



# Picture Process Maps Salvage

Auto Tie Baler Quick Reference

# Salvage– Auto Tie Baler Operation

## BEFORE YOU START:

1. Do not operate baler without being trained and signed off
2. **Do not operate baler without completing the Daily Checklist**
  - a. Daily Checklist is located on a clipboard on the threader
  - b. The checklist is turned into a Salvage Manager at the end of every shift. The Salvage Manager scans the document and its saved in an electronic file

Required Tools and Materials	
<input type="checkbox"/>	Gaylords (2)
<input type="checkbox"/>	Daily Checklist (see last page)

## Auto Tie Baler Operation – Information Screen

### INFORMATION SCREEN

Whenever the baler is on, this screen is on.

#### System Pressure

When the baler is compressing a bale, the pressure used is being indicated here.

#### Tie Length

The length of the bale currently being processed

#### BALE SIZE

The standard setting for the size of bale we use is 68

#### Message Screen

Important operating messages



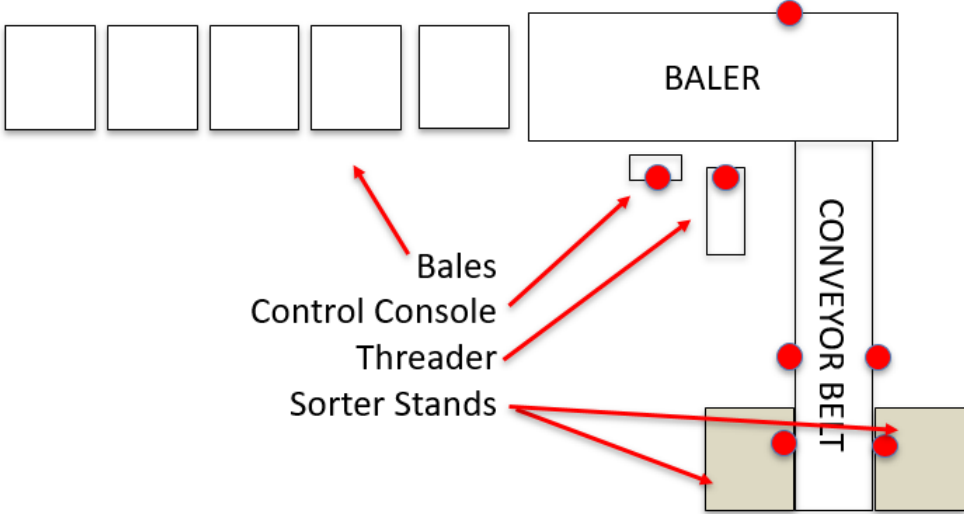
# Auto Tie Baler Components- Stack Light

The Stack Light is above the Control Console. Each color stands for a different mode of operation.

- WHITE**- Indicates the baler has been started.
- GREEN** - Indicates the baler is running in automatic
- BLUE** - Indicates the baler is in the tie cycle
- AMBER** -Indicates the baler is in start-up mode OR has a fault and has stopped, The light will pulse.  
If solid, it means the baler is trying to be started, and the HAND-AUTO switch is not in the HAND position.
- HORN**-Horn will blow whenever the amber light is on.



# Emergency Shut Off Locations



There are a total of **SEVEN** Emergency Shut Offs.

● Indicates location of Emergency Shut Off



# Auto Tie Baler- Start up

0. Ensure Key Exchange keys are in the correct position (no picture)
  1. Ensure electrical power is on (handle is up) (Pic #1)
  2. Ensure the Baler power toggle switch is turned on (Pic #2)
  3. Baler on/off switch, turn key to ON (Pic #3)
  4. Mode switch Hand/Auto: Ensure in "Hand" position (Pic #4)
  5. Resent Button: Press for a few seconds, release, press for a few more seconds (Pic #5)
  6. a. Press the start button until the stop button illuminates red (Pic #6 a/b)
- WAIT FOR MOTOR TO TURN ON**
7. Turn the Mode Switch to AUTO (Pic #4)



# Shut down

1. Baler on/off switch, turn key to OFF (Pic #3)
2. Ensure the Baler power toggle switch is turned off (Pic #2)
3. Ensure electrical power is off (handle is down) (Pic #1)

# Auto Tie Baler- Sorting

**SAFETY ALERT: DO NOT add any type of step, box, or other item on top of either sorter stands to stand on.**

Items need to be removed and placed in the appropriate Gaylord:

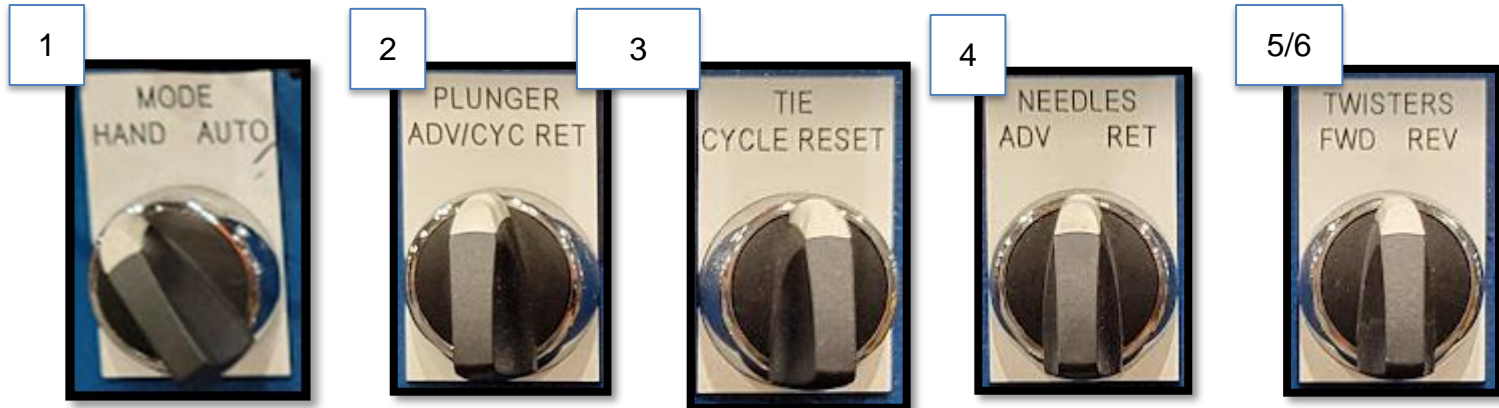
- Stuffed Animals
- Shoes
- Hangers
- Plastic/Plastic Bags
- Other non-cloth items



# Auto Tie Baler- Manual Tie

If the baler stops DURING THE TIE CYCLE (Blue light is on). if you need to stop the machine. always check to see if the blue light is on. If it is, do not stop the Baler until it has finished the Tie Cycle.

1. Mode switch is in "Hand" position (Pic #1)
2. Hold the Plunger on Advance for 5 seconds (Pic #2)
3. Hold the Plunger AND Tie Cycle at the same time for 5 seconds OR until the baler stops making noise (Pic #2/3)
4. Hold the Needle on Advance until it stops (Pic #4)
5. Hold the Twist on Forward until it stops (Pic #5/6)
6. Hold the Twist on reverse until it stops (Pic #5/6)



## Removing Bales

1. Bales should not be removed until they reach the yellow pillar (see red arrow) Generally, 6 bales.
2. The baling machine uses the weight of finished bales to compact the new bale against.



# Auto Tie Baler- Daily Checklist

## Auto Tie Baler Daily Check-Off List

Phoenix ROC ONLY

Date:

Maintenance Task	Clean Daily	Insp. Daily	Initials
Check infrared sensors (5) are lit	x		
Clean tier (Threader)	x		
Clean heat exchanger (top of the ATB)	x		
Clean loose material on floor, from behind the plunger, and on top of all machine surfaces	x		
Check hydraulic oil temp. If oil Temp exceeds 140 degrees, the machine will shut down		x	
Walk Around:			
Check oil level. If oil level is low, the machine will shut down		x	
Check for hydraulic oil leaks		x	
Check that all electrical covers are functional and secure		x	
Check that all bale wire feeds are smooth and unrestricted		x	
Check Twister Hooks for wear and alignment		x	
Check oil filter indicator		x	
Check that all safety sensors (including tier position switch) and guards are functional and secure		x	
NOTES:			

<b>Infrared Sensors (5)</b>	●
(2) Hopper windows	
(3) Tier (threader) inside, 1 south, 2 north	
<b>Heat Exchange (Fans)</b>	✕
On top of >>>>>>>>	
<b>Twister Hooks</b>	⚡
North/South side of compression chamber	
<b>Oil Gauge &amp; Check Oil Filter Indicator</b>	←

