

SOP Number:	Client Name & Logo Standard Operating Procedure Detailed Information	Page: 1 of 5
Date Written:		Revised By:
Date Revised:		Approved By:
Tree Location:		
Title: Replace Filling Assembly Components		

Safety/Environmental Requirements:

- | | |
|--|--|
| <input type="checkbox"/> H = Hazardous Materials | <input type="checkbox"/> S = Substance Containment Procedure Required |
| <input type="checkbox"/> C = Confined Space Requirements | <input type="checkbox"/> L = Lockout/Tagout Procedures Required |
| <input type="checkbox"/> T = Care Must Be Used Not To Exceed Tolerance Levels | <input type="checkbox"/> E = Special Safety Equipment Required |
| <input type="checkbox"/> R = Special Safety/Environmental Requirements | |
-

Objective:

Changeover the filling assembly components from size XX to size YY

Unique/Special Safety or Environmental Requirements:

Equipment / Materials Required (*Safety Items, Tools, Other Materials*):

Set of metric combination ratchets and/or sockets

Torque wrench capable of 57 Nm (42 lbf-ft)

Food-grade grease

Food-grade anti-seize thread compound

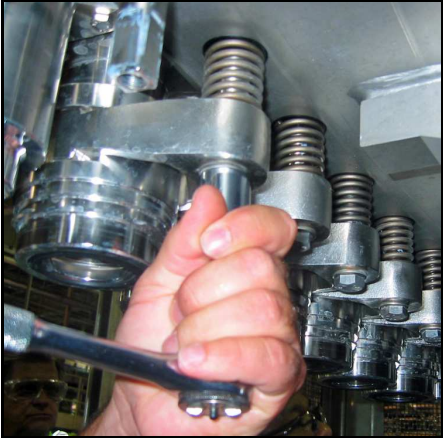
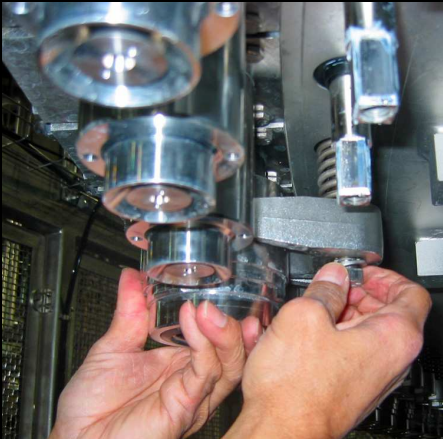

Replacement components:

List of machine-specific components and quantities

References:

Manufacturer's operations and maintenance manual

STEPS	AWARENESS
<p>PREPARE MACHINE FOR CHANGEOVER</p> <ol style="list-style-type: none"> 1. Check that the machine is run out of product and is stopped from the control station. 2. Check that the machine exterior has been cleaned. 3. Clear and reset any active E-Stops. 4. At the machine control panel, place the Mode Switch in Jog. 5. Jog the machine until the first 10 elements are accessible through the safety doors. 6. Open the safety doors as necessary to access changeover components. 7. Stage the changeover rack at the machine to receive components as they are removed. 	

STEPS	AWARENESS
<p>REMOVE XXX SIZE BELLS</p> <ol style="list-style-type: none">1. Using a 19mm socket wrench, loosen but do not remove the bolt attaching the XXX actuator fork to the control rod.2. Support the bell assembly to be removed and remove the bolt loosened previously.3. When the bolt is removed, slide the actuator fork, bell and spring off of the control rod.4. Store the bell assembly on the changeover rack and set the 19mm bolt aside for use on the YYY bell.	  

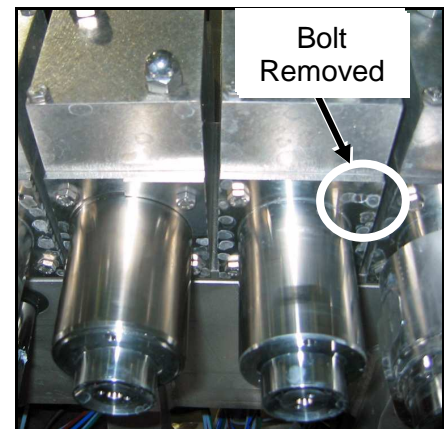
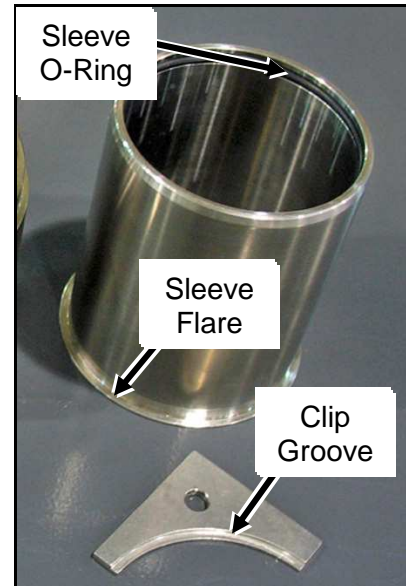
STEPS**AWARENESS****INSTALL YYY SLEEVES**

1. Obtain an YYY element sleeve and clip from the changeover rack.

NOTE: The end of the sleeve to be installed over the bottom of the element has a small flare that mates with the groove in the corner clip when it is installed on the element. The opposite end of the sleeve has an o-ring located in a groove in its inner circumference.

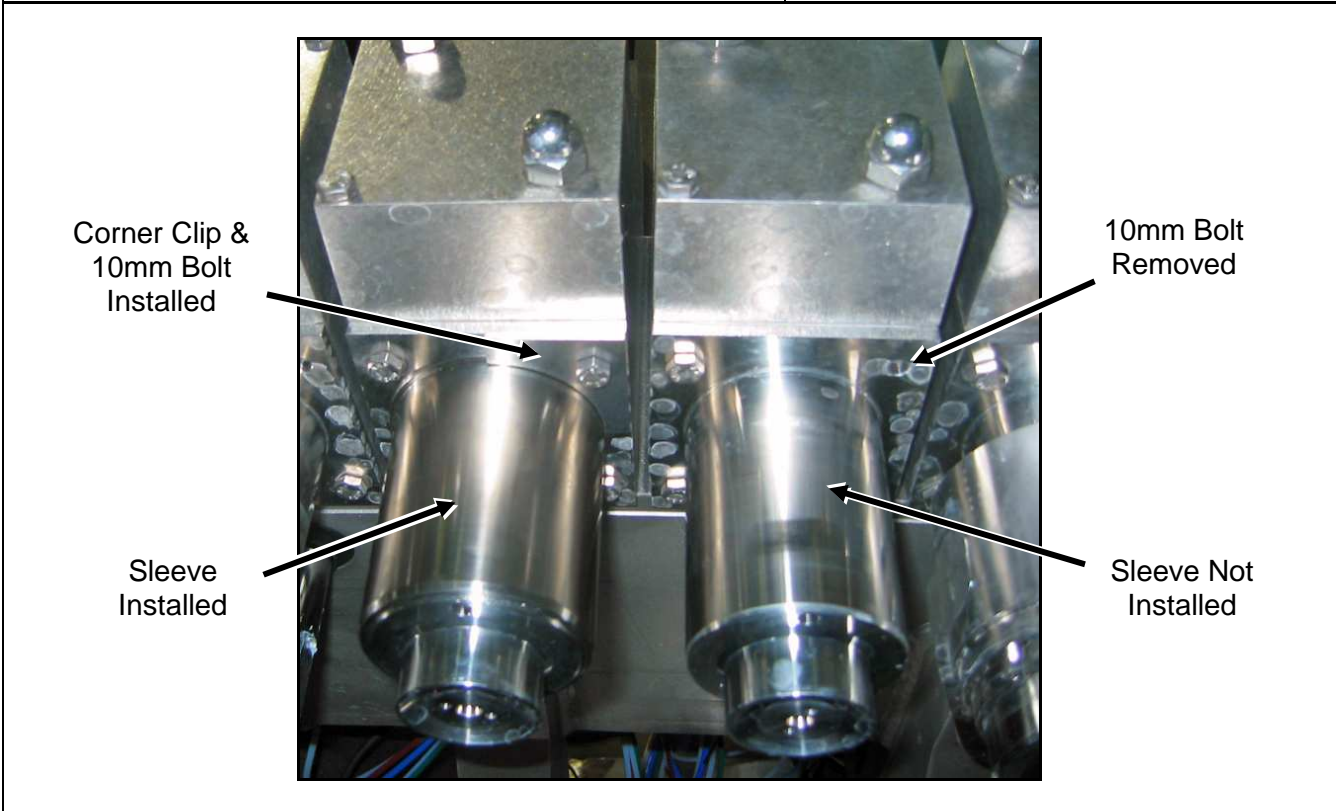
2. Using a 10mm wrench, remove a bolt from one front corner of the element. Set the bolt aside for installation of a sleeve clip.

3. Before installation, lubricate the sleeve o-ring with a thin coat of food-grade grease.



STEPS	AWARENESS
--------------	------------------

4. Slide the flared end of the sleeve over the element and press upward until the sleeve is seated firmly against the element.



5. Place the grooved side of the clip against the sleeve flare and install and tighten the 10mm bolt into the element.

Coat the threads of the bolt with food-grade anti-seize compound before installation.