847895369						
		-Q15	100-K09KF01	1.00	Allan bradley	Allen bradley	5703847895369						
<div><div>SKALS</div><div>- we'll sort it out!</div></div>		Skals Maskin Fabrik Hovedgaden 56 Skals		BOX / BAG Filler KSF640 / 650		Proj. no.: KSF640-650_V03_EN		Rev.: 16-03-2011		Item Des.		Page: 100	
						Date: 24-02-2011		Doc. no.:		Ver.:		Created by:	

Spare part list

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		-S1	800F-X10	1.00	Allan bradley	Allan Bradley	5703847849096				
		-S1.	800FP-LF3	1.00	Allan bradley	Allan Bradley	5703847847788				
		-S2	800F-X01	1.00	Allan bradley	Allan Bradley	5703847849102				
		-S2.	800FP-LF4	1.00	Allan bradley	Allan Bradley	5703847847795				
		-S10	800F-X10	2.00	Allan bradley	Allan Bradley	5703847849096				
		-S10.	800FP-SB32	1.00	Allan bradley	Allan Bradley	5703847848747				
		-S12	800F-X10	2.00	Allan bradley	Allan Bradley	5703847849096				
		-S12.	800FP-SB32	1.00	Allan bradley	Allan Bradley	5703847848747				
		-S14	800F-X10	1.00	Allan bradley	Allan Bradley	5703847849096				
		-S14.	800FP-LF7	1.00	Allan bradley	Allan Bradley	5703847847825				
		-S30	800F-X01	2.00	Allan bradley	Allan Bradley	5703847849102				
		-S30.	800F-15YSE112	1.00	Allan bradley	Allan Bradley	5703847894775				
		-S30.	800FM-MT44	1.00	Allan bradley	Allan Bradley	5703847849997				
		-S31	800F-X10	1.00	Allan bradley	Allan Bradley	5703847849096				
		-S31.	800FP-LF6	1.00	Allan bradley	Allan Bradley	5703847847818				
		-T1	24VDC 2,5A	1.00	Solar	Siemens	4025515150923				
		-T2	Trafo 0,1KVA	1.00	Solar	Siemens	4001869901138				
		-U	1492-ERL35	1.00	Allan bradley	Allan Bradley	5703847870625				
		-U31	25X60	1.00	Lemvigh Müller	VANPEE & WESTERBERG A/S	3245066361024				
		-U32	25X60	1.00	Lemvigh Müller	VANPEE & WESTERBERG A/S	3245066361024				
		-U37	25X60	1.00	Lemvigh Müller	VANPEE & WESTERBERG A/S	3245066361024				
		-U38	25X60	1.00	Lemvigh Müller	VANPEE & WESTERBERG A/S	3245066361024				
		-U39	TS35	1.00	Solar		8016445000057				
		-U40	TS35	1.00	Solar		8016445000057				
		-U42	TS35	1.00	Solar		8016445000057				
		-U43	TS35	1.00	Solar		8016445000057				
		-U44	1492-ERL35	1.00	Allan bradley	Allan Bradley	5703847870625				
		-U45	1492-ERL35	1.00	Allan bradley	Allan Bradley	5703847870625				
		-U46	1492-ERL35	1.00	Allan bradley	Allan Bradley	5703847870625				
 - we'll sort it out!		Skats Maskin Fabrik Hovedgaden 56 Skats		BOX / BAG Filler KSF640 / 650		Proj. no.: KSF640-650_V03_EN		Rev.: 16-03-2011	Item Des.		Page: 101
						Date: 24-02-2011		Doc. no.:		Ver.:	Created by:

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Function (=)	Place (+)	Product (-)	Type	Number	Deliver	Brand	EAN 13
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		-U50	1492-ERL35	1.00	Allan bradley	Allan Bradley	5703847870625
		-U51	1492-ERL35	1.00	Allan bradley	Allan Bradley	5703847870625
		-U52	1492-ERL35	1.00	Allan bradley	Allan Bradley	5703847870625
		-U53	1492-ERL35	1.00	Allan bradley	Allan Bradley	5703847870625
		-U54	1492-ERL35	1.00	Allan bradley	Allan Bradley	5703847870625
		-U55	PG16	1.00	Solar	Jacob	5705151001139
		-U56	PG9	1.00	Solar	Jacob	4024092012150
		-U57	PG16	1.00	Solar	Jacob	5705151001139
		-U58	PG16	1.00	Solar	Jacob	5705151001139
		-U59	PG16	1.00	Solar	Jacob	5705151001139
		-U60	PG9	1.00	Solar	Jacob	4024092012150
		-U61	CRN64200	1.00	Solar	Himel-Sarel	3606480159329
		-U62	25X60	1.00	Lemvigh Møller	VANPEE & WESTERBERG A/S	3245066361024
		-U63	1492-ERL35	1.00	Allan bradley	Allan Bradley	5703847870625
		-U64	1492-ERL35	1.00	Allan bradley	Allan Bradley	5703847870625
		-U65	25X60	1.00	Lemvigh Møller	VANPEE & WESTERBERG A/S	3245066361024
		-X1	1492-LG3T	1.00	Allan bradley	Allan bradley	5703847868325
		-X1	1492-L3T	4.00	Allan bradley	Allan bradley	5703847867267
		-X2	1492-LG3T	1.00	Allan bradley	Allan bradley	5703847868325
		-X2	1492-L3T	3.00	Allan bradley	Allan bradley	5703847867267
		-X3	1492-L3T	3.00	Allan bradley	Allan bradley	5703847867267
		-X3	1492-LG3T	1.00	Allan bradley	Allan bradley	5703847868325
		-X10	1492-LG3T	1.00	Allan bradley	Allan bradley	5703847868325
		-X10	1492-L3T	3.00	Allan bradley	Allan bradley	5703847867267
		-X10	1492-L3Q	1.00	Allan bradley	Allan bradley	5703847867076
		-X11	1492-L3T	7.00	Allan bradley	Allan bradley	5703847867267
		-X11	1492-LG3T	1.00	Allan bradley	Allan bradley	5703847868325



Skals Maskin Fabrik
Hovedgaden 56
Skals

BOX / BAG Filler
KSF640 / 650

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Created by:

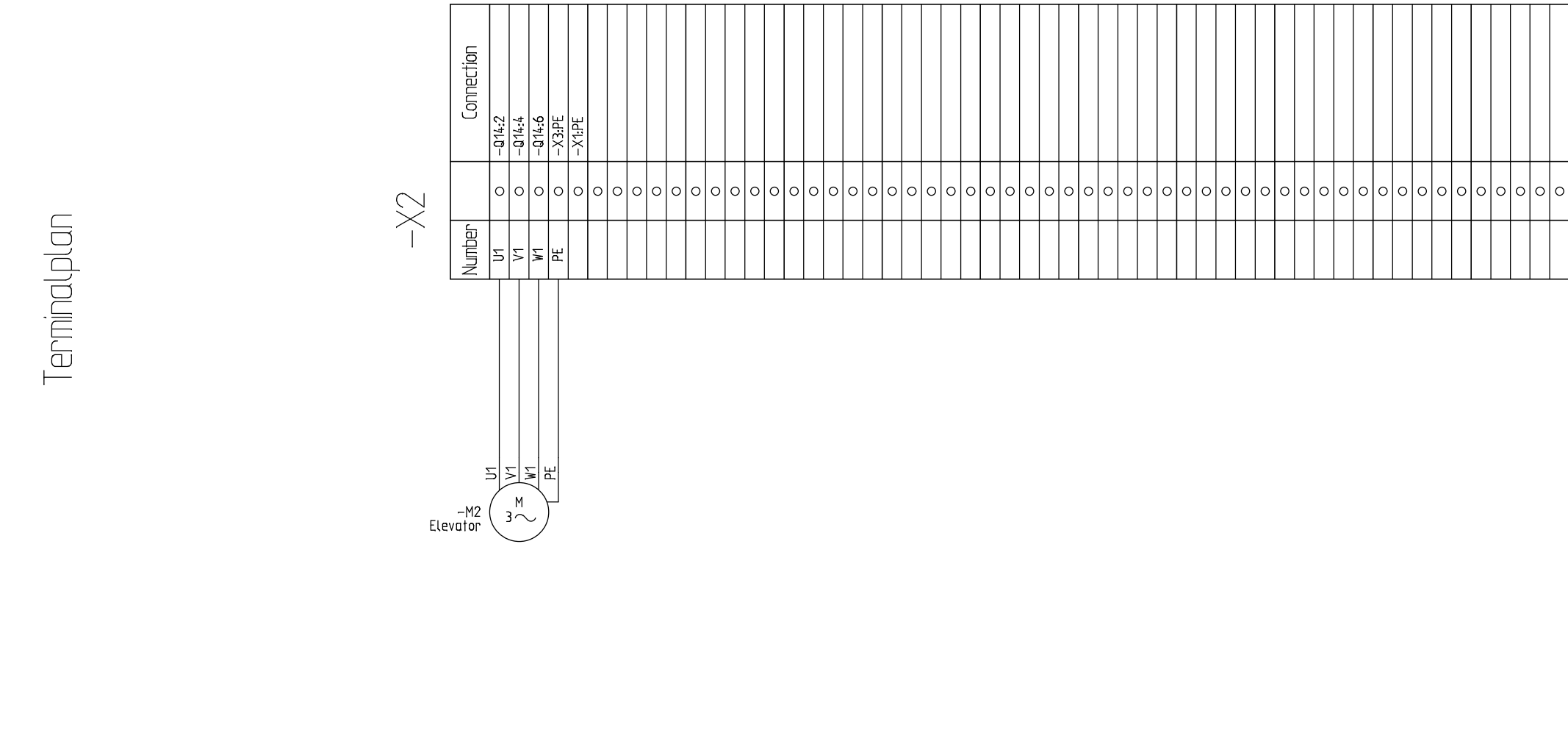
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Part list

Qty.	Type	Supplier	Brand	Decription	EAN 13				
1.00	E91S+N	AEG	AEG	Fuse C6 1P+N	5413656810698				
4.00	100-K09KF01	Allan bradley	Allan bradley	Contacto K09KF01 230V	5703847895369				
1.00	140M-C2E-B10	Allan bradley	Allen Bradley	Motor Protection Circuit Breaker.0,63-1A	5703847303543				
1.00	140M-C2E-B40	Allan bradley	Allen Bradley	Motor Protection Circuit Breaker.2,5-4A	5703847303574				
13.00	1492-ERL35	Allan bradley	Allan Bradley	ENDCLIPS 1492-ERL35	5703847870625				
1.00	1492-L3Q	Allan bradley	Allan bradley	Terminal L3Q	5703847867076				
20.00	1492-L3T	Allan bradley	Allan bradley	Terminal L3T	5703847867267				
5.00	1492-LG3T	Allan bradley	Allan bradley	PE Terminal LG3T	5703847868325				
1.00	194E-A25-NP	Allan bradley	Allan Bradley	N-CONTACTELEMENT	5703847167183				
1.00	194E-E25-1753	Allan bradley	Allan Bradley	Switch. 3P 0-1 90GR	5703847167145				
1.00	800F-15YSE112	Allan bradley	Allan Bradley	EMERGENCY STOP Ø60	5703847894775				
1.00	800FM-MT44	Allan bradley	Allan Bradley	Emergency Push button Ø40	5703847849997				
4.00	800F-N3W	Allan bradley	Allan Bradley	LAMP LED Withe 24VAC/DC	5703847848471				
1.00	800FP-LF3	Allan bradley	Allan Bradley	LAMP Push button Green	5703847847788				
1.00	800FP-LF4	Allan bradley	Allan Bradley	LAMP Push button Red	5703847847795				
1.00	800FP-LF6	Allan bradley	Allan Bradley	LAMP Push button Blue	5703847847818				
1.00	800FP-LF7	Allan bradley	Allan Bradley	LAMP Push button Clear	5703847847825				
1.00	800FP-P4	Allan bradley	Allen-Bradley	Pilot Light Red	5703847848136				
2.00	800FP-SB32	Allan bradley	Allan Bradley	Selector Switch 3 pos. Return from R/L	5703847848747				
3.00	800F-X01	Allan bradley	Allan Bradley	Contact NC	5703847849102				
7.00	800F-X10	Allan bradley	Allan Bradley	Contact NO	5703847849096				
1.00	DPA51CM44	Carlo Gavazzi	Carlo Gavazzi	Phase relay	8030956000566				
6.00	25X60	Lemvig Müller	VANPEE & WESTERBERG A/S	Cabel canal	3245066361024				
1.00	Limit stop	Skals MaskinFabrik		Limit stop					
1.00	Photo sensor	Skals MaskinFabrik		Photo sensor					
1.00	INDUCTIV	Skals MaskinFabrik		Inductiv sensor					
1.00	M1	Skals MaskinFabrik	DR Drives	Motor1					
1.00	M2	Skals MaskinFabrik	DR Drives	Motor2					
1.00	24VDC 2,5A	Solar	Siemens	LOGO Power 24VDC 2,5A	4025515150923				
1.00	440R-N23114	Solar	GUARDMARSTER	Safety relay	5703847851983				
<div><div><div>SKALS</div><div>- we'll sort it out!</div></div></div> <div>Skals Maskin Fabrik Hovedgaden 56 Skals</div>		BOX / BAG Filler KSF640 / 650		Proj. no.: KSF640-650_V03_EN		Rev.: 16-03-2011	Item Des.		Page: 200
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Nummer		Tilslutning
1		24VDC
2		-K1:1
3		24VDC
4		-K1:16
PE		PE
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		
		

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