

Tubing Machine SOP

Bimini Brothers, Inc

Department: Processing

Effective Date: 6/2026

PROCEDURE

1. Turn on the main power by switching the power switch, located near the monitor, to the "ON" position.
2. Allow the machine approximately 2 minutes to reboot. While the machine reboots, stage it by completing the following:
 - a. Remove all coverings.
 - b. Confirm the packaging type to be used for the material being run - fill the bin next to the shoot with your blank tubes.
 - c. Clean / Setup designated catch tote(s) for finished product to be stored in.
3. Once the machine has finished booting, press the blue "RESET" button located under the monitor.
4. Press the green "START" button.
5. On the monitor, tap "Intro Vibrating Bowl."
 - a. This activates the bowl and shooter.
6. You then will need to tap "Intro Off" that is also located on the monitor.
 - a. This button will activate the feeder screw and starwheel.
7. As tubes begin to fall from the shoot into the feeder screw, the operator must load prerolls, in the correct orientation, into the tubes before reaching the starwheel.

SAFETY

1. If any safety concerns become apparent, operators must immediately press the red "**EMERGENCY OFF**" button, located underneath the monitor.
2. Plastic doors must remain closed while the machine is running.
3. Keep fingers and other body parts away from all moving parts while the machine is in operation.
4. If a machine error occurs, refer to the Machine Fault Response guide posted on the machine for quick troubleshooting reference.

MACHINE FAULT & QUICK RESPONSE

Quick Reference Guide - Tube Filling Machine

Master Reset - Found on touchscreen (If unable to reset open door then close door to reset)

Fault Name	Area	Est. Downtime	Troubleshoot
Star Wheel Pinching	1	1-2 minutes	Remove tube by removing tube w/ pliers at pinch point. Will req. Master reset on touchscreen
Blocked Orientation Error Message	3	1-2 minute Req reset button pressed on screen (if code populates)	Open top of area 3 to pull out the jammed tube. Empty all tubes in section 3 on the diagram below.
Reed switch not reached (capper needle out)	1	<1 minutes	Slide/push needle in then flip to starting position
Reed switch not reached (capper needle in)	1	<1 minutes	Slide needle in or out
Tubes hang up in vibrator bowl either coil guide or metal railing - This creates an audible sound to alert operator of issue	4	<1 minutes	Guide or remove stuck tube. Or, just remove the tube and place back in the bowl will correct issue
Camera Issue / Tube color change	1	1 minute	Recipe change. Ex: white vs black tubes. On the touchscreen press the recipe button and select the correct recipe.
Reject Gate Code	1	<1 minutes	Check or clear out the chute to LM tote, push the reject gate back to normal position.
If you do any error corrections with it not immediately starting up per normal reset.	1	<1 minutes	Select master reset on the touchscreen. If unable push the M.R. then open/shut door to gain access

