BACE
BALER AND COMPACTION EQUIPMENT

OPERATIONS MANUAL

FOR VERTICAL BALERS - EXCEPT V32

August 01, 2021 Revision

BACE, LLC
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We meet ANSI Standard Z245.5

ATTENTION INSTALLER

MAKE SURE THE FACILITY MANAGER RECEIVES THIS MANUAL AND THE WARRANTY REGISTRATION IS FILLED OUT AND MAILED!

Product must be stored, installed, and operated in a DRY environment or damage will occur and the WARRANTY WILL BE VOIDED

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INTRODUCTION

Congratulations on the purchase of your new BACE equipment. This equipment is designed to provide safe, trouble-free operation for many years. All BACE equipment meets A.N.S.I. Z245.5 safety standards.

This Owner/Operators Manual is presented to give the owner and or operator the necessary information to properly and safely operate the equipment. It also provides information for the routine maintenance and trouble-shooting.

It is the owners responsibility to insure the operator is thoroughly familiar with this manual and fully trained before operating this equipment. Federal regulation prohibits operation of this machine by people under the age of 18.

An additional owner responsibility is to insure that the unit's operation is in accordance with safety requirements and codes, especially all applicable Occupational Safety and Health Act (OSHA) and American National Standard Institute (ANSI) regulations. BACE strongly recommends that the current ANSI and OSHA standards be available to operators at all times.

Failure to follow all prescribed safety instructions may result in Injury or Death.

If, after thoroughly reading this manual there are questions about the operation or repair of the equipment, call BACE @ 877-506-2223(BACE).

Our customer support hours are 8:00 am-5:00 pm EST Monday-Friday.

MANUFACTURERS LIMITED WARRANTY

VERTICAL BALERS

BACE, LLC (herein referred to as “BACE”) warranties parts and labor for a period of one (1) year on all equipment (unless specifically noted).

BACE provides an ADDITIONAL one (1) year parts and labor for all equipment that utilize a Submersible Power Unit (unless specifically noted).

BACE provides an additional two (2) years for parts replacement on major components (major components include cylinder, motor, pump and directional valve only), on all HD and XHD equipment. Balers with 1 Phase Power Units receive one (1) year parts and labor only.

BACE provides a total of ten years warranty (10) for the structure/frame on HD and XHD products and five (5) years warranty on all other equipment.

COMPACTORS

BACE, LLC (herein referred to as “BACE”) warranties parts and labor for a period of one (1) year on all equipment (unless specifically noted).

BACE provides an additional two (2) years for parts replacement on major components (major components include cylinder, motor, pump and directional valve only).

BACE provides a total of three years warranty (3) for the structure/frame on all equipment.

HORIZONTAL COMPACTORS - Model - DC6343-830AT

BACE, LLC (herein referred to as “BACE”) warranties the baler will be free from defective parts for a period of two (2) years or up to 4,160 hours of operation from date of shipment ofthe baler or 30 days from completion of manufacturing (whichever comes first) (4,160 hours is a period of time that corresponds to two full years, based on eight hours of operation per day, five days per week); parts and labor for a period of one (1) year on all equipment (unless specifically noted) ; and, be free from defective structural workmanship for a period of two (2) years or up to 4,160 hours of operation from date of shipment of the baler or 30 days from completion of manufacturing (whichever comes first) when used inaccordance with specifications and instructions supplied by BACE (4,160 is a period of time that correspondsto two full years, based on eight hours of operation per day, five days per week).

HORIZONTAL COMPACTORS - Model - Model - HCE 60 FE-8

BACE, LLC (herein referred to as "BACE") warranties parts and labor for a period of one (1) year on Model - HCE 60 FE-8 (unless specifically noted).

VERTICAL BALERS AND COMPACTORS

BACE's warranty is based on an 8-hour day and is devised accordingly.

Following the completion of installation of the equipment at the end user's facility, and evidence by a signed and dated installation report, and warranty registration returned to BACE will substantiate the warranty. If no registration form is remitted or the installation is not provided by the factory, the warranty period shall be considered to start on the date of shipment. As limited herein, BACE warranties the equipment sold under this warranty to be free from defects in material and workmanship.

This warranty does not apply to any defects caused by negligence, misuse, modifications, alterations, water damage to NEMA 12 components or accidents by purchaser or third parties. Warranty extends only to the original consumer and is nontransferable.

Further, at BACE's sole discretion, should it be deemed that a baler or compactor has been used for a material that it was not intended or in a manner contrary to good and safe procedures, the warranty will be void.

BACE reserves the right to void the warranty if the provided warranty card was not fully completed and/or not returned to BACE within 14 days of Equipment Installation. BACE reserves the right to determine if part(s) are genuine and/or defective. This warranty does not apply to any part that has been altered or repaired by any person not authorized by BACE, or which has been subjected to misuse, neglect or accident, or by any other cause beyond the control of the manufacturer.

This warranty excludes any obligation by BACE for loss of product, down time, or any other incidental or consequential damage incurred at any time.

BACE neither assumes nor authorizes anyone to assume for it any other obligation or liability in connection with such balers, compactors or containers.

If BACE's authorized installer/distributor is not on site at the time of equipment start-up, any labor or mileage obligation under this warranty will be voided.

THIS WARRANTY IS THE ONLY WARRANTY APPLICABLE TO BALERS, COMPACTORS AND CONTAINERS MANUFACTURED BY BACE AND IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

LIMITED WARRANTY INCLUDES:

- Repair, or replacement with a similar part, any part of the product of our manufacture which is returned to us within thirty (30) days after discovery of the defect, properly identified and transportation charges prepaid, and not more than 3 years, after purchase by original consumer.
- Shall furnish without charge, a similar genuine part to replace any part of a product of its manufacture, which proves to be defective in normal use and service during this period.
- Shall supply service labor for defective parts or workmanship with the manufacturer's equipment within the warranty period at the published BACE flat rate for mileage and labor.

LIMITED WARRANTY EXCLUDES:

- Any Any part(s), which has been altered, redesigned or repaired by any person or company not authorized by BACE.
- Water damage from outside storage, installation or operation.
- Any defected part which is the result of neglect of proper maintenance, improper installation, misuse, accident vandalism, fire or any other cause beyond the control of the manufacturer.
- Product of other manufacturers beyond such warranty as is made by such manufacturer is null and void from this warranty.
- Shipping and special handling charges to expedite part shipment.
- Maintenance instructions and proper cleaning instructions were neglected, which are determined by BACE.
- Ejector Chains and Limit Switch adjustments
- Broken or bent Cylinders (see details below)

PROCEDURES FOR WARRANTY CLAIMS

PROCEDURES FOR WARRANTY CLAIMS FOR DEFECTIVE PARTS:

ALL THE FOLLOWING PROCEDURES MUST BE FOLLOWED ON ALL PART RETURNS

DURING THE WARRANTY PERIOD. FAILURE TO COMPLY WITH THE FOLLOWING PROCEDURES WILL ABSOLVE BACE OF SUCH CLAIMS.
(SEE ATTACHED WARRANTY POLICY)

BACE CUSTOMER SERVICE: 877-506-2223(BACE)

MOTORS:

1. Once checked by a qualified technician who determines that no problems exist with fuses or wiring from incoming power source, then call BACE Service Department to notify us of the problem with the product model and serial number, and verify your warranty period and receive a warranty RGA number. We will then direct you to the nearest factory authorized motor diagnostic/repair facility.
2. If the factory facility determines that the problem is a factory defect, then the factory facility will replace the motor at no charge.
3. If it is determined that the motor problem was not due to a factory defect, then it will be the customer's responsibility to replace the motor.
4. BACE is not responsible for pick-up and delivery charges to the factory facility.

HYDRAULIC CYLINDERS:

1. Once checked by a qualified technician who determines that there is a problem with the cylinder, then call BACE Service Department to notify us of the problem with the product model and serial number, and verify your warranty period and receive a warranty RGA number.
2. BACE will at that time ship out a replacement cylinder from BACE or the cylinder manufacturer. Shipment will be normal freight rate, unless otherwise specified by the customer. For shipments other than normal freight (i.e. The determination of overnight shipping costs will be made solely by BACE.)
3. The customer is responsible for shipment of the defective cylinder, within 30 days, to BACE to determine the final warranty status.
4. In the event the cylinder is not received within the allotted time frame, then the customer will be billed the total amount of the replacement cylinder plus S & H.
5. BACE will not in any circumstance warrant a cylinder that has been used to compress material outside of it's designation, nor will cylinders be warranted that bend or break as a result of side-loading. This is not a common occurrence but does happen when balers are unevenly loaded. In these instances the cylinder will fail and will not be warranted.

ALL OTHER PARTS:

1. Once checked by a qualified technician and determined that there is a problem with the part, then call BACE Service Department to notify us of the problem with the product model and serial number, verify your warranty period, and receive a warranty authorization number.
2. BACE will at that time ship out a replacement part from BACE or authorize the customer to purchase the part from an authorized distributor, factory warehouse. Shipment will be normal freight rate, unless otherwise specified by the customer. For shipments other than normal freight (i.e. The determination of overnight shipping costs will be made solely by BACE.)

3. It is the customer's responsibility to ship the defective part back to BACE within 30 days with the RGA#, at BACE's discretion.
4. If the part is not received within 30 days and or if the part does not pass warranty inspection, the customer will be invoiced for the part and will not be held responsible for any charges for the corresponding repair.
5. All labor and travel will be paid per BACE's flat rate schedule. The work required to replace any part must first be authorized by BACE. (See below for Flat Rate Schedule).

The invoice from the customer must be itemized to include model, serial number of unit, work performed, an BACE warranty authorization number, location of equipment, labor hours & mileage.

FLAT RATE SCHEDULE FOR LABOR AND MILEAGE:

1. In all cases of replacement of parts, repair of structural components the customer is required to call in to BACE Service Department for a "Warranty Authorization Number." In cases where the work has begun and will exceed the Flat Rate Schedule more than 5% of the original estimate, you will be required to contact the Service Department for approval. In cases where the hours exceed the original flat rate schedule and/or work not authorized with a Warranty Authorization Number, that claim on the excess will be denied. NO CREDIT will be allowed for labor hours spent on the inspection or diagnosis of equipment problems.
2. In cases of structural repair by welding, re-fabrication, or modification of an existing design, an official authorization must be obtained from the BACE Service Department prior to work. The request must have the model number, serial number, brief description or drawing of work to be done
3. Warranty rates must be approved by BACE prior to the work being performed. We understand that in some instances an additional technician or helper may be required. This possibility has already been included in our total hours.
4. Travel time - BACE will reimburse at the same labor rate for the time approved by BACE and the travel incurred by the Service Technician.

NOTE: BACE uses mapping software to determine the time required for each Service request. Time will be adjusted to reflect actual time.

PARTS WHICH HAVE BEEN REPLACED:

5. In the event that a part fails during the first twelve month's of the equipment's warranty, the replaced part will be warranted for one (1) year from the time of installation. The labor to replace this part will be covered for 90 days after installation or the remainder of the original machine warranty, whichever is longer.

6. In the event that a part fails during the "part's only" period of a equipment's original warranty, the replaced part will have a one (1) year warranty and the labor to replace this part will be covered for 90 days after installation.
7. Replacement Parts will have a one (1) year parts only warranty.

CAUTION: Only factory original replacement parts or equivalent should be used to insure proper operation of equipment.

FAILURE TO COMPLY WITH ALL OF THE ABOVE PROCEDURES WILL VOID ALL WARRANTY CLAIMS

BACE has established some basic guidelines which will be used for the purpose of estimating jobs. These types of calls do not entail every possible scenario but do cover a majority of the issues that a equipment may encounter. BACE, through its years of experience directly, and indirectly through our broad service providers has developed a grid to use for the amount of time required to fix a particular issue. The times noted below are the maximum allowable unless written authorization is received by BACE.

Service Required	Man-hours Allowed
Replace Pump	1
Replace Motor	3
Replace/Adjust Limit Switch	0.5
Replace Cylinder	4
Repack Cylinder	5
Replace Directional Valve	1
Replace Pressure Switch	0.5
Electrical diagnosis / troubleshooting	1.5

PRE-OPERATION

The Vertical Baler requires adequate clear floor space and ceiling height for proper installation and operation. Please refer to your equipments spec sheet for requirements. This space should always be kept clear of materials which could interfere with the safe operations of the baler.

BALER IS SUPPLIED WITH NEMA 4 CONTROLS AND MUST BE STORED, INSTALLED AND OPERATED IN A DRY ENVIRONMENT OR DAMAGE MAY OCCUR AND WARRANTY WILL BE VOIDED (Weather covers are available).

POSITIONING

Positioning the vertical baler so that sufficient room is available for proper and safe operation. The back of the baler should be placed no less than 24 inches from any structure to allow room to insert wires and tie of the bale. Also, enough room in front of the baler must be present to allow the chamber door to swing fully open so the finished and tied bale can be ejected. THE BALER MUST BE STORED, INSTALLED AND OPERATED IN A DRY ENVIRONMENT OR DAMAGE MAY OCCUR.

ANCHORING

BACE recommends mounting the baler on a pad of steel reinforced concrete with a minimum of 3000 psi capacity. The pad should be at least 4 inches deep. The baler should be anchored to the pad adequately. Please refer to your equipments spec sheet for requirements. To allow for construction variances, the holes should be drilled after locating the baler in the desired position.

ELECTRICAL

A lockable fused disconnect switch (customer furnished) must be installed within 5 feet, and in the line of site of the baler electrical enclosure. This disconnect must be sized in accordance with the baler motor and voltage. (See Figure 1.1 for Single Phaseand Figure 1.2 for 3 Phase).

HYDRAULIC

Check for any hydraulic oil leaks and make sure that all hoses are tight.

NOTE: Ensure the plug has been removed from the hydraulic reservoir and the breather cap is installed. Failure to do this step will result in the Power Unit being damaged!

FINAL CHECKLIST BEFORE OPERATING YOUR BALER FOR THE FIRST TIME

In some cases the machine is shipped with the cylinder lowered. Inspect to make sure cylinder is bolted to the frame of the machine before the machine is operated.

- Make sure all appropriate safety decals are present and in their proper locations.
- Check the baler motor is wired for the correct voltage.
- Check that motor rotation is clockwise.
- Check that the motor starter has the correct thermal overloads for the installed voltage and that the transformer is wired for the correct voltage.

ELECTRICAL REQUIREMENTS

Figure 1.1 Single Phase Motor Voltage

Motor	Voltage	Full Load Amps	Power Supply Required
10HP	220V	50	100

Figure 1.2 Three Phase Motor Voltage

Motor	Voltage	Full Load Amps	Power Supply Required
10HP	208V	30	60
10HP	230V	28	60
10HP-SUB	415V	16.5	30
10HP	480V	14	30
10HP	575V	11	30
10HP	220V/240V	32	60
10HP	280V/400V	18	40
15HP	208V	46	80
15HP	230V	41	80
15HP	480V	20	40
15HP	575V	17	40
20HP	208V	59	100
20HP	230V	54	100
20HP	460V/480V	27	50
20HP	575V	22	50

MAINTENANCE INFORMATION

Note: BACE recommends that you maintain a record of your preventative maintenance inspections. Failure to perform regular maintenance may result in damage to the Baler.

⚠ CAUTION

LOCKOUT / TAGOUT: No Adjustments, Repairs, Or Cleaning should be done to the baler without performing the Lockout/Tagout procedures located on Page 17 of this manual.

DAILY:

- Inspect for Oil Leaks.
- Inspect Oil Level.
  - Note: With the Platen Up, Hydraulic Tank should be ¾ full.
- Inspect the following for Loose, Damaged or Missing:
  - Bolts
  - Ejector Chains
  - Limit Switches
  - Welds
  - Safety Decals
  - Guards
  - E-Stop Switch
- Inspect for Debris:
  - Remove All Debris Around Baler
  - Remove All Debris From Top Of Platen

MONTHLY:

- Check for Signs of Wear:
  - Inspect Cylinder for Scars on Rod
  - Oil Leaks
  - Mounting Bolts are Tight
  - Door Hinges/Hand Wheel for excessive play
  - UHMW on Gate and Platen for abnormal wear
  - Lubricate moving parts (Sprockets, Chains,Hinges and Turnbuckle (Repair or Replace if Required)
- Check Hydraulic Oil.
  - Should not be Cloudy or Milky in appearance (Replace if Required)
- Check Air Breather/Filter. (Replace if Required)
- Check Oil Filter; located in the Hydraulic tank under the access panel.
  - Change Every 12 Months
- Check Hydraulic Fittings and Connections. (Repair or Replace as Required)

YEARLY:

BACE recommends that an annual preventative maintenance schedule be arranged with your installer. Baler should be inspected one year after the baler has been installed or twice per year if the baler is used on multiple shifts.

Should you have further questions regarding annual PM's on your vertical baler, please call our corporate offices at 877-506-BACE (2223)

⚠ CAUTION

LOCKOUT / TAGOUT: No Adjustments, Repairs, Or Cleaning should be done to the baler without performing the Lockout/Tagout procedures located on Page 17 of this manual.

PARTS LIST - Please have the SERIAL # of the machine before calling for parts.

POWER UNITS

BWG13015 .....15HP/3PH/208/230/460 WEG MOTOR
BWG13020 .....20HP/3PH 208/230/460 WEG MOTOR
BBA15540 .....15HP/3PH/575V BALDOR MOTOR
BBA16000 .....20HP/3PH/575 V BALDOR
BEH11450.....10HP SUB/3PH/50HZ/200-415V MOTOR
BS251250-C.....14.6 GPM PUMP
BNA60501 ..... 10.5 GPM GEAR PUMP
BNA44560.....DIRECTIONAL VALVE
BYU10500.....UNLOADING VALVE
BNA34505 ..... DIRECTIONAL VALVE
BNK20040 ..... 3/4 A-B PORT SUB PLATE
BSU10000 ..... RELIEF VALVE
BNK13000.....SUB PLATE
BPD11200 ..... 4000PSI GAUGE
BUC21000 ..... SUCTION STRAINER 1”
BME12276 .....PRESSURE SWITCH
BMC12000 ..... TRANSFORMER
BAB900130 .....CONTACTOR (MOTOR STARTER)
BAB900452 .....CONTACTOR OVERLOAD
BAA12125 ..... RELAY
BID14000 ..... RELAY BASE
BTE12000 .....PUSH BUTTON, GREEN
BTE12200 ..... PUSH BUTTON, YELLOW
BTE13000 .....PUSH BUTTON, E-STOP
BAB13575 .....MAIN DOOR SWITCH
BAB13600 .....ANSI SWITCH
BAB1358.....SAFETY GATE SWITCH
BTE83600 .....ON/OFF KEY SWITCH 2 POS
BTE10000 .....RESET BUTTON
BHBC ..... BREATHER CAP

CYLINDER

B8485.5 ....8” X 48” X 5.5”
B63035 ..... 6” X 30” X 3.5”
B64835 ..... 6” X 48” X 3.5”
B64835.6..... 6” X 42” X 3.5”
B7605 ..... 7” X 60” X 5”

MECHANICAL PARTS

BECHVA .....EJECTOR CHAIN ASSEMBLY
BECQLVA .....EJECTOR CHAIN QUICK LINK
BMGHVA .....MAIN GATE HANDLE
BWTVA .....WHEEL TURNBUCKLE
BGGTVA .....GATE GUIDE TUBE ASSEMBLY (EACH)
BMGAVA .....MAIN GATE ASSEMBLY
BUHMWVA ..... UHMW KIT
BSMBVA ..... SWITCH MOUNTING BRACKET

BALER LOCKOUT/TAGOUT PROCEDURE

⚠ CAUTION

Before performing any maintenance, always "LOCK AND TAG OUT THE DISCONNECT."

This procedure establishes the minimum requirements for the lockout of a baler for service. It shall be used to ensure that the machine is isolated from all potentially hazardous energy, and locked out before employees perform any servicing or maintenance activities where the unintentional power-up could cause serious injury or fatality due to the electrocution or due to entrapment in moving parts. This procedure should be performed only by authorized personnel only.

1. Before locking baler out for service or repair, locate which breaker of disconnect applies to the baler to be locked out. Notify all affected employees that a lockout system is going to be utilized and the reason therefore.
2. If the machine or equipment is operating, shut it down by the normal stopping procedure. Run the press head/ram down to full stroke & press emergency stop button.
3. Lock out the disconnect or breaker that controls the baler. If locking out a breaker use a double-pole breaker lockout and lock.
4. Lockout the energy isolating devices with assigned individual locks. If more than one person is servicing the baler, then a hasp with a lock for each service person shall be used.
5. After ensuring that no personnel are exposed, and as a check on having closed the appropriate breaker or disconnect, have a qualified electrician confirm there is no power to the Baler. Then push the stop button. The baler is now locked out.
6. After the servicing and/or maintenance is complete and the equipment is ready for normal; production operations, check the area around the machines or equipment to ensure that no one is exposed.
7. After all tools have been removed from the baler and employees are in the clear, remove the lockout device. Operate the start button to restore energy to the baler.

EMERGENCY OPERATION

Should an emergency occur while operating the baler, press the RED STOP BUTTON and the baler will terminate all functions and shut down.

EVERYONE AUTHORIZED TO OPERATE THE BALER
SHOULD KNOW THIS EMERGENCY PROCEDURE.

CAUTION! IMPORTANT! READ BEFORE OPERATING THE BALER.

BACE Balers meet and exceed all safety standards set by A.N.S.I. that are applicable to the installation and use of Balers. Although BACE has included many safety features in the design and construction of the baler, safe operation of the equipment depends on the operator's adherence to the certain guidelines. To prevent accidents to the personnel or damage to the baler, the operator MUST NEVER VIOLATE ANY OF THE FOLLOWING SAFETY PRECAUTIONS. It is the client's responsibility to ensue these guidelines are known and followed by all operators of the baler.

NOTE:
Publication of these safety precautions does not imply or represent and inclusive list.

NEVER place hands or arms in the baler while it is operating.

NEVER stand behind the baler while it is operating.

NEVER climb in or on the baler, nor perform any maintenance/repairs unless the power is disconnected and locked out.

NEVER allow anyone except qualified electrical or hydraulic repair persons to work on the equipment.

NEVER disable any safety switch.

NEVER overload the baling chamber.

NEVER place concrete, heavy steel plate or castings, explosive materials, liquids, nor hazardous waste in the baler.

NOTE:
Hydraulic oil is the primary element of power transmission on the baler. Remember that hydraulic systems can remain pressurized even after the motor has stopped and the power is disconnected.

BALER OPERATIONS

⚠ CAUTION

To avoid side loading, keep material level in Baling Chamber or damage could occur.

1. Ensure the ejector chains are untwisted and set correctly in the grooves of the baler chamber floor.
2. Close and lock main door by tightening hand wheel lock.
3. Open Safety Gate and Load Material to be baled.
4. Pull Down Safety Gate.
5. Turn Key Switch to ON Position.
6. Press the Down Push Button, Platen will automatically cycle.

Repeat Steps 3 through 6 until Bale is formed,
Platen will automatically stop in the DOWN position when bale is full and the Full Bale Light that will come on at the same time the Platen automatically stops.

TIE-OFF AND EJECT BALE:

7. Open Main Door Fully when the Platen stops in down position.
8. Insert Baling Wires through the floor slots.
9. Insert Baling Wires back through the Platen slots from the rear of the Baler.
10. Tie-Off Baling Wires located in the front of Baler.
11. Located at the REAR of Baler, hook up the Ejector Chains to the Red Platen Brackets.
12. Place pallet in front of baler chamber opening to receive the bale (if desired)
13. Stand clear of the front of Baler and push the UP push button. (Notice that the Bale will automatically eject.)
14. Remove bale.
15. Close main chamber door and tighten door hand wheel lock.
    (DO NOT LOAD NEW MATERIAL AT THIS POINT. WAIT UNTIL STEP 16 IS COMPLETE.)
16. Remove ejector chains from their RED platen brackets and hang on the storage peg on rear of baler.

Ready to repeat steps 1 through 16 for next Bale.

⚠ CAUTION

Ensure ejector chain(s) are removed from Press Head after bale has been ejected and before new material is placed in the Baling Chamber.

BALER OPERATIONS - Balers with International Safety Package

⚠ CAUTION

To avoid side loading, keep material level in Baling Chamber or damage could occur.

1. Ensure that the ejector chains are untwisted and set correctly in the grooves of the baler chamber floor.
2. Close and lock main door by tightening hand wheel lock.
3. Open Safety Gate and Load Material to be baled.
4. Pull Down Safety Gate.
5. Turn Key Switch to ON Position.
6. Press the Safety Failure Button to turn off the Safety Failure light. If light does not turn off make sure the load gate, chamber door and rear doors are closed.
7. Press the Down Push Button, Platen will automatically cycle.

Repeat Steps 3 through 7 until Bale is formed, Platen will automatically stop in the DOWN position when bale is full and the Full Bale Light that will come on at the same time the Platen automatically stops.

TIE-OFF AND EJECT BALE:

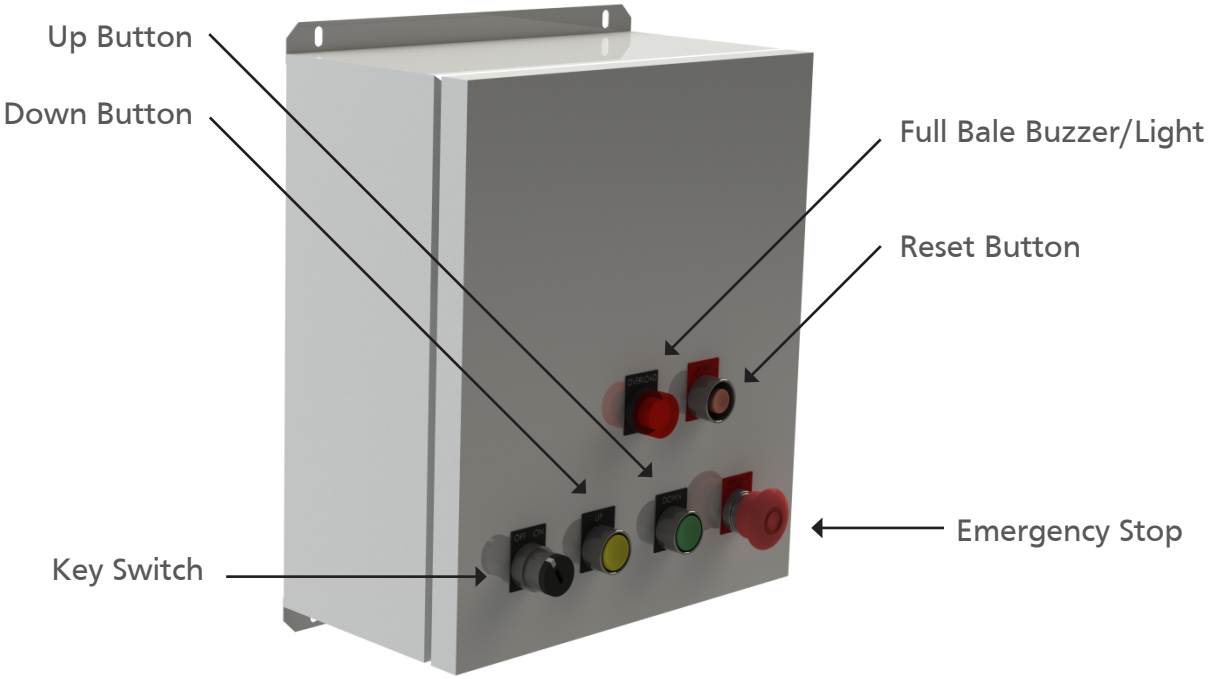
8. Open Main Door Fully when Platen stops in down position.
9. Insert Baling Wires through the floor slots.
10. Insert Baling Wires back through the Platen slots from the rear of the Baler.
11. Tie-Off Baling Wires located in the front of Baler.
12. Located at the REAR of Baler, hook up the Ejector Chains to the Red Platen Brackets (make sure the rear dors are fully closed after hooking up the ejector chains).
13. Place pallet in front of baler chamber opening to receive the bale (if desired)
14. With large front door open, stand on the side of the Power Unit to press BOTH eject buttons at the same time. (Notice that the Bale will automatically eject.)
15. Remove bale.
16. Close main chamber door and tighten door hand wheel lock.
    (DO NOT LOAD NEW MATERIAL AT THIS POINT. WAIT UNTIL STEP 14 IS COMPLETE.)
17. Remove ejector chains from their RED platen brackets and hang on the storage peg on rear of baler.

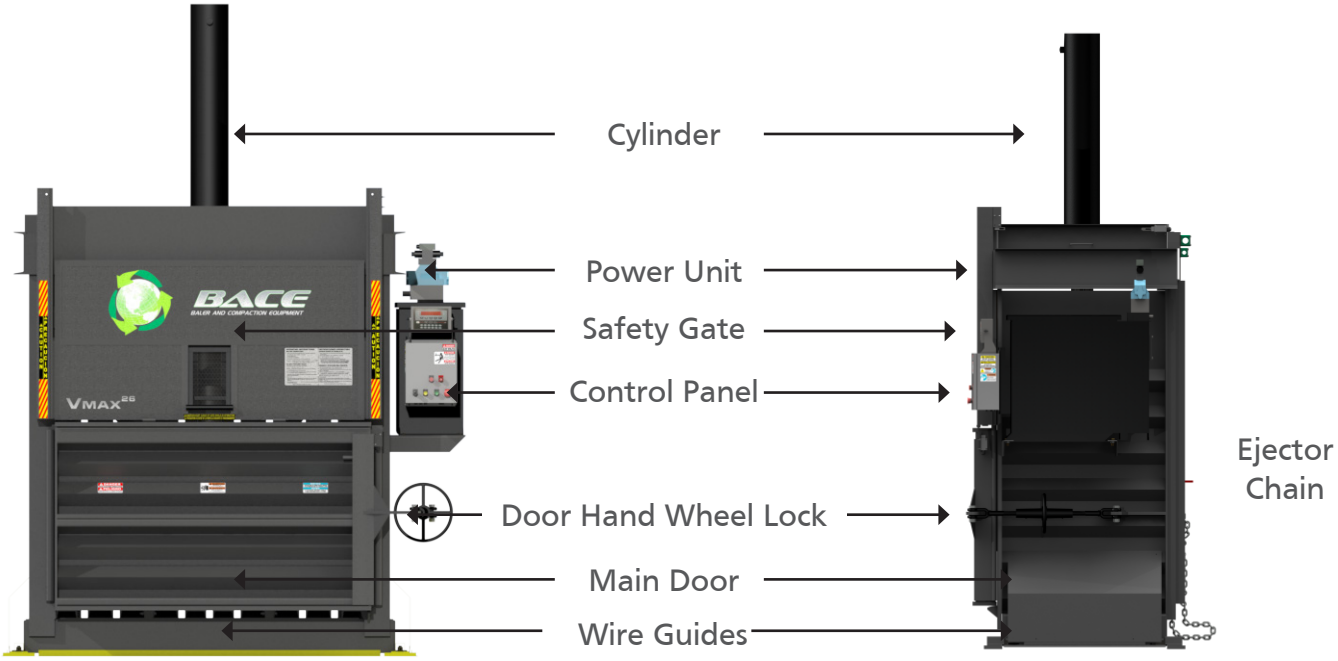
Ready to repeat steps 1 through 17 for next Bale.

⚠ CAUTION

Ensure ejector chain(s) are removed from Press Head after bale has been ejected and before new material is placed in the Baling Chamber.

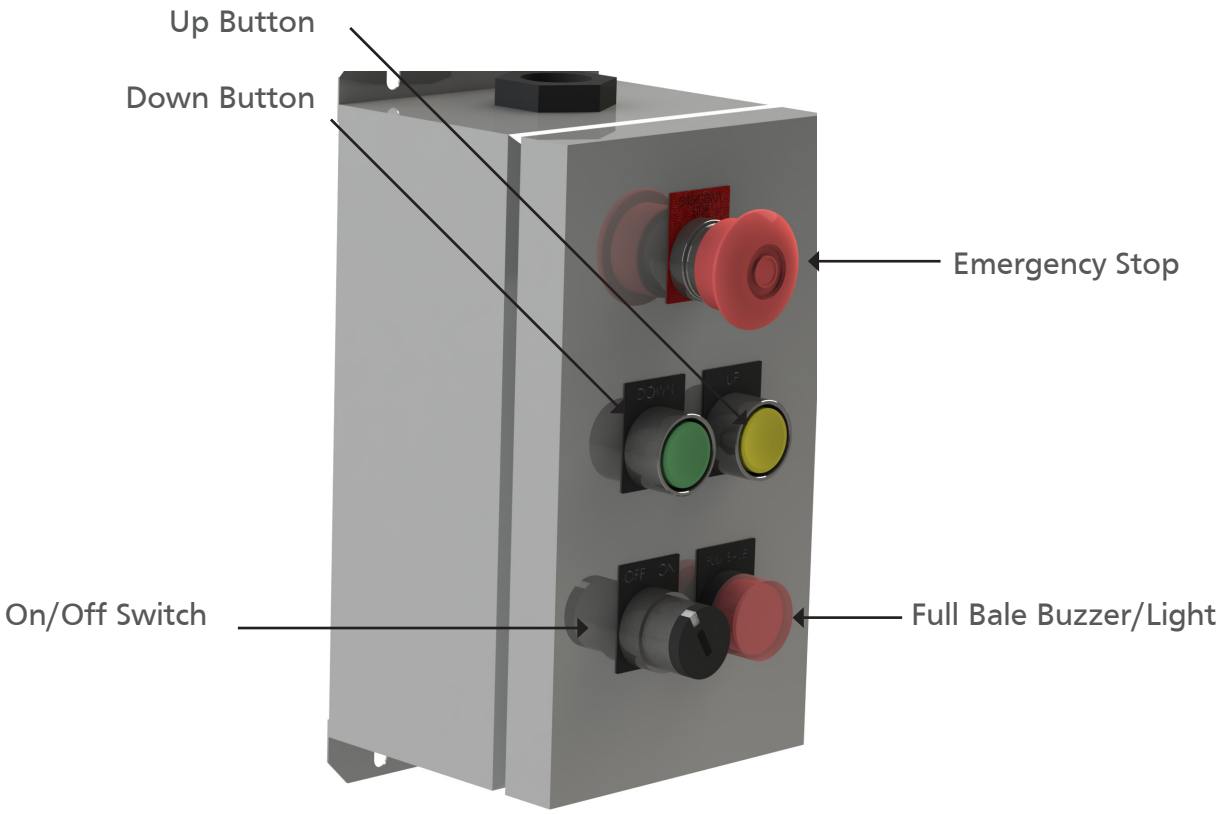
EQUIPMENT DIAGRAM
SIDE MOUNT CONTROL PANEL

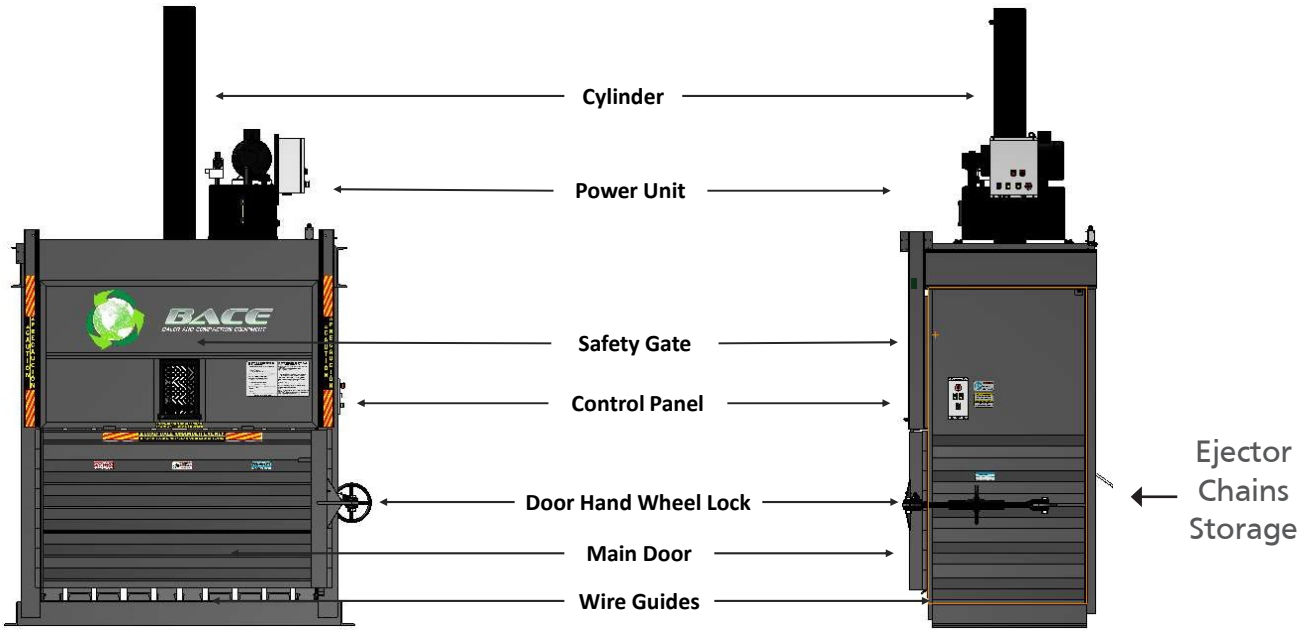




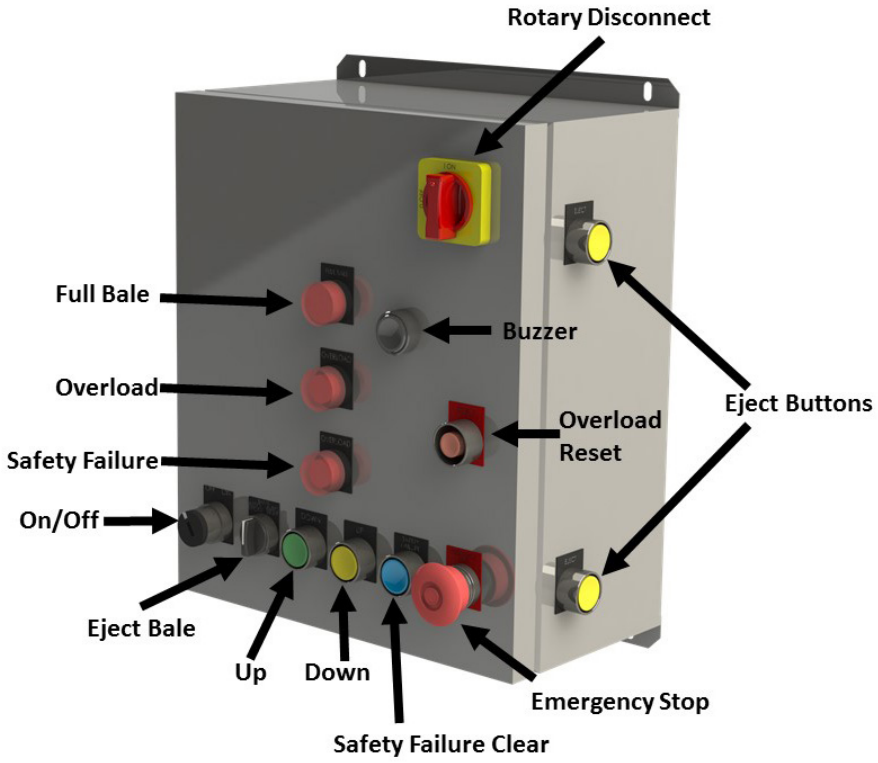
Baler shown with optional IntelliBALE System™

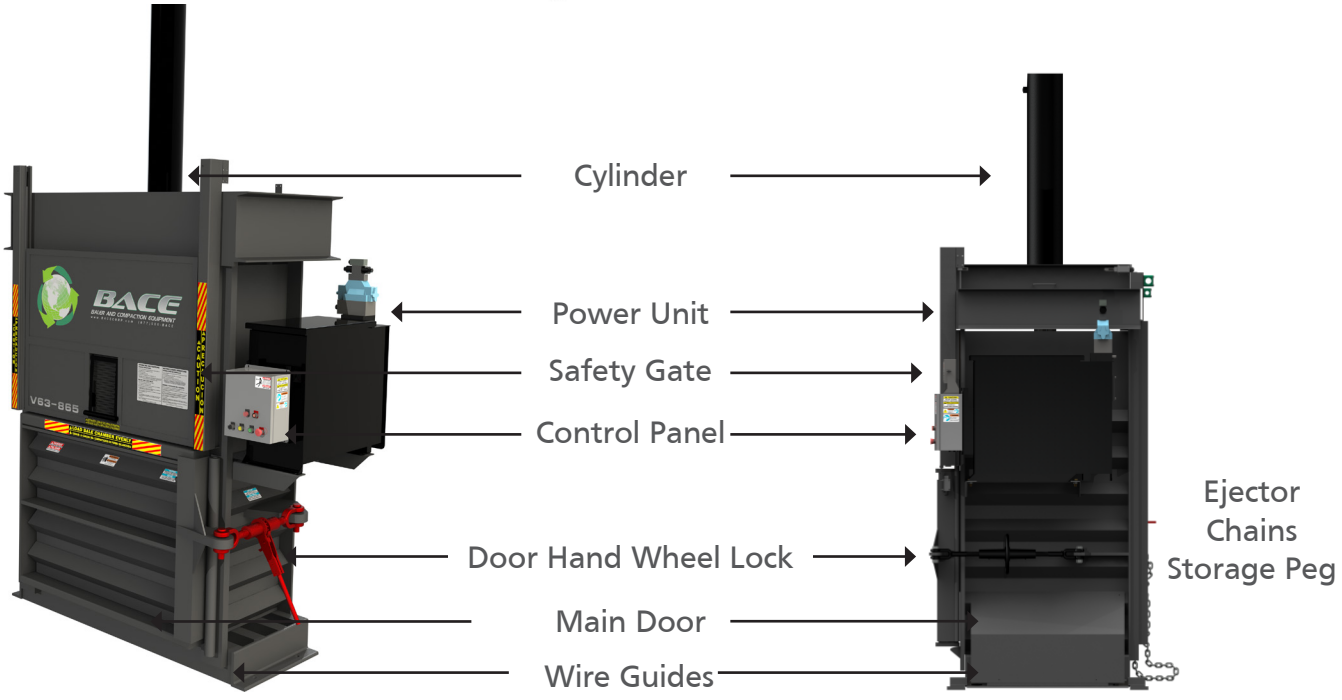
EQUIPMENT DIAGRAM
TOP MOUNT CONTROL PANEL





EQUIPMENT DIAGRAM
SIDE MOUNT CONTROL PANEL WITH INTERNATIONAL SAFETY OPTIONS





Baler shown with optional IntelliBale System™

TROUBLESHOOTING GUIDE

NOTE: ONLY FACTORY AUTHORIZED SERVICE REPRESENTATIVES SHOULD MAKE ADJUSTMENTS OUTSIDE THE SCOPE OF THIS MANUAL.

List below is a first check for a qualified technician

⚠ CAUTION

LOCKOUT / TAGOUT: No Adjustments, Repairs, Or Cleaning should be done to the baler without performing the Lockout/Tagout procedures located on Page 17 of this manual.

MOTOR WILL NOT OPERATE:
- Check fused disconnect.
- Check motor starter thermal overloads. Reset if necessary.
- Check motor starter coil.
- Check that safety gate switch is working properly.
- Check that main chamber door is fully closed.

MOTOR RUNS BUT PLATEN DOES NOT MOVE
- Check for proper motor rotation. (clockwise from the fan end)
- Check the directional valve for proper operation.
- Check the pressure switch.
- Check the relief valve for proper adjustment.
- Check the hydraulic fluid level. (Some may have Optional Low Oil Light)

BALE WEIGHTS ARE LOW
- Check for proper system pressure.
- Check for proper relief valve adjustment.
- Check for proper pressure switch adjustment.
- Check that baler is achieving full bale status. See “Operating Instructions.”

BALE SHIFTS ERRATICALLY
- Check for proper system pressure.
- Check for proper pressure switch adjustment
- Check relays and bases for signs or arcing.
- Check directional valve.

BALER MAKES EXCESSIVE NOISE
- Check hydraulic fluid level.
- Check for water or air in hydraulic fluid.
- Check oil filter and suction lines components for tightness.
- Check that bolts are tight on press head UHMW wear guides.

APPENDIX A

INTELLIBALE SYSTEM OPERATION

If your baler is equipped with a BACE IntelliBALE™ System.

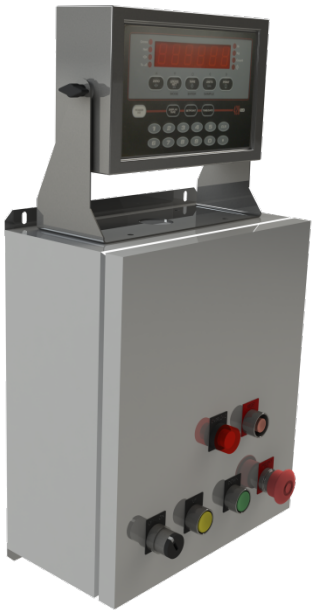
The BACE IntelliBALE™ System includes:

- Four Load Cells
- Four Foot Pads
- Four Pads Covers
- Junction Box
- Display/Control Panel
- (2) Protective "wing" guards
- May include buzzer/light for AWNS

Please ensure that, at all times, all foreign material is kept out from underneath the baler as it will affect the performance of the scale system.

Your IntelliBALE scaling system weighs bales prior to their ejection. These bales may weigh either the maximum weight that the baler can produce or they may be a bale of pre-set weight that has been programmed into your IntelliBALE System.

If the system has a pre-set weight, it will have an automatic weight notification system (AWNS) with a light and a buzzer to notify the operator when the pre-set weight has been reached.



DO NOT TOUCH ANY button on the IntelliBALE System display EXCEPT for the following:

The zero '0' button is required to be pushed after a bale has been completed to reset the scale to zero should residual material remain in/on the baling chamber.

The power (O/I) button in the event that the system needs to be reset. Resetting the system should only be authorized by a certified BACE or a Rice Lake technician.

Do not attempt service on the IntelliBALE™ System without consulting BACE.

Warranty Registration and Customer Acceptance Form

Complete and mail/fax to:
BACE, LLC - 322 West 32nd Street, Charlotte, NC 28206 OR Fax: (704) 394-2210

FORM MUST BE FILLED OUT AND EMAILED, MAILED or FAXED WITHIN 7 DAYS OF INSTALLATION

MODEL	SERIAL NUMBER	INSTALLATION DATE	PURCHASE DATE	PURCHASED FROM

Purchasing Company: _____ Contact Name: _____

Address: _____ City: _____ State: _____ Zip: _____

Phone: _____ Fax: _____ E-mail: _____

Installer Installation Check List:

Equipment must be stored, installed and operated in a dry environment unless optional nema 4 controls are installed.

- ☐ Fuse disconnect and 12 ft. pigtail installed.
- ☐ Is supplied voltage compatible with baler specifications.
- ☐ Check full bale switch. (Run ram down, override full bale switch, at bottom baler should shut off)
- ☐ Check main door (door open, baler should shut off).
- ☐ Check safety gate (with baler running open safety gate and baler should stop).
- ☐ Check up stop (with platen moving up, press the UP stop switch and platen should stop).
- ☐ Check all electrical connections are tight.
- ☐ Check hydraulic level in sight glass.
- ☐ Check hydraulic hoses and fittings.
- ☐ Ejector system is ok.
- ☐ Baler is lagged down.
- ☐ Breather cap is installed.
- ☐ All Decals are in place and undamaged.
- ☐ Baler has been checked for scratches and repaired if required.

Installer Post-Installation Customer Acceptance Check List:

- ☐ Owner/Operator has manuals, extra copies of electrical and hydraulic schematics and keys.
- ☐ Owner/Operator has been properly trained in the operation and safety features.
- ☐ Baler is free of scratches and/or damaged decals.
- ☐ Pictures of Installation required to be sent to BACE - full front, full left side, full right side.

INSTALLER NAME & SIGNATURE: _____ DATE: _____

CUSTOMER NAME & SIGNATURE: _____ DATE: _____

SCHEMATICS

Schematics for the power units are contained inside the control panel of each baler.
If additional schematics are required (including hydraulics) call the BACE offices at (704) 304-2230 or email service@bacecorp.com