



4 BAGGER CONVEYOR

The 4 bagger bag closing conveyor by Express Scale Parts has an overall length of 86". It has a 12" wide, 3 ply, neoprene and a rough top belt.

The conveyor body is connected to 4 legs, which are adjustable in height by changing pin positions. Holes have been provided so that adjustments can be made every 2 inches. The 6" wide metal backboard is adjustable in the same manner.

The adjustable sew column is designed to handle most portable type sewing heads. The bracket holding the sewing head is easily positioned up and down with the hand crank and in and out through the sliding bar. The sewing head when centered over the conveyor can be secured with the locking bolts.

The conveyor is driven by a 1/2 HP, variable speed, DC motor operated by a single phase supply of 120 VAC or 220 VAC. The controls of the system consist of an OFF/ON switch, 2 Position foot switch, motor starter, bag switch, and DC drive with potentiometer. The OFF/ON switch turns the entire system off. The potentiometer controls the speed of the belt. The bag switch is to stop the bag before it enters the sewing head. The two position foot switch, position 1 starts the conveyor and position 2 to start the sewing head. When using on existing sewing head it must be wired N.C. to operate with the foot switch.

The timing of the portable sewing head and the conveyor must be uniform. This is extremely easy to adjust on the conveyor inside the control box with the knob on the DC controller board.

It is extremely easy to check and see if the conveyor and sewing head are in fact in time. If the sew line across the top of the bag is straight, then the two are running together. If the sew line is at an angle, then either the bag is running too fast or too slow for the sewing head.

BASIC OPERATION:

The operation is basically as follows. The operator places bag 1 on the bagging machine spout and starts filling. When bag 1 is filled, it is released to the moving conveyor below. Bag 2 is placed on the bagger and the filling begins. Bag 1 has moved down the conveyor to the wand switch and stops the conveyor before the bag enters the sewing machine. The operator steps to

the left, gussets the bag, and with the foot switch starts the conveyor half way down and the sewing machine fully depressed.

After sewing the bag the operator releases the foot pedal, the sewing head will stop, the operator pushes the bag back slightly thus pushing the thread into the cutter, cutting the thread, the conveyor will continue to run until the next bag reaches the bag switch. Bag 2 is released and bag 3 is placed on the bagger, and the process continues.

Typical speed is one man can bag fill, sew and stack at 4 bags per minute at 50 minutes per hour or 200 bags per hour.