

Graco F█ Mixed Meter Operating Procedure

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Revision #: █

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DOCUMENT APPROVALS:

Document Approval Requirements	Approved By	Date
VP of Operations: (Required: SOPs, and Work Instructions that affect more than one facility)		
Director Customer Quality: (Required: SOPs, and Work Instructions, that affect more than one facility)		
Operations Management: (Required: SOPs, and Work Instructions, that affect only one facility)	N/A	N/A
Quality Engineer: (Required: SOPs, and Work Instructions that affect only one facility)	N/A	N/A

PURPOSE:

The purpose of this document is to outline and detail the operating steps for the Graco F█ Mixed Meter.

SCOPE:

This document is applicable to █ facilities per █ Controlled Document Index.

RESPONSIBILITIES:

Operator/Supervisor: Gloves must be worn when touching process material or process contact surfaces.

REFERENCE DOCUMENTS:

N/A

DEFINITIONS:

N/A

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EXHIBITS:

- Attachment 1: Pressure Relief Procedure
- Attachment 2: Startup
- Attachment 3: Flow Meter Verification
- Attachment 4: Ratio Check
- Attachment 5: Set the Color Stack and Color Percentage

PROCESS:

1. The Graco [REDACTED] Mixed Meter will operate to mix Liquid Silicone Rubber (LSR) for injection into a Silicone Mold Press Machine.
2. This procedure outlines the steps to take to perform the key operating processes to Start, Set-up, Purge, Verify and connect the appropriate LSR supply to the Silicone Mold Press.
3. This procedure does not outline operations for the Silicone Mold Press.
4. Changeover:
 - 4.1. Pressure Relief Procedure:
 - 4.1.1. Follow Steps in Attachment 1: Pressure Relief Procedure

NOTE: Ensure a container for catching overflow material is placed under valves as they are opened to release pressure
 - 4.2. Startup:
 - 4.2.1. Follow Steps in Attachment 2: Startup
 - 4.2.1.1. Step 6: Set Pressure to 20psig

NOTE: If going straight into material purge, set pressure to 65 ± 5 psig

 - 4.2.1.2. Step 7: Deleted when raising the pump head

NOTE: If going straight into material purge, perform the following

 - 4.2.1.2.1. Verify the ram director valves of the rams are set to lower the ram.
 - 4.3. Lift and Clean Pump Head
 - 4.3.1. Press the push button and Lift lever up on the air control module controlling the head to be raised:

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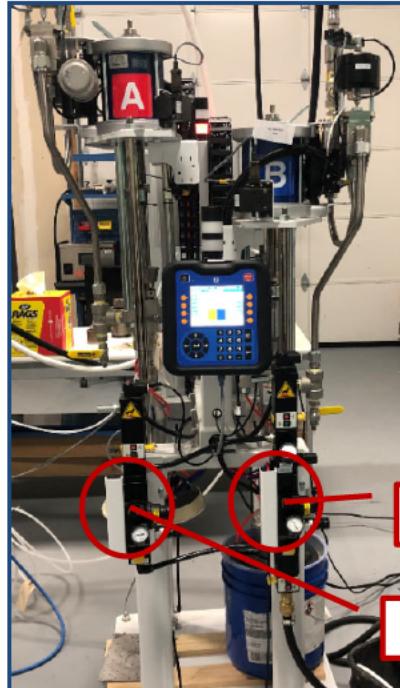
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4.3.1.1. Head A: Left Lever as viewing the machine

4.3.1.2. Head B: Right Lever as viewing the Machine

NOTE: When platen is near top of bucket, raise the platen with short, light bursts to prevent silicone material from spraying out of bucket



4.3.1.3.

Figure 1 – Machine view with Head A Raised

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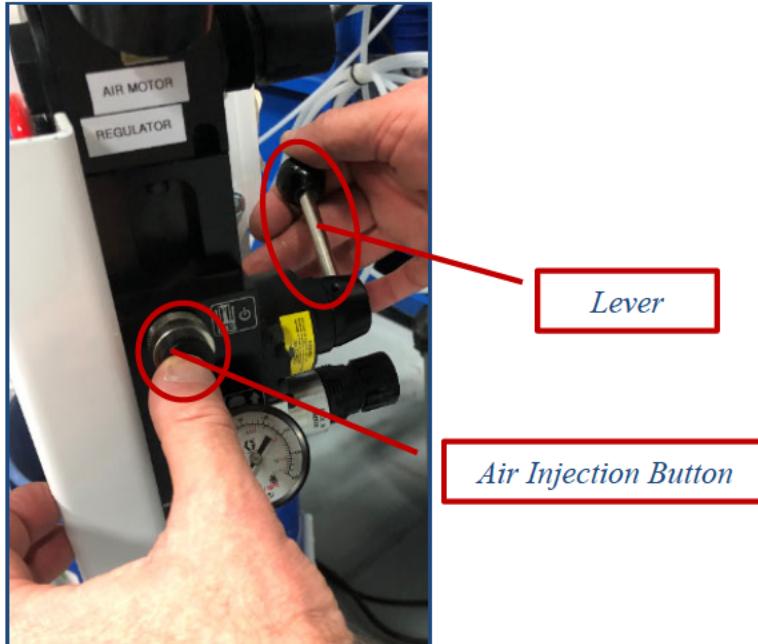


Figure 2 – Lifting lever and injecting air to raise Head [B]

4.3.2. Clean Head Gasket

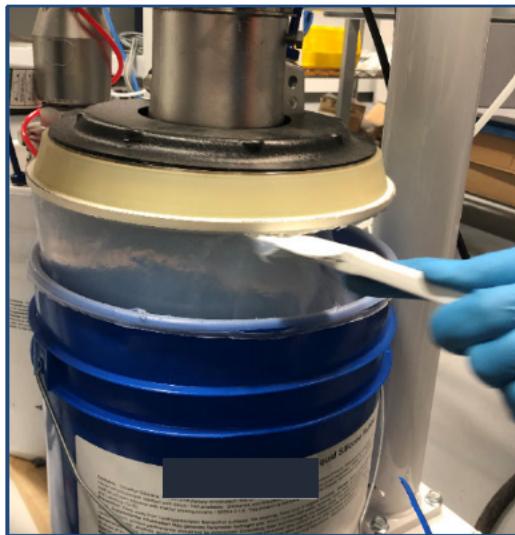


Figure 3 – Cleaning Pump Head with Spatula