

Startup Procedure Facility/Maintenance Departments and Tasks

PR-03-003

Date: 12/11/25

Rev: 1

Author: Brentt Hawkins

1.0 Scope

1.1 To establish a guide to teach Maintenance Technicians the Maintenance Start-Up procedure.

1.2 This document applies to the Maintenance Department Technicians. It includes text, Images, titles, machine/part names, and sub-step instructions that explain the Start-Up Procedure and its purpose.

2.0 Responsibility

1.1 It is the responsibility of the supervisor to ensure the requirements of this document are followed.

1.2 It is the responsibility of all production personnel to adhere to the guidelines described in this document.

REVISION DESCRIPTION	REVISION AUTHOR	REVISION DATE	REVISION
Initial Release	Rick Bastiansen	06/07/11	0
	Brentt Hawkins	12/11/25	0

3.0 Process 3.1 Locate Emergency Cell Figure # 1

3.1.1 Locate Red/Yellow Emergency Stop Button.

3.1.1.2 Locate Green Control Button.

3.1.1.3 Locate Black Dispense Button.

Product Development & Engineering	Quality	* Manufacturing
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3.1.1.4 Locate Both A/B black button.

3.1.1.4 Locate Black Dispense Recirc Test Button.

3.1.1.5 Locate Red Cycle Stop button.

3.1.1.6 Locate Green Cycle Start Button.

4.0 Press Green Cycle Start Button Figure # 2

5.0 HMI/Monitor Homing/Start Up Process Figures # 2 and # 3

5.1.1 HMI screen appears with a blue box screen.

5.1.2 Press Change Nozzle.

5.1.3 Press Cycle Start in the middle to begin the Homing process.

5.1.4 See Homing procedure on the screen.

5.1.5 Start Process Rotation, then the screen will go away. Now grab a cup and purge air out of the System.

5.1.6 Homing/Start Up Process Screen will appear.

5.1.7 Press Green Control Start button to begin the Homing Process.

6.0 The monitor/machine will begin Homing/Start-Up Process. Figure # 3

7.0 Main menu will appear on Monitor screen. Figures # 4, 5, 6

7.1.1 Press Diagnostics window.

7.1.2 Enter Security Code 3094.

7.1.3 Press Pump window on Pump Setup Window.

8.0 Pump Setup window appears Figures #6, 7, 8, 9

8.1.1 Flashing Rectangle appears.

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8.1.2 Temporarily disable the rectangular window.

8.1.3 Disable Safety Curtains so the machine can be dispensed.

9.0 Press the Dispense Button when the screen stops moving. Figure #10, 11, 12, 13

9.1.1 Locate Dispense Machine.

9.1.2 Press Dispense button.

9.1.3 Inside the Air Solenoids operate the Inject Slide and the Purge Tube.

9.1.4 Safety Disabled to Dispense the machine.

9.1.5 Dispense Machine. Inside Air Solenoids operate the Inject Slide and the Purge Tube.

Solenoids move the plunger so chemical can be pushed through the Tah Head and out of the mixing block.

9.1.6 Safety disabled to dispense machine.

9.1.7 Inject Slide Tah Head. Purge Black Liquid, which is Urethane/B Chemical.

9.1.8 Purging Clear Liquid/A Chemical.

9.1.9 Purge to make sure there are no Air Bubbles in the line.

9.1.10 See Air Solenoid Enclosure and Inject Slide Enclosure.

9.1.11 Press Dispense Button.

9.1.12 Use Cup for chemicals to mix Black and White Slide Handle.

10. Begin Purging Air. Figure #11, 12, 13, 14

10.1.1 Ensure there are no air Bubbles.

10.1.2 Start Process Rotation. The screen will go away.

10.1.3 Grab a cup and purge the air out of the System.

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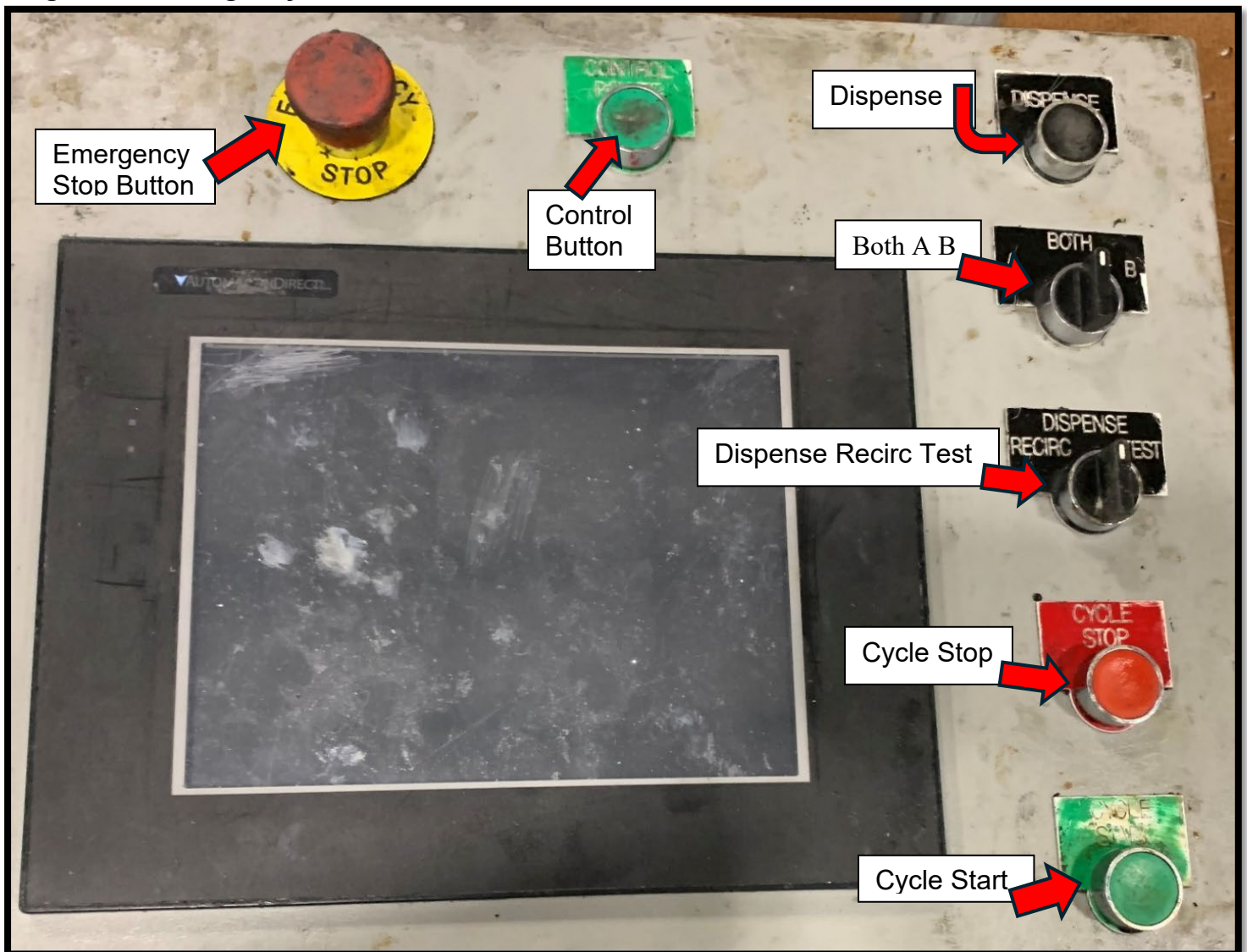
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11.0 Check Tanks A and B Figure # 15

12.0 Check Day Tank Monitor Figure # 16

13.0 Check Mixer Motor Figure # 17

Figure # 1 Emergency Cell/Carousel



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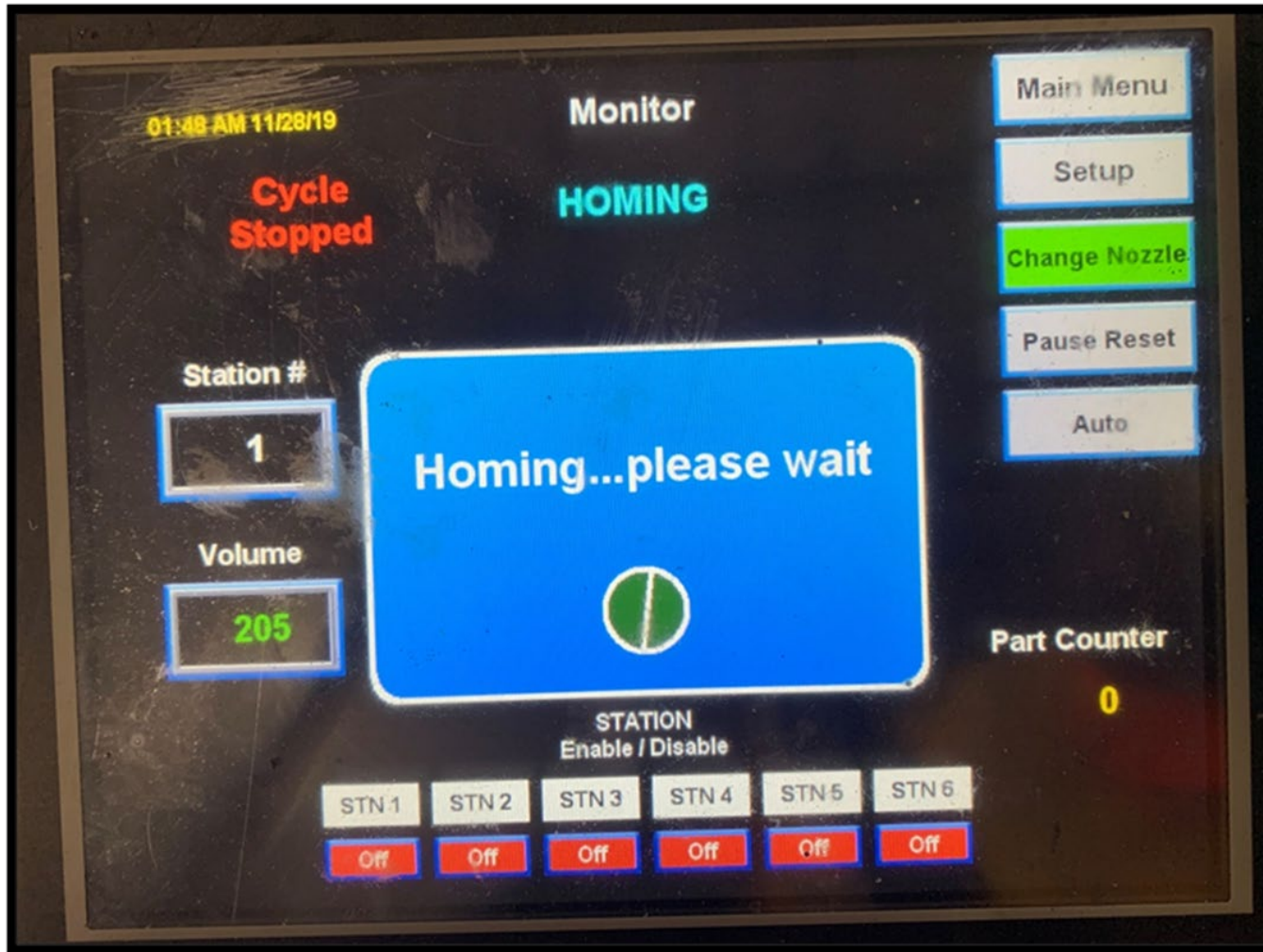
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Figure # 2 Cycle Start

Figure #3 Homing/Start-Up Process



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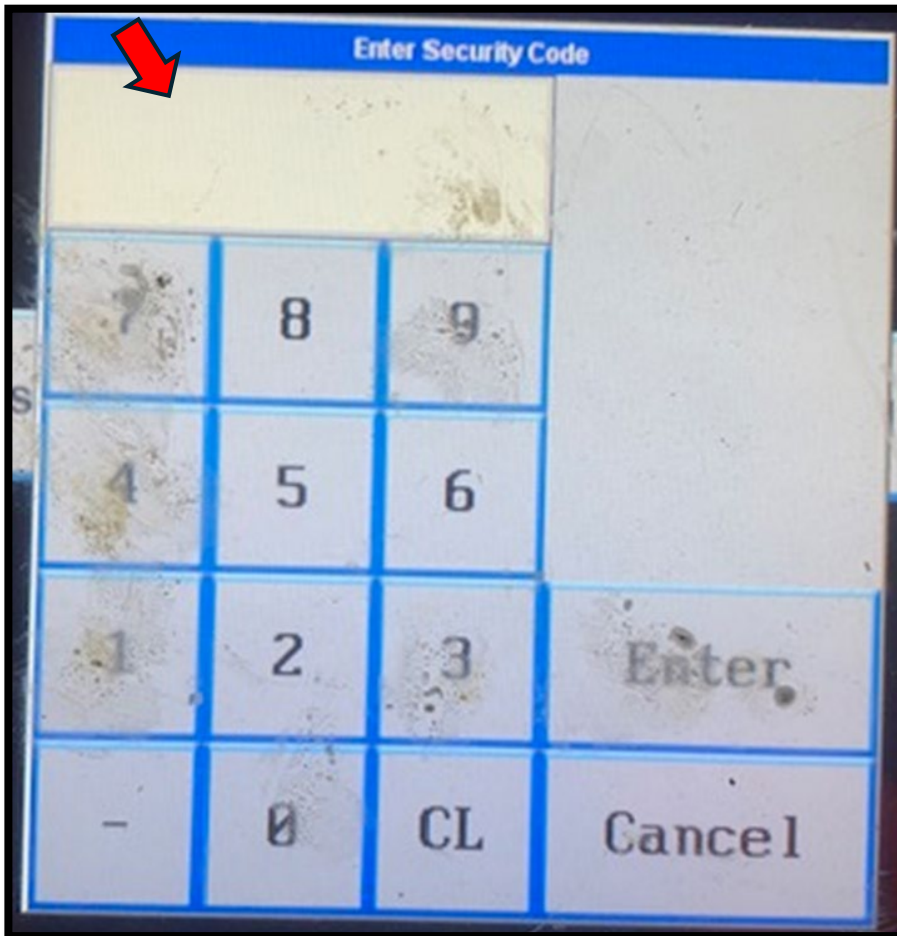
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Figure # 4 Main Menu Diagnostics Window



Figure # 5 Security Code Window Enter 3094



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Figure # 6 Pump Set Up Window

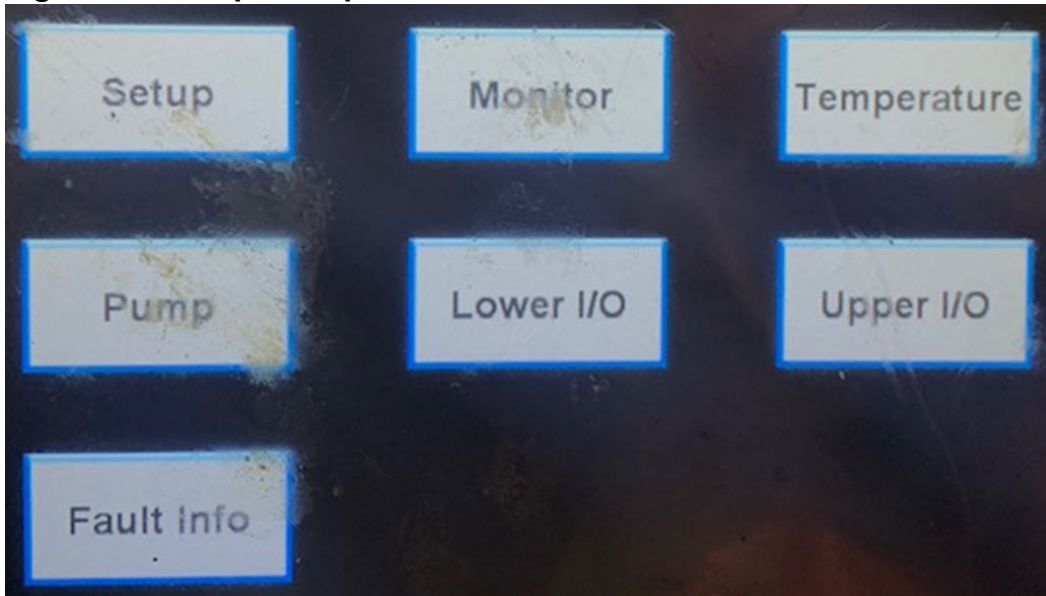
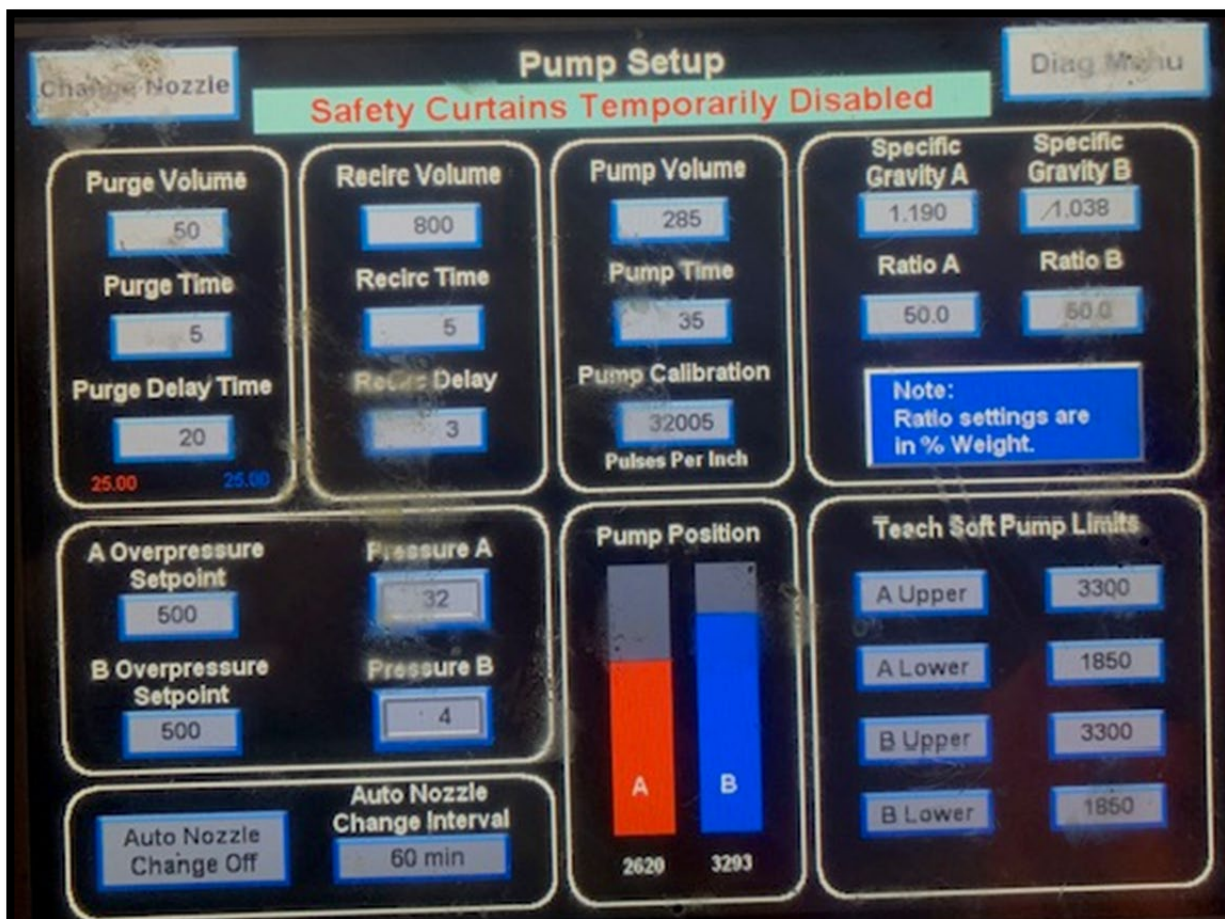


Figure # 7 Pump Set Up/Safety Curtains Temporarily Disabled



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Figure # 8 Pump Set Up Window Safety Curtains Temporarily Disabled

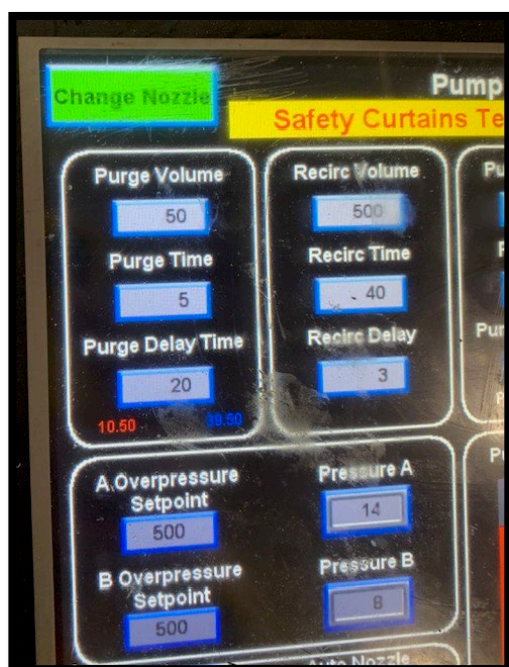
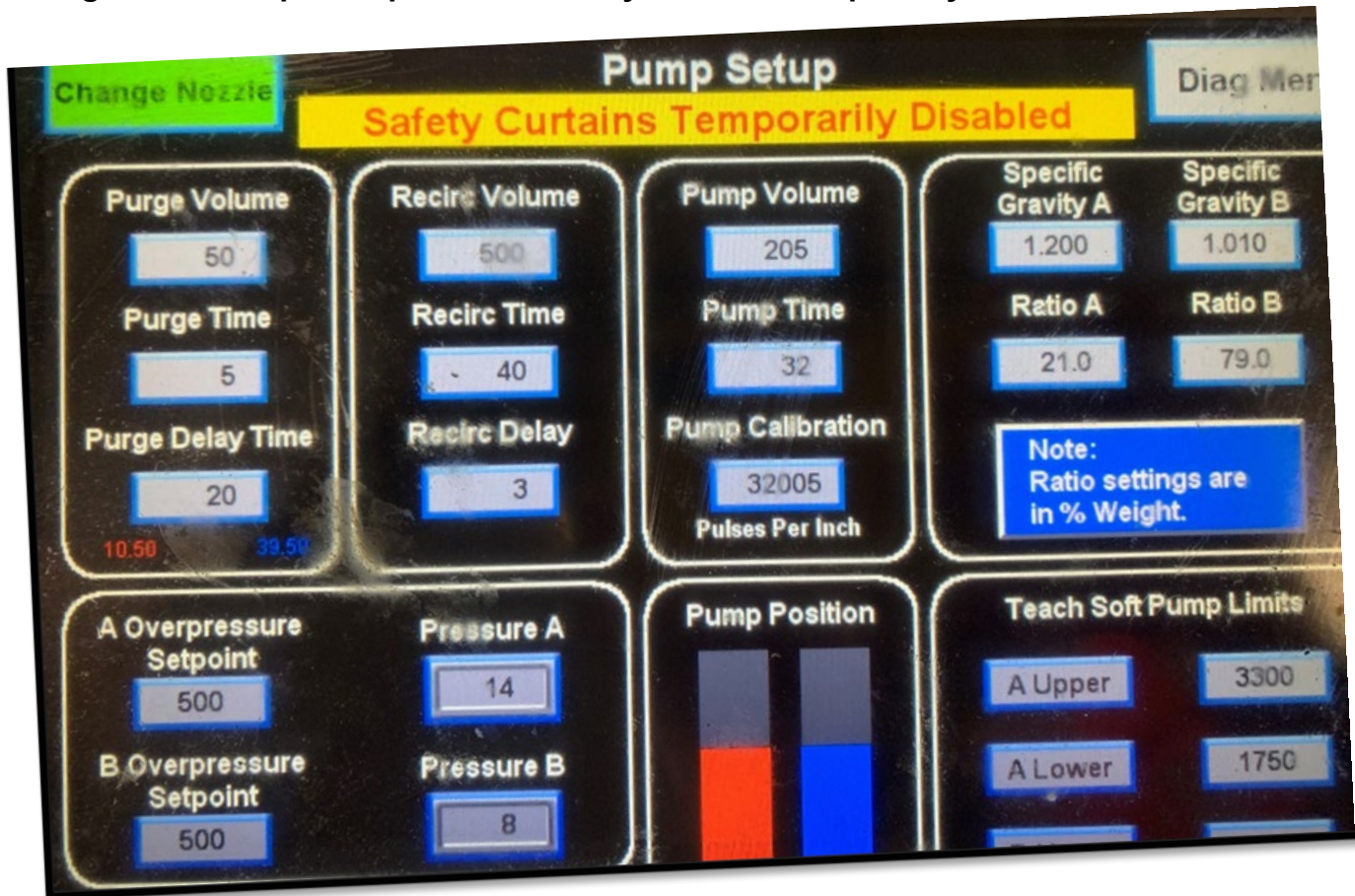


Figure # 9 Safety Curtains Temporarily Disabled

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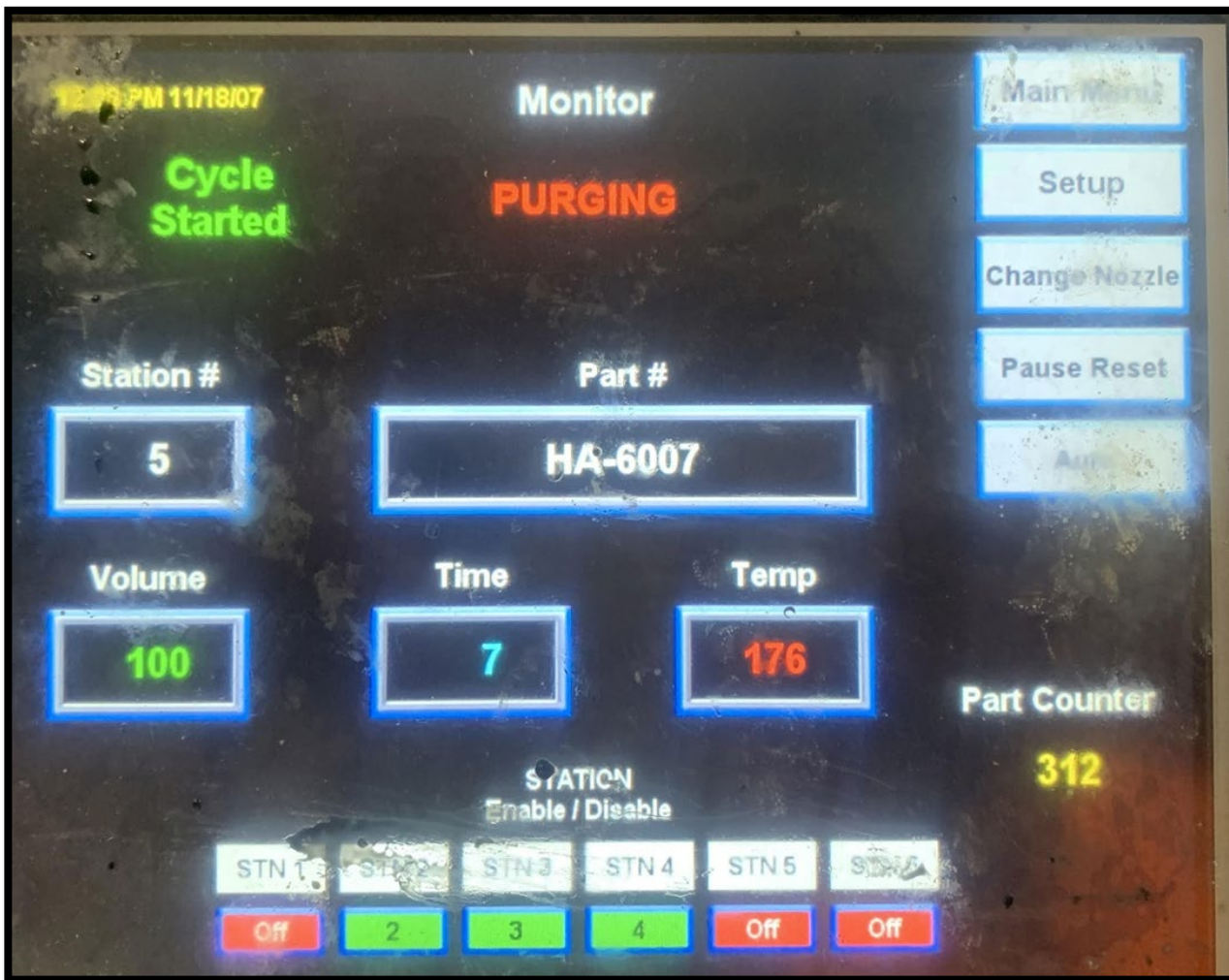
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Figure # 10 Dispense Button



Figure #11 Purging Monitor



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Figure #12 Dispense Machine Inside the air solenoids operate the Inject Slide and Purge Tube. With safety disabled, the solenoids move the plunger, pushing the chemical through the TAH head and out of the mixing block.

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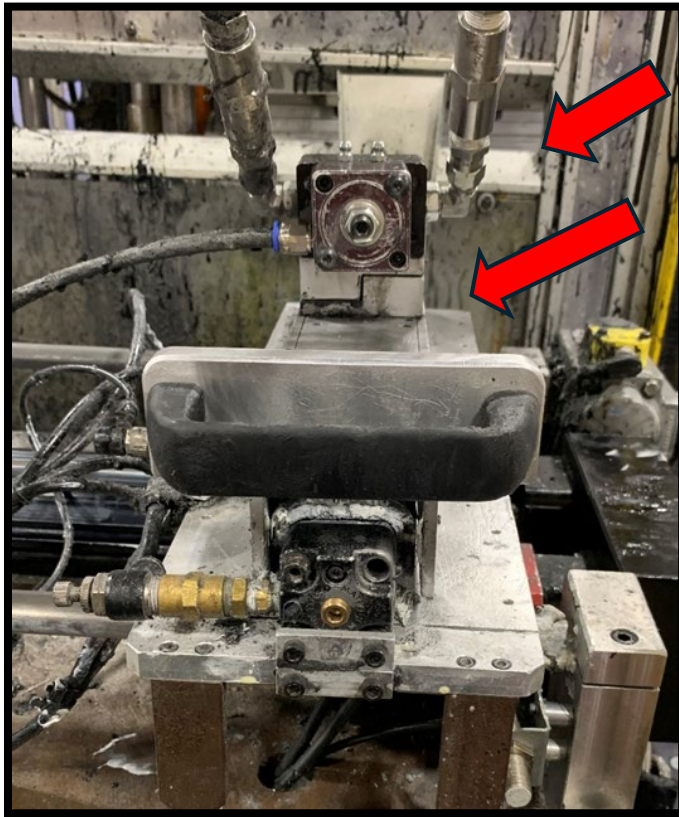


Figure # 13

Tah Head

Inject Slide

Figure # 14 Purging Inject Slide and Tah Head

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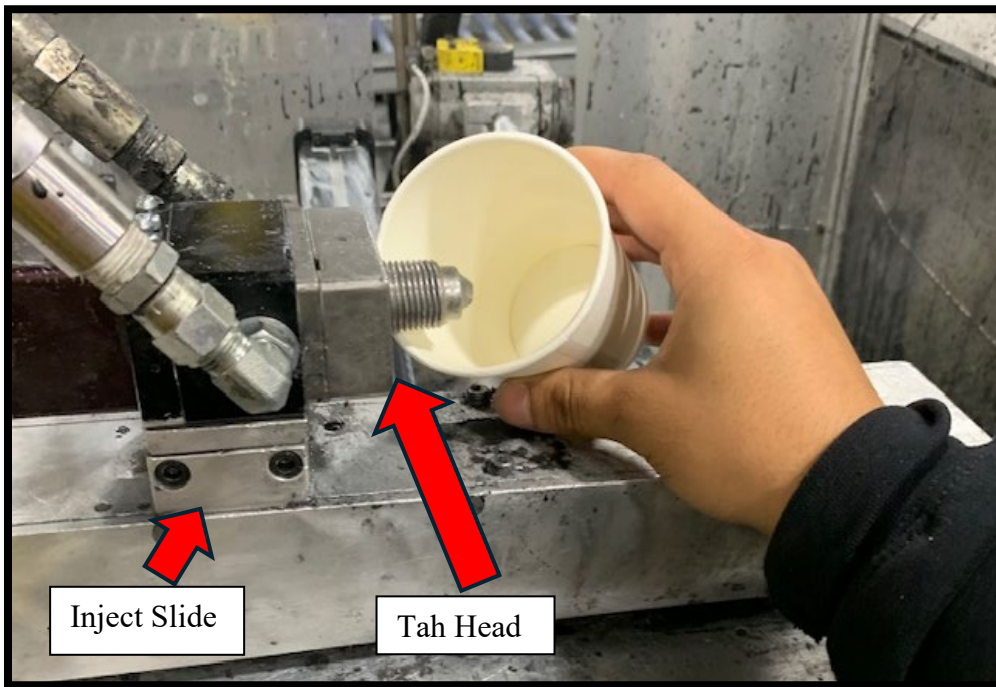


Figure # 16 Day Tank Monitor



Figure # 15 Day Tank Gravity A and B

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Figure #17 Mixer Motor

