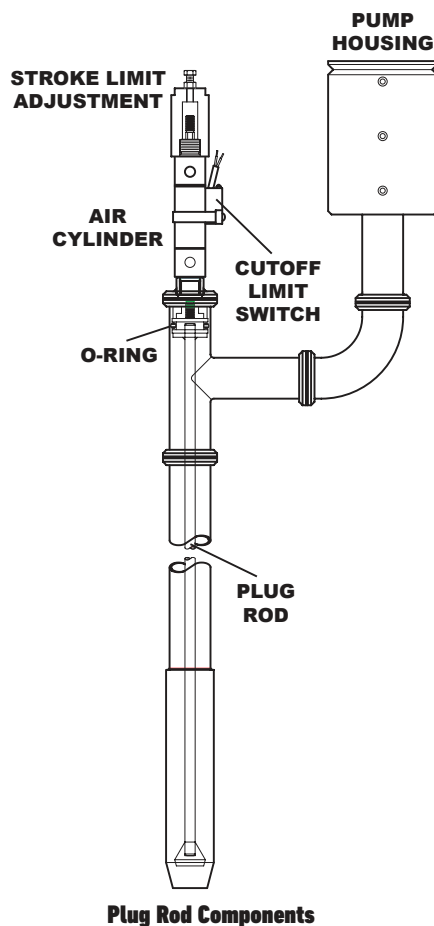


PLUG ROD CUTOFF INSTRUCTIONS

Liquid, cream, and other high viscosity products used with ALL-FILL fillers may use a Plug Rod Cutoff accessory to effectively dispense product with a minimum of dripping, spill, or waste. This publication describes cutoff components, operation, connection details, and cleaning recommendations for continued, efficient use of the Cutoff with your ALL-FILL equipment.

COMPONENTS & OPERATION

Cutoff consists of a Plug Valve Nozzle assembly, Air Cylinder and mounting, internal Plug Rod, an air cylinder limit switch, and a stroke limit adjustment. Typical Plug Rod cutoff components are shown in the following:



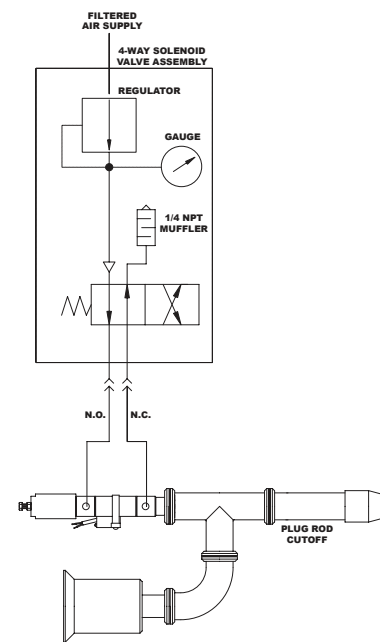
When a fill cycle is initiated, the solenoid is actuated to actuate the air cylinder of the cutoff. The air cylinder retracts to raise the plug rod to dispense product. At the completion of the fill, the air cylinder extends to seal the nozzle.

AIR CONNECTION

During the installation, the cutoff must be connected to a suitable source of compressed air. The source of compressed air should be within 40-60p.s.i for proper operation.

IMPORTANT

Excessive air pressure may result in premature wear of plug rod components.. Use of a separate regulator gauge for the cutoff may be required to control air pressure to prevent wear. Additionally, a flow control valve may be recommended for installation between the cutoff and solenoid valve so that air pressure can be controlled to prevent any leaking product from the cutoff. A typical air schematic for a plug rod cutoff is shown in the following.



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ADJUSTMENTS

The only setup adjustment of the Plug Rod cutoff is to adjust the stroke so that the nozzle seals at the end of the fill.

CLEANING RECOMMENDATIONS

The cutoff and components should be periodically cleaned to prevent contamination and/or product buildup. If necessary, the entire cutoff can be disassembled for thorough cleaning. Disassemble by disconnecting inlet connection from pump housing, nozzles, separating the air cylinder, and removing the Plug Rod. Clean with warm soapy water or equivalent, as application requires.

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