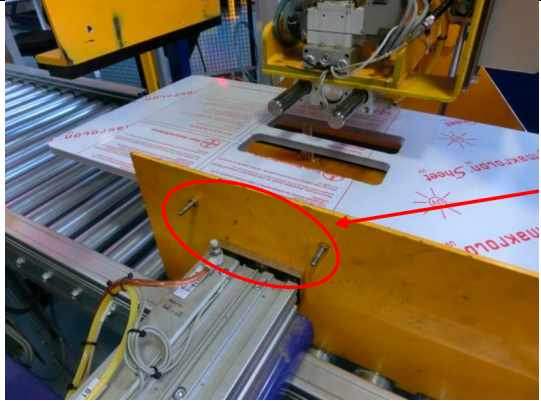
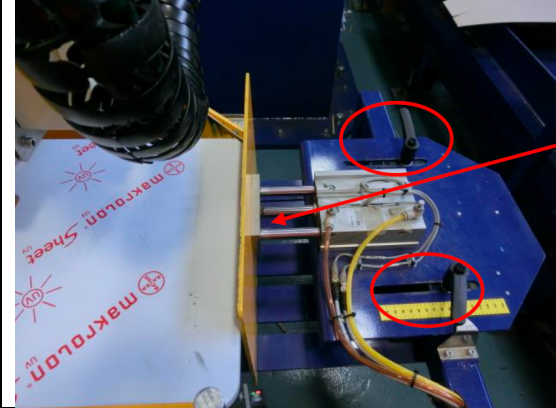
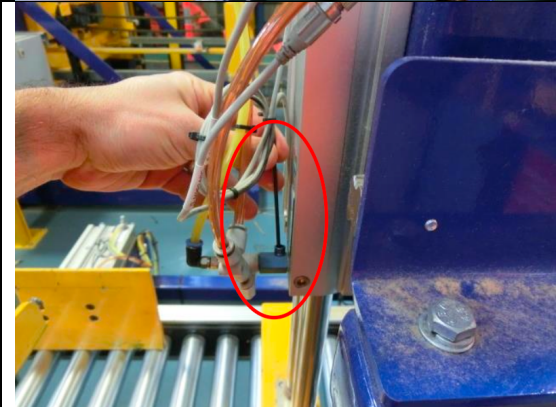
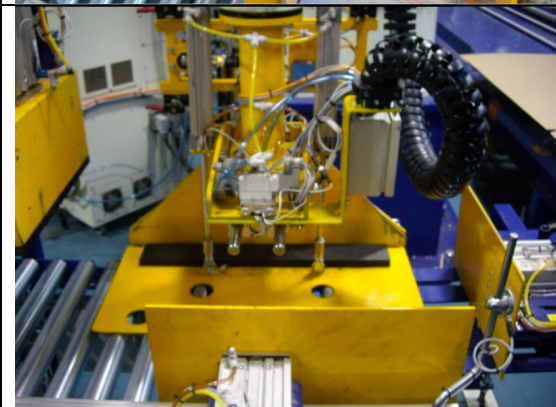


PRO SOS2 Palletisation Gripper Set Up

1. **PURPOSE** Bag positioning for robot gripper
2. **SCOPE** Changeover of finished bag length for correct bag pick up and placement by robot gripper
3. **RESPONSIBILITY** Operators
4. **METHOD**

VISUAL DIAGRAMS	STEPS	SPECIAL REQUIREMENTS
	Step 1: Enter the robot cell using the safety access key. This key must be in possession at all times when in the robot cell.	
	Step 2: Select the correct bag template for the finished length of bag on the BPO.	
	Step 3: Using the correct template, place studs in locating holes of backing plate and fit nuts so that the template is secure.	

	Step 4: Fully extend the right side stop cylinder and loosen the clamps to adjust the cylinder to meet the template. Tighten the locks once in correct position.	
	Step 5: Release the air pressure from the cylinder on the lower port.	
	Step 6: Extend the left cylinder down; loosen the clamp to adjust the cylinder to meet the template. Tighten the clamp once in correct position.	
	Step 7: Remove the template, so robot gripper is ready for production.	