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## SERVICE REPORT

**Date:-** 3<sup>rd</sup> September 2016 - 10<sup>th</sup> September 2016  
**Contract number:-** 21861, 21862, 21863  
**Equipment Type:-** 310MD Press, Belt Sealer, Line equipment  
**Customer:-** Unilever Russia  
**Purpose of the visit:-** Controls, Initial install and machine start up.

Sat 3/9/2016 Travel

Sun 4/9/2016 At Hotel 13:00

Mon 5/9/2016  
07:45 Start

Many delays getting through security and induction.  
Get to machine 11:00

Interconnects wired.

Low oil lube pressure fault removed if off.

Sealer conveyor height has been adjusted, everything has to be adjusted to suit. Cap applicator needs adjusting to suit.

Told not to undertake high work Unilever contractors will sort. Customer request we not arrive on site till 8:30 in the morning.

19:00 back at Hotel.

Tue 6/9/2016  
08:00 Start.

Wire in estop interconnect Press<->Sealer. Mark up drawings.

Separator and side belt indication set at Zero fully in to conveyor. Increase as wind out. One took 1000 revs to zero.

New date time setting screen added.

Password levels for operator access added. To only change recipe and slightly tune height.

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18:00 back at hotel.

Wednesday 9/7/2016

08:00 Start.

Press comms error keeps coming up. Timeout is set to 2500ms generally gets to 1000ms which is what you'd expect from 2s pulse. However if one cycle is missed will not deal with it therefore increased to 4000ms.

Time which was taken up to 20min dropped to 1 min. FC35 NW1  
Cap folding under issues.

1000s of containers run to get white container sorted.

Final run of approx. 400 all good.

Get back to hotel 19:05

15 min email.

Thu 8/9/2016

8:00 Start

Fix broken grease fitting on press head.

Customer wants Fault when only 1 missed cap detected, code changed.  
FC31 No Cap

Power and encoder for servo moved to left to allow shorter route for interconnects.

Interconnects properly fitted.

Early start requested by customer for Friday

19:15 back at hotel

Fri 9/9/2016

07:15 Start

PLC backups given to customer.  
Elec drawings given

eWon connection explained.

10:30 small run of filled jars.

Q back on delay timer changed from 100ms to 400ms.

Some caps coming off after applying.

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Many problems with downstream boxer holding up tests.

Filler speed ramped from 60 CPM to 100 CPM filler completely fails tests stopped.

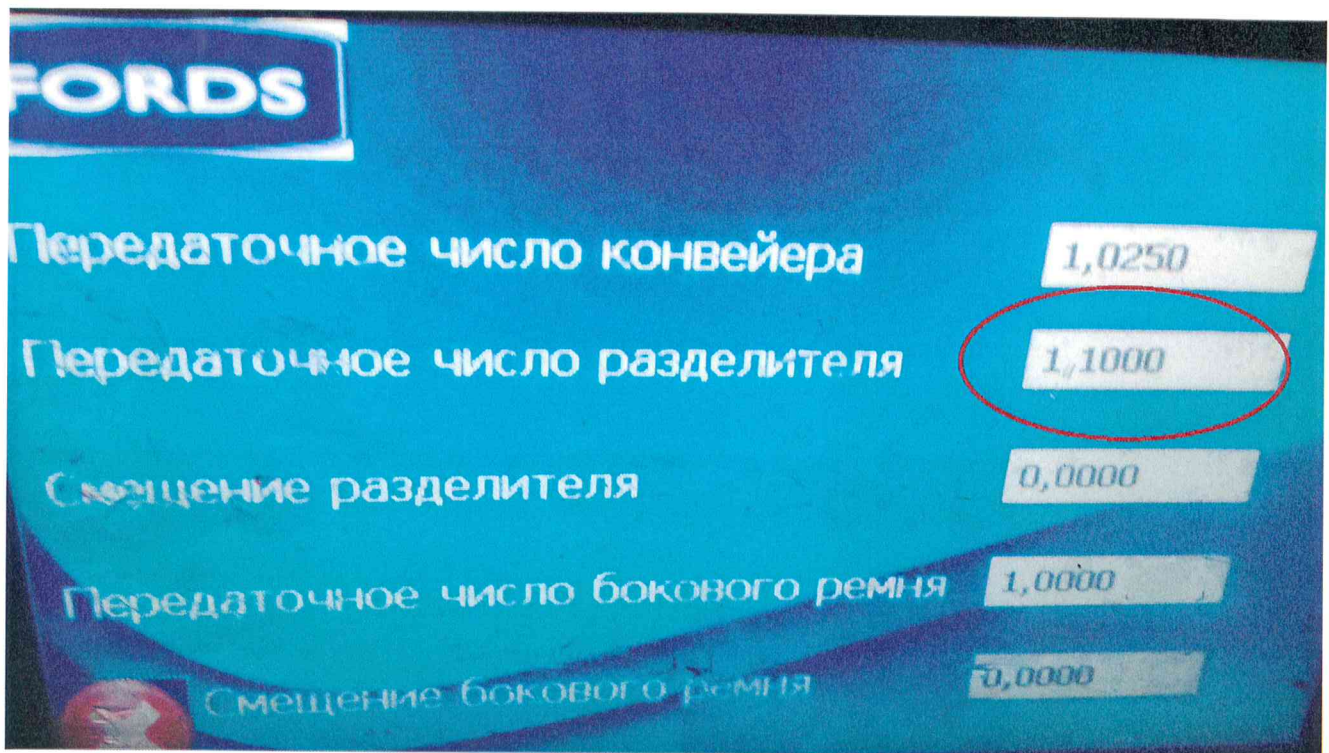
Conclusions:

Machine control fully setup and running.



Recommendations;

Once in production speed of separator wheels may need some fine tuning. See screen shots below:





**Machine Parameters:**

▼ ParameterSet[2]	*Parameter Set*	148.0		
■ Number	Int	0.0	8	2
■ Name	String[22]	2.0	'Recipe'	'White'
■ Sealer Height	Real	26.0	120.0	46.5
■ Belt Speed	Real	30.0	24.0	24.0
■ Sealer Power	Int	34.0	75	83
■ rOutput1OnAn...	Real	36.0	0.0	1.0
■ rOutput1OffAn...	Real	40.0	221.0	221.0
■ rOutput2OnAn...	Real	44.0	222.0	222.0
■ rOutput2OffAn...	Real	48.0	350.0	350.0
■ rConveyorRatio	Real	52.0	1.0	1.025
■ rSeparatorRatio	Real	56.0	1.0	0.75
■ rSideBeltRatio	Real	60.0	1.0	1.0
■ iSideBeltPos	Int	64.0	10	76
■ iSeparatorPos	Int	66.0	20	82
■ iColour	Int	68.0	1	2
■ rCPM	Real	70.0	100.0	100.0

▼ ParameterSet[1]	*Parameter Set*	74.0		
■ Number	Int	0.0	8	1
■ Name	String[22]	2.0	'Recipe'	'green'
■ Sealer Height	Real	26.0	120.0	51.5
■ Belt Speed	Real	30.0	24.0	24.0
■ Sealer Power	Int	34.0	75	81
■ rOutput1OnAn...	Real	36.0	0.0	1.0
■ rOutput1OffAn...	Real	40.0	221.0	221.0
■ rOutput2OnAn...	Real	44.0	222.0	222.0
■ rOutput2OffAn...	Real	48.0	350.0	350.0
■ rConveyorRatio	Real	52.0	1.0	1.025
■ rSeparatorRatio	Real	56.0	1.0	1.1
■ rSideBeltRatio	Real	60.0	1.0	1.0
■ iSideBeltPos	Int	64.0	10	64
■ iSeparatorPos	Int	66.0	20	58
■ iColour	Int	68.0	1	1
■ rCPM	Real	70.0	100.0	100.0

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