

1250M Auto Prime



Table of contents

Section 1: Auto Prime

- Introduction to Auto Prime

- Auto Prime steps 1-7

Section 2: Abort Auto Prime

- Introduction to abort Auto Prime BEFORE production

- Abort Auto Prime steps 1-3

- Introduction to abort Auto Prime DURING production

- Abort Auto Prime steps 1-11

Section 1

Auto Prime



Introduction to Auto Prime

Auto Prime is a feature that allows the operator to load the machine with little human interaction.

The Auto Prime feature on the 1250M is especially easy to navigate and execute. Please follow the steps and notes below to properly execute the Auto Prime sequence.

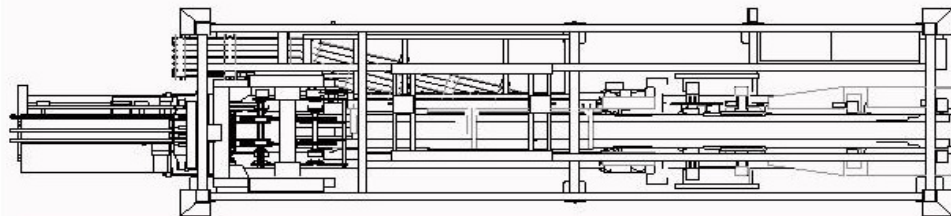
Before Starting

Make sure that all gates are clear of any cans. Also check to make sure that no cans were left in between the gates and the metering/grouping conveyors. This will avoid for a big mess upon start of the Auto Prime sequence.

Make sure that the machine is empty before starting Auto Prime. To verify that the machine is empty look at the “Product in Machine” button towards lower left of HMI main screen (see picture next page). If it’s not illuminated then the machine is empty.

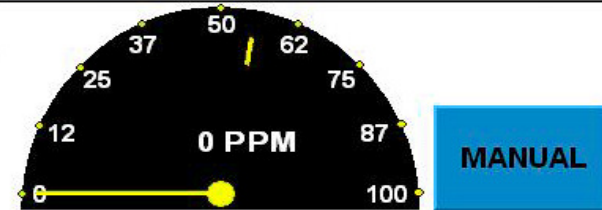
VERSION 2.6.8
SERIAL # 1095

MeadWestvaco



INDEX FEEDER	PRIME INFEED CONVEYOR	PRODUCT FAULT BYPASS	LUBE
GLUE TANK READY 	PRODUCT IN MACHINE 	CIP ACTIVE	

RUNOUT	AUTO PRIME
CLEAR OUT	METERING CONVEYOR BRAKE RELEASE



PACK COUNTER

3042

SHIFT 1 COUNTER

6



4X6X1 12 oz CAN DuoDozen

VACUUM WHEEL 1

ON

OFF

VACUUM WHEELS 2 & 3

ON

OFF



PACK HOLD-DOWN



GLUE CARRIAGE



MAGAZINE SLIDE



Automatic

Operator

7:26:04 AM

11/11/2014

Run Screen

Diagnose

Reports

Maintenance

Configuration

Change
Language

Login



Remote Run

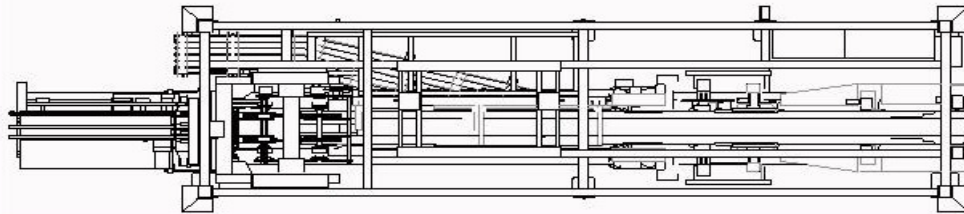
Step 1 - Enable

Press the Auto Prime button. Once this button is illuminated, this means that the machine is ready to run Auto Prime.

See photo next page

VERSION 2.6.8
SERIAL # 1095

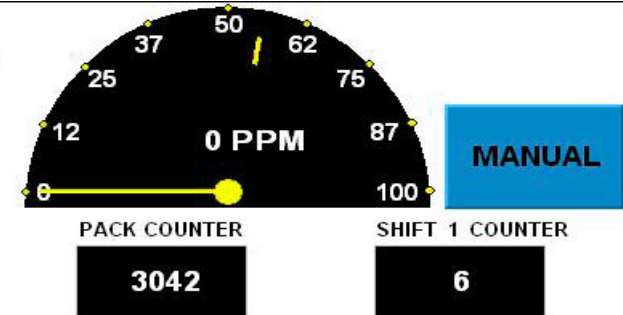
MeadWestvaco



VACCUM CONTROL NOT ALLOWED DURING AUTO PRIME

INDEX FEEDER	PRIME INFEED CONVEYOR	PRODUCT FAULT BYPASS	LUBE
GLUE TANK READY 	PRODUCT IN MACHINE 	CIP ACTIVE	

RUNOUT	AUTO PRIME
CLEAR OUT	METERING CONVEYOR BRAKE RELEASE



4X6X1 12 oz CAN DuoDozen

VACUUM WHEEL 1		VACUUM WHEELS 2 & 3	
PACK HOLD-DOWN		GLUE CARRIAGE	MAGAZINE SLIDE

Automatic

Operator

7:29:32 AM

11/11/2014

Run Screen	Diagnose	Reports	Maintenance	Configuration	Change Language	Login	
-------------------	----------	---------	-------------	---------------	--------------------	-------	--

Remote Run

Note

Once the Auto Prime button is pressed, all gates will close. The Run push button and Cycle Stop push button will begin flashing. (Green for the Run push button and Red for the Cycle Stop push button.)

See photo next page



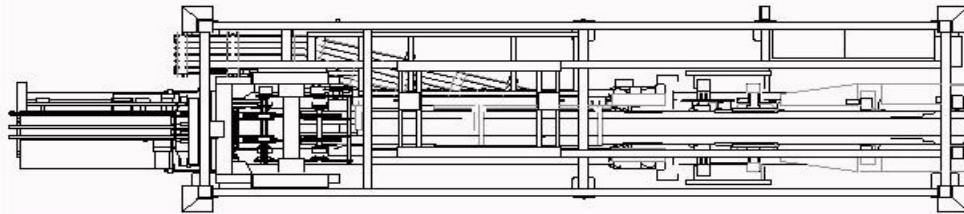
Step 2 – Prime Infeed

Press the prime infeed conveyor button to move cans up to the gates. This button is located directly above the Product in Machine indicator button.

See photo next page

VERSION 2.6.8
SERIAL # 1095

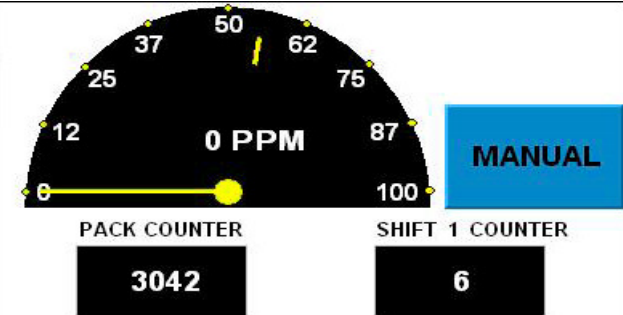
MeadWestvaco



VACCUM CONTROL NOT ALLOWED DURING AUTO PRIME

INDEX FEEDER	PRIME INFEEED	PRODUCT FAULT BYPASS	LUBE
GLUE TANK READY	PRODUCT IN MACHINE	CIP ACTIVE	

RUNOUT	AUTO PRIME
CLEAR OUT	METERING CONVEYOR BRAKE RELEASE



4X6X1 12 oz CAN DuoDozen

VACUUM WHEEL 1		VACUUM WHEELS 2 & 3	
ON	OFF	ON	OFF
PACK HOLD-DOWN		GLUE CARRIAGE	MAGAZINE SLIDE

Automatic

Operator

7:29:32 AM

11/11/2014

Run Screen	Diagnose	Reports	Maintenance	Configuration	Change Language	Login	Remote Run
------------	----------	---------	-------------	---------------	-----------------	-------	------------

Note

Once cans have made it to the Auto Prime gates, disengage the operator side light curtain and physically check to make sure that no cans have fallen during the prime infeed conveyor process.

Do not turn on the vacuum pumps!!!!

Vacuum pumps for Feeder Wheels 1-3 will start automatically once the Auto Prime process begins

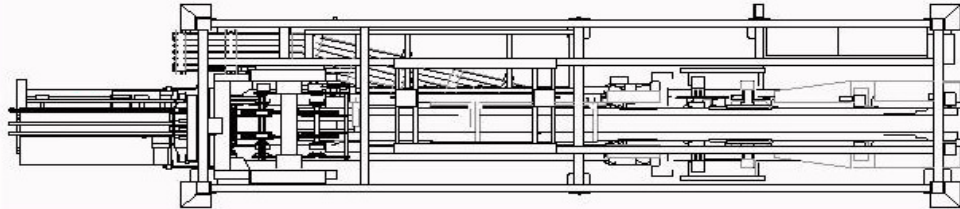
Step 3 - Run

Press the run button. Once the run button is pressed, the machine will start automatically and go through a series of cycles. Also the prime infeed conveyor will turn off and the product in machine indicator will illuminate

See photo next page

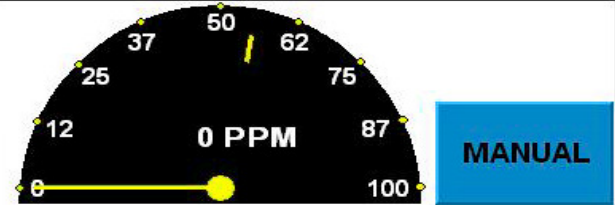
VERSION 2.6.8
SERIAL # 1095

MeadWestvaco



VACCUM CONTROL NOT ALLOWED DURING AUTO PRIME

INDEX FEEDER	PRIME INFEEED CONVEYOR	PRODUCT FAULT BYPASS	LUBE	RUNOUT	AUTO PRIME
GLUE TANK READY	PRODUCT IN MACHINE	CIP ACTIVE		CLEAR OUT	METERING CONVEYOR BRAKE RELEASE



PACK COUNTER

3042

SHIFT 1 COUNTER

6



4X6X1 12 oz CAN DuoDozen

VACUUM WHEEL 1



VACUUM WHEELS 2 & 3



PACK HOLD-DOWN



GLUE CARRIAGE



MAGAZINE SLIDE



Automatic

Operator

7:36:43 AM

11/11/2014

Run Screen

Diagnose

Reports

Maintenance

Configuration

Change Language

Login



Remote Run

Step 4 – Gates Cycle

As the Auto Prime process starts the vacuum pumps will engage automatically and cartons will be pulled to the first gate position.

Each cycle will begin with a horn burst and then the machine will automatically move to the appropriate cycle position, the gate that corresponds with the pocket will open and cans will file in to the metering and grouper conveyors.

Depending on the pack configuration the Auto Prime sequences will go through a series of cycles, one for each row of cans in the current pack format

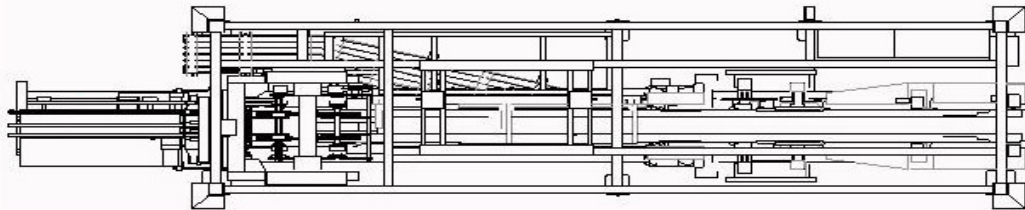
Step 4 continued...

Once the Auto Prime process has completed the machine will stop with leading pack in front of the loading wheels, so that the operator can check the pack for proper can placement. A message will display in the information box on the main run screen prompting you Auto Prime is done and to check pack.

See photo next page

VERSION 2.6.8
SERIAL # 1095

MeadWestvaco



VACUUM CONTROL NOT ALLOWED DURING AUTO PRIME

Auto Prime DONE. CHECK PACK

INDEX
FEEDER

PRIME
INFEED
CONVEYOR

PRODUCT
FAULT
BYPASS

LUBE

GLUE TANK
READY

PRODUCT IN
MACHINE

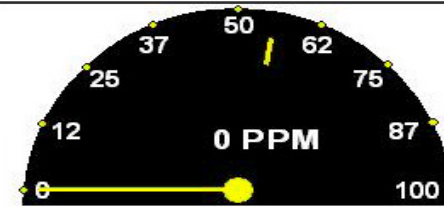
CIP
ACTIVE

RUNOUT

AUTO
PRIME

CLEAR OUT

METERING
CONVEYOR
BRAKE
RELEASE



PACK COUNTER

3042

SHIFT 1 COUNTER

6



4X6X12 oz CAN DuoDozen

VACUUM WHEEL 1

ON

OFF

VACUUM WHEELS 2 & 3

ON

OFF



PACK
HOLD-DOWN



GLUE
CARRIAGE



MAGAZINE
SLIDE



Automatic

Operator

7:36:43 AM

11/11/2014

Run Screen

Diagnose

Reports

Maintenance

Configuration

Change
Language

Login



Remote Run

Note

If so desired you can disengage the Auto Prime pack check. If this function is disengaged the Auto Prime sequence will not stop for a pack check and instead will go directly into production.

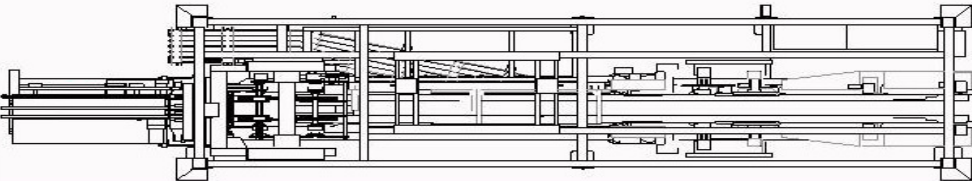
To disengage follow the photos and steps listed below.

Step 5 - Optional

Located on the Run screen. Press the Maintenance button

VERSION 2.6.8
SERIAL # 1095

MeadWestvaco



VACCUM CONTROL NOT ALLOWED DURING AUTO PRIME

INDEX FEEDER

PRIME INFEEED CONVEYOR

PRODUCT FAULT BYPASS

LUBE

GLUE TANK READY

PRODUCT IN MACHINE

CIP ACTIVE

RUNOUT

CLEAR OUT

AUTO PRIME

METERING CONVEYOR BRAKE RELEASE

0 PPM

PACK COUNTER
3042

SHIFT 1 COUNTER
6

MANUAL



4X6X1 12 oz CAN DuoDozen

VACUUM WHEEL 1
ON OFF

VACUUM WHEELS 2 & 3
ON OFF

PACK HOLD-DOWN

GLUE CARRIAGE

MAGAZINE SLIDE

Automatic

Operator

7:36:43 AM

11/11/2014

Run Screen

Diagnose

Reports

Maintenance

Configuration

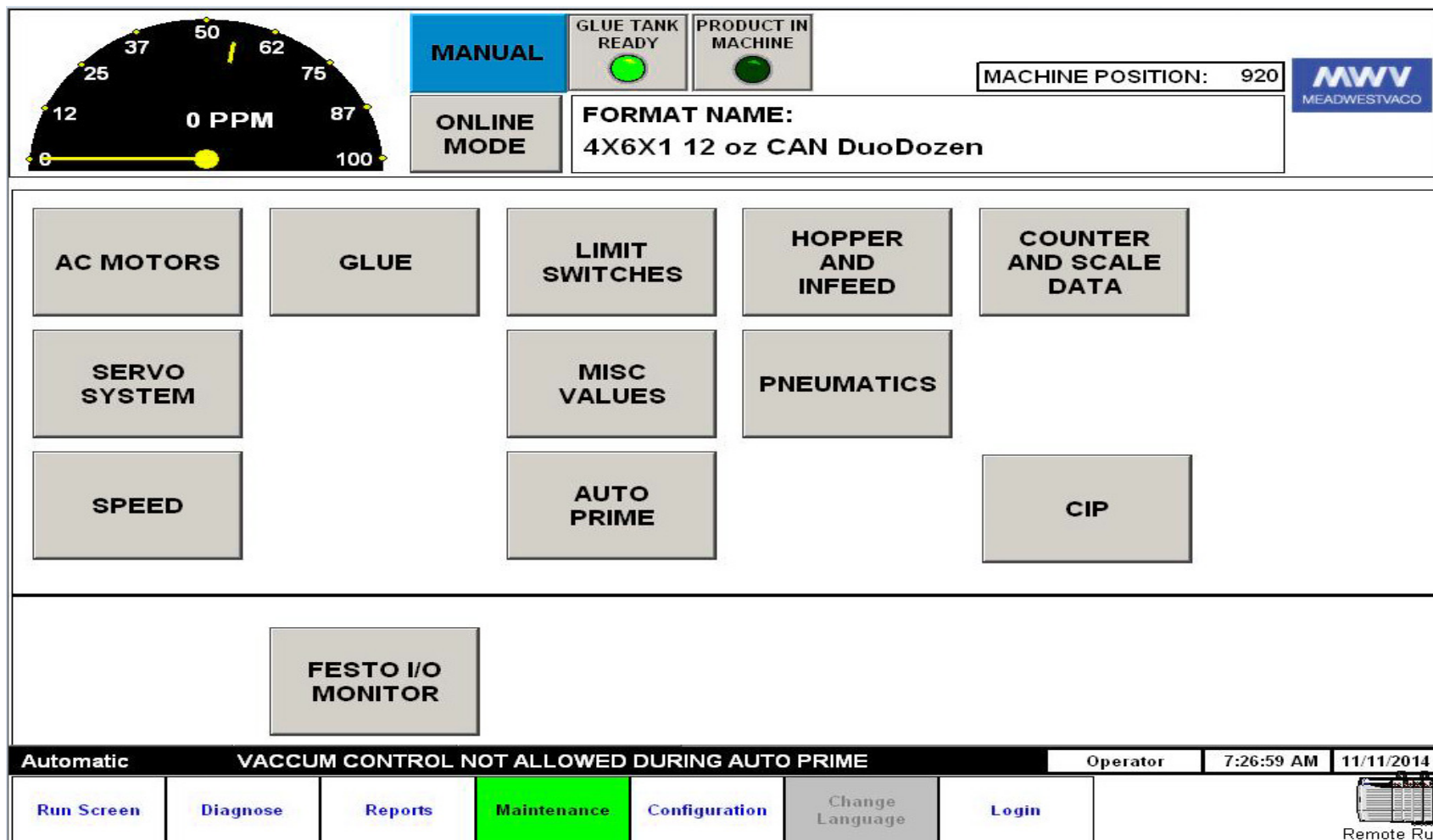
Change Language

Login


Remote Run

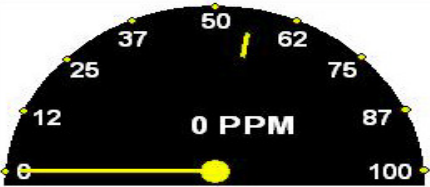
Step 6 - Optional

Located on the Maintenance screen. Press the Auto Prime button



Step 7 - Optional

Located on the Auto Prime screen. Press Auto Prime (AP) Check Pack button.



MANUAL
ONLINE MODE

GLUE TANK READY
PRODUCT IN MACHINE

MACHINE POSITION: 920

FORMAT NAME:
4X6X1 12 oz CAN DuoDozen

AUTO PRIME

AUTO PRIME CYCLE STOP POSITION	0.001 INCH	920	SAVED: 920
NUMBER OF CYCLE TO START POSITION	POCKETS	7	SAVED: 7
MAX NUMBER OF CYCLES	POCKETS	21	SAVED: 21

AP CHECK PACK

ABORT AUTO PRIME

Automatic

VACCUM CONTROL NOT ALLOWED DURING AUTO PRIME

Operator

7:30:31 AM

11/11/2014

Run Screen

Diagnose

Reports

Maintenance

Configuration

Change Language

Login


Remote Run

Section 2

Abort Auto

Prime



Introduction to Abort Auto Prime

This function allows you to abort Auto Prime BEFORE or DURING the Auto Prime sequence.

If Auto Prime is aborted BEFORE sequence starts and no product is in the machine you can simply restart the Auto Prime process.

If Auto Prime is aborted DURING the sequence, then it cannot be restarted until the machine is Empty of cans and cartons and “Product in Machine” indicator is OFF.

Abort Auto Prime

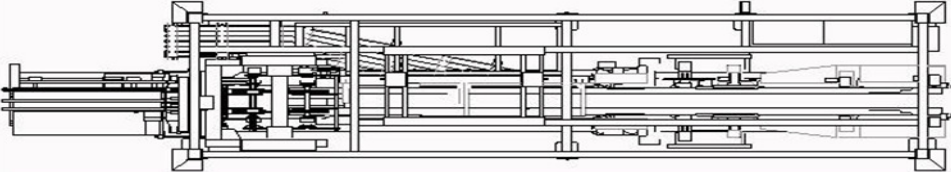
If the “Product in Machine” indicator on the Main run screen is NOT illuminated, then the machine is EMPTY and Auto Prime can be restarted BEFORE the sequence has begun using the following steps.

Step 1

On the run screen locate and press the maintenance button

VERSION 2.6.8
SERIAL # 1095

MeadWestvaco



0 PPM

PACK COUNTER
3042

SHIFT 1 COUNTER
6

4X6X1 12 oz CAN DuoDozen

VACUUM WHEEL 1
ON OFF

VACUUM WHEELS 2 & 3
ON OFF

PACK HOLD-DOWN

GLUE CARRIAGE

MAGAZINE SLIDE

INDEX FEEDER
PRIME INFEEED CONVEYOR
PRODUCT FAULT BYPASS
LUBE
RUNOUT
AUTO PRIME
GLUE TANK READY
PRODUCT IN MACHINE
CIP ACTIVE
CLEAR OUT
METERING CONVEYOR BRAKE RELEASE

Automatic

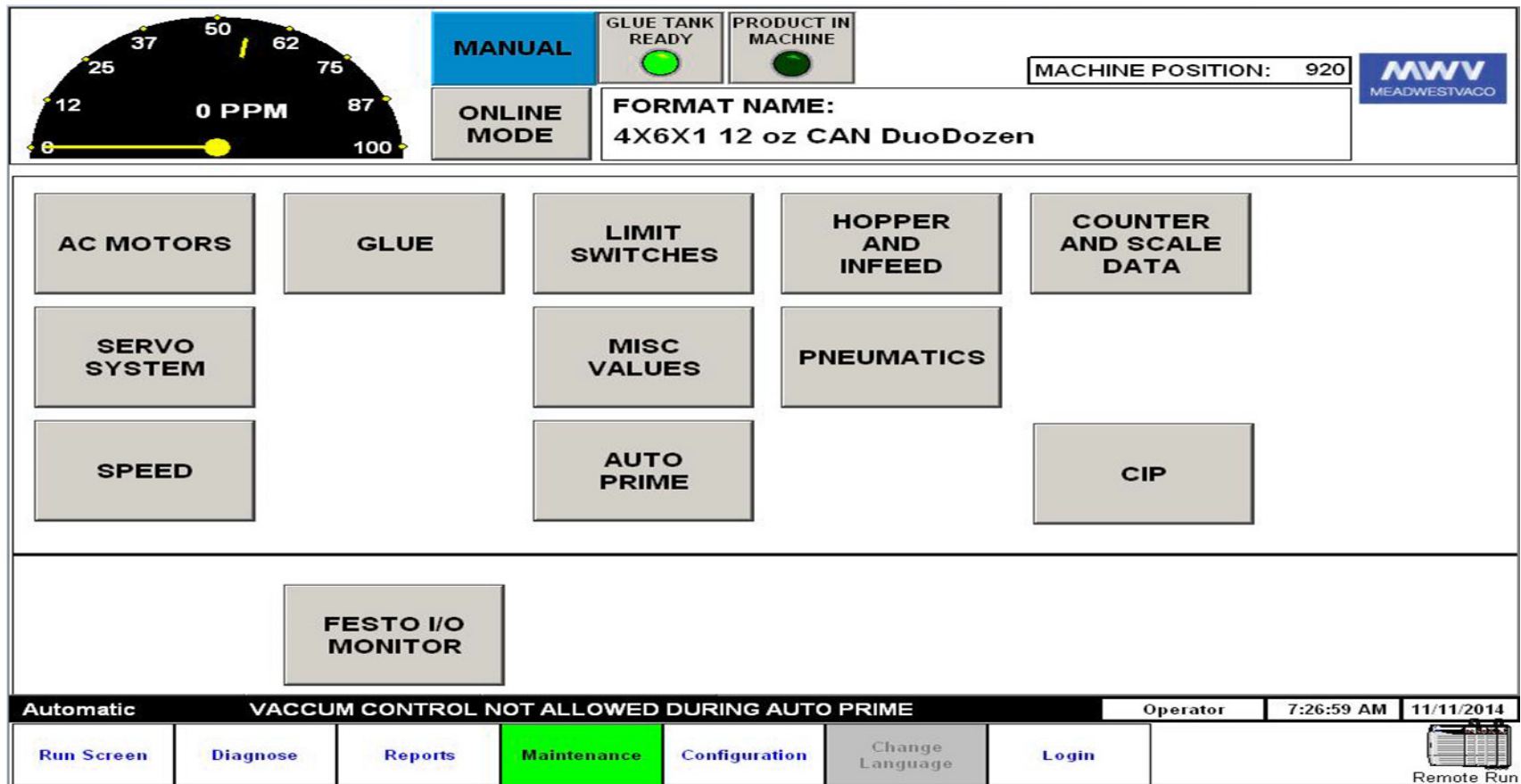
Operator 7:26:04 AM 11/11/2014

Run Screen Diagnose Reports Maintenance Configuration Change Language Login

Remote Run

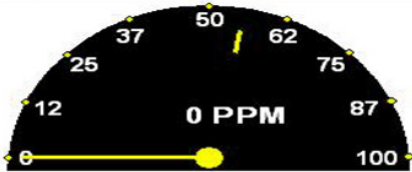
Step 2

On the Maintenance press the Auto Prime button



Step 3

On the Auto Prime Screen press Abort Auto Prime



MANUAL

ONLINE MODE

GLUE TANK READY

PRODUCT IN MACHINE

MACHINE POSITION: 920

FORMAT NAME:
4X6X1 12 oz CAN DuoDozen

AUTO PRIME

AUTO PRIME CYCLE STOP POSITION	0.001 INCH	920	SAVED: 920
NUMBER OF CYCLE TO START POSITION	POCKETS	7	SAVED: 7
MAX NUMBER OF CYCLES	POCKETS	21	SAVED: 21

ABORT AUTO PRIME

AP PACK CHECK

Automatic

VACCUM CONTROL NOT ALLOWED DURING AUTO PRIME

Operator

7:30:31 AM

11/11/2014

Run Screen

Diagnose

Reports

Maintenance

Configuration

Change Language

Login

Remote Run

Note

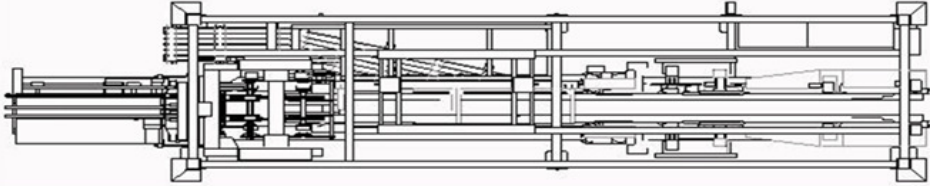
The gates will open when the Abort Auto Prime push button is pressed.

Step 4

Turn off vacuum pumps. See the right/bottom side of the Main run screen.

VERSION 2.6.8
SERIAL # 1095

MeadWestvaco



VACCUM CONTROL NOT ALLOWED DURING AUTO PRIME

INDEX FEEDER

PRIME INFED CONVEYOR

PRODUCT FAULT BYPASS

LUBE

GLUE TANK READY

PRODUCT IN MACHINE

CIP ACTIVE

RUNOUT

CLEAR OUT

AUTO PRIME

METERING CONVEYOR BRAKE RELEASE

0 PPM

PACK COUNTER

3042

SHIFT 1 COUNTER

6

4X6X1 12 oz CAN DuoDozen

VACUUM WHEEL 1

VACUUM WHEELS 2 & 3

ON

OFF

ON

OFF

PACK HOLD-DOWN

GLUE CARRIAGE

MAGAZINE SLIDE

Automatic

Operator

7:36:43 AM

11/11/2014

Run Screen

Diagnose

Reports

Maintenance

Configuration

Change Language

Login

Remote Run

Step 5

Check and make sure that no product has moved beyond or under the gates.

At this point you can restart the Auto Prime sequence if desired.

Abort Auto Prime

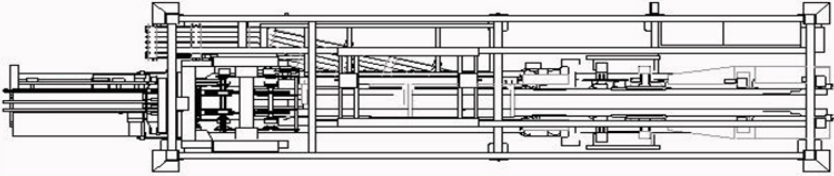
To successfully abort Auto Prime DURING Auto Prime sequence has started please complete the following steps.

Step 1

Cycle stop the machine. Press the Maintenance button on the Main run screen.

VERSION 2.6.8
SERIAL # 1095

MeadWestvaco



VACCUM CONTROL NOT ALLOWED DURING AUTO PRIME

INDEX FEEDER

PRIME INFED CONVEYOR

PRODUCT FAULT BYPASS

LUBE

GLUE TANK READY

PRODUCT IN MACHINE

CIP ACTIVE

RUNOUT

CLEAR OUT

AUTO PRIME

METERING CONVEYOR BRAKE RELEASE

0 PPM

PACK COUNTER

3042

SHIFT 1 COUNTER

6



4X6X1 12 oz CAN DuoDozen

VACUUM WHEEL 1

ON

OFF

VACUUM WHEELS 2 & 3

ON

OFF

PACK HOLD-DOWN

GLUE CARRIAGE

MAGAZINE SLIDE

Automatic

Operator

7:36:43 AM

11/11/2014

Run Screen

Diagnose

Reports

Maintenance

Configuration

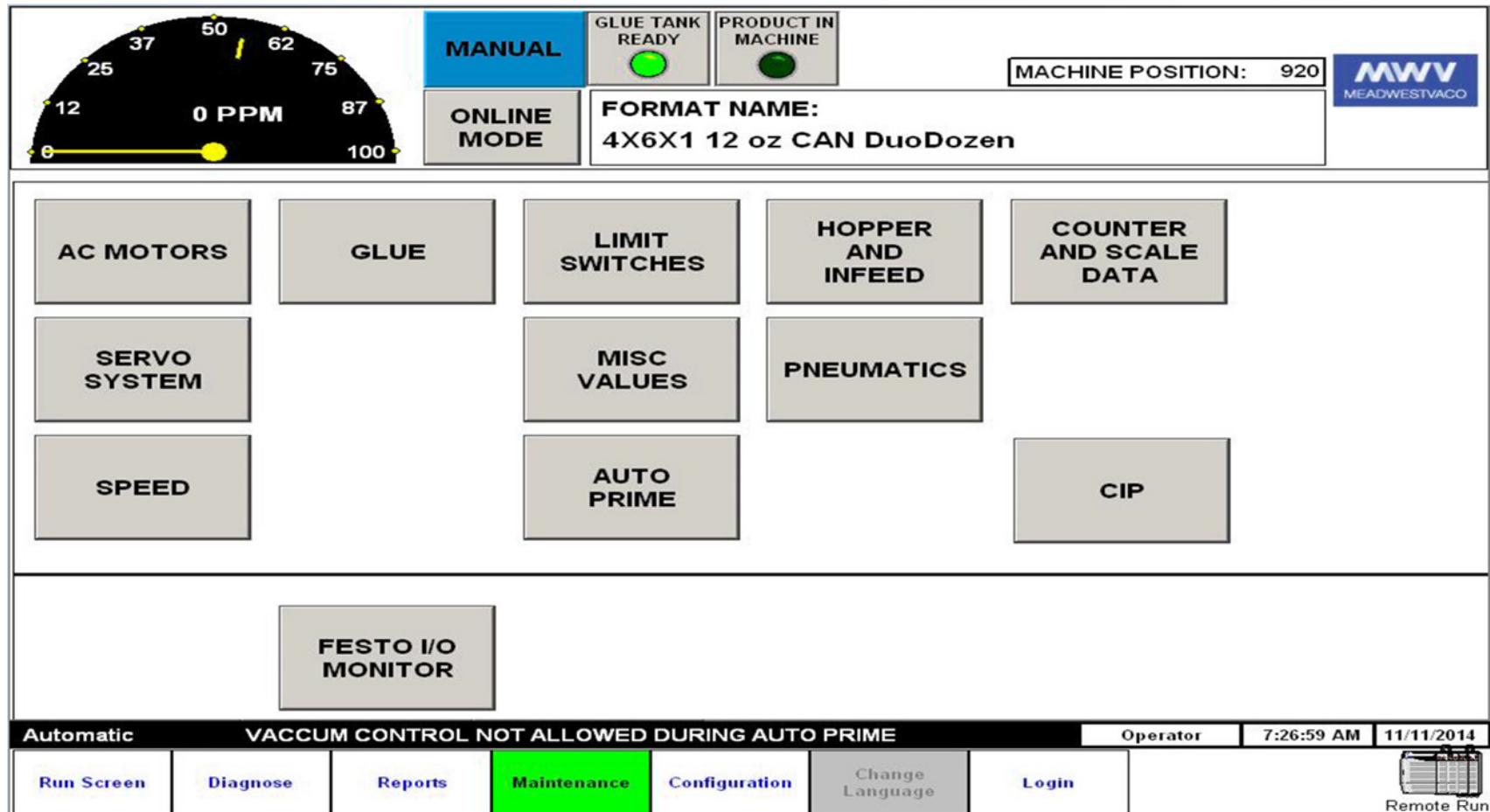
Change Language

Login

Remote Run

Step 2

On the Maintenance screen press the Auto Prime button



Step 3

On the Auto Prime screen press Abort Auto Prime



MANUAL
ONLINE MODE

GLUE TANK READY
PRODUCT IN MACHINE

MACHINE POSITION: 920

FORMAT NAME:
4X6X1 12 oz CAN DuoDozen

AUTO PRIME

AUTO PRIME CYCLE STOP POSITION	0.001 INCH	920	SAVED: 920
NUMBER OF CYCLE TO START POSITION	POCKETS	7	SAVED: 7
MAX NUMBER OF CYCLES	POCKETS	21	SAVED: 21

ABORT
AUTO PRIME

AutomaticVACCUM CONTROL NOT ALLOWED DURING AUTO PRIMEOperator7:30:31 AM11/11/2014

Run ScreenDiagnoseReportsMaintenanceConfigurationChange LanguageLogin

Remote Run

Note

After pressing Abort Auto Prime, the can gates will open and the machine is no longer in Auto Prime mode - even though there may be cans and cartons in the machine.

Auto Prime cannot be restarted again until the machine is
“Empty”

In order to Empty the machine, complete the remaining steps.

First check and make sure that no product has moved beyond or under the gates. Also you will have to turn off the vacuum pumps located on the run screen.

See photo next page

Step 4

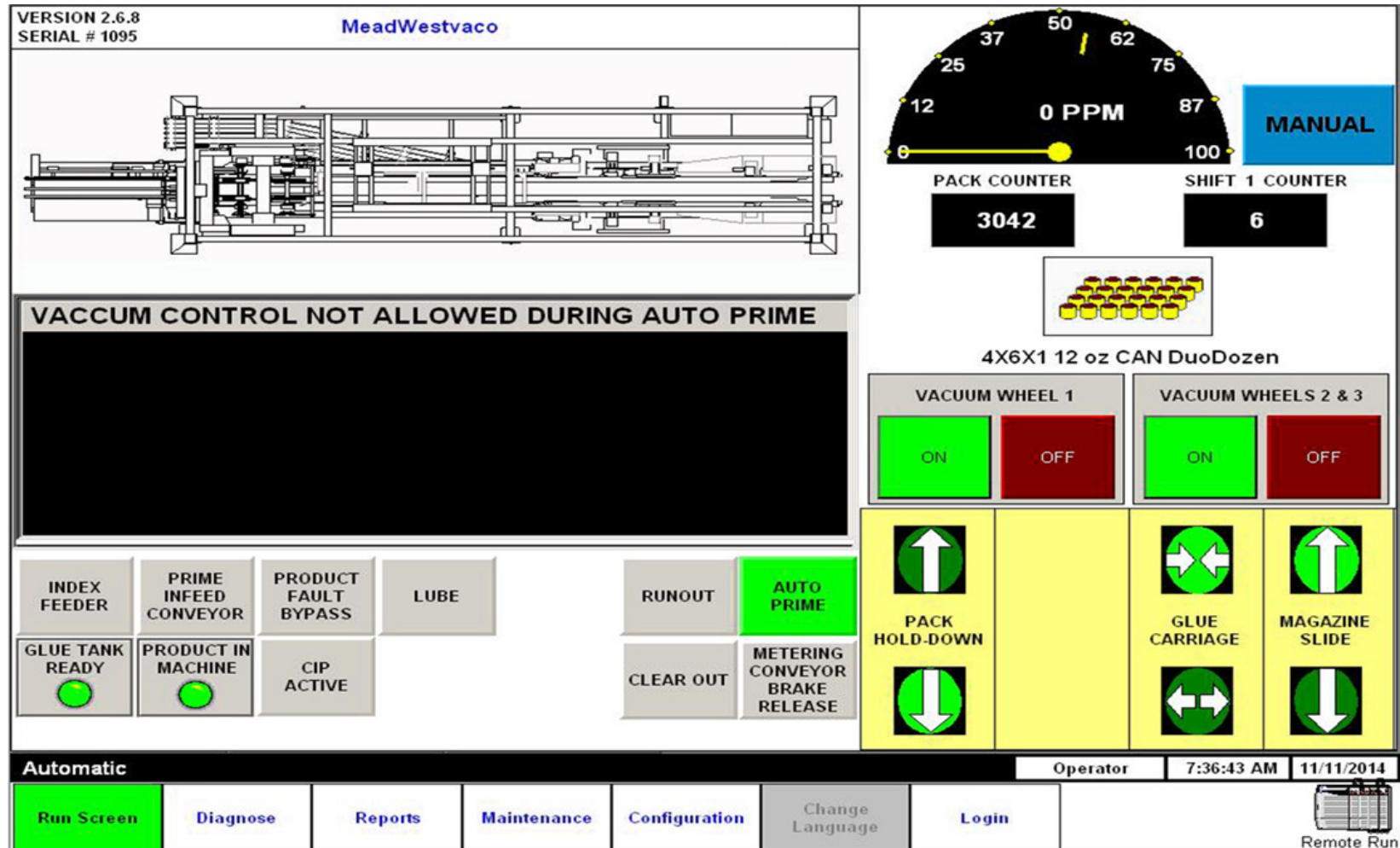
Check and make sure that no product has moved beyond or under the gates.

Step 5

Turn off the vacuum pumps
(located on the Main run screen).

See photo next page

The vacuum controls are located on the right/bottom side of the main run screen.

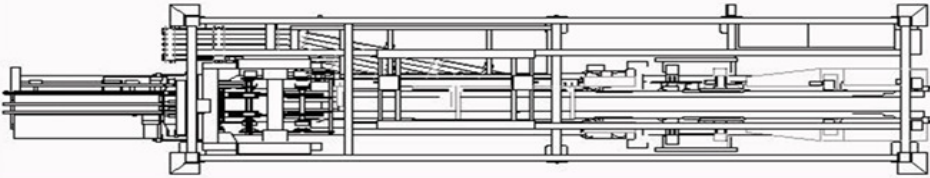


Step 6

On the Main run screen locate and press the Maintenance button

VERSION 2.6.8
SERIAL # 1095

MeadWestvaco



VACCUUM CONTROL NOT ALLOWED DURING AUTO PRIME

INDEX FEEDER

PRIME INFEEED CONVEYOR

PRODUCT FAULT BYPASS

LUBE

GLUE TANK READY

PRODUCT IN MACHINE

CIP ACTIVE

RUNOUT

CLEAR OUT

AUTO PRIME

METERING CONVEYOR BRAKE RELEASE

0 PPM

PACK COUNTER
3042

MANUAL

SHIFT 1 COUNTER
6



4X6X1 12 oz CAN DuoDozen

VACUUM WHEEL 1
ON OFF

VACUUM WHEELS 2 & 3
ON OFF

PACK HOLD-DOWN

GLUE CARRIAGE

MAGAZINE SLIDE

Automatic

Operator7:36:43 AM11/11/2014

Run Screen

Diagnose

Reports

Maintenance

Configuration

Change Language

Login

Remote Run

Step 7

From the Maintenance screen press the AC Motors button.

The screenshot displays the MWV MeadWestvaco machine control interface. At the top left is a semi-circular gauge with a scale from 0 to 100 and a needle pointing to 0, labeled "0 PPM". To its right are two status indicators: "GLUE TANK READY" (green light) and "PRODUCT IN MACHINE" (green light). Further right is a "MACHINE POSITION: 920" display and the "MWV MEADWESTVACO" logo. Below these are two buttons: "MANUAL" (blue) and "ONLINE MODE" (grey). A "FORMAT NAME:" field displays "4X6X1 2 oz CAN DuoDozen". The main area contains a grid of buttons: "AC MOTORS" (highlighted in green), "GLUE", "LIMIT SWITCHES", "HOPPER AND INFEED", "COUNTER AND SCALE DATA", "SERVO SYSTEM", "MISC VALUES", "PNEUMATICS", "SPEED", "AUTO PRIME", and "CIP". A "FESTO I/O MONITOR" button is located below the main grid. The bottom status bar shows "Automatic", "VACCUUM CONTROL NOT ALLOWED DURING AUTO PRIME", "Operator", "7:26:59 AM", and "11/11/2014". A navigation bar at the very bottom includes buttons for "Run Screen", "Diagnose", "Reports", "Maintenance" (highlighted in green), "Configuration", "Change Language", and "Login". A "Remote Run" icon is in the bottom right corner.

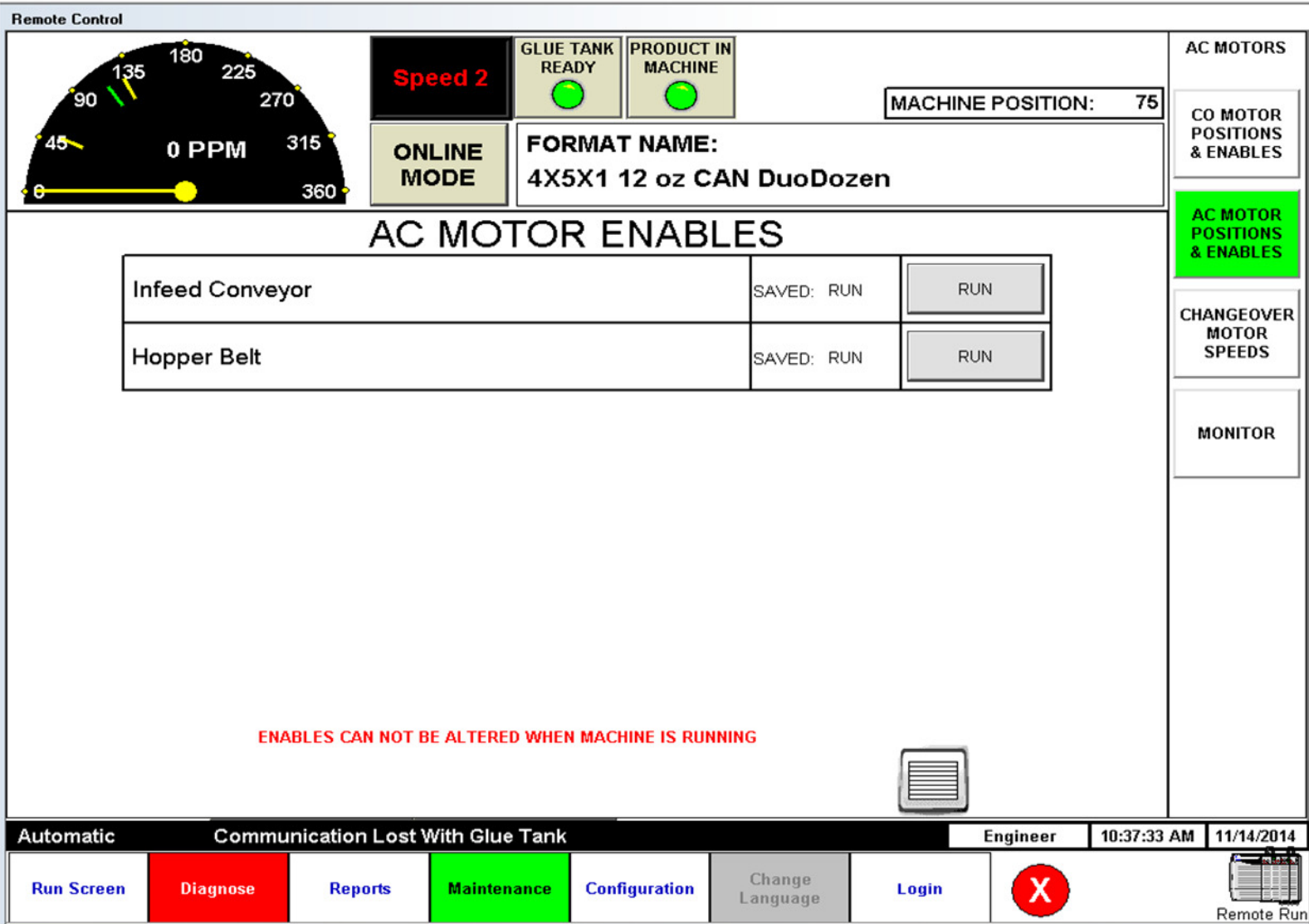
Automatic		VACCUUM CONTROL NOT ALLOWED DURING AUTO PRIME				Operator	7:26:59 AM	11/11/2014
Run Screen	Diagnose	Reports	Maintenance	Configuration	Change Language	Login	Remote Run	

Step 8

On the AC Motors enable screen locate the run button in the infeed conveyor column. Press the run button and a screen will appear asking if you want to run or stop the infeed conveyor. Press stop .

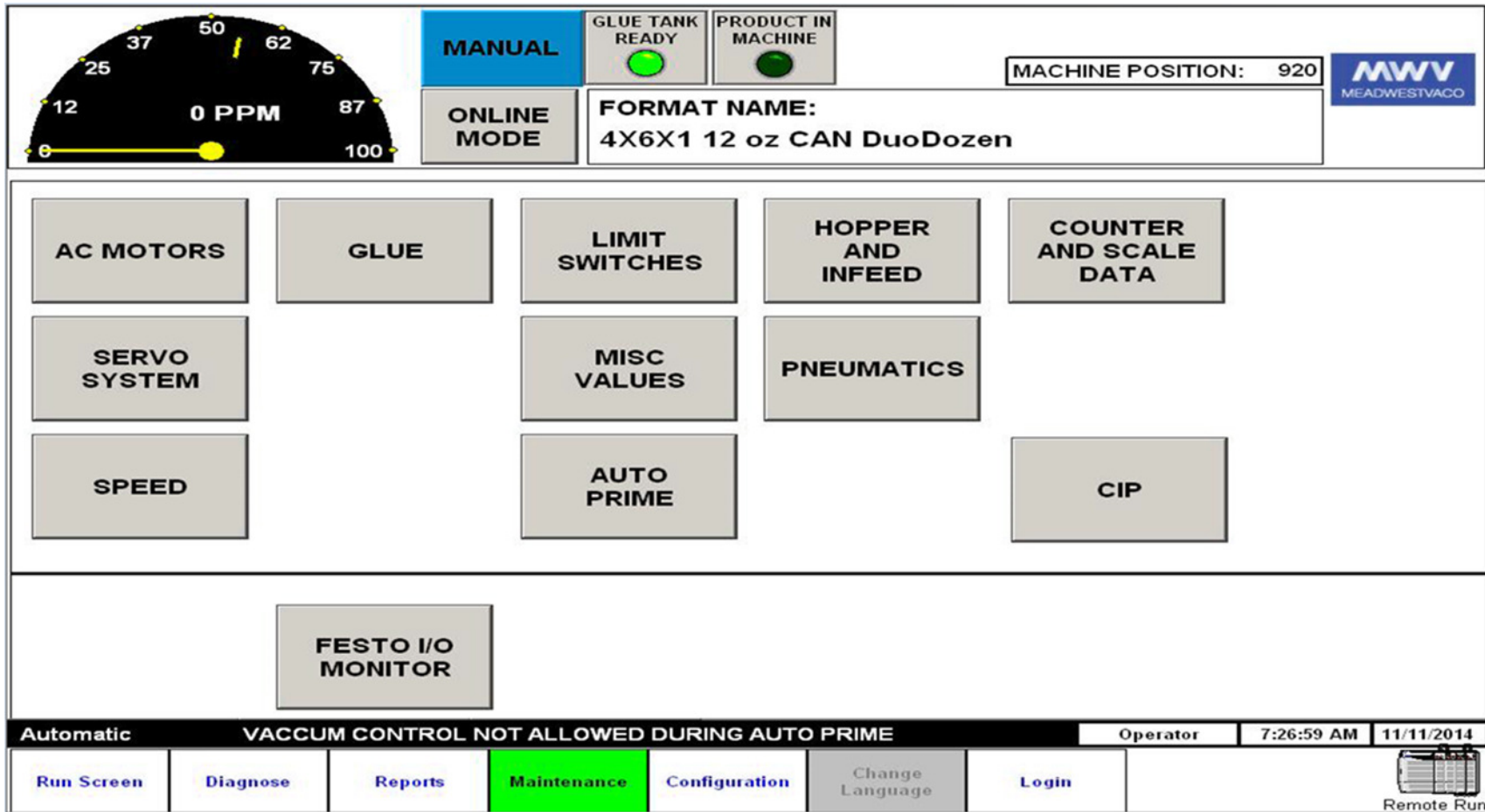
You have just disabled the infeed conveyor

See photo next page



Step 9

Press the Maintenance button. The maintenance screen will appear. Locate and press the Servo System button.





Speed 2

ONLINE MODE

GLUE TANK READY

PRODUCT IN MACHINE

MACHINE POSITION: 75

FORMAT NAME:
 4X5X1 12 oz CAN DuoDozen

SERVO SYSTEM

SERVO OFFSETS & ENABLES

Axis Name	Offset	SAVED	ACTUAL	ENABLE
08-Metering Conveyor	0.01 INCH	0	0.75	RUN
09-Grouping Conveyor	0.01 INCH	1170	0.41	RUN
10-LH Loading Wheel	0.01 INCH	120	1.95	RUN
11-RH Loading Wheel	0.01 INCH	120	1.95	RUN
12-LH Folding Wheel	0.01 INCH	1550	5.02	RUN
13-RH Folding Wheel	0.01 INCH	1550	5.02	RUN
14-LH Compression Belt	0.01 INCH	0	12.00	RUN

CAM
 SERVO DROP POS & MISC.
 SERVO DRIVE STATUS
 SERVO MOTOR TORQUE
 SERVO CONTROLLER
 SET SERVO ZERO

PAGE DOWN
 PAGE UP

PAGE 2

Automatic
 DOWN PRODUCT LANE 2
 Engineer
 10:49:07 AM
 11/14/2014

Run Screen
 Diagnose
 Reports
 Maintenance
 Configuration
 Change Language
 Login

Remote Run

SERVO AXIS OFFSETS & ENABLES

08-Metering Conveyor	0.01 INCH	0	SAVED: 0 RUN ACTUAL: 0.75	RUN
09-Grouping Conveyor	0.01 INCH	1170	SAVED: 1170 RUN ACTUAL: 0.41	RUN
10-LH Loading Wheel	0.01 INCH	120	SAVED: 120 RUN ACTUAL: 1.95	RUN
11-RH Loading Wheel	0.01 INCH	120	SAVED: 120 RUN ACTUAL: 1.95	RUN
12-LH Folding Wheel	0.01 INCH	1550	SAVED: 1550 RUN ACTUAL: 5.02	RUN
13-RH Folding Wheel	0.01 INCH	1550	SAVED: 1550 RUN ACTUAL: 5.02	RUN
14-LH Compression Belt	0.01 INCH	0	SAVED: 0 RUN ACTUAL: 12.00	RUN

SOME ITEMS INACCESSIBLE FOR DISABLED MOTOR OR RUNNING MACHINE

PAGE
DOWN

PAGE
UP

PAGE 2



Automatic

DOWN PRODUCT LANE 2

Engineer

10:49:07 AM

11/14/2014

Run Screen

Diagnose

Reports

Maintenance

Configuration

Change
Language

Login



Remote Run

Step 10

Locate the page up/down buttons. Page down until you see Metering and Grouping conveyors (8&9).

On the servo system enable screen locate the run button for the metering and grouping conveyors. Press the run button and a screen will appear asking if you want to run or stop each conveyor . Press stop .

You have just disabled Metering and Grouping conveyor

Step 11

Return to Main Run screen.

Press and hold the Run button until the “Product in Machine” indicator is off.

The machine is now “Empty”.

Re-enable Infeed, Metering and Grouping conveyors using similar steps as before.

Restart the Auto Prime sequence if desired.