

SOP-014 · Palletiser Gripper Set-Up

Revision 3 · Reviewed 05/2026 · Owner: Maintenance Team Lead

1. Purpose

Correct positioning of the bag gripper for the palletising robot after a bag length changeover.

2. Scope

Applies to all changeovers of finished bag length on Palletiser Line 2.

3. Responsibility

Machine operators trained on Line 2. Maintenance to be notified of any template damage.

4. Equipment arrangement

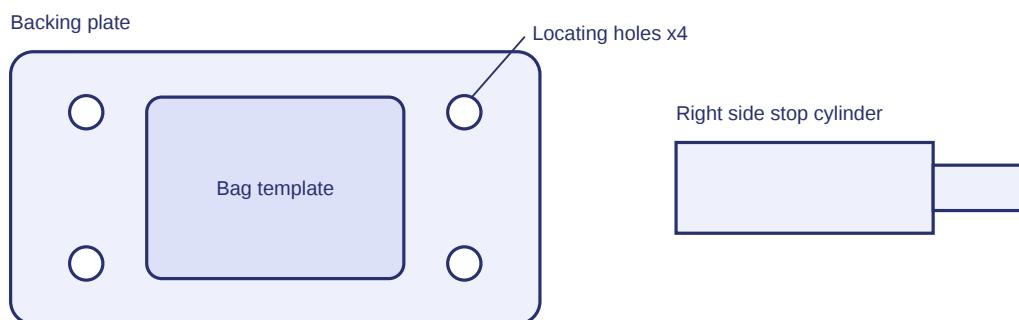


Fig. 1 - Template and stop cylinder arrangement (locating holes shown open)

5. Method

Step	Action	Safety note
1	Enter the robot cell using the safety access key. Keep the key on you at all times inside the cell.	Lockout applies — cell must be isolated.
2	Select the correct bag template for the finished bag length on the BPO.	
3	Place studs in the locating holes of the backing plate (Fig. 1) and fit nuts so the template is secure.	Check studs for wear before fitting.
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 position.	Pinch point — keep hands clear of the clamp faces.
5	Exit the cell, return the access key, and run one dry cycle before releasing the line.	

6. Records

Record the changeover in the Line 2 shift log, including bag length, template ID, and operator initials.

7. Revision history

Rev	Date	Change	Approved
1	11/2024	First issue	S. Walker
2	07/2025	Added dry cycle before line release	S. Walker

3	05/2026	Pinch point warning added to step 4; Fig. 1 added	M. Harris
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