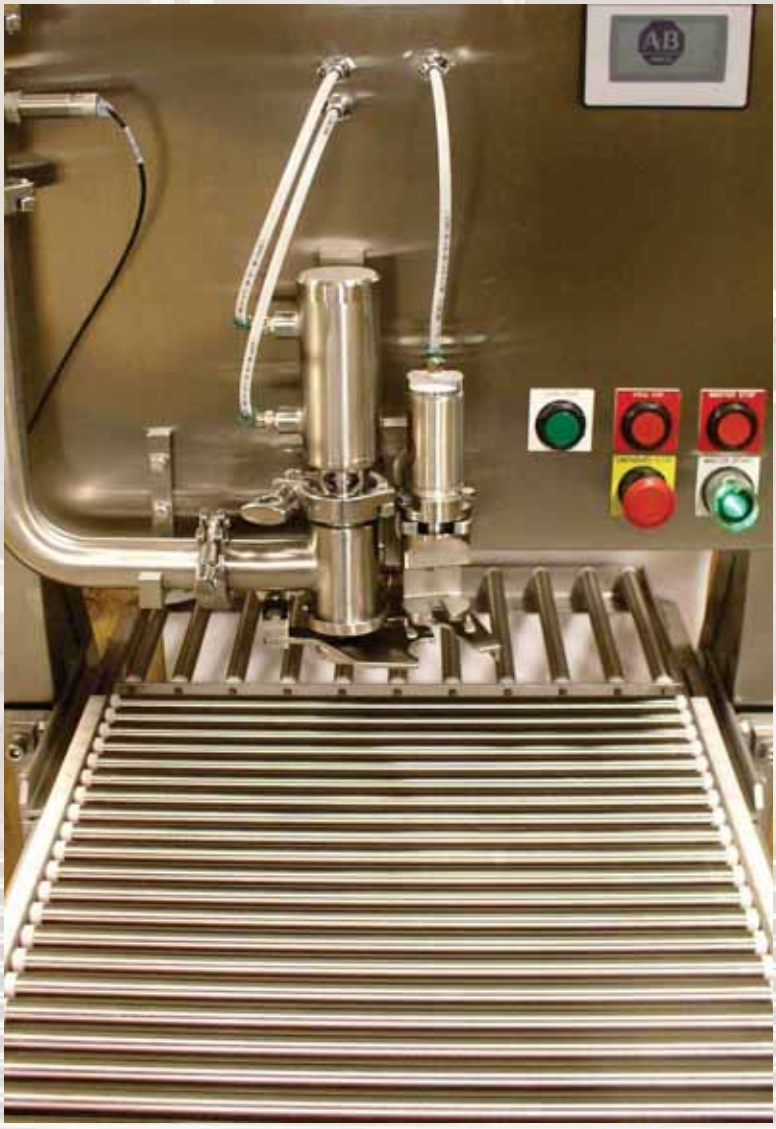
M125 SEMI-AUTOMATIC FILLING MACHINE
OPERATOR INSTRUCTION MANUAL



HOLLAND MFG,INC.
KENOSHA, WI
PH: 262-654-5300
FAX: 262-654-6449
EMAIL: info@holland-mfg.com

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OPENING THE CRATE

1. THE M125 SHIPS IN A FULLY ENCLOSED WOOD BOX FASTENED TOGETHER WITH DRY WALL SCREWS.
2. TO OPEN, USE A HAND DRILL WITH PHILLIPS HEAD DRIVER BIT.
3. REMOVE TOP.
4. REMOVE SIDES.
5. MAKE SURE FILLER IS SECURELY BANDED TO SKID WITH ROLLER TABLE AND ANY OPTIONS THAT WERE TO ACCOMPANY IT.
6. INSPECT FOR DAMAGE IF ANYTHING APPEARS TO BE LOOSE.
7. NOTIFY SHIPPER IMMEDIATELY IF DAMAGE HAS OCCURED.

8. MOVE FILLER NEAR THE LOCATION OF INSTALLATION WHILE STILL BANDED TO SKID.
9. CUT THE THREE STEEL BANDS, REMOVE AND DISPOSE OF.
10. REMOVE ROLLER TABLE AND SET IT OUT OF THE WAY.
11. LIFT MACHINE FROM SKID AND SET INTO PLACE.
12. OPEN CABINET DOOR AND INSPECT FOR ANYTHING THAT MAY HAVE COME LOOSE DURING TRANSIT. CHECK THAT ALL COMPONENTS ARE SECURELY MOUNTED TO DIN RAILS, WIRES ARE ATTACHED TO TERMINALS, AND CABLE FROM PANELVIEW IS PLUGGED INTO SIDE OF PLC.
13. AFTER INSPECTION, REMOVE KEYS TAPED TO INSIDE OF DOOR, CLOSE AND LOCK CABINET, AND PUT KEYS IN SAFE PLACE.
14. CUT WIRE TIES HOLDING POWER CORD AND PLUG IT INTO A 120/60VAC OUTLET.
15. STORE SKID TOGETHER WITH WALLS AND TOP FOR FUTURE USE.

INITIAL SET UP

ADJUSTABLE LEVELING FOOT

1. ADJUST AS REQUIRED MAKING SURE ALL FEET MAKE CONTACT WITH FLOOR SO MACHINE SITS RIGID AND DOES NOT "ROCK".

ROLLER TABLE IN/OUT ADJUSTMENT

1. IN AND OUT ADJUSTMENT OF ROLLER TABLE IS DETERMINED BY BAG LENGTH. BAG SHOULD BE SUPPORTED ALL AROUND SO THAT IT DOESN'T HAVE A TENDENCY TO FALL OR "FLOP" OFF AS PRODUCT IS SEEKING THE LOWEST POINT DURING FILL.
2. TIGHTEN LOCKING SCREW UNDER SIDE BRACKETS WHEN ADJUSTED.
3. DOCUMENT POSITION FOR ALL CONTAINER SIZES AND PRODUCTS FILLED.

ROLLER TABLE VERTICAL ADJUSTMENT

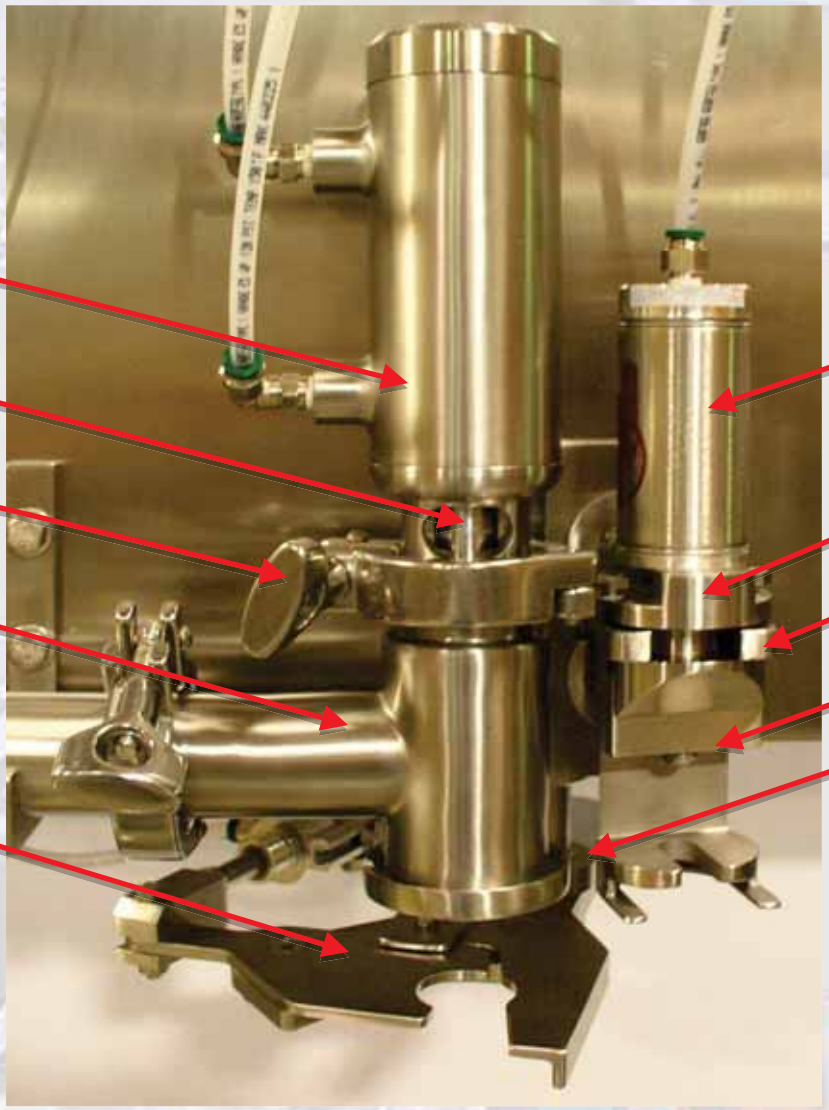
1. BEFORE ADJUSTING TABLE HEIGHT, REMOVE ROLLER TABLE ASSEMBLY FROM SIDE BRACKETS AND SET IT ASIDE. **IF TABLE REMAINS IN BRACKETS WHEN THEY ARE LOOSENED, IT WILL FALL RAPIDLY, POSSIBLY CAUSING DAMAGE OR INJURY.**
2. SLIDE BRACKETS TO DESIRED POSITION MAKING SURE BOTH ARE AT AN EQUAL DISTANCE FROM BOTTOM OF CABINET AND TIGHTEN AS SHOWN.
3. SLIDE ROLLER TABLE IN AND CHECK HEIGHT.
4. CORRECT HEIGHT ADJUSTMENT IS DETERMINED BY THE AMOUNT OF AIR REMAINING IN THE BAG AFTER IT HAS BEEN FILLED WITH PRODUCT AND CAPPED. THE TABLE SHOULD BE SET AS CLOSE TO THE FILL VALVE AS POSSIBLE WITHOUT PRODUCT SPLASHING OR "BURPING" OUT DURING THE DOWN/OVER/UP MOTION AFTER FILL.
5. DOCUMENT HEIGHT LOCATION FOR ALL CONTAINER SIZES AND PRODUCTS FILLED.

AIR FILTER/REGULATOR

ALWAYS TURN AIR OFF BEFORE SERVICING MACHINE

1. TO TURN AIR ON, MOVE RED COLLAR ON SLIDE VALVE TO THE RIGHT. TO TURN OFF, MOVE TO THE LEFT.
2. TO ADJUST AIR PRESSURE, PULL UP ON LOCKING KNOB LOCATED AT TOP OF REGULATOR AND TURN CLOCKWISE TO INCREASE PRESSURE. (FACTORY SETTING = 70/80PSI)
3. PUSH DOWN ON KNOB TO LOCK IN PLACE.

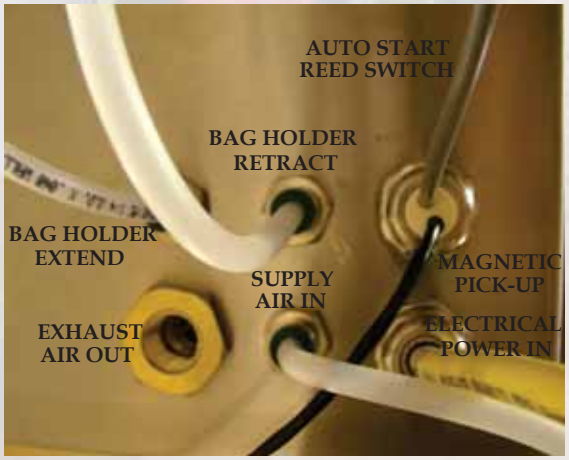
COMPONENT OVERVIEW



AUTO START REED SWITCH LOCATION

1. IN "AUTO MODE", REED SWITCH WILL START THE FILL CYCLE WHEN THE BAG IS LOADED AND THE JAW IS PUSHED CLOSED.

BOTTOM LEFT SIDE OF CABINET



OPERATOR PUSH BUTTONS

STAY CLEAR OF MOVING PARTS WHEN PRESSING MASTER START OR RELEASING EMERGENCY STOP SWITCH

1. MASTER START - TURNS ON POWER TO ELECTRICAL AND PNEUMATIC COMPONENTS WHEN EMERGENCY STOP BUTTON IS IN THE "OUT" POSITION. IF EMERGENCY STOP BUTTON IS IN THE "IN" POSITION, MASTER START WILL POWER UP ELECTRICAL COMPONENTS ONLY. PNEUMATIC COMPONENTS WILL ENERGIZE THE MOMENT THE E-STOP IS PULLED OUT.

2. MASTER STOP - TURNS OFF ALL POWER TO ELECTRICAL AND PNEUMATIC COMPONENTS. NOTE: FILL VALVE STEM STAYS CLOSED UNDER PRESSURE WHEN MACHINE IS COMPLETELY OFF. WHEN SERVICING FILL VALVE, CUT OFF MAIN AIR AT AIR REGULATOR WITH THE SAFETY SLIDE VALVE.

3. EMERGENCY STOP - CLOSES FILL VALVE IMMEDIATELY AND TURNS OFF ALL PNEUMATIC COMPONENTS. BEFORE PULLING THE E-STOP OUT, REMOVE BAG AND MANUALLY PUSH THE BAG HOLDER OVER TO THE CAPPER BLOCK. **KEEP HANDS, ADAPTERS, AND TOOLS CLEAR WHEN RELEASING E-STOP. THE BAG HOLDER AND CAPPER WILL JUMP TO HOME POSITION.**

4. CYCLE STOP - IN "FULLY INSERTED" AND "PARTIALLY INSERTED" MODES, CYCLE STOP WILL CLOSE FILL VALVE IMMEDIATELY, SEND TOOLING BACK TO HOME POSITION, AND COMPLETELY CAP AND EJECT BAG AT ANY POINT DURING A FILL CYCLE.
   IN "CIP" AND "PAIL/TOTE" MODES, CYCLE STOP WILL CLOSE FILL VALVE IMMEDIATELY, BAG HOLDER WILL DROP, MOVE OVER AND WAIT FOR ADAPTER TO BE REMOVED. **WHEN SWITCHING BACK TO "PI" AND "FI", BAG HOLDER WILL RAISE UP TO CAPPER BLOCK. **KEEP HANDS, ADAPTERS, AND TOOLS CLEAR WHEN CHANGING MODES.**

5. CYCLE START - IN "FULLY INSERTED" AND "PARTIALLY INSERTED" MODES, CYCLE START INITIATES THE FILL CYCLE BY DECAPPING, MOVING BAG SPOUT OVER AND UP ONTO NOZZLE, AND THEN OPENING THE FILL VALVE. THE BAG WILL FILL UNTIL EITHER THE "PULSE COUNT SET POINT" IS REACHED, CYCLE STOP IS PRESSED, OR E-STOP IS PRESSED.
   IN "CIP" MODE, IT FUNCTIONS THE SAME AS ABOVE EXCEPT A CIP ADAPTER IS LOADED INSTEAD OF A BAG. THE CIP CYCLE CAN ONLY BE STOPPED BY PRESSING CYCLE STOP OR E-STOP.
   IN "PAIL/TOTE MODE", CYCLE START INITIATES THE FILL CYCLE BY FIRST MOVING THE ADAPTER OVER AND UP ONTO THE NOZZLE, THEN WAITS FOR CYCLE START TO BE PRESSED A SECOND TIME TO OPEN THE FILL VALVE. THE PAIL WILL FILL UNTIL EITHER THE "PULSE COUNT SET POINT" IS REACHED, CYCLE STOP IS PRESSED, OR E-STOP IS PRESSED.

BASIC PROCEDURE FOR OPERATION

1. MAKE SURE AIR IS SET TO 70/80 PSI AND ELECTRIC IS CONNECTED TO 120/60VAC.
2. PRESS MASTER START AND WAIT FOR PANELVIEW TO RUN THROUGH THE INITIALIZATION PROCESS (APPROX 45 SEC).
3. ON SCREEN #1, CHOOSE MANUAL, RESET BAG COUNT, AND CHANGE SET POINT TO DESIRED VALUE.
4. ON SCREEN #2, CHOOSE APPROPRIATE MODE, THEN PRESS "GO TO NEXT".
5. ON SCREEN #3 PRESS "GO TO MAIN".
6. LOAD BAG INTO CAPPER AND BAG HOLDER. MAKE SURE IT IS LOADED IN STRAIGHT AND SEATED COMPLETELY.
7. PRESS CYCLE START (MACHINE WILL UNCAP, MOVE BAG OVER AND ONTO NOZZLE AND BEGIN TO FILL).
8. WHEN THE SET POINT IS REACHED, VALVE WILL CLOSE AND BAG WILL BE CAPPED AND EJECTED.
9. REMOVE FILLED BAG, CHECK IT FOR ACCURACY, ADJUST SET POINT IF NECESSARY, AND FILL ANOTHER BAG.
10. REPEAT STEPS 6 THROUGH 9 AS REQUIRED UNTIL CORRECT VOLUME IS ACHIEVED.
11. DOCUMENT THE SET POINT FOR EACH CONTAINER SIZE AND PRODUCT FILLED.

MAIN SCREEN 1

1. PRESS "MODE RESET".
2. CHOOSE EITHER "MANUAL" OR "AUTO".
3. IN MANUAL MODE, USE START BUTTON TO CYCLE.
4. IN AUTO MODE, WHEN BAG HOLDER JAW IS CLOSED, MACHINE WILL CYCLE.

MAIN SCREEN 1

5. PRESS "BAG COUNT RESET" TO "ZERO" BATCH COUNTER.
6. PULSE COUNT FIELDS REPRESENT THE VOLUME OF LIQUID FILLED INTO EACH BAG.
7. THE "ACT" FIELD SHOWS THE ACTUAL PRODUCT COUNT RISING TO THE DESIRED SET POINT AS THE BAG IS FILLED.
8. PRESS "SP" TO CHANGE THE AMOUNT OF PRODUCT FILLED.

MAIN SCREEN 1

9. AFTER PRESSING "SP", THE SET POINT SCREEN WILL SHOW.
10. TO INCREASE OR DECREASE COUNT, PRESS RIGHT ARROW TO ENABLE THEN LEFT ARROW TO MOVE CURSOR THRU THE NUMBERS.
11. USE THE UP AND DOWN ARROWS TO CHANGE VALUES.
12. PRESS ENTER IN LOWER RIGHT TO ACCEPT.
13. PRESS "GO TO NEXT".

MAIN SCREEN 2

STAY CLEAR OF MOVING PARTS WHEN CHANGING MODES

14. PRESS "MODE RESET"
15. CHOOSE APPROPRIATE MODE
16. IN "PAIL/TOTE" OR "CIP", THE BAG HOLDER WILL DROP TO ALLOW AN ADAPTER TO BE LOADED.
17. IN "FULLY INSERTED", THE CAPPER WILL DROP.
18. PRESS "GO TO NEXT"

MAIN SCREEN 3

19. PRESS "GO TO MAIN" TO RETURN TO SCREEN 1.
20. A USER NUMBER AND PASSWORD ARE REQUIRED TO GO BEYOND THIS POINT.

MAIN SCREEN 3

21. TO ENTER SET UP SCREENS, PRESS "LOG IN" OR "GO TO SET UP".

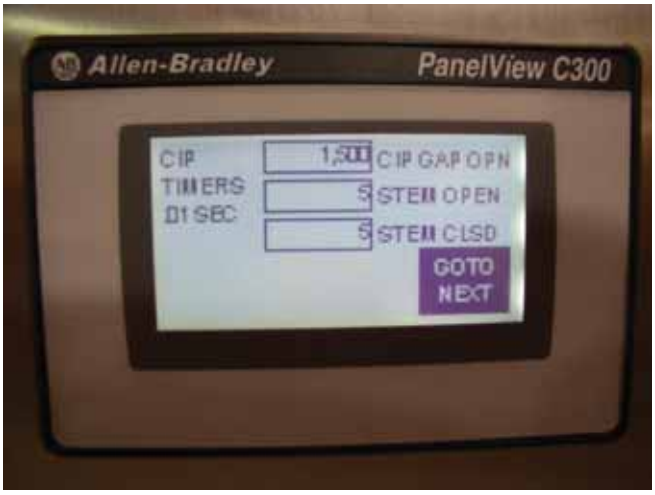
SET UP PASSWORD SCREEN 1

22. AFTER PRESSING "LOG IN" OR "GO TO SET UP", THE PASSWORD SCREEN WILL SHOW.
23. USE UP/DOWN ARROWS TO FIND USER NUMBER, THEN PRESS ENTER IN LOWER RIGHT TO ACCEPT.
24. THE PASSWORD SCREEN WILL NOW SHOW. REPEAT STEP #23, ENTER PASSWORD NUMBER AND ACCEPT.

SET UP PASSWORD SCREEN 2

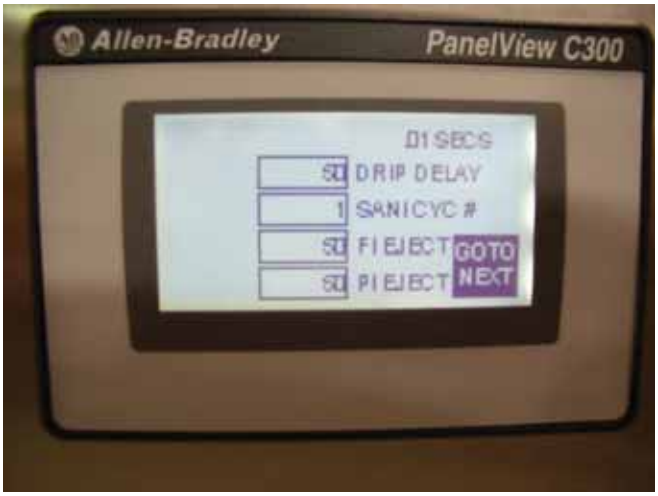
25. "ACCESS DENIED" SCREEN WILL SHOW WHEN WRONG USER, PASSWORD, OR "ESCAPE" IS ENTERED.
26. PRESS "OK" TO RETURN TO MAIN SCREEN 3 AND TRY AGAIN.

SET UP SCREEN 1



27. WHEN CORRECT USER AND PASSWORD HAVE BEEN ENTERED, SET UP SCREEN 1 WILL SHOW.
28. "CIP GAP OPEN" SETS THE TIME THE VALVE STAYS OPEN BETWEEN STEM OSCILLATIONS. (5 SEC TO 5 MIN)
29. "STEM OPEN" SETS THE TIME STEM IS IN OPEN POSITION DURING OSCILLATION. (.04 SEC TO .15 SEC)
30. "STEM CLOSED" SETS THE TIME STEM IS IN CLOSED POSITION DURING OSCILLATION. (.04 SEC TO .15 SEC)
31. PRESS "GO TO NEXT".

SET UP SCREEN 2



32. "DRIP DELAY" SETS THE TIME THE BAG SPOUT STAYS UP ON THE FILL NOZZLE AFTER THE FILL VALVE CLOSES. (.5 SEC TO 5 SEC)
33. "SANICYC#" SETS THE NUMBER OF CYCLES COMPLETED (OR BAGS FILLED) BETWEEN SPRAYS FROM THE OPTIONAL SANITIZING SPRAYER ASSEMBLY. (1 TO 10)
34. "FI EJECT" SETS THE TIME THAT THE BAG HOLDER JAW REMAINS CLOSED DURING CAPPING TO INSURE THAT THE CAP FULLY SEATS ON THE SPOUT. (.5 SEC TO 2 SEC)
35. "PI EJECT" SETS THE TIME THAT THE CAPPER BLOCK IS DOWN AND JAW REMAINS CLOSED DURING CAPPING TO INSURE THE CAP IS FULLY SEATED. (.5 SEC TO 2 SEC)
36. PRESS "GO TO NEXT"

REMEMBER, AFTER SET UP IS COMPLETE, "LOG OUT" TO SECURE SETTINGS. IF NOT DONE, SET UP SCREENS CAN BE ACCESSED AT ANY TIME DURING OPERATION (SEE MAIN SCREEN 3)

SET UP SCREEN 3

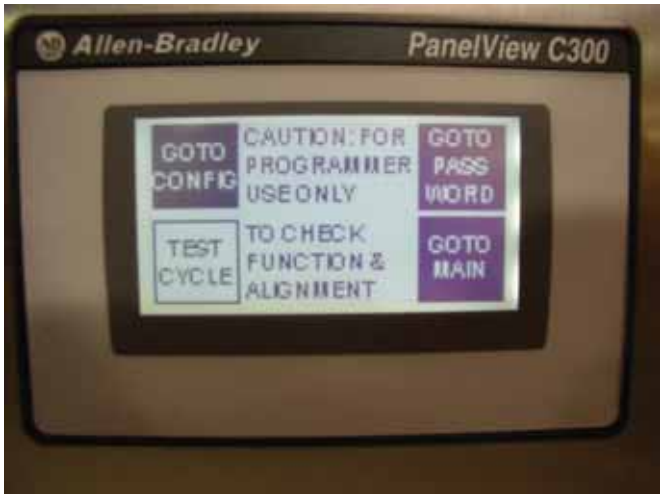
37. "SANITIME" SETS THE TIME THE SANITIZING SPRAYER ACTUALLY SPRAYS SOLUTION. (.1 SEC TO 2 SEC)
38. "SANI SPRAY OFF" MANUALLY TURNS THE SANITIZING SPRAYER OFF AND ON AS NEEDED.
39. PRESS "GO TO MAIN" OR "GO TO NEXT".

FACTORY SETTINGS FOR SET UP SCREENS

CIP GAP OPEN - 1,500 = 15 SEC
STEM OPEN - 5 = .05 SEC
STEM CLOSED - 5 = .05 SEC
DRIP DELAY - 50 = .5 SEC
SANI CYCLE - 1
FI EJECT - 50 = .5 SEC
PI EJECT - 50 = .5 SEC
SANI TIME - 50 = .5 SEC

REMEMBER, AFTER SET UP IS COMPLETE, "LOG OUT" TO SECURE SETTINGS. IF NOT DONE, SET UP SCREENS CAN BE ACCESSED AT ANY TIME DURING OPERATION (SEE MAIN SCREEN 3)

SET UP SCREEN 4



SET UP SCREEN 4

40. "GO TO CONFIGURE" FOR PROGRAMMER USE ONLY.
41. "GO TO PASSWORD" TO LOG OFF SET UP SCREENS.
42. "GO TO MAIN" TO RUN MACHINE.
43. "TEST CYCLE" MODE IS FOR "DRY" CYCLING ONLY WHEN THERE IS NO PRODUCT PRESSURE AT FILL VALVE. IT IS USED FOR TESTING FUNCTION AND ALIGNMENT ONLY.

NOTE - CONFIGURE SCREENS SHOULD ONLY BE ACCESSED BY EXPERIENCED PERSONEL ONLY, AS PROGRAM COULD BE LOST BY ACCIDENTLY DELETING OR RESETING TERMINAL

THE FOLLOWING SCREENS ARE SHOWN FOR REFERENCE ONLY.

FIGURE 1

FIGURE 2

FIGURE 3

FIGURE 4

FIGURE 5

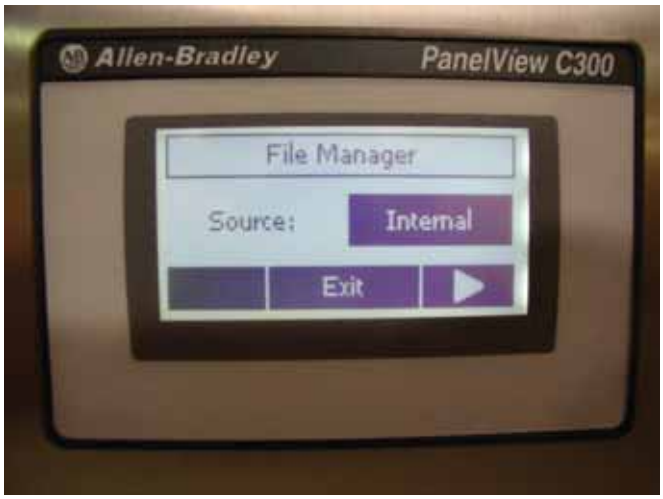


FIGURE 6

FIGURE 7

FIGURE 8

FIGURE 9

FIGURE 10

FIGURE 11

FIGURE 12

FIGURE 13

FIGURE 14

FIGURE 15

FIGURE 16

FIGURE 17

FIGURE 18

FIGURE 19

FIGURE 20

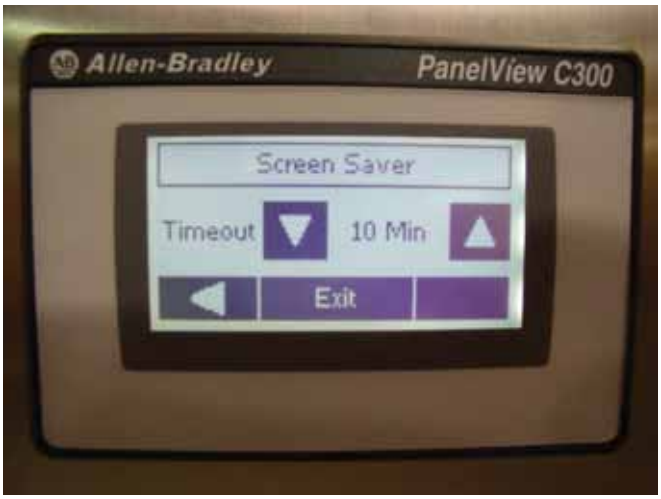


FIGURE 21

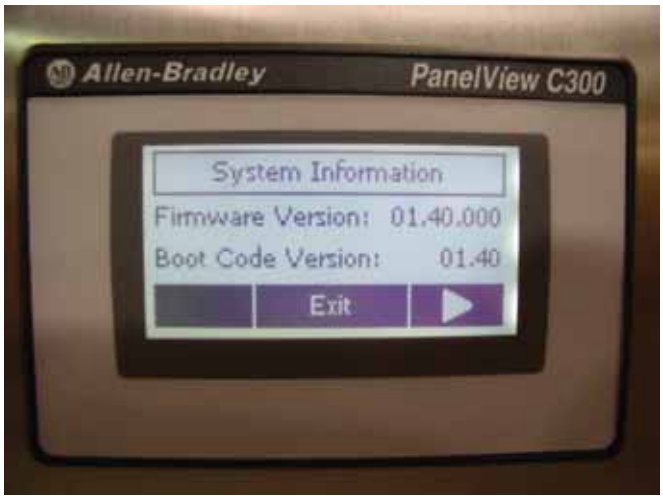


FIGURE 22

FIGURE 23

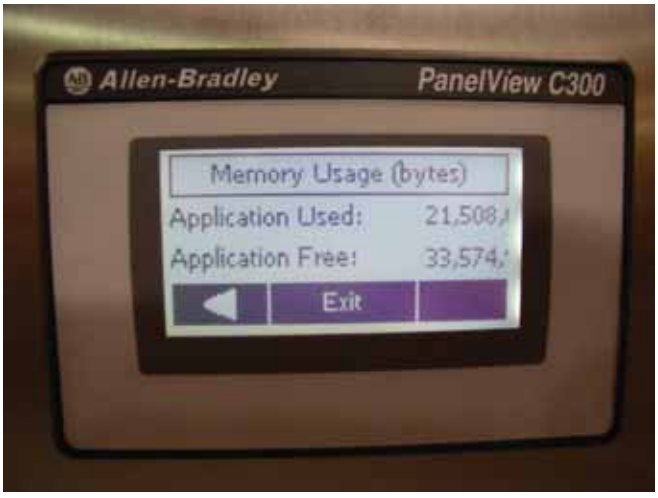
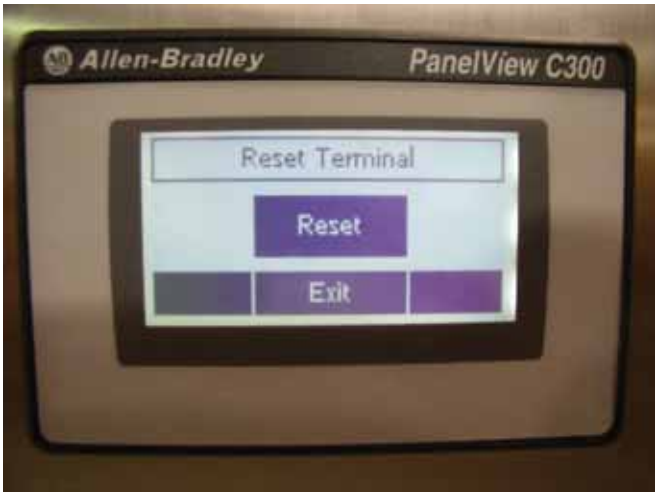


FIGURE 24



LOADING THE BAG

1. IMPORTANT: ALWAYS MAKE SURE THAT THE MODE OF OPERATION MATCHES THE CAP POSITION ON THE BAG. FOR EXAMPLE, NEVER RUN A FULLY INSERTED BAG WHILE IN "PARTIALLY INSERTED" MODE. THE BAG COULD GO UP ONTO THE FILL HEAD WITH CAP IN PLACE. WHEN VALVE OPENED, PRODUCT WOULD SPRAY OUT UNPREDICTABLY.
2. WHEN LOADING, MAKE SURE THE CAP AND BAG ARE SIMULTANEOUSLY PUSHED FIRMLY AND STRAIGHT INTO THE TOOLING.
3. THE BOTTOM SIDE OF THE CAP RIM MUST BE SET ON TOP OF THE CAPPER GUIDE "FINGERS" WHILE THE LEAD EDGES OF THE BAG HOLDER BODY AND JAW FIND THEIR WAY INTO THE FLANGED GRIP RING AREA OF THE SPOUT.
4. WHEN LOADED PROPERLY, THE BAG WILL SLIDE IN SMOOTHLY AND STOP WITH A SLIGHT "SNAP- IN" FEEL.
5. IF LOADED IMPROPERLY, RESISTANCE WILL BE FELT BEFORE IT IS FULLY SEATED. STOP, REMOVE BAG AND TRY AGAIN.

6. STARTING THE FILL CYCLE AFTER LOADING THE BAG CAN BE DONE TWO DIFFERENT WAYS.
7. WHEN MACHINE IS IN "MANUAL MODE", PRESS THE GREEN START BUTTON. WHEN IT IS IN "AUTO MODE", IT WILL START AUTOMATICALLY AS THE FITMENT IS SEATED INTO THE TOOLING.
8. ONCE STARTED, THE BAG HOLDER WILL MOVE DOWN TO DE-CAP, OVER TO THE FILL POSITION, AND UP ONTO THE FILL NOZZLE. THE VALVE WILL OPEN AND PRODUCT WILL FILL THE BAG.
9. WHEN THE "PULSE COUNT SET POINT" IS REACHED, THE VALVE WILL CLOSE AND THE BAG HOLDER WILL MOVE DOWN, OVER, AND UP TO RE-CAP THE BAG.
10. AFTER BAG IS EJECTED FROM TOOLING, REMOVE IT FROM THE ROLLER TABLE AND LOAD ANOTHER ONE.
11. OCCASIONALLY INSPECT A FILLED BAG AFTER IT EJECTS TO INSURE IT IS FULLY CAPPED AND NOT LEAKING.
12. REMEMBER: KEEP HANDS, ADAPTERS, AND TOOLS CLEAR DURING THE FILL CYCLE.

USING THE CIP ADAPTER

1. TO "CLEAN IN PLACE", MACHINE MUST BE IN "MANUAL MODE". CHANGE IF NECESSARY ON MAIN SCREEN 1.
2. GO TO MAIN SCREEN 2 AND PRESS "MODE RESET" THEN "CIP".
3. WHEN "CIP" IS CHOSEN, THE BAG HOLDER WILL DROP TO THE DOWN POSITION.
4. LOAD CIP ADAPTER INTO BAG HOLDER AS SHOWN.
5. NEVER CHANGE MODES WHEN CIP ADAPTER IS IN THE BAG HOLDER. THE ASSEMBLY WILL RAISE, CAUSING AN INTERFERENCE CONDITION WHICH WILL DAMAGE PARTS.
6. PRESS CYCLE START AND THE ADAPTER WILL MOVE OVER AND UP ONTO THE FILL NOZZLE.
7. THE VALVE WILL THEN OPEN AND ALLOW THE SOLUTION TO PASS THROUGH.
8. PRESS CYCLE STOP WHEN CLEANING IS COMPLETE. THE VALVE WILL CLOSE AND THE ADAPTER WILL MOVE DOWN AND OVER.
9. REMOVE CIP ADAPTER.
10. CHANGE TO THE APPROPRIATE MODE TO BEGIN FILLING.

NEVER CHANGE MODES WHEN CIP ADAPTER IS IN THE BAG HOLDER. THE ASSEMBLY WILL RAISE, CAUSING AN INTERFERENCE CONDITION WHICH WILL DAMAGE PARTS.

FILL VALVE DISASSEMBLY

1. LOOSEN TEE NUT ON UPPER MOUNTING BRACKET ABOVE THE FLOW METER, BUT DON'T OPEN THE CLAMP.
2. REMOVE CLAMP AT THE FILL HEAD AS SHOWN ABOVE.
3. PULL PRODUCT ELBOW ASIDE ALLOWING IT TO REST IN THE SUPPORT BRACKET.

4. REMOVE THE TWO QUICK DISCONNECT FITTINGS ABOVE THE AIR ACTUATOR.

5. LOOSEN TEE NUT ON FILL HEAD MOUNTING BRACKET AND OPEN CLAMP .
6. REMOVE FILL HEAD ASSEMBLY AND PLACE ON A CLEAN WORK SURFACE.

NOTE: ALWAYS HANDLE FILL VALVE PARTS WITH CARE. NEVER THROW OR DROP PARTS INTO THE CLEANING VESSEL. NEVER SUBMERGE AIR ACTUATOR IN CLEANING SOLUTION. ALWAYS KEEP THESE PARTS FREE OF DAMAGE AND CONTAMINANTS.

7. SLIDE FILL HEAD TEE OFF ACTUATOR AND STEM.
8. PULL SHUT OFF STEM OUT OF ACTUATOR KEEPING IT STRAIGHT AND INLINE WITH BORE.

SCRATCHES AND DENTS IN THE BORE OF THE ACTUATOR BONNET WILL CAUSE O'RING DAMAGE AND PRODUCT WILL LEAK OUT OF THE BONNET WINDOW. IF THIS OCCURS FREQUENTLY AFTER NEW O'RINGS ARE INSTALLED, THE ACTUATOR WILL HAVE TO BE REBUILT WITH A NEW BONNET.

9. CLEAN PARTS PER THE FACILITIES ESTABLISHED REQUIREMENTS.
10. INSPECT O'RINGS AND CHROME PLATING ON STEM.
11. REPLACE O'RINGS IF SIGNS OF WEAR OR DAMAGE ARE PRESENT. REPLACE STEM IF NECESSARY.
12. APPLY A THIN COAT OF SANITARY LUBRICANT TO O'RINGS BEFORE RE-ASSEMBLY.

FILL VALVE ASSEMBLY

1. WHILE HOLDING THE ACTUATOR IN ONE HAND, TAKE THE TOP AIRLINE, OPPOSITE THE BONNET, AND PLUG IT INTO THE TOP HOLE IN THE FACE OF THE CABINET. LET OTHER AIRLINE HANG FREE.
2. THIS WILL PUSH THE PISTON INSIDE TO THE DOWN POSITION WHICH WILL OPEN THE COUPLER.

3. SLIDE STEM UP INTO BONNET AND APPLY ENOUGH FORCE TO "SNAP" IT INTO THE OPEN COUPLER INSIDE. IF "SNAP IN" DOESN'T OCCUR, THEN COUPLER AND STEM AREN'T ENGAGED. INCREASE FORCE UNTIL IT DOES.

4. WHILE CONTINUING TO APPLY UPWARD FORCE ON THE STEM, UNPLUG AIRLINE FROM FACE OF CABINET. THIS WILL ALLOW THE STEM TO SLIDE UP INTO THE ACTUATOR CLOSING THE COUPLER.

5. ASSEMBLE FILL HEAD TEE TO ACTUATOR AS SHOWN AND LIGHTLY TIGHTEN CLAMP.
6. ALIGN AIRLINE FITTINGS AND PRODUCT INLET PORT PARALLEL WITH CABINET FACE.
7. RE-ATTACH THE PRODUCT ELBOW TO FILL HEAD TEE WITH CLAMP, REVERSING STEPS #2 & #3 ON PAGE #15.
8. AFTER PRODUCT ELBOW IS SECURELY CLAMPED, FINISH TIGHTENING THE CLAMP ON THE FILL HEAD MOUNTING BRACKET SHOWN ABOVE.
9. TIGHTEN THE TEE NUT ON THE UPPER MOUNTING BRACKET ABOVE THE FLOW METER, REVERSING STEP #1 ON PAGE #15.
10. PLUG THE LOWER AIRLINE HANGING FROM THE ACTUATOR INTO THE LOWER HOLE IN THE FACE OF THE CABINET AND UPPER AIRLINE HANGING FROM THE ACTUATOR INTO THE UPPER HOLE IN THE FACE OF THE CABINET.
11. DRY CYCLE THE MACHINE A FEW TIMES AND MAKE SURE THAT THE STEM OPENS DURING THE FILL STAGE AND CLOSES WHEN "CYCLE STOP" IS PRESSED. IF IT DOESN'T, IT MEANS THE COUPLER ISN'T ENGAGED WITH THE STEM AND ALL STEPS ON PAGES #15 & #16 HAVE TO BE REPEATED.

DO NOT PLUG AIRLINES INTO CABINET UNTIL THE FILL VALVE IS COMPLETELY ASSEMBLED AND SECURED WITH THE CLAMP. STEM COULD "SHOOT" OUT CAUSING INJURY OR DAMAGE.

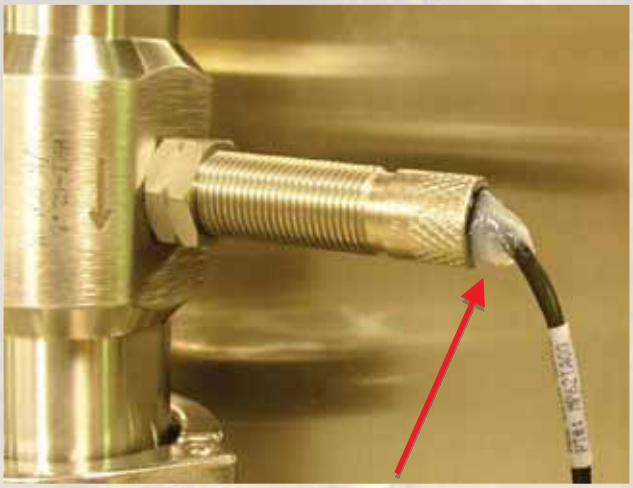
FLOW METER DISASSEMBLY

1. TO REMOVE FLOW METER FOR CLEANING AND SERVICE, FIRST REMOVE UPPER MOST CLAMP.
2. LOOSEN THUMB NUT ON UPPER MOUNTING BRACKET, SLIDE 6" LG STRAIGHT PIPE UP AND OUT OF THE WAY AND RE-TIGHTEN NUT.

3. REMOVE #10 MESH GASKET.
4. LOOSEN AND REMOVE BOTTOM CLAMP. **DON'T LET FLOW METER FALL.**

5. WHILE HOLDING FLOW METER BODY WITH ONE HAND, LOOSEN JAM NUTS WITH WRENCH IF NECESSARY.
   DO NOT TURN MAGNETIC PICK UP.

6. WHILE HOLDING THE MAGNETIC PICK-UP STATIONARY, TURN THE FLOW METER BODY COUNTER CLOCKWISE TO LOOSEN. **NEVER TURN THE MAGNETIC PICK-UP. THE CABLE WILL EVENTUALLY TWIST OFF AND SEVER FROM THE END.**
7. WHEN NEARING THE END OF THE THREAD, BE CAREFUL NOT TO DROP THE FLOW METER AS IT COMES APART.
8. HANG PICK UP ON THE CABINET SOMEWHERE OUT OF THE WAY. **DON'T LET THE END COME IN CONTACT WITH METALLIC PARTICLES. THEY WILL GET INTO THE THREADS AND TIP AND WON'T ALLOW THE PICK-UP TO SEAT COMPLETELY INTO THE FLOW METER.**
9. PLACE FLOW METER ON A CLEAN WORK SURFACE.

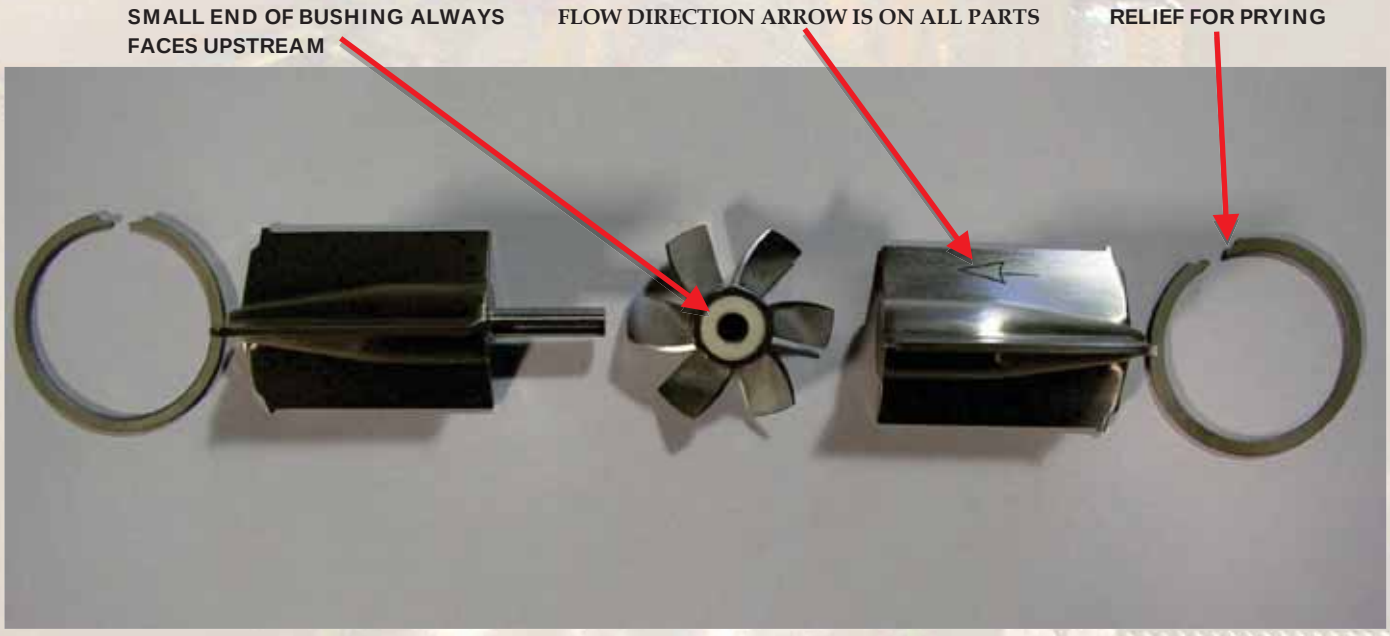


NOTE: WHEN INSTALLING A NEW MAGNETIC PICK-UP ASSEMBLY, APPLY SILICONE AS SHOWN. THIS MAKES THE CONNECTION MORE DURABLE WHICH LENGTHENS THE LIFE OF THE UNIT.

FLOW METER DISASSEMBLY

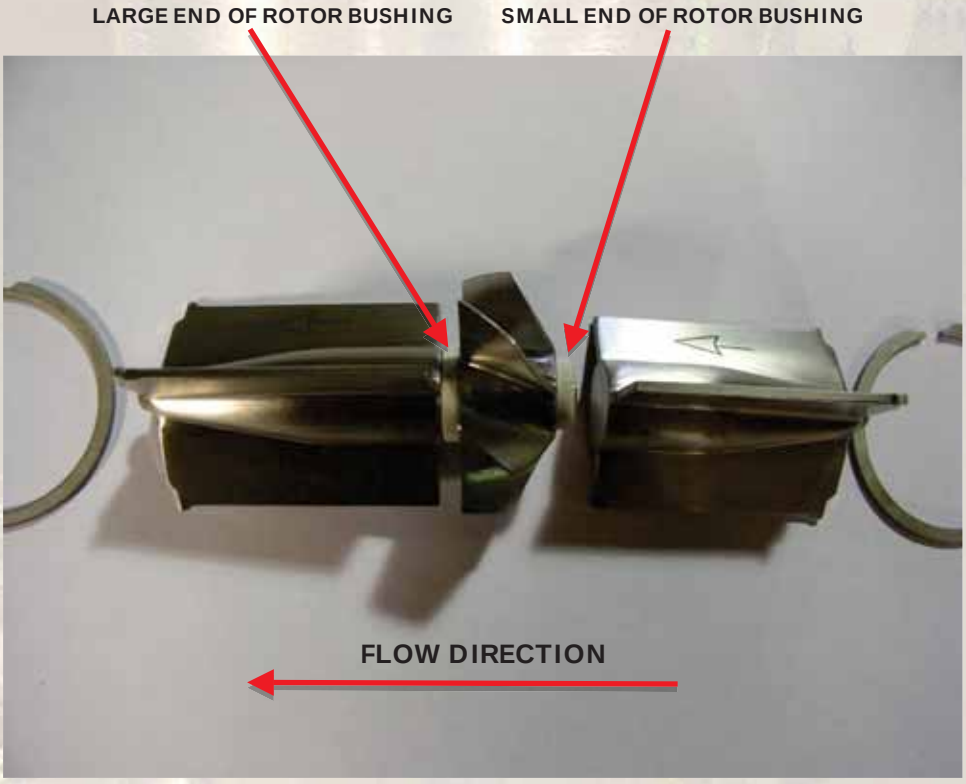
PAY ATTENTION TO PART ORIENTATION WHEN DISASSEMBLING INTERNALS FROM BODY.

1. STARTING IN ONE END OF THE BODY, INSERT A SMALL SCREW DRIVER INTO THE RELIEF MACHINED INTO THE SNAP RING AND PRY INWARD. USE ANOTHER FLAT BLADED TOOL TO SIMULTANEOUSLY LIFT UP THE END BEING PUSHED INWARD.
2. WORK THE RING OUT OF GROOVE BY FOLLOWING IT AROUND AND LIFTING IT OUT. HOLD ONTO THE RING AS COMES FREE OUT OF THE BORE. SET IT ASIDE IN A SAFE PLACE.
3. DUMP THE UNRETAINED INTERNALS OUT OF THE BODY BEING CAREFUL NOT TO LOSE OR DAMAGE THEM. REPEAT ALL STEPS ON OTHER END.
4. CLEAN PARTS PER THE FACILITIES ESTABLISHED REQUIREMENTS.



PRODUCT FLOW MUST ALWAYS PUSH ROTOR ONTO SHAFT

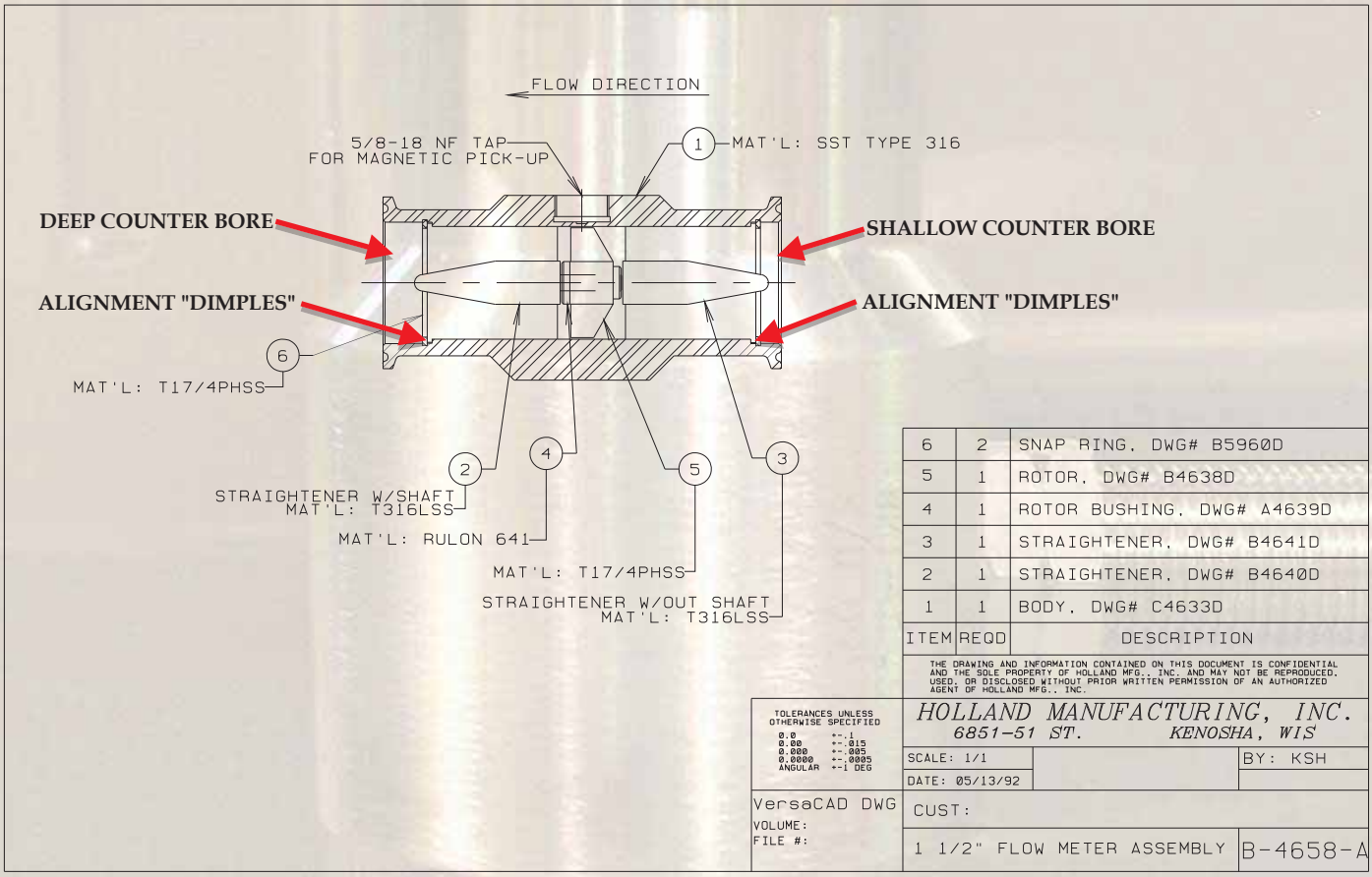
NEVER ASSEMBLE INTERNALS BACKWARD, THEY WILL DESTROY THEMSELVES



FLOW METER ASSEMBLY

****PAY ATTENTION TO PART ORIENTION WHEN ASSEMBLING INTERNALS INTO BODY****

1. SLIDE THE ROTOR, LARGE END FIRST, ONTO THE FLOW STRAIGHTENER WITH SHAFT.
2. PLACE THE ROTOR/STRAIGHTENER ASSEMBLY INTO THE END OF THE BODY WITH THE DEEPER COUNTER BORE. MAKE SURE ONE OF THE STRAIGHTENER FINS SLIDE BETWEEN THE ALIGNMENT "DIMPLES" IN THE BORE.
3. WHILE HOLDING THE STRAIGHTENER IN PLACE, TURN THE BODY OVER AND INSERT THE OTHER STRAIGHTENER INTO THE SHALLOW COUNTER BORE MAKING SURE A FIN SLIDES BETWEEN THE ALIGNMENT "DIMPLES".
4. WHILE HOLDING THE INTERNALS IN PLACE, SET THE ASSEMBLY ON END WITH THE SHALLOW COUNTER BORE END DOWN.
5. INSERT A SNAP RING INTO BORE PUSHING ONE END DOWN UNTIL IT SNAPS INTO THE GROOVE. CONTINUE TO PUSH DOWN AND AROUND UNTIL ENTIRE RING FINDS ITS' WAY INTO THE GROOVE.
6. TURN ASSEMBLY OVER AND REPEAT STEP #5 WITH THE OTHER SNAP RING.
7. REVERSE STEPS #1 THRU #7 ON PAGE #17 TO INSTALL ON THE FILLING MACHINE.



ITEM	REQD	DESCRIPTION
6	2	SNAP RING, DWG# B5960D
5	1	ROTOR, DWG# B4638D
4	1	ROTOR BUSHING, DWG# A4639D
3	1	STRAIGHTENER, DWG# B4641D
2	1	STRAIGHTENER, DWG# B4640D
1	1	BODY, DWG# C4633D

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TOLERANCES UNLESS OTHERWISE SPECIFIED
0.0 +-.1
0.00 +-.015
0.000 +-.005
0.0000 +-.0005
ANGULAR +-1 DEG

HOLLAND MANUFACTURING, INC.
6851-51 ST. KENOSHA, WIS

SCALE: 1/1 BY: KSH
DATE: 05/13/92

VersaCAD DWG
VOLUME:
FILE #:

CUST:

1 1/2" FLOW METER ASSEMBLY B-4658-A

****MAKE SURE FLOW DIRECTION ARROW ON FLOW METER POINTS TOWARD THE FILL VALVE****

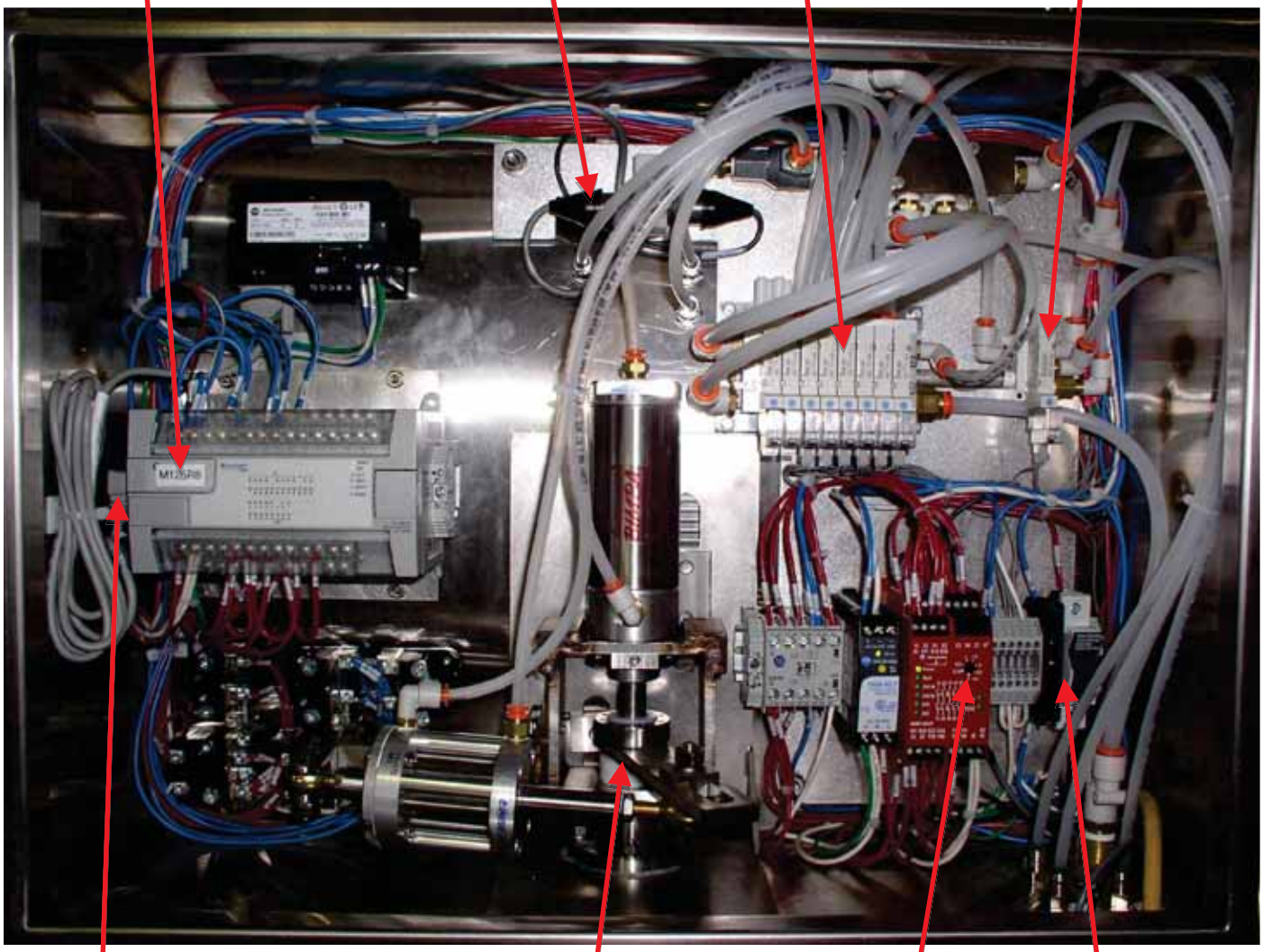
INSIDE THE CABINET

MEMORY MODULE FOR PLC

PREAMPLIFIER FOR FLOW METER

SOLENOID VALVES

MASTER SOLENOID VALVE



MAKE SURE CABLE IS PLUGGED INTO PLC AFTER SHIPPING

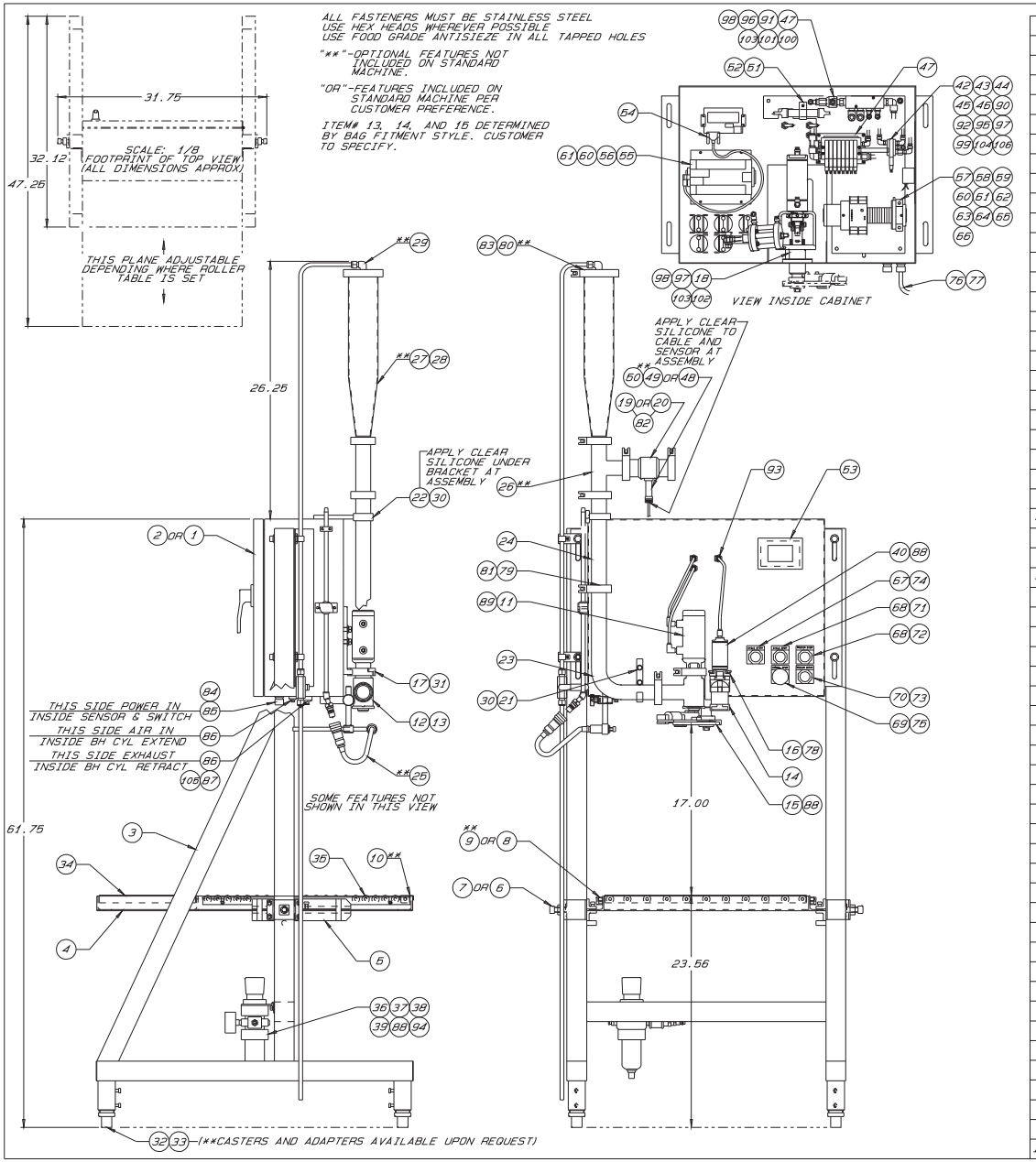
TRANSFER MECHANISM

SAFETY RELAY SET TO 2 SECONDS

FUSE HOLDERS

KEYS ARE TAPED TO INSIDE OF DOOR DURING SHIPPING. REMOVE AND STORE IN A SAFE PLACE AFTER INSTALLATION.

ELECTRICAL SPECIFICATION LABEL LOCATED INSIDE CABINET DOOR.



ITEM#	REQ'D	DESCRIPTION
108	REF	ELECTRICAL SCHEMATIC, DWG# C7936E
107	REF	PNEUMATIC DIAGRAM, DWG# D7949P
106	1	UNION "Y" FITTING, SMC# KQ2U07-00
105	1	BRANCH "Y" FITTING, SMC# KQ2U11-36S
104	1	STRAIGHT FITTING, SMC# KQ2H11-34S
103	2	STRAIGHT FITTING, SMC# KQ2H07-36S
102	1	STRAIGHT FITTING, SMC# KQ2H07-34S
101	1	SWIVEL ELBOW, SMC# KQ2L11-36S
100	2	SWIVEL ELBOW, SMC# KQ2L11-35S
99	2	SWIVEL ELBOW, SMC# KQ2L11-34S
98	4	SWIVEL ELBOW, SMC# KQ2L07-36S
97	6	SWIVEL ELBOW, SMC# KQ2L07-34S
96	1	MANIFOLD, MC# 5085K34
95	1	1/8 X 3"LG PIPE NIPPLE, SST.
94	1	MALE CONNECTOR, PARKER# BH2C
93	3	QUICK COUPLER, PARKER# 394P-4-4
92	1	PLUG, PARKER# 218P-2
91	1	HEX NIPPLE, PARKER# 216P-6-4
90	1	ADAPTER, PARKER# 222P-2-2
89	2	SWIVEL ELBOW, PARKER# 169PL-4-2
88	4	STRAIGHT FITTING, PARKER# 68PL-4-2
87	1	ANCHOR COUPLING, PARKER# 207ACBH-6
86	3	BULKHEAD FITTING, PARKER# 62PLBH-4
85	1	CORD GRIP, MC# 7091K21
84	1	CORD GRIP, MC# 6907K14
**83	1	3" CLAMP GASKET, BRADFORD# 40MP-U300
82	1	1 1/2" GASKET W/SST MESH, BR#40MP5-U150
81	3-4	1 1/2" CLAMP GASKET, BRADFORD#40MP-U150
**80	1	3" TRI-CLAMP, BRADFORD# 13MHHM300
79	3-5	1 1/2"TRI-CLAMP, BRADFORD#13MHHM100-150
78	2	1/4-20NC X 3/8LG HEX HEAD, SST
77	BFT	POWER CORD, SJEOOW 16/3 300V
76	1	PLUG, HUBBLE# 5965VY
75	1	LEGEND PLATE, AB# 800H-W700E EMERG.STOP
74	1	LEGEND PLATE, AB# 800H-W406 CYCLE START
73	1	LEGEND PLT, AB# 800H-W500E MASTER START
72	1	LEGEND PLT, AB# 800H-W300E MASTER STOP
71	1	LEGEND PLATE, AB# 800H-W376 CYCLE STOP
70	1	GREEN ILLUM EXT PB, AB# 800H-PRAH16G
69	1	RED PUSH/PULL, AB# 800H-FRXT6A5
68	2	RED PUSH BUTTON, AB# 800H-AR6D2
67	1	GREEN PUSH BUTTON, AB# 800H-AR1D1
66	1	END BARRIER, AB# 1492-EBJ3
65	10	TERMINAL BLOCK, AB# 1492-J3
64	1	END BARRIER, AB# 1492-N37
63	1	FUSIBLE SWITCH, AB# 1492-H4
62	1	FUSE HOLDER, AB# 1492-FB1C30
61	4	END ANCHOR, AB# EAJ35
60	AR	35MM DIN MOUNTING RAIL, #199-DR1
59	1	CONTROL RELAY, AB# 700-K40E-D
58	1	24VDC POWER SUPPLY, AB# 1606-XLP15E
57	1	SAFETY RELAY, AB# 440R-M23141
56	1	MEMORY MODULE, AB# 1762-MM1
55	1	PLC, MICROLOGIX 1200R, AB# 1762-L40BWAR
54	1	CABLE, AB# 1761-CBL-PM02
53	1	PANELVIEW C300, AB# 2711C-T3M
52	1	AMPLIFIER BRACKET, DWG# C4623D DET# 2
51	1	AMPLIFIER, RED LION# ASTC0000
**50	1	SENSOR CABLE, ELECTRO# CA210
**49	1	SENSOR, ELECTRO# 3030HTB
48	1	SENSOR, RED LION# MP62TA00
47	1	QUICK EXHAUST, HUMPHREY #50E2
46	1	SHUTTLE VALVE, SMC# VR1220F-07
45	9	CONNECTOR ASSY, SMC# SY100-30-3A 110VAC
44	1	SOLENOID VALVE, SMC#SY3140-3LZ-01T
43	1	MOUNTING BASE, SMC# SS5Y3-42-08-N7T
42	8	SOLENOID VALVE, SMC# SY3140-3LOZ
41	1	VALVE MOUNTING PLATE, DWG# B7935D
40	1	CAPPER CYLINDER, BIMBA #SR-171
39	1	SLIDE SAFETY AIR VALVE, MC# 4622K63
38	1	MOUNTING BRACKET, PARKER# PS707P
37	1	GUAGE, PARKER# GC230
36	1	FILTER/REGULATOR, PARKER# 06E11A13A
35	21	ROLLER, INTERROLL#1.101.519.S03RL=20.62
34	11	ROLLER, INTERROLL#1.101.519.S03 PL=9.88
33	4	SLEEVE, 1 1/2"OD X 16GA X 3.25LG, SST
32	4	ADJUSTABLE FOOT, FMP# 119-1061
31	1	TAPPED PLATE, DWG# C4104D
30	2	TAPPED BAR, DWG# C4623D DET# 3
**29	1	BLEED VALVE ASSEMBLY, DWG# C6951D
**28	1	3" END CAP, DWG# C6951D
**27	1	STAND PIPE, DWG# C7449D
**26	1	1 1/2" TEE, DWG# C7449D
**25	1	SANITIZING SPRAY ASSEMBLY, DWG# D6958A
24	1	FILL STRAIGHT, DWG# B4584D
23	1	FILL ELBOW, DWG# B4622D
22	1	UPPER MOUNTING BRKT, DWG# C4623D DET#1
21	1	ELBOW SUPPORT, DWG# B4653D
20	1	1" FLOW METER ASSEMBLY, DWG# B4671A
19	1	1 1/2" FLOW METER ASSEMBLY, DWG# B4658A
18	1	TRANSFER ASSEMBLY, DWG# D6959A
17	1	MOUNTING BRACKET, DWG# C4104D
16	1	CYLINDER MOUNT, DWG# B6076D
15	1	BAG HOLDER ASSEMBLY, CUSTOMER TO SPEC.
14	1	CAPPER BLOCK, CUSTOMER TO SPECIFY
13	1	FILL HEAD TEE, CUSTOMER TO SPECIFY
12	1	FILL HEAD SHUT OFF STEM, DWG# B2237D
11	1	AIR ACTUATOR ASSEMBLY, DWG# C4028A
**10	1	FRONT LIP GUARD, DWG# B6957D
**9	2	ROLLER SHAFT GUARD, DWG# B6956D
8	2	ROLLER SHAFT GUARD, DWG# B5123D
7	2	CLAMP BRACKET ASSEMBLY, DWG# B6400D
6	2	CLAMP BRACKET ASSEMBLY, DWG# C3969A
5	2	CLAMP ANGLE, DWG# C3970D
4	1	ROLLER TABLE FRAME, DWG# D3994D
3	1	STAND WELDMENT, DWG# D3267A
2	1	CABINET-PANELVIEW/NO SPRAY, DWG# D7930D
1	1	CABINET-PANELVIEW/SPRAY, DWG# D7890D
ITEM#	REQ'D	DESCRIPTION

JOB#
REQ'D:

TOLERANCES UNLESS OTHERWISE SPECIFIED
0.0 ±.1
0.00 ±.02
0.000 ±.005
0.0000 ±.0005
ANGULAR ±.1 DEG

VersaCAD DWG VOLUME:
FILE #:

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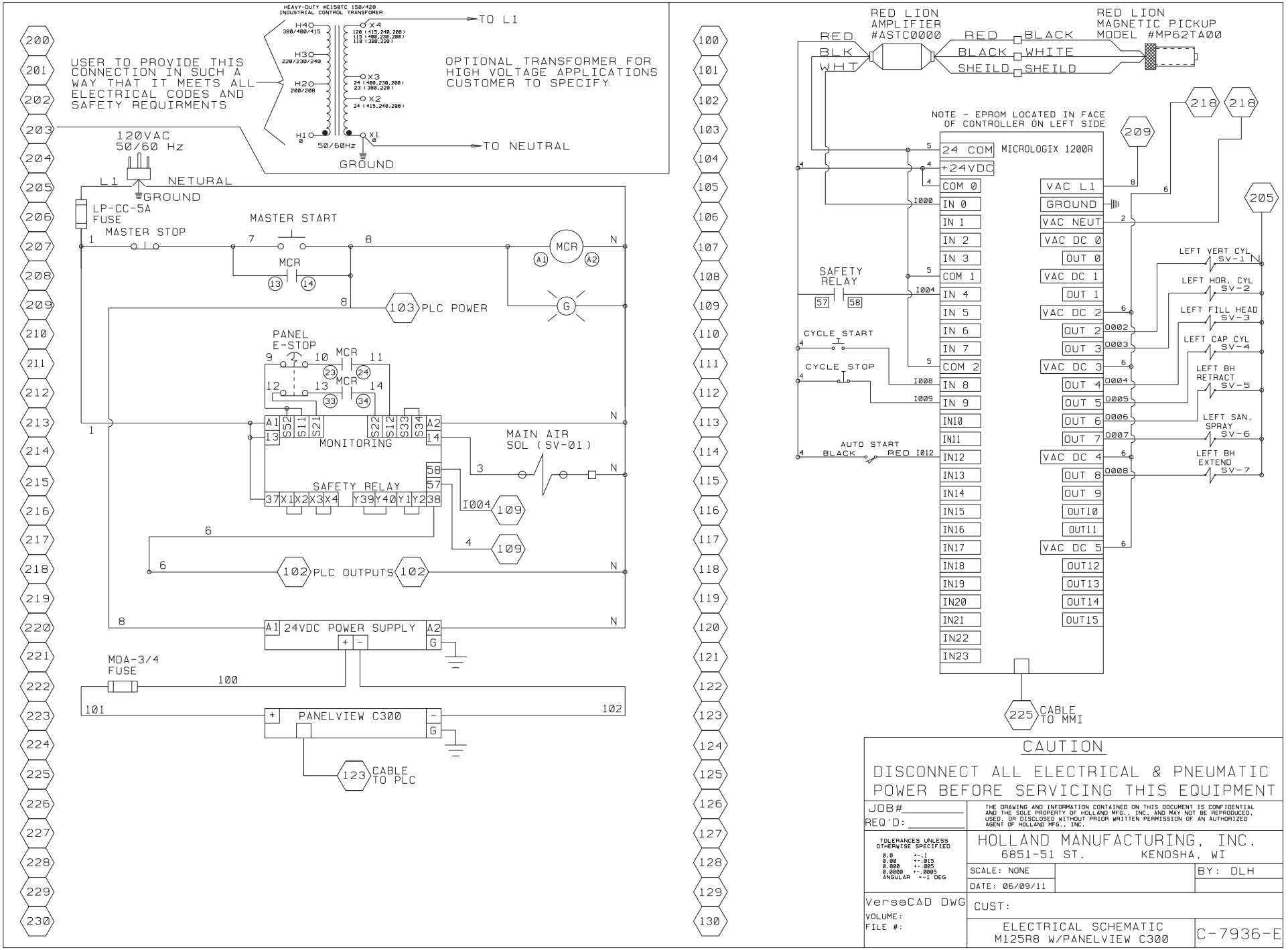
HOLLAND MANUFACTURING, INC.
6851-51 ST. KENOSHA, WI

SCALE: 3/16 BY: KSH
DATE: 01/15/09
CUST:

MAIN ASSEMBLY
M125 FILLING MACHINE

D-7940-A



CAUTION

DISCONNECT ALL ELECTRICAL & PNEUMATIC POWER BEFORE SERVICING THIS EQUIPMENT

JOB#_____
REQ'D:_____

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TOLERANCES UNLESS OTHERWISE SPECIFIED
0.0 +-.1
0.00 +-.015
0.000 +-.005
0.0000 +-.0005
ANGULAR +-1 DEG

HOLLAND MANUFACTURING, INC.
6851-51 ST. KENOSHA, WI

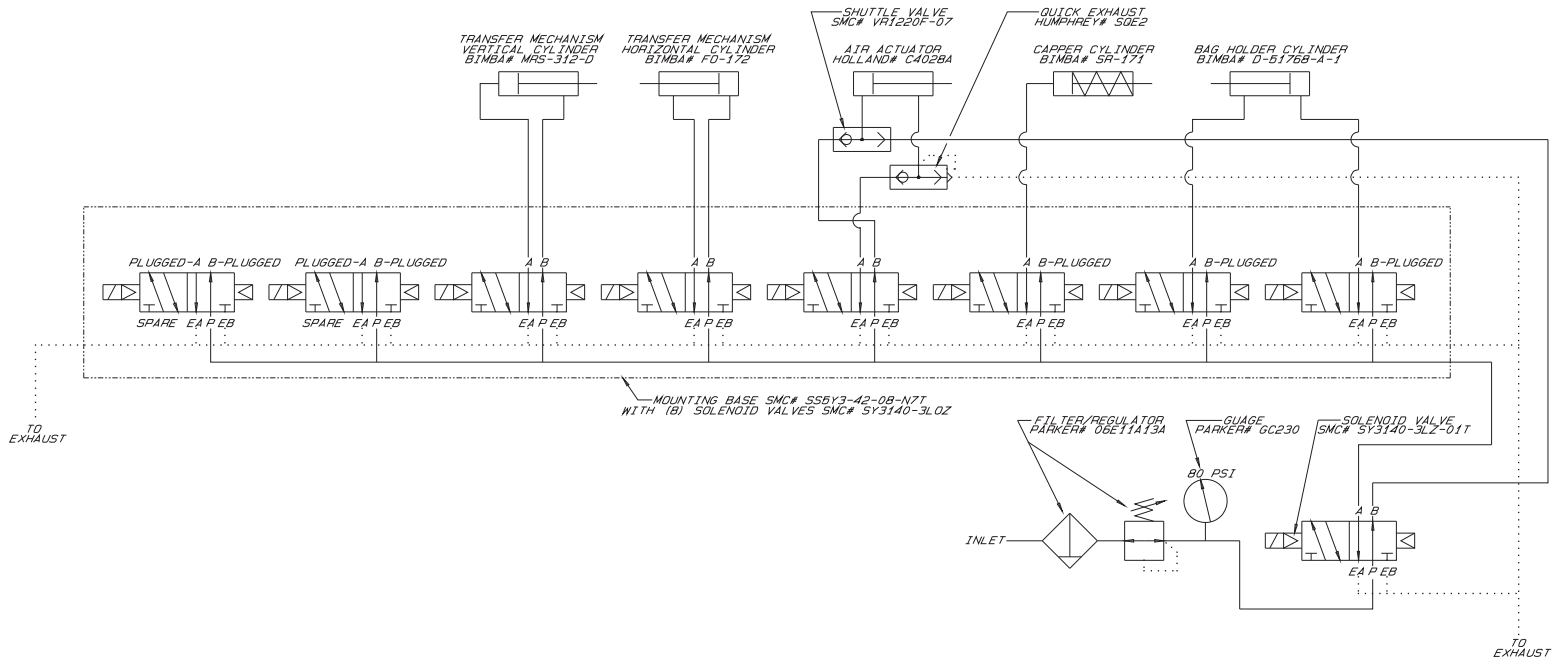
SCALE: NONE
BY: DLH
DATE: 06/09/11

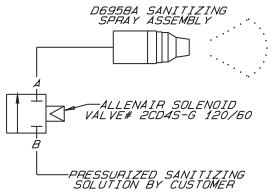
VersaCAD DWG
VOLUME:
FILE #:

CUST:

ELECTRICAL SCHEMATIC
M125R8 W/PANELVIEW C300

C-7936-E





OPTIONAL SANITIZING SPRAY SOLENOID

JOB# REQ'D:	THE DRAWING AND INFORMATION CONTAINED ON THIS DOCUMENT IS CONFIDENTIAL AND THE SOLE PROPERTY OF HOLLAND MFG., INC. AND MAY NOT BE REPRODUCED, USED, OR DISCLOSED WITHOUT PRIOR WRITTEN PERMISSION OF AN AUTHORIZED AGENT OF HOLLAND MFG., INC.	
TOLERANCES UNLESS OTHERWISE SPECIFIED 0.0 +-.1 0.00 +-.02 0.000 +-.005 0.0000 +-.0005 ANGULAR +-1 DEG	HOLLAND MANUFACTURING, INC. 6851-51 ST. KENOSHA, WI	
	SCALE: NONE	BY: KSH
	DATE: 08/05/11	
VersaCAD DWG VOLUME: FILE #:	CUST:	
	PNEUMATIC DIAGRAM M126 WITH PANEL VIEW	D-7949-P

RECOMMENDED SPARE PARTS LIST

QTY	DESCRIPTION	PART#	LOCATION
2	5 AMP FUSE	LP-CC-5A	MAIN FUSE HOLDER
2	3/4 AMP FUSE	MDA-3/4	SMALL FUSE HOLDER
1	MAGNETIC PICK-UP	MP62TA0000	SCREWED INTO FLOW METER
1	PREAMPLIFIER	ASTC0000	MOUNTED TO SUB-PANEL
1	MAGNETIC REED SWITCH	MRS.087	BAG HOLDER CYLINDER
2	SOLENOID VALVE	SY3140-3LOZ	MOUNTED TO SUB-PANEL
1	AIR CYLINDER	D-51768-A-1	BAG HOLDER
1	AIR CYLINDER	SR-171	CAPPER CYLINDER MOUNT
1	COUPLER STUD	A4019D	INSIDE AIR ACTUATOR
1	COUPLER	GR-600	INSIDE AIR ACTUATOR
1	SPACER	92678A518	INSIDE AIR ACTUATOR
4	U-CUP SEAL	S6-26	INSIDE AIR ACTUATOR
3	1 1/2 CLAMP GASKET	40MP-U150	PRODUCT PIPING
5	#113 O'RING	#113 O'RING VITON 75 DURO	VALVE STEM SHANK
5	#114 O'RING	#114 O'RING VITON 90 DURO	VALVE STEM TIP
5	#220 O'RING	#220 O'RING BUNA 75 DURO	ACTUATOR BONNET
2	#210 O'RING	#210 O'RING BUNA 75 DURO	INSIDE AIR ACTUATOR
4	#224 O'RING	#224 O'RING BUNA 75 DURO	INSIDE AIR ACTUATOR
3	1 1/2 CLAMP	13MHHM100-150	PRODUCT PIPING
5	SHORT ROLLER	1.101.S19.S03 RL=20.62	ROLLER TABLE
5	LONG ROLLER	1.101.S19.S03 RL=9.88	ROLLER TABLE
2	VALVE STEM	B2237D	FILL VALVE ASSEMBLY
1	CAPPER BLOCK	TO BE DETERMINED	CAPPER ASSEMBLY

NOTE: ALL ITEMS CAN BE ORDERED DIRECT FROM HOLLAND MFG OR THROUGH ANY DISTRIBUTER THAT MAY BE CONVENIENT. FOR REFERENCE, A LIST OF MANUFACTURERS IS PROVIDED FOR THE ABOVE ITEMS: LINE ITEMS #3 & #4 RED LION, #5, #7, & #8 BIMBA, #6 SMC CORP, #9, #22, & #23 HOLLAND MFG, #10 HANSEN, #11 MCMASTER CARR, #20 & #21 INTERROLL. ALL OTHER ITEMS ARE MADE BY MANY DIFFERENT MANUFACTURERS AND THE PART NUMBERS/DESCRIPTIONS ARE UNIVERSAL.

FOR MORE ASSISTANCE AND INFORMATION ON COMPONENTS, REFER TO THE FOLLOWING WEB SITES:

www.ab.com
www.rockwellautomation.com
www.redlion.net
www.smcusa.com
www.bimba.com
www.parker.com
www.interroll.com

M125 SEMI-AUTOMATIC FILLING MACHINE

The M125 is a machine that combines both versatility and reliability. It has become well known in the field for its adaptability and low maintenance features. These aspects along with operator friendly controls and simplicity of design have allowed it to develop a solid reputation with many credible establishments.

It was specially designed to fill non-particulate products for the dairy and food industries. Typically filled items include milk, ice cream mix, edible oils, flavorings, syrups, mustards and sauces. Products can be filled into a variety of container shapes and sizes. Originally designed to fill bags, it can accomodate over twenty five different cap/spout configurations made by the leading bag manufacturers. An adapter can also be used to fill pails, totes, drums, and other open top containers.

On standard machines, product volume is controlled by a turbine flow meter. When product with particulate is to be filled or a higher rate of accuracy is required, the M125 can be equipped with an electromagnetic flow meter, coriolis meter, or load cell. Other options available for special requirements include a chopping type fill valve assembly for particulates, centrifugal, PD, or diaphram pump mounted with product piping, shock tube with bleed valve, sanitizing spray assembly, post fill bag plug for reduced air intake, pre-fill vacuum, post fill nitrogen and casters for mobility.

Materials used for construction are all industry approved. Cabinet, stand, roller table, and brackets are all made of type 304 stainless steel. All product contact surfaces are made of either 304 or 316 stainless with sanitary welds and #4 polish all over. Turbine flow meter is made of 316 and 17/4ph stainless. Product contact gaskets and seals are made of Buna-n and Viton. Bearings and bushings are made from Delrin, uhmw, and Rulon 641. Machine logic and operator interface are field proven Allen-Bradley components and pneumatics are controlled through SMC valves and Bimba air cylinders.

The M125 is available in several configurations, the Single head filler, either left hand (standard) or right hand, the Twin head filler with one left and one right mounted to a single frame, and the single cabinet Dual head filler (M225) sharing common product piping and operator interface controls.

The M125 has been used in applications for filling test samples of prototype product, increasing productivity for small businesses, and complimenting existing equipment in large scale operations.

For more information, please contact:
Holland Manufacturing, Inc.
Kenosha, Wi
Ph: 262-654-5300
Fax: 262-654-6449
Email: info@holland-mfg.com

Specifications:

Electrical requirements - 120 vac, 50/60 Hz, 5 amp
Compressed air supply - 70 to 80 psi
Dry cycle time (uncap to recap) - approx 3 sec
Accuracy - Dependant on product, pump, meter, & other variables
Fill capacity - 1 gallon to 1200 gallons
Filling speed - minimum 10 gpm to maximum 70 gpm
Volume control - 1" or 1 1/2" turbine flow meter