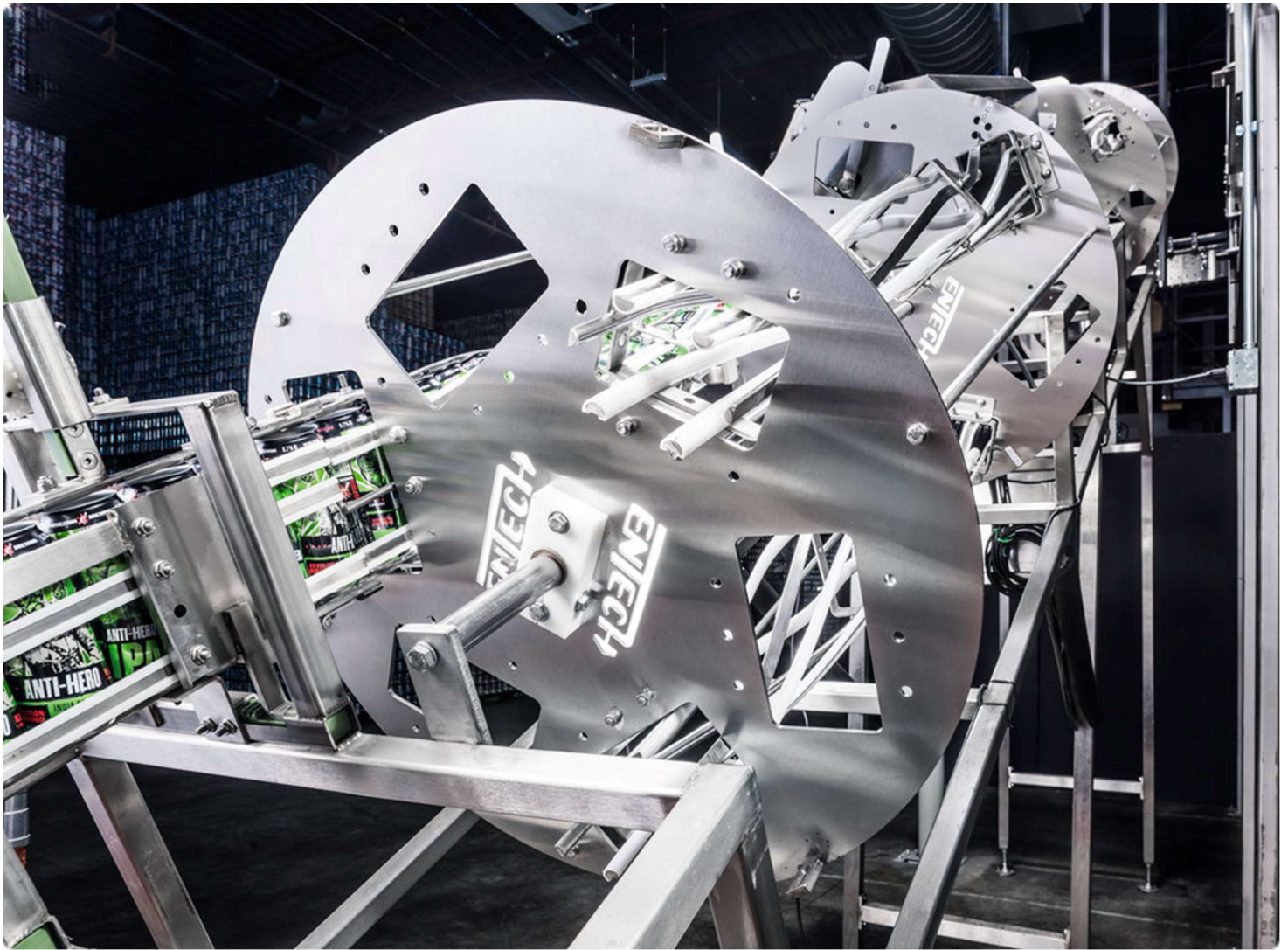


OPERATIONAL MANUAL

Gatling Gun Can Rinser

The Gravity Twist Can Rinser



PRODUCT INFORMATION

PRODUCT NAME: Entech Gatling Gun Can Rinser

SERIAL NUMBER: 2553-21-AR

DELIVERY DATE: November 2021

COMPANY: Blue Marble Products

In order to ensure safe, efficient and continuous operation of your Entech Gatling Gun Can Rinser, and to keep your Entech Warranty valid, all Entech equipment should be inspected, installed and serviced by Entech's factory-trained and bonded professional technicians. Proper installation is key to worry-free operation of your Rinser.

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PRODUCT INFORMATION	2
1. General Information	6
1.1. Contact Information	6
1.2. Product Model Number	6
1.3. General Advisory	7
1.4. Important Information	7
2. Equipment Information	8
2.1. Description	8
2.2. Identification of Main Components	8
2.3. Technical Specifications	10
2.4. Expected Use	12
2.5. Accessories Supplied with the Machine	12
3. Safety	13
3.1. Safety Information	13
3.2. Safety Instructions	14
3.3. Safety Labels and Signs	15
3.4. Safety and Protection Devices	15
4. Installation	17
4.1. Installation and Your Product's Warranty	17
4.2. Transporting	17
4.3. Placement	17
4.4. Power, Pneumatics and Water	18
4.5. Installation Procedure	19
4.6. Maintenance Platform	21
4.7. Equipment Storage	21
5. Operation	22
5.1. Description	22
5.2. Sequence of Operations	22
5.3. Pre-Operational Checklist	23

5.5. Starting and Stopping the Machine	23
6. Changeovers	24
6.1. Overview	24
6.2. Prior to Changeover	24
6.3. Changeover Procedure Steps	24
6.4. Post-Changeover Verification	25
6.5. Post-Changeover Testing	25
7. Troubleshooting	27
7.1. Cans do not fit	27
7.2. Cans do not flow through system	28
7.3. Turret Drum cannot be rotated	28
7.4. Rinsing Chamber does not operate	28
7.5. No Suction on Debris Removal System	28
8. Maintenance	30
8.1. Maintenance Recommendations	30
8.2. Inspections	30
8.3. Cleaning and Sanitation	30
9. Warranty	32
10. Repairs and service requests	33
10.1. Replacement Parts	33
10.2. Service Requests	33
11. Addendum	34
11.1. Tools needed for typical installation	34
11.2. Typical Installation Procedure	35
11.3. Typical Connection/Hook-up Procedure-Ionized Air Rinser	36
11.4. Hardware List - Single Lane Rinser - All Stainless Steel	37
11.5. Pre-ship Inspection	38

1. GENERAL INFORMATION

1.1. Contact Information

For questions or comments about your product, please contact Entech Fabrications, Inc. by mail or telephone at the contact information below:

Entech Fabrications, Inc.
P.O. Box 238
14002 Harrison Avenue
Posen, IL 60469
Telephone (708) 597-5568
Fax (708) 489-2869
Emergency Contact (847) 809-2999

Additional product information may be found on our website at:

www.EntechFabrications.com

1.2. Product Model Number

Your Entech Gatling Gun Can Rinser (Rinser) product model number is listed on Page 2 of this manual and on a label on your equipment.

When inquiring about your equipment for service or ordering parts, please refer to this model number. Not all products have the same configuration. It is important to use your model number to ensure you receive the proper replacement parts and/or service for your equipment.

1.3. General Advisory

Before you unpack, install, inspect, test, operate, troubleshoot or maintain this equipment, please read this manual completely and familiarize yourself with all sections and instructions. If you are uncertain about any instructions or information in this manual, contact Entech Fabrications, Inc. for clarification BEFORE you proceed. Failure to do so may void your warranty, result in damage to your equipment and may lead to serious injury to your workers. When in doubt, ASK first.

1.4. Important Information

All plant personnel who will supervise, operate, maintain and clean the Rinser MUST read this entire manual for SAFETY and INSTRUCTIONS before beginning any tasks.

The Entech Fabrications, Inc. Gatling Gun Can Rinser Operations Manual is NOT meant to supersede or replace more stringent, established customer plant safety procedures, or any lock-out or tag-out procedures.

2. EQUIPMENT INFORMATION

2.1. Description

The Gatling Gun Can Rinser is an integrated can rinser with adjustable components to accommodate various size cans. The Rinser pre-cleans food and beverage cans using a high velocity stream of purified water or ionized air prior to filling.

Entech's commitment to purity includes expertise with water and air rinsing medias, as well as compressed and blower air systems, ensuring that optimal taste profiles are delivered.

The Gatling Gun Can Rinser consists of adjustable rails, Turret Drums with Twist Fittings, a stainless steel Rinsing Chamber, and nozzles for distributing water or air into cans for removing contaminants or debris.

Using Rack and Pinion Adjusters, the rails can be adjusted to preset can sizes, using both height (Top Adjuster) and width (Bottom Adjuster). The Twist Fittings consist of durable eight-bar construction with hard chroming on top and bottom bars for optimal performance and extended service life. The rotating Twist Fittings can accommodate:

Beverage Applications

- Cans from 5.4 to 24 ounces
- Up to 12 can sizes on the same line

Food Applications

- Containers from 2.5 to 64 ounces
- Up to 12 container sizes on the same line

Customization available upon request.

2.2. Identification of Main Components

The Figures below show the main components of the Gatling Gun Can Rinser.

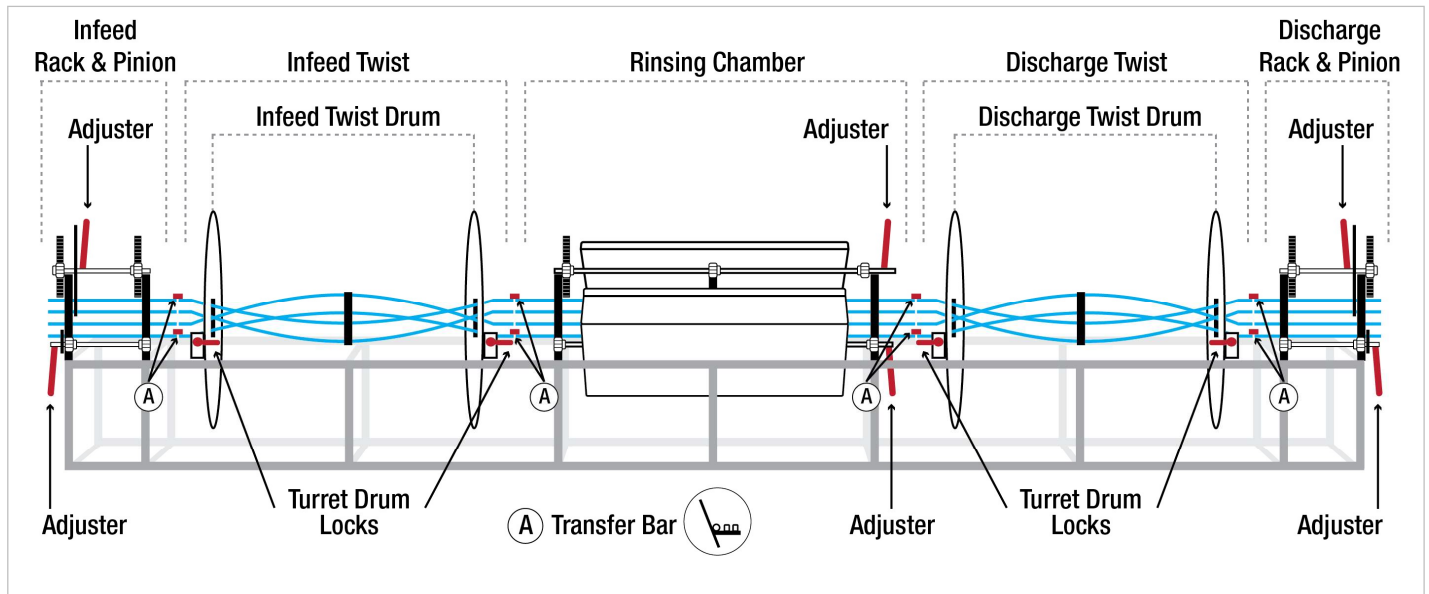


Figure 1: Schematic of Gatling Gun Can Rinser

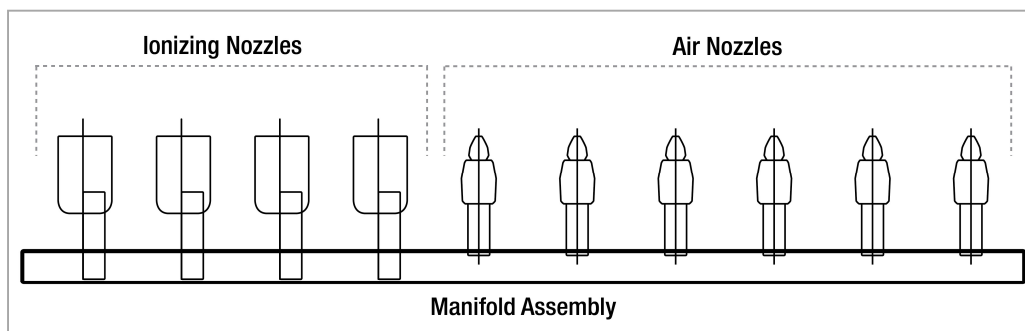
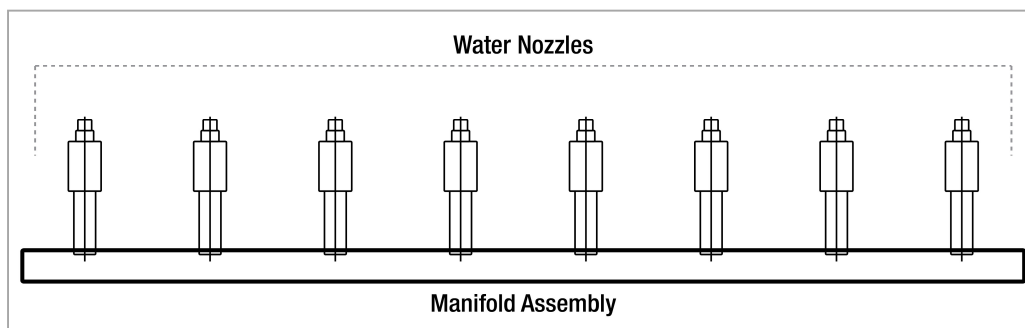


Figure 2: Schematic of Typical Air Rinsing Manifold Assembly

Figure 3: Schematic of Typical Water Rinsing Manifold Assembly



2.3. Technical Specifications

The following table contains the site-specific information of your machine. Refer to this information when ordering field support services or spare parts.

Typical Ionized Air Rinser

PRODUCTS	
Containers	2.5 to 64 ounces
Material	aluminum, steel or composite
RINSER COMPONENTS	
Nozzles	Stainless steel flat spray – 4 Simco™ ionizing nozzles + 6 stainless steel, flat spray nozzles Nozzle orifice diameter: .05 in. Flow rate: .03 gpm at 20 psi, .05 at 40 psi
Ionizer power units (IPUs)	
Spray bar	¾ in. NPT fed with ¾ in. NPT Regulator, Supply line ¾ in. NPT
Solenoid valve	Air inlet shutoff valve
Regulator valve	4 stage, .01 micron filter
Suction fan	3hp, washdown motor
REQUIREMENTS	
Power (solenoid valve)	24 Vdc or 120 Vac
Power (IPUs)	120 Vac, ¾ amp draw, max
Power (Blower)	220 /440 Vac, 3 phase, 3.5 –7 amp

Typical Purified Water Rinser

PRODUCTS	
Beverage cans	5.4 to 24 ounces
Material	aluminum, steel or composite
RINSER COMPONENTS	
Nozzles	Stainless steel flat spray – 8 equally spaced per lane Nozzle orifice diameter: .05 in. Flow rate: .03 gpm at 20 psi, .05 at 40 psi
Spray bar	$\frac{3}{4}$ in. NPT fed with $\frac{3}{4}$ in. NPT Regulator, Supply line $\frac{3}{4}$ in. NPT
Solenoid valve	Water inlet shutoff valve
REQUIREMENTS	
Purified Water	1½ – 3 gpm at 40 psi
Power (solenoid valve)	24 Vdc or 120 Vac

2.4. Expected Use

The Gatling Gun Can Rinser is designed to operate solely as a rinser of empty cans, using either purified water or ionized air as a rinsing media. Each Gatling Gun Can Rinser is designed to customer specifications for their individual use requirements. The expected use of this equipment is for these pre-determined purposes only.

2.5. Accessories Supplied with the Machine

The Gatling Gun Can Rinser is an all stainless steel construction with a hinged access- hood (Rinsing Chamber). Accessories supplied depend on the chosen cleaning media (ionized air, purified water or customized). The Gatling Gun Can Rinser can accommodate other accessories based on the needs of each customer.

3. SAFETY

3.1. Safety Information

Safety information provides important instructions to users. Entech Fabrications, Inc. recommends you read and familiarize yourself with all these safety instructions before installation, operation, maintenance and/or repair of your Rinser. Failure to follow the safety instructions could result in serious personal injury, damage to the equipment or operational difficulty.

This Entech Fabrications, Inc. Gatling Gun Can Rinser Operations Manual is not meant to supersede or replace more stringent customer plant safety procedures already in place.

WARNING — Refers to personal safety. Failure to follow WARNING notices could result in personal injury and damage to the equipment.

CAUTION — Directs attention to general precautions. Failure to observe CAUTION notices could result in personal injury, damage to the equipment or operational difficulty.

DANGER — Identifies the most serious safety hazards and the greatest exposure to potential harm. Failure to follow the DANGER notices could result in personal injury, death or damage to the equipment.

3.2. Safety Instructions

The following safety instructions are applicable to your equipment:

WARNING

- Use caution when unloading the equipment.
- Never climb on machine frame.
- Never service or adjust equipment while it is in operation.
- Always wear serviceable and suitable clothing when around equipment.
- Remove all jewelry, fasten any loose articles of clothing and keep long hair tied back.
- Always use required personal protection gear (shields, safety glasses, ear plugs, lifting belts, safety belts respirators and safety shoes) appropriate to the job.
- Entech will not be liable for unauthorized modifications which lead to bodily injury or damage to the equipment.
- Keep unauthorized personnel away from the work area.

CAUTION

- Move the unopened crates and skids as close as possible to their installation site to avoid misplacing or damaging any of the contents.
- Make routine walk-around inspections to minimize injury to personnel and damage to equipment.
- This equipment must only be used for its intended purpose.
- Keep work area clean and uncluttered.
- In the event of any unusual noise or excessive vibration during operation, stop the equipment immediately. Do not proceed with operation until the cause of the trouble has been identified and corrected.

- Qualified personnel must perform routine maintenance and repairs.
- Replace worn or broken parts only with recommended Entech replacement parts.

DANGER

- Operating, servicing and repairing of the equipment must not be done by persons under the influence of alcohol, drugs or medication.
- Never reach into equipment while it is operating.
- Some machine functions may be automatically controlled.
- This equipment starts automatically.
- Cleaning operations should never be performed until main electrical disconnects have been turned off.
- Repair pneumatic and machine components only after they have been depressurized.

3.3. Safety Labels and Signs

Adhere to all safety and instruction labels that are affixed to the frame of the machine.

3.4. Safety and Protection Devices

Regarding safety and protection devices:



CAUTION: REMOVE CAN AND FLIP TRANSFER BARS BEFORE ROTATING DRUM

- Always wear serviceable and suitable clothing when around equipment;

- Remove all jewelry, fasten any loose articles of clothing and keep long hair tied back when around equipment; and
- Always use required personal protective gear (shields, safety glasses, ear plugs, lifting belts, safety belts, respirators and safety shoes) appropriate to the job.

4. INSTALLATION

Acceptable operation of the Gatling Gun Can Rinser depends on correct installation, proper use and sufficient maintenance. Any modifications to the Rinser not made by an authorized by Entech Fabrications, Inc. technician may result in less than acceptable operation and void the warranty. The Gatling Gun Can Rinser must be properly installed prior to start-up and testing of the equipment.

Installation requires fine-tuning of infeed and discharge connections and the adjustable fittings after the equipment is “hung” in its custom location and angle. Entech technicians have extensive knowledge of the equipment and experience in these set up modifications.

4.1. Installation and Your Product’s Warranty

In order to ensure safe, efficient operation and to keep your Entech Warranty valid, all Entech equipment must be inspected and installed by Entech’s factory-trained, bonded technicians. Throughout the use of your Entech Rinser, the company requires that only Entech technicians service each component to keep equipment running efficiently and to ensure your factory warranty remains valid.

4.2. Transporting

All components, along with some of the tools required by the installation technicians, will be shipped to your facility in the days before installation. Entech will provide you with a detailed list of materials and tools, box count and tracking details of the shipment.

After the shipment is received, carefully store the unopened crate. Upon notice from the shipper that all boxes have been delivered, Entech will confirm an installation schedule with your facility. An Entech technician team will be dispatched for your scheduled installation. Upon arrival, Entech technicians will open the crate and confirm all parts against the packing list.

4.3. Placement

With the Entech team on-site, place the Rinser in designated location for your application. Remove any rail brackets and supports on the Rinser.

In order to allow for safe, efficient installation, all Entech boxes must be within the installation area, with easy access and sufficient room for both the installer technician and the equipment. The technician must have access to the line where the Rinser is being installed, area to work on installation, and space to fit infeed and discharge rails to your line.

4.4. Power, Pneumatics and Water

Depending on the rinsing media of the unit being installed, power, pneumatics and water will need to be available at the installation site. Please see your custom specification sheet for the utilities required for the installation of your rinsing equipment.

4.5. Installation Procedure

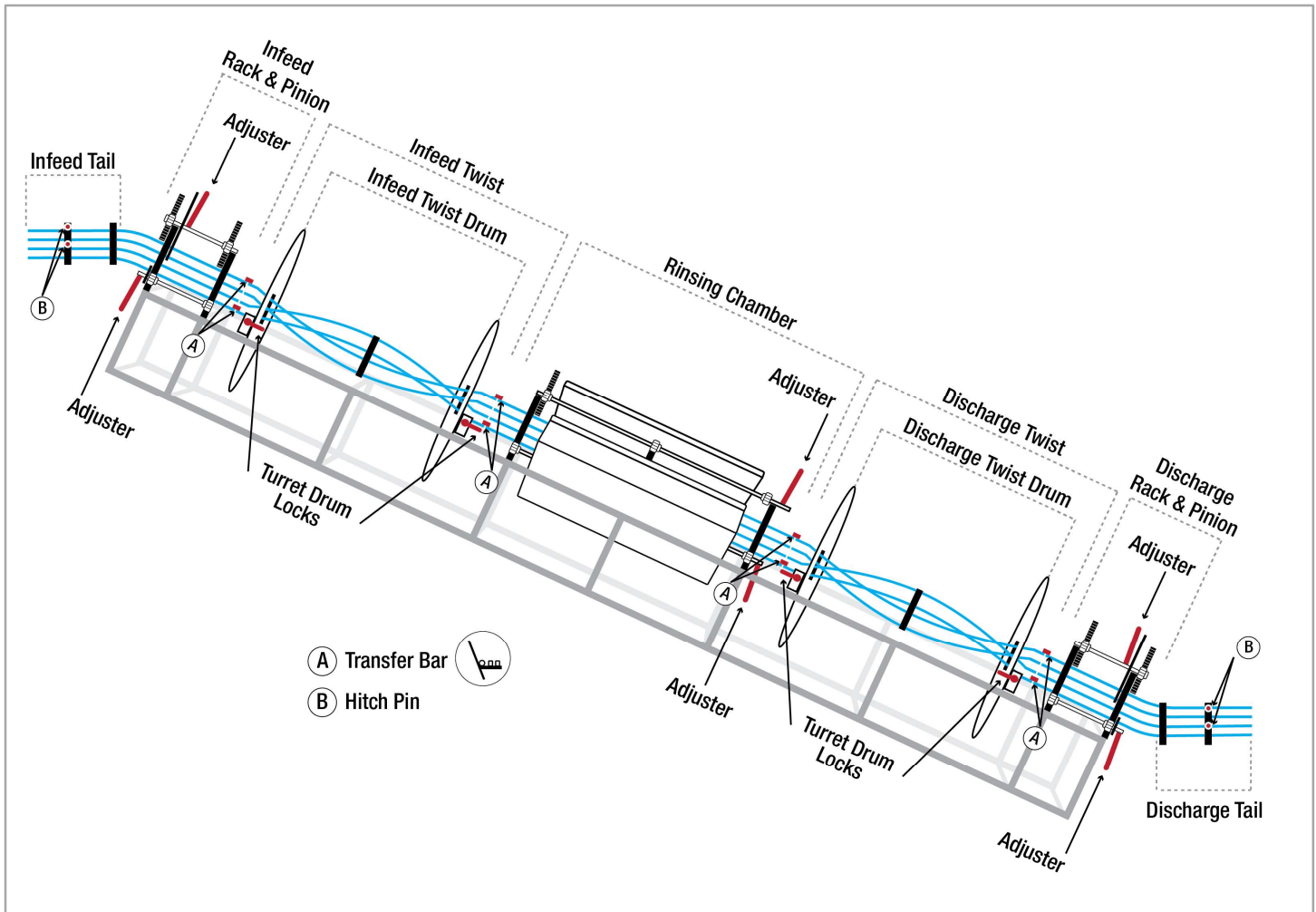


Figure 4: The Gatling Gun Can Rinser is installed at an approximate 25° to 30° incline from discharge to infeed, depending on specific equipment dimensions and site space.

Your Entech professional technician will need approximately three (3) to four (4) days for installation of your Gatling Gun Can Rinser. During this time, your installer will:

- Inspect your line, electric and, where applicable, water lines upon arrival;
- Inspect installation area and operation area for suitability;
- Inspect all Entech equipment to be installed;

- Build onsite and manually adjust both infeed and discharge rails for a custom fit to your line;
- Install fittings, including side adjustment and top adjustment plastic components and spring-loaded positioning pins;
- Install and adjust inverter rails from the infeed;
- Ensure, with company personnel, that proper lock-out procedures are observed for all relevant electrical, air and/or purified water systems.
- Install and adjust inverter rails from the Gatling Gun Can Rinser to the discharge rails;
- Have a customer-approved contractor connect necessary electrical connections, air compressor unit and/or purified water fittings; and
- If possible, test run the Gatling Gun Can Rinser.

Upon initial completion and testing of Gatling Gun Can Rinser, Entech technician will:

- Instruct [all shifts of] company personnel on the proper operation of Gatling Gun Can Rinser;
- Instruct company personnel on the proper procedure to changeover inverter rails and adjust all components for various-sized can runs;
- Test and demonstrate each separate Gatling Gun Can Rinser inverter rail set;
- Be on hand for start-up of can rinsing line; and
- Be available to answer questions on the Gatling Gun Can Rinser Operations Manual and warranty with company personnel.

4.6. Maintenance Platform

Upon completion of installation, Entech recommends that the customer install a maintenance platform along the front of the Rinser. A maintenance platform will enable easier, faster and safer implementation of the maintenance and change-over procedures.

4.7. Equipment Storage

Typically, there is no need to store any equipment for the Gatling Gun Can Rinser. Twist Fittings not in use are stored on the Turret Drums within the Rinser unit. [Exception: For hybrid Rinsers, Quick Change Fittings will need to be stored.]

If for any reason a Twist Fitting is removed from the machine, it is vital to store these rails in a safe manner, with convenient, uncluttered access. These components are vulnerable to damage while not in use. It is the customer's responsibility to store them properly on your premises. Entech will not warranty components that have been damaged at the customer site after installation.

5. OPERATION

5.1. Description

Your Entech Rinser has been designed to your exact specifications using leading CAD standards. It is capable of running up to 1,800 cans per minute per lane. Depending on each customer's application, the cleaning media is either ionized air or purified water. The unique feature of this Rinser is the ability to quickly change the line to accommodate different size cans. This changeover requires minimum effort and can be accomplished in under six (6) minutes.

The Entech Gatling Gun Can Rinser is driven by the line conveyor upstream of the Rinser unit. Using gravity, cans run through the Rinser and are then picked up by the conveyor system downstream of the Rinser unit.

5.2. Sequence of Operations

The following describes the sequence of operations performed by the Gatling Gun Can Rinser as the flow of cans enter the can Rinser from the conveyor line:

- 1) Empty cans are rotated 135 degrees in the Infeed Twist and fed into the Rinsing Chamber;
- 2) In the Rinsing Chamber, the cans are rinsed with purified water or with ionized air;
- 3) After exiting the Rinsing Chamber, the cans drip off. With air rinsing, this segment can be used for an optional second blowing area; and
- 4) After the cleaning (rinsing) process, the cans are rotated back at the Discharge Twist (standing on the can bottom) and transferred to the conveyor system.

5.3. Pre-Operational Checklist

The items listed below must be met for start-up of your equipment:

- The rinsing media must be completely installed, including all service hook-ups.
- A sufficient amount of your product must be on hand for a substantial run.
- All personnel who are directly involved with the operation of the Rinser must be present at initial start-up.

If you are running this equipment for the first time, the following checks should be performed before proceeding with normal operation:

- Verify that rinsing media is available for rinsing.
- Test the system by feeding several trial runs of can through the machine.

5.5. Starting and Stopping the Machine

Cans are brought to and exit from the Gatling Gun Can Rinser by the conveyor both upstream and downstream of the Rinser. Movement within the machine is driven by gravity.

The only additional components needed for operation are a water supply or air supply, depending on the rinsing configuration.

6. CHANGEOVERS

6.1. Overview

The Gatling Gun Can Rinser is equipped with a patented changeover device to allow for quick can-size changes without the need of special tools or detailed training.

The straight pieces of rails are adjusted using two Adjusters—one for the height of the can and the other for the width of the can. There are three (3) sections of straight rail, and two (2) Turret Drum sections with Twist Fittings within the full length of the Gatling Gun Can Rinser. Each Turret Drum comes with preconfigured Twist Fittings for specified can sizes.

6.2. Prior to Changeover

The Gatling Gun Can Rinser can quickly change over from one size can to another. Follow these steps for a quick and safe changeover.

Before starting the numbered steps below:

- Know the desired new can size. All can sizes that are available for your Gatling Gun Can Rinser are pre-marked on your unit. You will need to know the desired can size to successfully configure your Rinser.
- Verify there are no cans on the rails of your Gatling Gun Can Rinser, or in the Rinsing Chamber. If cans are present, remove all cans prior to performing Step 1.

6.3. Changeover Procedure Steps

1. Start at the Discharge Twist section of the Rinser. Flip open four (4) Transfer Bars – one (1) pair located upstream and one (1) pair located downstream of the Turret Drum. With the Transfer Bars open, unlock both Turret Drum Locks and rotate the Turret Drum to the desired can size. After completing the rotation, close both Turret Drum Locks and flip down all four (4) Transfer Bars.
2. Proceed to the Infeed Twist section of the Rinser. Flip open the four (4) Transfer Bars – one (1) pair located upstream and one (1) pair located downstream of the Turret Drum. With the Transfer Bars open, unlock both Turret Drum Locks and rotate the drum to the desired can size. After completing the rotation, close both Turret Drum Locks and flip down all four (4) Transfer Bars.

3. Proceed to the Infeed Tail section of the Rinser. Remove the Hitch Pin[s] from the adjustable collar. Retract the plastic peg[s].
4. Proceed to the Infeed Rack and Pinion section of the Rinser. Adjust height and width of track rails using the two Adjusters. Adjusters are pre-marked to your available can sizes. Once adjusted, ensure both Adjusters are locked in their new position.
5. After Step 4 is completed, proceed to Infeed Tail section of the Rinser. Reinsert the plastic peg[s] and reinsert and secure the Hitch Pin[s] removed in Step 3 into the adjustable collar.
6. Proceed to the Rinsing Chamber section of the Rinser. Adjust height and width of track rails using the two Adjusters. Adjusters are pre-marked to your available can sizes. Once adjusted, ensure both Adjusters are locked in their new position.
7. Proceed to the Discharge Tail section of the Rinser. Remove the Hitch Pin[s] from the adjustable collar. Retract the plastic peg[s].
8. Proceed to the Discharge Rack and Pinion section of the Rinser. Adjust height and width of track rails using the two Adjusters. Adjusters are pre-marked to your available can sizes. Once adjusted, ensure both Adjusters are locked in their new position.
9. After Step 8 is complete, proceed to Discharge Tail section of the Rinser. Reinsert the plastic peg[s] and reinsert and secure the Hitch Pin[s] removed in Step 7 into the adjustable collar.

6.4. Post-Changeover Verification

The following verification shall be performed after a changeover:

- Verify all Transfer Bars are down and all Turret Drums Locks are closed;
- Verify all Adjusters are locked; and
- Verify the Hitch Pins are inserted and secured on the Infeed and Discharge Tails sections.

6.5. Post-Changeover Testing

If available, run test samples through the system. If any difficulties are encountered, readjust the section of track and repeat the test. Once the cans can move within the system freely, you are ready to run the new batch.

7. TROUBLESHOOTING

The following table lists the symptoms, probable causes and recommended corrective actions for problems that may arise during operation of the Entech Rinser. These instructions should assist you in troubleshooting. If the problem persists after following all these procedures, contact Entech Fabrications, Inc.

Knowing the sequence of operation of the machine will help you isolate the problem and perform the recommended corrective actions.

SYMPTOMS	PROBABLE CAUSE	CORRECTIVE ACTIONS
Cans do not fit	Malformed can or Rinser set to wrong size	Inspect cans Check Rinser size settings
Cans do not flow	Malformed can or Rinser set to wrong size	Inspect cans Check Rinser size settings
Turret cannot be rotated	Drum Locks Closed or Transfer Bars are Closed	Open Drum Locks or Open Transfer Bars
Rinser does not operate	Low Pressure or Low Volume	Check Power at Control Valve
No Suction on Debris Removal System	Loss of Suction Pressure at Inlet	Check Power at Fan Blower

7.1. Cans do not fit

If cans are unable to enter the Entech Gatling Gun Can Rinser, determine if the entrance to the Rinser is blocked; if so, remove the blockage. If the blockage is from a malformed can, correct the cause of the can malformation before continuing to use the Rinser.

If the infeed size of the Rinser does not match the incoming cans, review the changeover procedure and ensure the Rinser and all of its sections are configured to the proper can size. If the Rinser is not configured properly make the proper adjustments per the changeover

procedures before using the Rinser. If the Rinser is properly configured inspect the Infeed section of the Rinser to verify that none of the rails are bent or broken.

7.2. Cans do not flow through system

If cans are able to enter the Rinser, but do not flow through the Rinser, determine if the jam is caused by a malformed can. If so, correct the cause of the can malformation before continuing to use the Rinser.

If the source of the jam is not a malformed can, ensure the Rinser and all of its sections are configured to the proper can size. If the Rinser is not configured properly make the proper adjustments per the changeover procedure before using the Rinser. If the Rinser is properly configured inspect the Rinser to verify that none of the rails are bent or broken.

7.3. Turret Drum cannot be rotated

During operation both Turret Drums must be in a closed, lock position. If during changeover a Turret Drum cannot be rotated, stop all effort to rotate the Turret Drum to avoid damaging the components. Verify that the two (2) Turret Drum Locks are open and that all four (4) Transfer Bars are flipped open.

If the Turret Drum Locks are closed then open them. If any Transfer Bars are closed then flip them open. Gently rotate the Turret Drum to the desired can size. Inspect the Twist Fittings and Turret Drum to ensure no component was bent or damaged before continuing to use the Rinser. If components were damaged contact Entech Fabrications, Inc. for further instructions.

7.4. Rinsing Chamber does not operate

If the rinsing media (ionized air or purified water) is not available in the Rinsing Chamber, check for power on the inlet solenoid valve. Also check for clogged inlet filters.

7.5. No Suction on Debris Removal System

If the air debris removal system does not operate in the Rinsing Chamber (available for ionized air Rinsers only), check for loss of power on the suction blower fan or a clogged filter located upstream of the blower fan.

8. MAINTENANCE

8.1. Maintenance Recommendations

This section contains information and recommendations for conducting preventative maintenance and adjusting the equipment. When conducted regularly, these steps will assure peak performance and minimum downtime with your Entech Gatling Gun Can Rinser.

Periodic visual inspections and a cleaning schedule of equipment should be established. This preventive maintenance is relatively simple and can be scheduled with no impact on routine operations.

8.2. Inspections

Visual inspections should be done daily or before every operating period. Equipment should be inspected for damage, wear and missing parts. It is especially important to check any items pertaining to safety. Special attention should also be paid to cleanliness of the equipment and surrounding areas. There should be no obstruction or foreign objects on or near the equipment.

While equipment is in operation, check for vibration and leaks. Stop equipment for more thorough investigation whenever anything abnormal occurs.

8.3. Cleaning and Sanitation

Maintaining cleanliness of the equipment is essential to production performance. A dirty environment and buildup of dirt, dust, oil, grease or other foreign matter can affect equipment operation and eventually cause breakdown. When equipment is cleaned regularly, maintenance is minimized.

The cleaning method and frequency is mainly determined by local conditions, type of product handled and user's company policies.

General minimum guidelines are as follows:

- Sanitize Rinsing Chamber three times a week.

- If your rinsing media is PURIFIED WATER use a diluted foam or other cleaning media. The foam should not be too caustic. A caustic, undiluted foam that is applied or left on the device too long will damage the guide rails in the Rinser.
- If your rinsing media is IONIZED AIR use only an alcohol-based cleaning media. Failure to do so may damage the ionizing air nozzles in the Rinser.
- Clean air and/or water nozzles with a soft nylon brush regularly.
- Wash down can twists and infeed and discharge rails three times a month.
- Check all hardware on Rinser for tightness every six months.
- CAUTION: Avoid over tightening, failure to do so can lead to equipment damage.

9. WARRANTY

Entech Fabrications, Inc. warrants for a period of twelve (12) months or 2,080 operating hours (whichever comes first) that the equipment furnished shall be free of defects in materials or workmanship if properly installed, used and maintained.

Entech Fabrications, Inc. liability is limited to repair or replacement of nonconforming equipment at its option. F.O.B. point of manufacturer and in no event shall Entech be liable for any direct, indirect or consequential damages of any kind which occur during or as a result of installation and/or operation of the equipment. There is no implied or express warranty of merchantability beyond that specifically described in the purchase agreement. Any electrical parts furnished are covered by manufacturer's warranty only.

10. REPAIRS AND SERVICE REQUESTS

10.1. Replacement Parts

Replacement parts for the Entech Gatling Gun Can Rinser can be ordered by contacting Entech Fabrications, Inc.

10.2. Service Requests

Please contact Entech Fabrications, Inc. for service requests.

Please note: a purchase order is required prior to the dispatching of any Entech Fabrications, Inc. personnel.

11. ADDENDUM

11.1. Tools Needed for Typical Installation

1. Lift truck to move crate and lift Rinser into position, provided by customer.
2. Lift straps, chain falls and chains as needed.
3. Scissor lift provided by customer.
4. Concrete drill and anchors.
5. Worktable with vice.
6. Stud gun with studs, $\frac{1}{4}$ -20- $\frac{3}{4}$, 1 in. and 1- $\frac{1}{4}$ in. lengths.
7. PPE: Steel toe shoes, glasses, ear plugs, high visibility vest, hard hat and gloves.
8. Standard hand tools, drill, grinder, Metabo™.
9. $\frac{5}{8}$ in. half round bending bars.
10. TIG welder, filler rod and helmet.

11.2 Typical Installation Procedure

11. Check crate and equipment for damage sustained in transit.
12. Remove perimeter crating.
13. Check contents of crate against packing list.
14. Remove Rinser, legs, braces and blower from skid.
15. Using dollies, move Rinser to install area.
16. Rig Rinser for lifting into position. Try to lift/rig so that Rinser is lifted at approximate angle in which it will be installed.
17. Check dimension from supplied side view drawing for position of Rinser in relation to the infeed and discharge conveyor.
18. Install support legs and braces.
19. Level Rinser legs and framework.
20. Anchor legs.
21. Install 3hp blower on center leg. Have discharge of blower at a height high enough to avoid exhausting into face of operators (option to clock exhaust up or down).
22. Install Simco™ power supply panel (if air rinser) and connect cables to nozzles.
23. Fabricate and install infeed rails from supply conveyor to Rinser infeed.
24. Fabricate and install discharge rails from Rinser to filler infeed conveyor.
25. Run cans through Rinser, checking for proper clearances and transfer points.
26. Remain onsite to assist with optimization of run speed standards, as requested by customer or integrator.
27. Perform operator training, as requested by customer or integrator.

11.3 Typical Connection/Hook-up Procedure—Ionized Air Rinser

28. Minimum 1 in. diameter drop from main airline to feed, filter regulator, capable of 18-20 SCPM at 75 psi.
 - Air Pressure is typically set between 35 – 45 psi.
29. 220/440, 3 Phase drop for 3 hp blower. 3.5/7 Amp.
30. 120 Volt power drop for Simco™ power supply.
31. 24 Vdc power drop for pressure switch and on/off solenoid.
32. All integration of utilities & controls to be performed by the customer or integrator.

11.4 Hardware List: Single Lane – All Stainless Steel

<u>Typical “Gatling Gun” Hardware</u>		<u>3 Legs</u>	<u>4 Legs</u>
Leg	Bolts – $\frac{3}{8}$ in. x 1 in. hex	6 pcs.	8 pcs.
	Nuts – $\frac{3}{8}$ in.	6 pcs.	8 pcs.
	Washers – $\frac{3}{8}$ in.	12 pcs.	16 pcs.
Leg Brace	Bolts – $\frac{5}{16}$ in. x $\frac{3}{4}$ in.	12 pcs.	16 pcs.
	Nuts – $\frac{5}{16}$ in.	12 pcs.	16 pcs.
	Washers – $\frac{5}{16}$ in.	24 pcs.	32 pcs.
Leg Spreader	Bolts – $\frac{5}{16}$ in. x $\frac{3}{4}$ in.	16 pcs.	20 pcs.
	Washers – $\frac{5}{16}$ in.	16 pcs.	20 pcs.
Concrete Anchors	$\frac{3}{8}$ in. x $3\frac{1}{2}$ in.	6 pcs.	8 pcs.
Wedge ALL-WA37312SS-R			
* $\frac{1}{4}$ in. Whiz Nuts	$\frac{1}{4}$ -20 Coarse	100 pcs.	100 pcs.
* $\frac{1}{4}$ in. Flat Washers		150 pcs.	150 pcs.
* $\frac{1}{4}$ in. Nylock Nuts		50 pcs.	50 pcs.
* Brackets	330-E	2 pcs.	2 pcs.
	19-H	2 pcs.	2 pcs.
	172 AB	4 pcs.	4 pcs.

Note: *Quantities double for two (2) lanes

11.5 Pre-Shipment Inspection

The pre-ship inspection consists of confirming that each Entech Rinser, Inverter, or Fitting is thoroughly inspected to ensure quality, performance and fit specifications are met. The Inspection begins by changing over each Rinser or Inverter including all can sizes. In addition, cans are jogged through each Rinser or Inverter, with careful attention being given to proper fit and alignment of each and every transition, including all Rack & Pinions, transfer bars, fittings and side bars. This inspection process ensures that each and every Entech Rinser, Inverter and Fitting is capable of high speed rinsing/inverting, while delivering maximum uptime and long service life from start-up through the millions of cans processed. Lastly, all installation equipment, including hardware, options including Foreign Liquid Detection and Code Dating, are inspected to ensure that all Plan View dimensions and Purchase Order details are delivered.

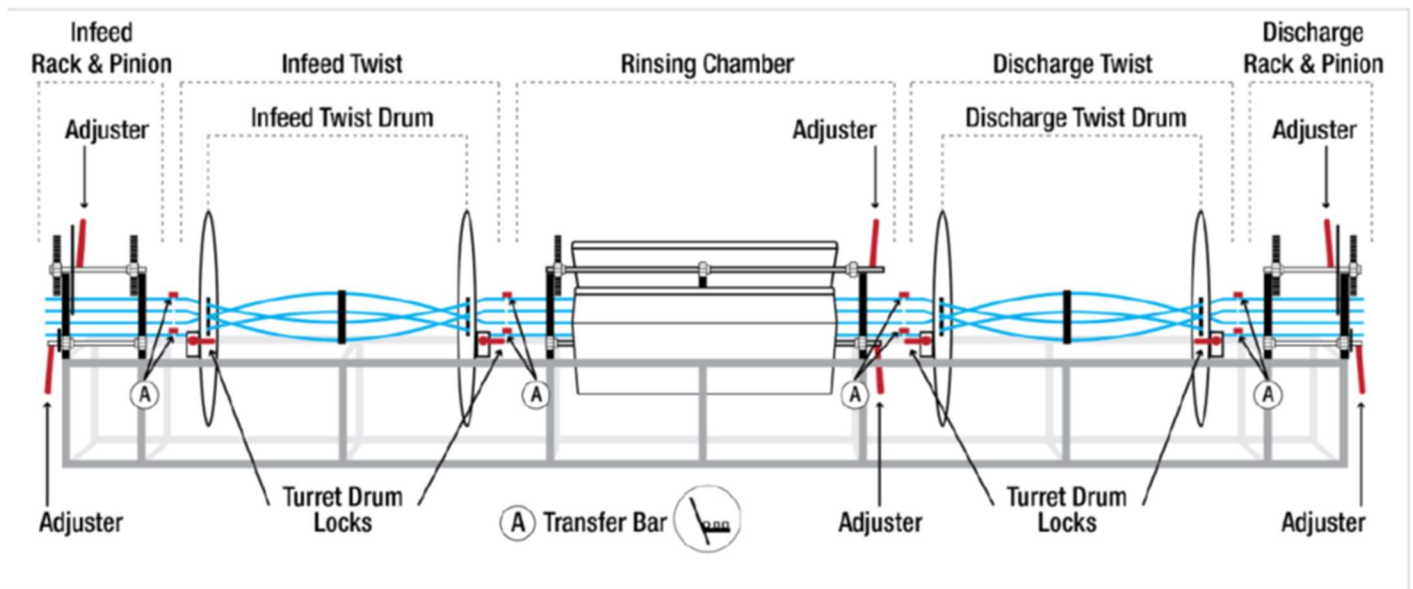


Figure 1: Schematic of Gatling Gun Can Rinser

Need further assistance? Contact us...

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