

# Graco F Mixed Meter Operating Procedure

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## DOCUMENT APPROVALS:

Document Approval Requirements	Approved By	Date
<b>VP of Operations:</b> (Required: SOPs, and Work Instructions that affect more than one facility)		
<b>Director Customer Quality:</b> (Required: SOPs, and Work Instructions, that affect more than one facility)		
<b>Operations Management:</b> (Required: SOPs, and Work Instructions, that affect only one facility)	N/A	N/A
<b>Quality Engineer:</b> (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 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±5psig
      - 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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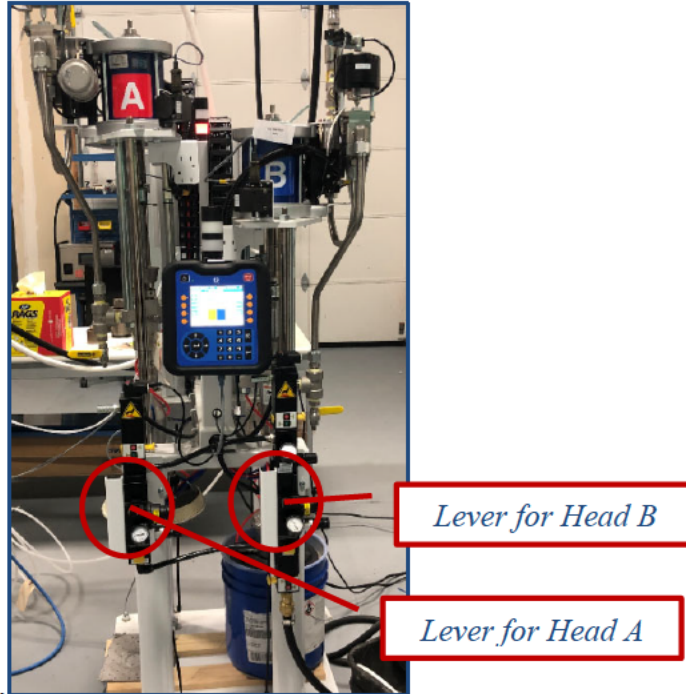
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4.3.1.1. Head A: Left Lever as viewing the machine

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.

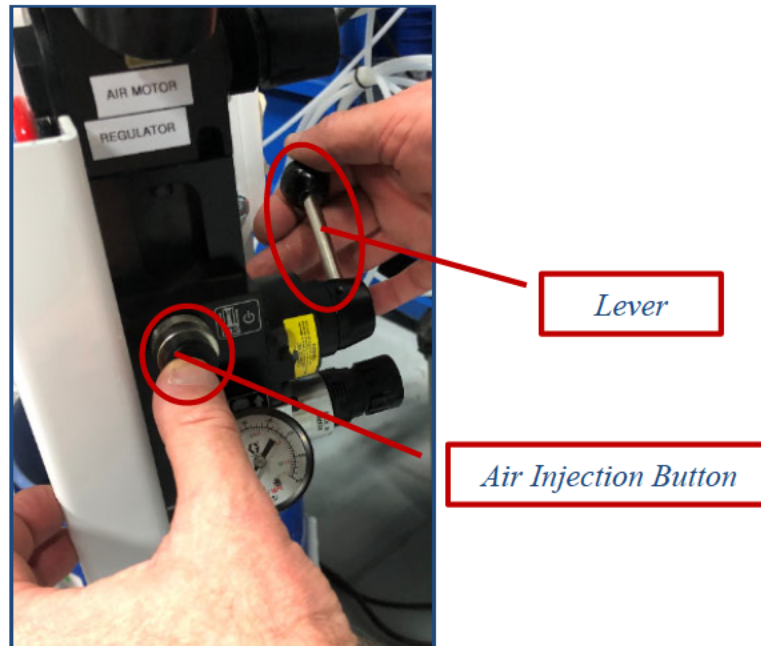
*Figure 1 – Machine view with Head A Raised*

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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*