

**7.5.1.1.323 SOP A ZYN Packing Line
Checkweighers**

Revision No.: 1
Revision Date: 1/28/2020

Quality & Environmental
Management System

Process Owner: (b) (6)
(Superintendent ZYN Manufacturing)
Document Type: Standard Operating Procedure

Approved by: (b) (6)
Document Author:
(b) (6)

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1.0 Purpose: Provide an overview of ZYN Packing Line's checkweigher operation.

2.0 Scope:

2.1

2.2

(b) (4)

3.0 Respo

3.1

3.2

(b) (4)

4.0 Definition/Abbreviations/Acronyms:

4.1 NIST/FTC stands for National Institute of Standards and Technology/Federal Trade Commission

5.0 Requirements:

5.1 Checkweigher Station

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5.2 Daily Start Up and Checklist

5.2.1 Confirm the checkweigher is powered on.

5.2.2 (b) (4)
[Redacted]
[Redacted]
[Redacted]
[Redacted]

(b) (4)

.1 Confirm there is no debris on any the conveyor belts moving either in or out of the checkweigher.

5.2.3 (b) (4)
[Redacted]

5.2.

(b) (4)

5.2.5 Confirm the Tare Weight is properly presented on the Home screen.

5.3 Target Weight, Tare Weight, Target Throughput, and Container Width

5.3.1 The target net weight, tare weight, target throughput, and container width have been previously determined and downloaded into the program. See (Table 5.3.1) Target Container Dimenstions.

Target Net Weight (grams)	Target Weight (grams)	Target Throughput	Container Width (mm)
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(Table 5.3.1) Target Container Dimensions)

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- 5.3.2 The target weight and tare weight are displayed in the top left corner of the home screen. See (Picture 5.3.2) Home Screen.



- 5.3.3 The throughput is located within the program and not visible on the home screen.

5.4 Checkweigher Zone Classifications

- 5.4.1 The checkweigher zone classifications are used to group the net weight of each individual container into user defined weight zones as shown in (Table 5.4.1) Checkweigher Zone Classifications.

Zone	Net Weight range (grams)	Action
(b)	(4)	

(Table 5.4.1) Checkweigher Zone Classifications

- 5.4.2 These zones allow for distribution analysis of the container weights as well as determines which containers are to be rejected.

- 5.4.3 (b) (4)

- 5.4.4 The checkweigher also tallies the containers within each zone.

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5.5 Home Screen

5.5.1 This screen as shown in (Picture 5.5.1) Checkweigher Home Screen shows the vital checkweigher operating information.

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5.6 Checkweigher Reject

5.6.1 Filled cans not meeting the required specifications are rejected at the reject station into a reject bucket.

5.6.2 (b) (4)
(b) (4)
(b) (4)
(b) (4)

(b) (4)

5.6.3 Reject Container

.1 Open, correct and place back onto the production line any rejected cans.

a. (b) (4)
(b) (4)

b. (b) (4)

.2 (b) (4)

5.7 End of Day

5.7.1 Turn off the conveyor belt by pressing the red stop button located on the front of the checkweigher conveyor belt. See (Picture 5.7.1) Stop Button

5.7.2 The checkweigher typically remains in the ON position.

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5.8 Safety Notes

5.8.1 Primary hazards that may be faced.

- .1 Possible pinch points within the guarded areas of the checkweigher and along the conveyor belts.
- .2 Noise levels above 85 dB.

5.8.2 Hazard Mitigation Methods.

- .1 Keep fingers together when placing and removing it conveyor belt.
2. Use of hearing protection to reduce noise exposure.
Located on the north wall outside of the break room
See (Picture 5.8.2.1) Hearing Loss Location

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(Picture 5.8.2.1) Hearing Loss Location

5.8.3 E-Stop & Conveyor Control locations as shown in (Picture 5.9.3) E-Stop and Conveyor Control Button Locations.

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(Picture 5.8.3) E-Stop and Conveyor
Control Button Locations.

5.8.4 Eye wash locations (west wall near washroom) as shown in (Picture 5.8.4) Eye Wash Location

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(Picture 5.8.4) Eye Wash Location

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6.0 Records:

Document Number	Responsible (by Person)	Document Location	Minimum Retention Period
None			

7.0 Dependent Documents:

7.1 Charts

Document Number	Document Title
None	

7.2 SOPs

Document Number	Document Title
None	

7.3 Other

Document Number	Document Title
None	

8.0 Responsible for Process:

Paper copies of this document can be found in these places:

Document Location	Number	Responsible for Updating
(b) (4)		(b) (6)

9.0 Revision History:

12/11/19
1/28/2020

(b) (4)