

RUN TIME

EVERGREEN PACKAGING
PARTS AND SERVICE



Training Manager
Dennis Meagher
in 1994

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ASK AN ENGINEER

How and when do I replace my PLC battery?

Many programming logic controllers use a battery back-up to preserve machine settings when power is turned off. These batteries last several years, but eventually they will require replacement. For N-8, EQ-5, EH-2, EH-3, H-9 and H-10 machines and stand-alone spout systems, the "BATT" indicator light located on the front of the controller will turn on when the battery needs to be replaced.



A dead battery does not stop the machine. But when machine power is turned off for more than a few minutes and the battery cannot maintain the PLC memory, the program in memory is lost. When the controller is powered on, the factory default program is loaded from non-volatile memory. This default program will change machine settings like heater temperatures and machine timing set-points to their factory default values. So replacing the battery *before* it dies will save you a lot of time and hassle.

To replace the PLC battery, turn off the power and remove the processor from the rack. The battery is located toward the back of the processor. Remove the battery by unplugging the connector from the circuit board and pulling the battery out of the retaining clips.

Once the battery is removed, a capacitor will preserve the machine program for about 30 minutes. After 30 minutes, the machine program is lost and will be replaced by the factory default program when the processor is turned back on.

Installing a new battery is as simple as inserting the battery into the retaining clips and plugging it in into the circuit board. The processor can then be reinstalled into the PLC rack. Once the processor is installed in the PLC rack and powered on, the machine is ready for normal operation.



I hope this information provides some assistance. If you have questions about this or any other issue, don't hesitate to "Ask An Engineer."

- Nate Walker
Controls Engineer



PARTS DISCOUNTS

Surplus/Obsolete Discounts

Take advantage of these huge discounts on overstocked parts. The part numbers and prices in **red** may have been further reduced from previous discounts. To order, make sure you ask for the surplus/obsolete price. Stock is limited to the quantities shown, so order now!

Part no.	Description	Model	Qty	List price	DISCOUNT PRICE
2201466	Pivot Bar	Quart	3	\$1,657	\$950
3057428	Mandrel Condensate Kit	Quart	1	\$4,473	\$1,900
3058379	Clutch Kit	N8 SN1534-1583	2	\$5,055	\$3,200
3058477	Spout Welder Rebuild Kit	EH3 SN5600-5626	1	\$12,300	\$8,500
3058557	Bottom Folder Major Rebuild Kit	N8	1	\$13,950	\$9,500
3111334	Quart Mandrel	EQ4, Q11, Q14	3	\$8,710	\$2,950
3151620	Tie Rod	H5, H90	11	\$367	\$195
3153070	Line Hookup for CIP	Quart	24	\$250	\$195
3153457	Metering Bowl Subassembly	N5, NEP170	2	\$3,352	\$1,500
3159505	Stationary Block - Dater	Quart	3	\$1,112	\$750
3281842	Air Cylinder Assembly	EH	6	\$2,878	\$2,250
3284768	Carton Stop Subassembly	EH	12	\$1,323	\$950
3481731	Elevator Subassembly	EQ5	1	\$4,573	\$1,950
3482905	Bearing Adapter	EQ5	3	\$1,028	\$750
3483081	Infeed Drive Shaft Assembly	EQ5	1	\$13,080	\$4,400
3493668	Infeed Support Assembly	N8	1	\$10,990	\$4,900
3990530	CPU A-B 5/03	EQ4, EQ5, N8, Spout	1	\$5,520	\$2,500
5513982	Temperature Controller	Q11, QPC12	4	\$1,336	\$1,000
5517385	Horn, VE2 Quart Spout	H9, EH2, EQ5	1	\$3,928	\$1,500
5540845	O-Ring Silicone (-022) 1/16 X 1 ID	Various	1,470	\$5.70	\$1.95
6511076	Generator-Ultrasonic 1700 Watt	SM Spout	5	\$16,880	\$6,000
7053695	Mandrel Hub Stainless Steel	N5, QPC11	2	\$4,809	\$3,900
7055415	Inlet Valve	N5, N7	8	\$600	\$375
9030065	3/8ODX.032 HH Copper	Various	922	\$33/FT	\$15/FT

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We welcome comments and suggestions. Please send all mailing address changes to the editor.

Evergreen Packaging Equipment is proud to be ISO 9001:2008 certified. We are dedicated to quality and continuous improvement.

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about in-plant training using our N-8 fill system or SPOUT-PAK® training stands.

- EQ-70: Sep 17-28
- N-8: Oct 8-16
- N-8: Oct 18-26

To request training for a specific filler model, please contact Mike at 319-270-3594 or mike.tisdale@everpack.com.

Training can be held at the Evergreen Cedar Rapids facility or at your own plant. Also ask

For the most up-to-date training school information, visit evergreenpackaging.com.

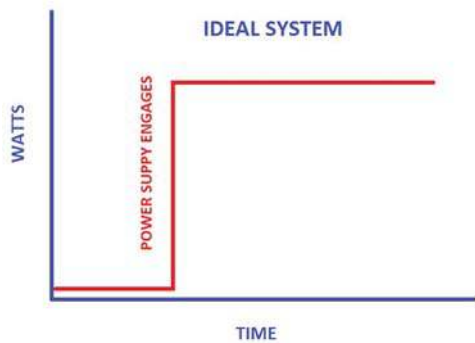
SERVICE TIP

Correct Air Cushion Setting is Critical on Weld By Watts Spout System

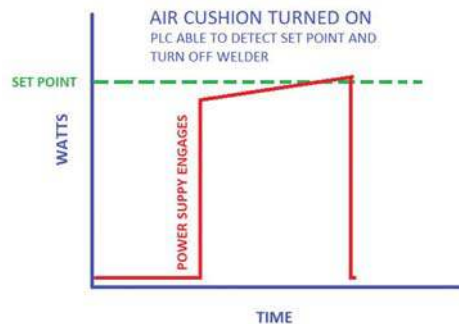


Early spout welding systems use “weld by watts” controls. After a level of watts is entered, the controlling PLC brings the horn and anvil together and turns on the ultrasonic power supply until it receives feedback that the watts level has been reached.

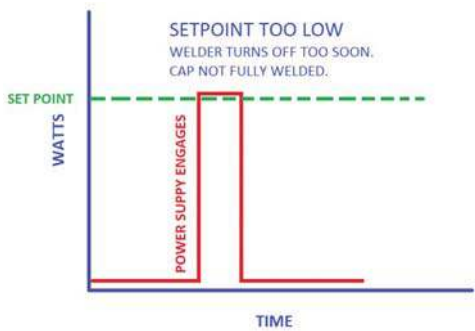
The problem is that watts is an instantaneous reading. So in an ideal system, when the power supply is turned on, the watts would instantly go to the level available from the power supply:



This is where the air cushion comes into play. With the air cushion just slightly engaged, the horn and anvil are delayed from coming fully together for the last few thousandths of an inch. The level of watts coming out of the power supply is proportional to the pressure the horn and anvil see on each other. So as they come together, the pressure increases, and the delivered watts increases. This gives the PLC a slope on the feedback line, so it knows when to shut off the power supply:



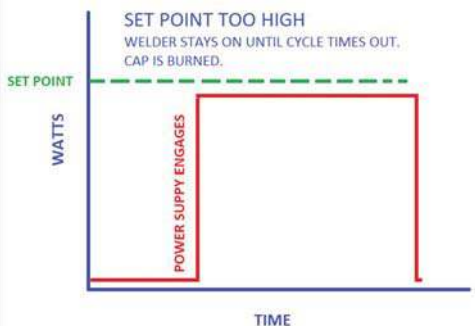
If the set point is just under this level, the weld time will be too short, and the cap will hardly be welded at all:



To make this adjustment, completely loosen the nut and air cushion adjustment screw on the air cylinder. Then tighten the screw one half turn. That will provide the amount of cushion needed for a good weld. Tighten the nut.



If the set point is just over this level, the weld time will be too long, and the cap will be burned through:



Newer spout systems use “weld by energy” (WBE) modules, or have this function built into the newer DCX ultrasonic power supplies. This eliminates the problem by measuring the actual level of joules being generated over the entire weld cycle, rather than an instantaneous wattage reading.

- Jim Goranson
N-8/Spout Engineer

EVERGREENPACKAGING is a global leader in beverage packaging systems, serving the dairy, juice, specialty, and other liquid food markets. The Evergreen Packaging business employs nearly 4,100 people worldwide. Besides the North American facilities, Evergreen Packaging includes wholly owned subsidiaries in China, South Korea and Taiwan, and joint ventures in Israel, Latin America, North Africa and Saudi Arabia.

Evergreen Packaging is owned by Reynolds Group Holdings Ltd, an investment company that also owns Reynolds Packaging, Pactiv Corporation, Closure Systems International and Graham Packaging.

The Evergreen Packaging product line includes:

- Gable top packaging equipment—which forms, fills, and seals paper gable top cartons—available for pasteurized, ESL (Extended Shelf Life), ELL (Extended Long Life), and hot fill applications. These machines fill cartons from 4 oz. up to half-gallon (150 ml up to 2 liter), at speeds from 30 to 340 cartons per minute.
- SPOUT-PAK® twist-off closures for most gable top cartons.
- Gable top materials available through our global network of converting plants.

A Farewell Letter from Training Manager Dennis Meagher

THANK YOU AND FAREWELL

It is with great hesitation that I have decided to move on in the next chapter of my life: retirement. Anyone who knows me knows I totally enjoyed my job and more importantly, I equally enjoyed the thousands I have had a chance to work with over the years. That includes both internal and external customers. My goal has always been 100% customer satisfaction. I have no idea how many people I have trained in my 25 years as Training Manager, because numbers mean nothing to me. What matters most is your success, and I have seen plenty of that over the years. I would love to mention names, but I would feel bad if I left someone out. Besides, you know who you are. Training is something I was always passionate about, but you helped to show me there is a lighter side to this job.

Of course, it is not a job if you love what you do. Evergreen/Cherry-Burrell has been a great company to work for, and I thank them for putting up with me for more than 34 years. It was never, ever a matter of me having to put up with them because they treated me excellent over the years. Y'all know I can get to rambling, so let us end this by simply saying: "CLASS IS DISMISSED. The Marriott van is waiting."

My last day at Evergreen will be Oct 12. If anyone desires to stay in touch, I can be reached by phone at 610-562-4053 or via my personal email epetrainer@aol.com. In the meantime, I will enjoy driving my Ford to our cabin in the Poconos and spending time with my wife Judy and family. I am sure that along the way I just may have to help a Dodge, Chevy, Toyota or some other inferior vehicle out of a predicament in which they have found themselves.

Thanks again.

Dennis J Meagher

You Will Always Have a Friend in Pennsylvania



Every part you purchase from EVERGREEN PACKAGING EQUIPMENT is backed by our:

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- Team of knowledgeable sales coordinators to make sure you get the part you need, when you need it.
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ANNOUNCEMENT

The Evergreen Packaging facility will be closed on Monday, September 3 for the Labor Day holiday. On that day, we will ship parts and schedule service on an emergency basis only.

Happy holiday!



Evergreen Sponsors Webinar on Beverage Growth Opportunities

You are always looking for new ways to expand your product line. Evergreen Packaging is always

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We are one of the leading sponsors of a Dairy Foods webinar on September 13 at 2:00pm EDT that will help you learn about the latest trends in milk and nondairy beverages.

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