
	<b>Filler Clean</b>		
	Owner: T. Guire	AGCO-PG-L06- 0031	
	Approved by: M. Awoman	Rev: 2	Rev. Date: 06/22/2022

1. **Scope** - Packaging Line 06 Filler Clean standard operating procedure instructions.
2. **Purpose** - To ensure that Line 06 Filler Clean standard operating procedure is performed per the instructions.
3. **References** - AGCO-PG-L02-0012 Filler 6 CIP.PDF
4. **Safety Considerations / Requirements**

<input type="checkbox"/> Hazardous Materials	<input type="checkbox"/> Confined Space Permit Required
<input type="checkbox"/> CO2/Gas Exposure	<input type="checkbox"/> Lockout Tagout Procedures Required
<input type="checkbox"/> Glass Exposure	<input type="checkbox"/> Substance Containment Procedure Required
<input type="checkbox"/> Special Safety Equipment Required	<input type="checkbox"/> Other: _____
5. **Additional Personal Protective Equipment (PPE) Requirements** - Assumes Safety Glasses, Safety Shoes, Bump Cap and Hearing Protection are worn in required areas and locations.

<input checked="" type="checkbox"/> Chemical Suit/Apron & Coat	<input checked="" type="checkbox"/> Face Shield
<input checked="" type="checkbox"/> Chemical Gloves	<input type="checkbox"/> Goggles
<input type="checkbox"/> Cut Resistant Gloves	<input type="checkbox"/> Dust Mask
<input checked="" type="checkbox"/> Rubber Boots	<input type="checkbox"/> Arm Guards
<input checked="" type="checkbox"/> Other: High-visibility attire _____	
6. **Equipment and Materials** - Water Hose, Bucket, Long-handled brush, Scotch Brite pads, Push broom, Shovel, Dustpan, High Pressure Hose, Lock (If needed), Mild detergent solution (such as water & Dawn), Portable or wall mounted foaming units,
7. **Food Safety Risks and Requirements** - because of open containers: Hairnet (regardless of hair length), Beard Net (if any visible facial hair), Nitrile gloves (over cut resistant gloves if cut resistant gloves also required)
8. **Quality Considerations** – N/A
9. **Environmental** – N/A
10. **Applicable Job Title** – Line Operator

	<b>Filler Clean</b>		
	Owner: T. Guire	AGCO-PG-L06- 0031	
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**11. Terminology and Acronyms – N/A**

**12. Special Notes – N/A**



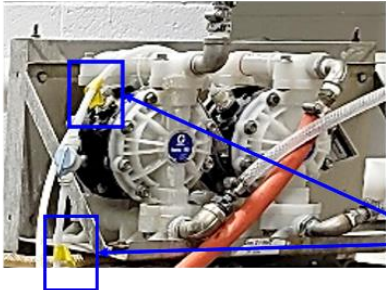
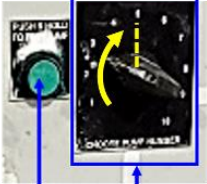
**13. Quick Steps (include if applicable)**

**Quick Summary of Steps (see SOP on next pages for details):**

1. Prepare to Clean & Remove Bottle Handling Parts (Steps 1-5)
2. Clean Filler & Crowner from Platform (Steps 6-10)
3. Clean Inside Filler from Rear-Access Doors (Steps 11-18)
4. Clean Bottle Handling Parts (Step 19)
5. Clean Rinser (Steps 20-22)
6. Clean Conveyors, Floors & Drains (Steps 23-30)
7. Replace Bottle Handling Parts (Step 31)

	<b>Filler Clean</b>		
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**14. Procedure**

STEPS	Image and/or Additional Information
<b>Prepare to Clean &amp; Remove Bottle Handling Parts</b>	
<ol style="list-style-type: none"> <li>1. Bring cleaning supplies shown on front page to Filler.</li> <li>2. Fill tank on portable foam applicator unit by doing the following:               <ol style="list-style-type: none"> <li>a. Take portable foam applicator unit to chemical room.</li> <li>b. Turn pump selector dial to #5 (yellow) for AFCO 5339</li> <li>c. Place dispensing wand into tank.</li> <li>d. Press &amp; hold green button to activate pump until tank is filled</li> </ol> </li> </ol>	
	<div style="border: 1px solid black; padding: 5px;"> <ol style="list-style-type: none"> <li>1. Select appropriate pump number</li> <li>2. Place dispensing wand in container</li> <li>3. Press &amp; Hold green button to activate pump</li> </ol>    </div>
<ol style="list-style-type: none"> <li>3. Remove all empty bottles from line.</li> </ol>	Filler, Bottle Infeed, Rinser, Infeed & Discharge conveyors.



# Filler Clean

Owner: T. Guire

AGCO-PG-L06- 0031

Approved by: M. Awoman

Rev: 2

Rev. Date: 06/22/2022

4. Remove all bottle handling parts except parts listed & shown in photo. Keep organized on platform to be cleaned later:

- Infeed Guide (at worm)
- Crouner Infeed Guide & Star Wheel



5. Cover Checkmat inspection unit with plastic.

### Clean Filler & Crouner from Platform

6. Rinse Filler & Crouner on the platform side with a water hose to remove:

- Loose glass
- Crowns
- Grease
- Product residue
- Mold







# Filler Clean

Owner: T. Guire

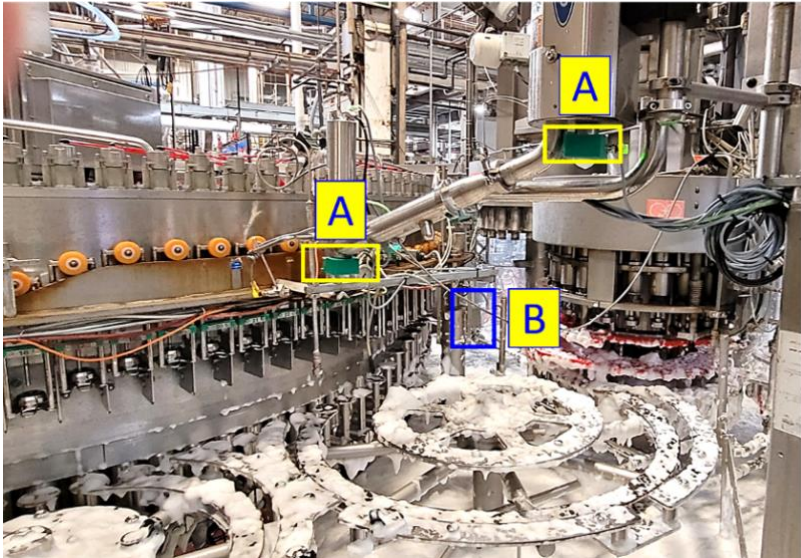
AGCO-PG-L06- 0031

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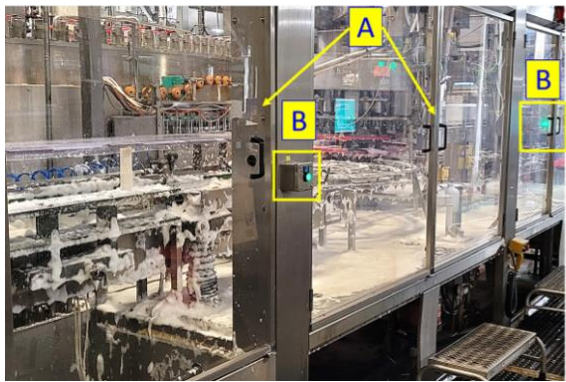
Rev: 2


Rev. Date: 06/22/2022

- 7. Do the following on the platform side of the Filler:
  - a. Ensure that the Nitrogen dosing heads are covered.
  - b. Take note of location of electronic control box inside Filler: DO NOT spray with foam.
  - c. Spray all accessible parts & surfaces of Filler & Crouner, except as noted, with foam.



- 8. After all surfaces on platform side are foamed, do the following:
  - a. Close all doors.
  - b. Ensure doors are locked by verifying door interlock button is illuminated solid green.
  - c. At Filler HMI, press [Reset]
  - d. Turn key to [ I ]



	<b>Filler Clean</b>		
	Owner: T. Guire	AGCO-PG-L06- 0031	
	Approved by: M. Awoman	Rev: 2	Rev. Date: 06/22/2022

9. After foam has been on surfaces for at least 10 minutes, thoroughly rinse foam off all surfaces.



10. Hand scrub the Crowner Chute with Scotch Brite then rinse with water.

To get rid of any metal fibers from the crowns.


**Clean Inside Filler from Rear-Access Doors**

In preparation for foam-cleaning all the Filler heads, you will be doing several of the same steps (Steps 11 through 13) that are done to prepare for the Filler Clean-in-Place (CIP).

11. On the cabinet behind pipe PRC CIP-R #3 (on the bottom of the two sets of pneumatic supply assemblies), turn the Lift Cylinder Air Supply OFF by turning indicated knob by 90 degrees.





	<b>Filler Clean</b>		
	Owner: T. Guire	AGCO-PG-L06- 0031	
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12. Open rear-access doors 13 & 14 to the Filler:
- Push blue/green illuminated door interlock button.
  - Light will start flashing.
  - Turn the 2-door latch handles 90 degrees & open both doors.



13. Using foot-operated jog switch, rotate Filler for 2 revolutions to drop lift cylinders.

Possible issues you may encounter:

- If Filler faults & will not rotate, press black reset button on side of foot pedal & try again.
- If Filler still will not rotate check if blue light on Filler HMI is flashing. If so, safety circuit may have faulted & must be reset.
- If any lift cylinders don't drop completely, pull them down manually.





# Filler Clean

Owner: T. Guire

AGCO-PG-L06- 0031

Approved by: M. Awoman

Rev: 2

Rev. Date: 06/22/2022

14. Foam each of the areas indicated:
- a. All filling valve positions (valves, vent tubes, tulips, lifters ...). You will need to jog the Filler with the foot pedal switch to access all positions.
  - b. Inside of doors & metal guard surrounding filler, along with pipes & floor inside Filler
  - c. Inside of Plexiglas windows.



15. After foam has been on surfaces for at least 10 minutes, thoroughly rinse foam off all surfaces.


Check for any grease or mold that remain or might have blown out while rinsing. Spray it out, if possible.

If necessary, use a Scotch-Brite pad or bristle brush to loosen it, then spray surface clean.

It may take extensive scrubbing along with several rinses to clean all mold & grease from Filler – especially if the Filler has run for a long time without cleaning.





	<b>Filler Clean</b>		
	Owner: T. Guire	AGCO-PG-L06- 0031	
	Approved by: M. Awoman	Rev: 2	Rev. Date: 06/22/2022

16. When the Filler has run for a long time without cleaning, for example 10 days or more, and is very dirty, the tulips on each head will need to be removed & individually cleaned after they have been foamed & rinsed. To do so:
- a. Remove clamp holding tulip in place.
  - b. Lift out tulip.
  - c. Soak tulips in a bucket of water with Dawn solution to break down mold & grease.
  - d. Scrub each tulip with a Scotch-Brite pad before placing back onto Filler.



17. If performing Clean-in-Place (CIP) of the Filler, this is the time to do so. Reference AGCO-PKG-L060319 Filler 6 CIP SOP for instructions.
18. Close Rear-Access Doors & reset Door Switch.
19. Turn air back **“ON”** to Lift Cylinders (see images in Step 11).



# Filler Clean

Owner: T. Guire

AGCO-PG-L06- 0031

Approved by: M. Awoman

Rev: 2

Rev. Date: 06/22/2022

## Clean Bottle Handling Parts

20. Apply foam to bottle handling parts.

After foam has been on surfaces for at least 10 minutes, thoroughly rinse foam off all surfaces.

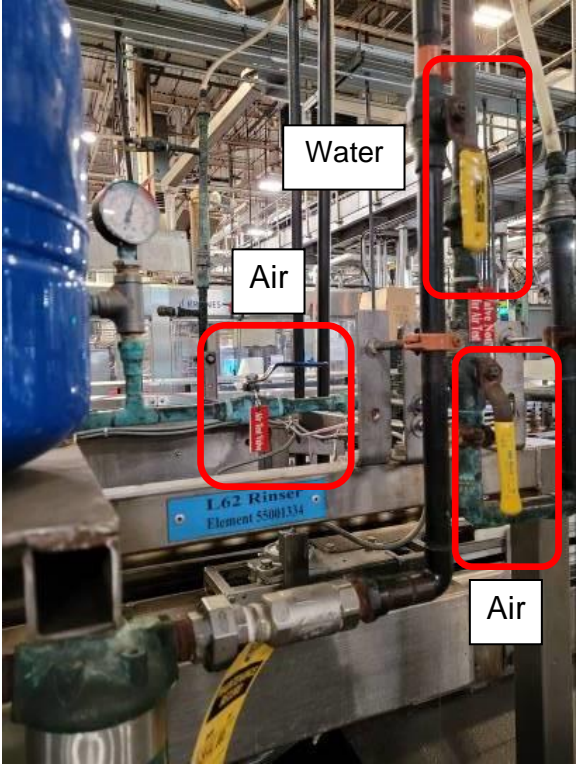
If any debris remains, hand-scrub with a Scotch-Brite pad & a solution of Dawn with water.



## Clean Rinser

21. Close air & water valves for Rinser.

(Note: Valves are on NW side of Rinser)







# Filler Clean

Owner: T. Guire

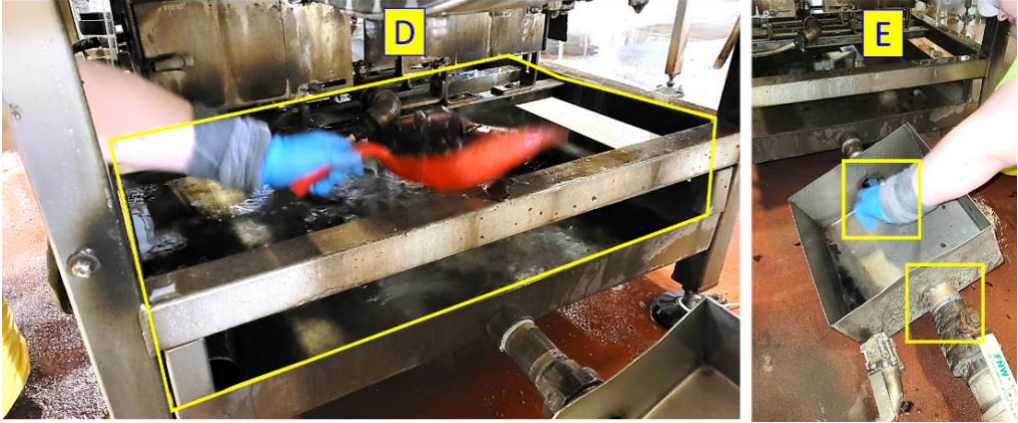
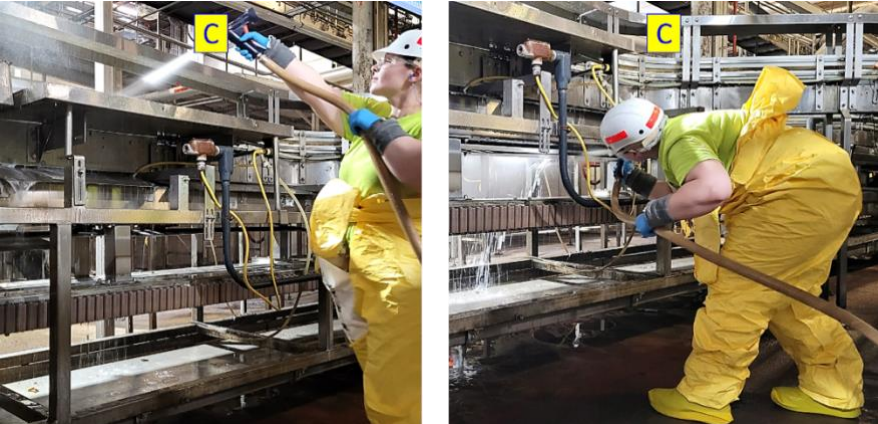
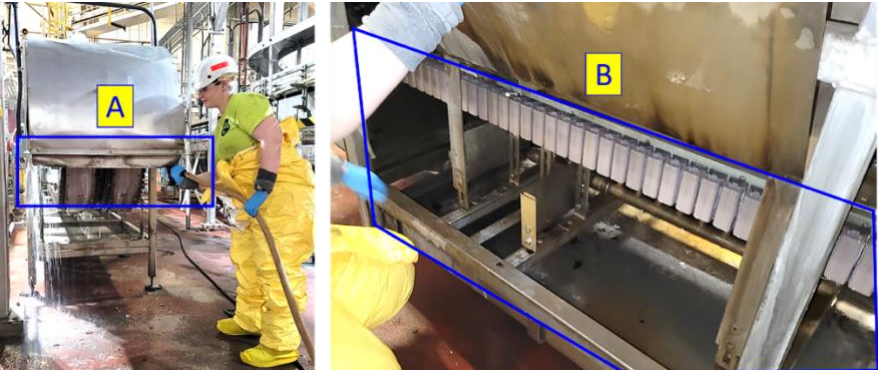
AGCO-PG-L06- 0031

Approved by: M. Awoman

Rev: 2

Rev. Date: 06/22/2022

22. Rinse glass & other debris from all surfaces of Rinser, from top-to-bottom around all sides:
- a. Both ends: Pull end cover up & spray inside.
  - b. North end trap doors on each side
  - c. Entire length of Rinser on both sides
  - d. Glass reservoir at north end: Scoop out glass that collects here with dustpan.
  - e. Pipe just before drain, north of Rinser glass reservoir







# Filler Clean

Owner: T. Guire

AGCO-PG-L06- 0031

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Rev: 2

Rev. Date: 06/22/2022

23. Completely foam all areas of Rinser that were just rinsed.

After foam has been on surfaces for at least 10 minutes, thoroughly rinse foam off all surfaces.



Space Intentionally Left Blank



# Filler Clean

Owner: T. Guire

AGCO-PG-L06- 0031

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Rev: 2

Rev. Date: 06/22/2022

## Clean Conveyors, Floors & Drains

- 24. Do the following to the infeed conveyors:
  - a. Pick off all bottles. Empty debris from drip pans.
  - b. Rinse off all broken glass. Rinse out drip pans.
  - c. Foam all surfaces. Let remain at least 10 minutes.
  - d. Rinse conveyors with high-pressure water. Get under the conveyors, looking for any mold buildup.
  - e. Scrub any remaining debris.







# Filler Clean

Owner: T. Guire

AGCO-PG-L06- 0031

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Rev: 2

Rev. Date: 06/22/2022

- 25. Do the following to the metal belt discharge conveyors between the Filler & the plastic discharge table:
  - a. Pick off all bottles.
  - b. Rinse off all broken glass.
  - c. Do not foam! Conveyors too close to Checkmat. May damage it. Instead, run metal belts while holding Scotch Brite pad against belt & space between belts. Do repeatedly for all belts until all slime is removed.



- 26. Do the following to plastic discharge conveyors on the discharge table:
  - a. Pick off all bottles. Empty debris from drip pans.
  - b. Rinse off all broken glass. Rinse out drip pans.
  - c. Foam all surfaces. Let remain at least 10 minutes.
  - d. Rinse conveyors with high-pressure water. Get under the conveyors, looking for any mold buildup.
  - e. Scrub any remaining debris.



- 27. Scrub inside & outside of Plexiglas safety doors with a clean rag dampened by a solution of Dawn detergent.
- After hand scrubbing, rinse doors with water.







# Filler Clean

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AGCO-PG-L06- 0031

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Rev: 2


Rev. Date: 06/22/2022


28. Do the following to the floors in entire area:
- a. Hose floors toward floor drains so debris goes down drains & glass can be swept up easily.
  - b. Squeegee floors
  - c. Sweep glass up & dispose of it in the glass hopper.


Be sure to direct glass that's underneath the Filler to the other side for cleanup.



29. Clean out area floor drains.
30. Roll up hoses & pick up cleaning supplies.
31. Return equipment & supplies to designated storage area.

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<b>Return Bottle Handling Parts</b>	
<p>32. After the CIP (if required) has been completed, return all bottle handling parts removed at start of cleaning.</p>	
<p>If cleaning after shutdown, follow the LOTO Guide instructions on locking and tagging energy sources before you begin cleaning. Refer to your Cleaning SOP for detailed cleaning instructions.</p>	
<p>To make updates to this document, please note any changes or revisions to this document and route to your supervisor. Your input is critical. Thank You.</p>	

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**Revision History**

Rev. Date	Rev	Rev. by	Approved by	Approval Date	Revisions
04/26/2015	1	T. Guire	J. Super	04/26/2015	New SOP
06/22/2022	2	T. Guire	M. Awoman	06/22/2022	No Revision Notes