



# HONEY *& other things* STRAW FILLER



***Patent Pending***

**Designed and Manufactured by Anthony's Beehive**

# INSTRUCTIONS

Updated 7-7-20

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Website: [www.AnthonysBeehive.com](http://www.AnthonysBeehive.com)

Video: <https://youtu.be/gcnge8bNOBo>



**Please Read Before Operating!**

# **INSTRUCTIONS**

**And Owner's Manual**

**STEP  
ONE:**

[View ONLINE for Updates and Videos:  
https://bit.ly/Straw\\_Machine\\_Owners\\_Manual](https://bit.ly/Straw_Machine_Owners_Manual)

**PLEASE READ CAREFULLY  
NOT DESIGNED FOR CHILDREN  
INCLUDES INSTRUCTIONS FOR SAFETY,  
CLEANING, OPERATION**

Thanks for your purchase of our honey straw filling machine. We hope that you find it simple to use - and rewarding. Please be advised that much of the process is manual - that is what makes the machine affordable and versatile.

Filling Straws can be a messy process, and there is a learning curve. Most straws will have to be cleaned to finish the process. Warm water works Great on Honey.

Please take the time to review these instructions before operating the machine.

**NOTE:** The Holders are often shipped **UNGLUED** because some uses are better suited to not using the stop. Epoxy or Super Glue will attach the bracket to the holder.

# Some Assembly Required

→ Carefully unpack and check to make certain that you received the following:

- ◆ Machine, Ring Assembly, HUB, 14 Screws
- ◆ Heat Sealer with Extra Elements
- ◆ TWO Straw Holders
  - One with stop (might need to be glued together)
  - One without stop
    - For variable length straws
- ◆ Empty Straws (reorder info below)
  - Regular Machine - 2500 Straws
  - “Green” Upgrade - 200 Straws

→ REORDER STRAWS AT:

- ◆ Direct from Us
  - [AnthonysBeehive.shop](https://www.anthonysbeehive.shop)
- ◆ Regular Straws from Sam’s Club Online
  - [https://www.samsclub.com/sams/jumbo-unwrapped-straws-2500-ct/155875.ip?xid=plp\\_product\\_1\\_6](https://www.samsclub.com/sams/jumbo-unwrapped-straws-2500-ct/155875.ip?xid=plp_product_1_6)
- ◆ Environmentally Friendly Straws from Eco-Products
  - [https://www.ecoproductsstore.com/7\\_75in\\_clr\\_straw\\_unwrapped.html](https://www.ecoproductsstore.com/7_75in_clr_straw_unwrapped.html)
  - Options include clear, colored, striped

**\*\*\* Other Straws Likely Won’t Fit! \*\*\***



Colors Vary - PLA (corn based) Plastic Components

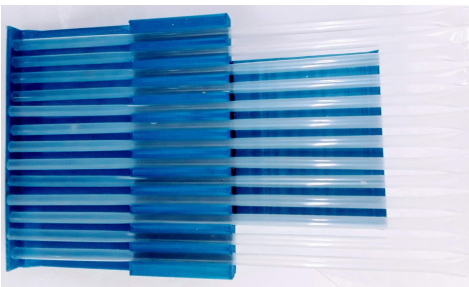
# Assembly Instructions

To prevent damage during shipping, we have to switched to a partially disassembled machine. This also makes it easier to Clean.



- The HUB and the OUTER RING must be attached before use.  
They can also be REMOVED FOR CLEANING
- **It is CRITICAL to TIGHTEN THE SCREWS GENTLY**
- A ¼ inch Nut Driver is Needed
  - ◆ A drill or power driver is NOT RECOMMENDED as it is easy to damage the plastic components
- You Will Receive a Bag with 14 Screws
  - ◆ 10 for The Ring
  - ◆ 4 for the Hub
- NO GLUE IS NEEDED
- **PROCEDURE**
  - ◆ Line Up The Holes (some units are marked)
  - ◆ Insert and Tighten (Gently) the first screw
  - ◆ Insert & Tighten SUBSEQUENT SCREWS in OPPOSITE positions (not Adjacent)
    - In other words, each screw should be inserted into the hole **FARTHEST** away from the previous screw
  - ◆ One of The STRAW Holders may need to be glued to the STOP BRACKET with Epoxy, E6000, or Super Glue





# Sealers

VERY Important



The machine uses a standard electric impulse sealer to seal the ends of the straws. We can include a decent sealer with your Machine, or you can provide your own. Many people already own one. Only a good sealer with adequate wattage will work. If you chose the deluxe sealer, you will receive a Very Good, high wattage, American Made sealer. If you chose the standard package, you will receive a good sealer. **If you want to purchase your own, we have provided suggestions below.** We charge \$50 less for the machine if you chose to buy it without a sealer.

## GOOD \*\* BETTER \*\* BEST

The Links Below are for the MANUFACTURER, we have been buying from [www.Pack-Secure.com](http://www.Pack-Secure.com), but there or other choices.

**GOOD SEALER** - American Made, various Vendors, 500 Watt, Does 12 straws at a time empty or full. Several Sources. Around \$100. 2 mm wide

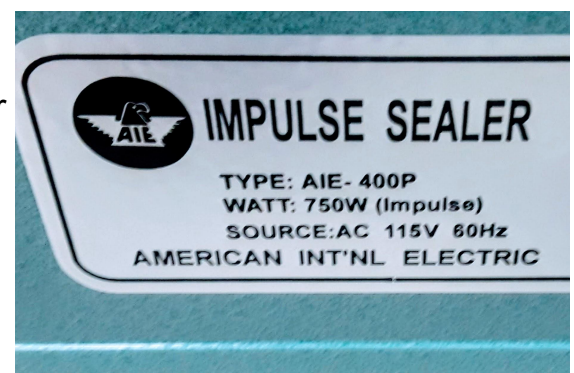
**BETTER SEALER** - American Made, various Vendors, 750 Watt, 16" -Does 12 to 24 straws at a time. Several Sources. Around \$150. 2 mm wide

**BEST SEALER** - American Made, various Vendors, 1000 Watt, 16" -Does 12 to 24 straws at a time. Several Sources. Around \$150. 5 mm wide

**Note:** Some customers have reported good results with commercial vacuum sealers.



Upgrading to the AIE-400P or 405P sealer will allow you to seal 24 straws at a time.



# **HELPFUL HINTS for SEALING STRAWS**

- Bring arm Straight Down and hold firmly for at least 5 seconds AFTER it clicks OFF
  - Don't let the arm travel from side-to-side on the way down.
- Green straws work best at a lower setting and longer hold time
- EXPERIMENT!
- Test initial seals with a baby nostril aspirator bulb
- Use the middle of the element
- Keep wet rag handy to clean teflon cloth strip as necessary
  - Replace Teflon cloth strip and elements when they are worn enough to affect performance (usually after about 1,000 straws)
- Store filled straws vertical (quart jars work well) for some time before sealing 2nd end in order to allow an air gap to form at the unsealed end - top. Better seal and no mess!
- If some straws are not sealing well, then try using every-other slot, especially once straws are full.

## → Step One: Seal One End of Straws

- ◆ Load Straws into Straw the Straw Holder.
  - 12 at a time with the ends flush.
    - **If you are having trouble sealing all the straws, try loading the holder EVERY-OTHER-SLOT**
    - *Test random straws with a Baby Nose Aspirator*
  - Hold the straw holder firmly with the ends on the straws lined up about 1/8" past the sealer element.
  - Set the Sealer on 6.
    - Hold down firmly until you hear it click off
    - **THEN LEAVE THE HANDLE FIRMLY PRESSED DOWN FOR 5 SECOND AFTER THE CLICK!**
  - **Helpful Hint: Make certain that the arm of the sealer comes down Squarely aligned with the heating element. Do this by keeping a close eye as you lower the handle, avoiding any SIDE-to-SIDE movement of the Sealer Arm.**
- ◆ Straws that are not well sealed will make a mess in the machine and waste product.
  - You will become very fast at this step with practice.
- ◆ User SUGGESTION: Save time by sealing one end on a large number of straws in advance.

**NOTE: GREEN MACHINE ONLY - Set Sealer on 5 and hold the arm down for 10 SECONDS - to prevent pinhole leaks**



→ Seal Straws on one end, using the impulse sealer included with the machine.

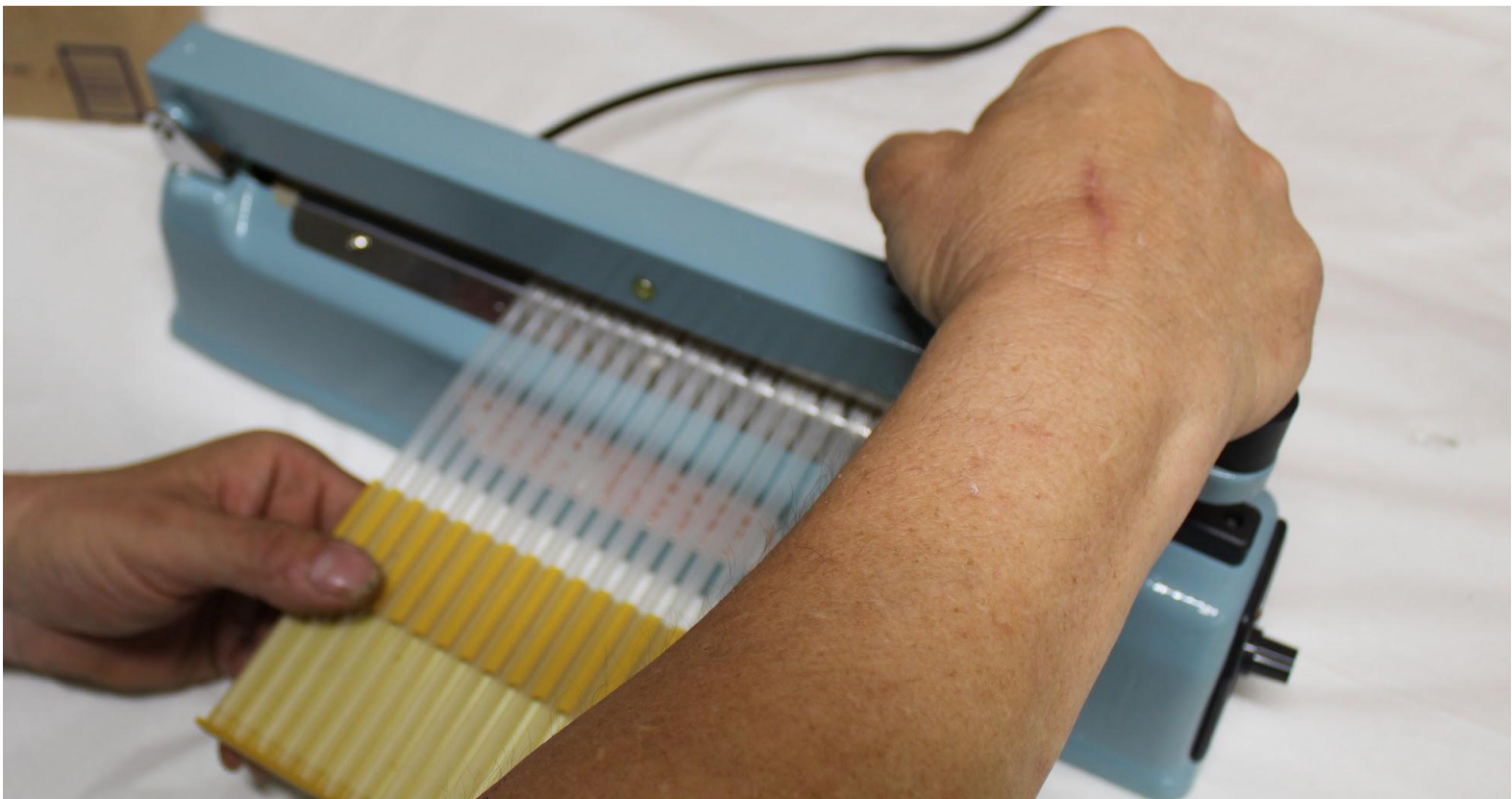
◆ Set on 6 and **hold the arm down for at least 5 seconds after the click.**

- Might take longer once the element wears a little
- Turn it up at least one number for filled straws
- Too HOT can be as much of a problem as too cold

**NOTE: GREEN MACHINE ONLY - Set Sealer on 5 and hold the arm down for 10 SECONDS - to prevent pinhole leaks**

◆ Helpful Hints

- **Keep the arm aligned perfectly with the lower portion - don't let it wander side-to-side**
- Try loading every-other-slot
- Use warm Honey
- **Keep the sealing area CLEAN by keeping warm water and a towel nearby!**





**Note: 2,500 Straws are shipped with the Machine.**

REORDER STANDARD STRAWS AT:

[https://www.samsclub.com/sams/jumbo-unwrapped-straws-2500-ct/155875.ip?xid=plp\\_product\\_1\\_6](https://www.samsclub.com/sams/jumbo-unwrapped-straws-2500-ct/155875.ip?xid=plp_product_1_6)

**\*\*\* Other Straws Likely Won't Fit! \*\*\***

## **GREEN MACHINE ONLY:**

- ◆ Environmentally Friendly Straws from Eco-Products
  - [https://www.ecoproductsstore.com/7\\_75in\\_clr\\_straw\\_unwrapped.html](https://www.ecoproductsstore.com/7_75in_clr_straw_unwrapped.html)
- ◆ Also Available from [AnthonysBeehive.shop](https://www.anthonysbeehive.shop)

## **IMPORTANT**

- One of the MOST important steps is to properly seal one end. **Straws should look like the ones at the bottom LEFT.** If you are unsure about the seal, use a baby nose aspirator as shown bottom RIGHT to see if the straw holds air. With a little practice, all straws will seal easily. If poorly sealed straws become more frequent, then replace the element in the sealer (2 extra are included). The element is typically good for 1,000 straws. The element and the Teflon strip will last longer and perform better if it is kept clean by quickly removing excess honey with a wet rag between batches.



## Step Two: Load 40 Sealed (one end) Straws into the Machine.

- Push open end through the hub and then slide backwards until the sealed end is all the way into the tube at the outer perimeter.
- ◆ **All 40 holes must be filled with a straw, If not, liquid will be flung out of the hub and make a mess**
- ◆ Straws must be fully loaded one at a time so that the portion protruding into the center of the hub does not interfere with the smooth insertion of subsequent straws.
- ◆ **SEE VIDEO BELOW**



## StepThree - Fill the Hub:

- Prepare your recipe of Honey or Other Liquid and pour into the top of the hub.
  - ◆ DOUBLE-CHECK that all 40 holes have a straw in them
  - ◆ Pre-measure 200cc - that should fill 40 straws
    - Some liquid will start making its way into the straws. This is anticipated and won't affect the process.
- Regarding warmed honey (and runny liquids)
  - ◆ Warmed honey (100 F) will go in faster.
    - It will also increase the effect of any end-leaks
  - ◆ If the honey is over-heated, it will no longer be raw, and it can make the process more messy if there are small leaks.
- Adjust the amount for subsequent batches, if necessary
  - ◆ NOTE: If you use the straw-shortening feature, you will need to adjust the amount accordingly.
- PRE-MEASURE your liquid and pour it all into the Hub before starting the machine. Start with 200 ml and tweak until you know your specific batch size.



## **Step Four - Turn it On and Fill The Straws:**

### **→ TURN IT ON**

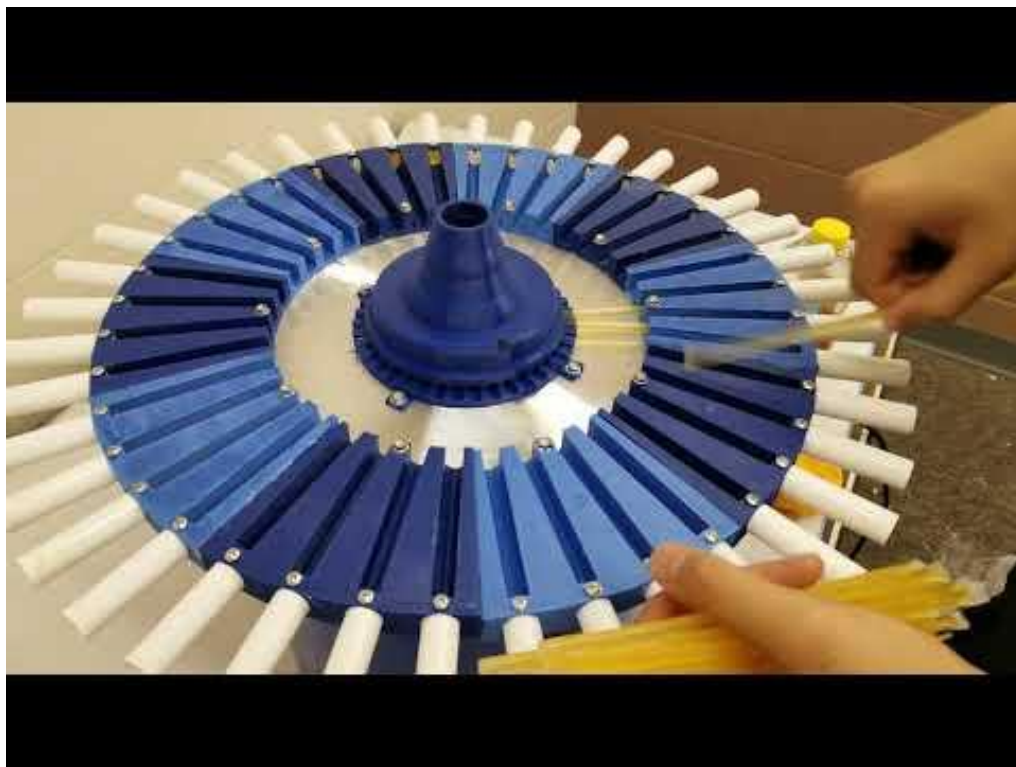
- ◆ Turn the adjustable speed knob all the way up
  - Increase the speed if necessary
- ◆ It will work in either direction, but do NOT change the direction while running.
- ◆ Run until the hub is nearly empty.
  - Start with 30 seconds to 1 minute
    - Varies with product and temperature
  - Experiment - run time will vary with liquid and temp
  - Won't hurt to stop and check - you'll get the hang of it
    - If you run too long you might get some over-seep on top of the straws



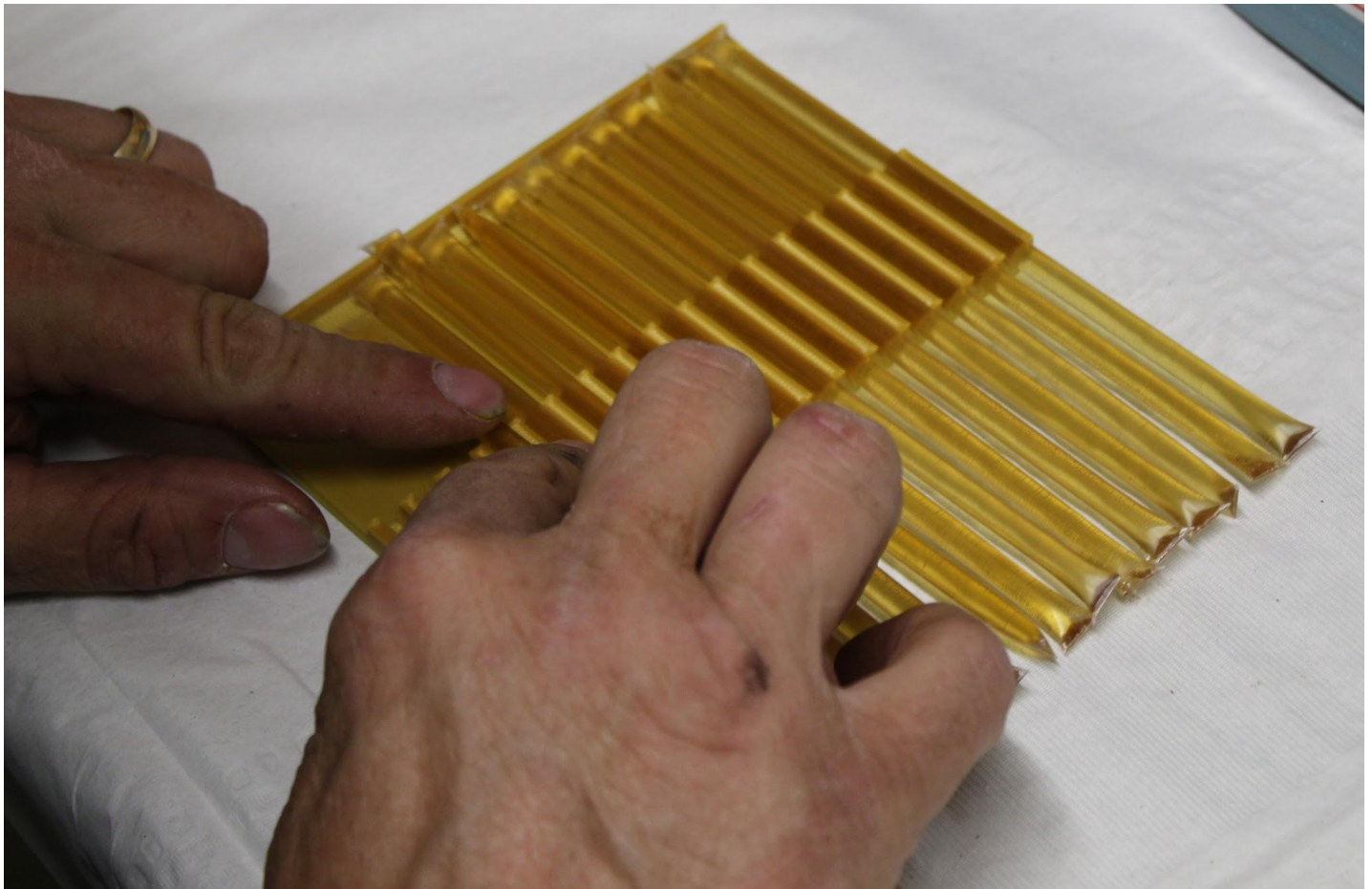


## **Step Five - Remove the straws:**

- If some straws are not completely filled, try these 2 things:
  - ◆ Push back into the tube to make certain that the straw is not protruding inside of the hub, where it can't fill.
  - ◆ Leave the straw in for the next batch (if it is going to be the same flavor)
- **TO REMOVE:** Pinch the straw and slide it into the hub until the sealed end clears the tube. This will allow you to lift the outer end and slide the filled straw out.
  - ◆ It is best if a little honey oozes out into the hub as you pinch and remove it. That will allow for a small air gap at the end, which will make sealing easier and less messy.
- **HELPFUL HINT:**
  - ◆ After removing straws, place them vertical in a jar or cup, sealed side down. By the time you are ready to seal a bunch of them, the honey will have settled, leaving an air gap at the top. This helps achieve a better seal, and reduces waste and mess.
  - ◆ This also reveals if any of the original seals are bad. Product from poorly sealed straws will leak out the bottom and can be recaptured for future use.



**Step Six:** Once the filled straws are removed from the machine, insert them back into the straw holder, just like in step one. **The sealer might do a better job at this point if you load the straws into every other slot.** Experiment to decide. Seems to depend on temperature, viscosity, how clean the sealer is & how much the element has been used. Average life of the element seems to be about 1,000 straws. **NOTE:** Placing the filled straws vertically into a jar with the open end up can let them settle (an hour or so) with an air gap on top. This makes a better seal and less waste/mess.



**Note:** Make certain that the tops (unsealed ends) of the straws are in a very straight line.

# What's Different with the GREEN MACHINE?

- Uses Environmentally Friendly Corn-Based Straws from [ecoproducts.com](http://ecoproducts.com)
- The straws are a little longer and a little wider than the standard straws, so the Green hub has been designed to fit
- Straws are a little more brittle, and subject to cracking if you bend them.
- The corn-based straws melt at a lower temperature
  - The impulse sealer will need to be set lower so that it does not melt through.
  - MORE IMPORTANTLY, the sealer handle needs to be held down longer because the warm corn-based-plastic is melty and will open a pin-hole size leak if the pressure from the sealer handle is released too soon.
  - Careful when heating the product, much over 100 will begin to distort the straws.



**NOTE: GREEN MACHINE ONLY - Set Sealer on 5 (empty straws) and 7 (full straws) and hold the arm down for 10 SECONDS - to prevent pinhole leaks. EXPERIMENT.**

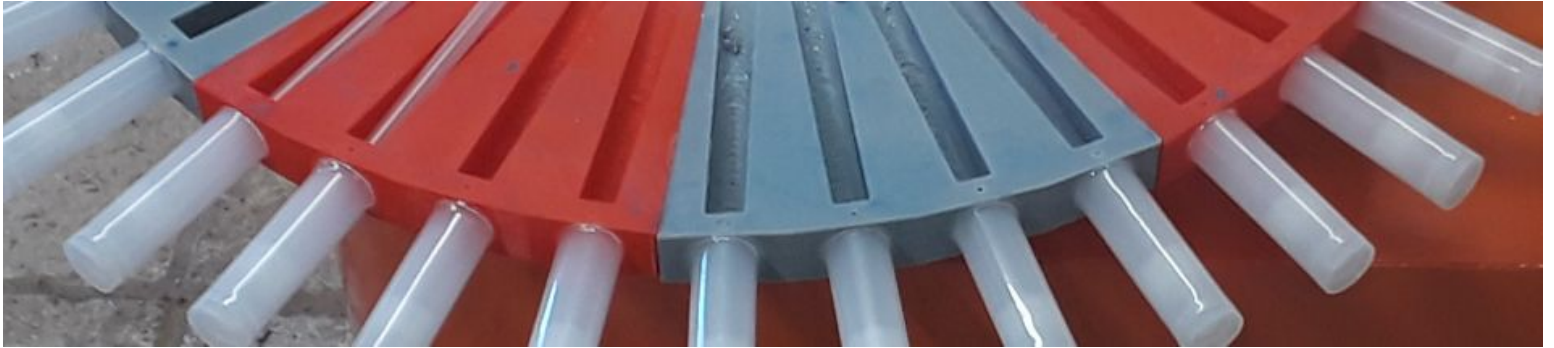
## **GREEN MACHINE ONLY EMPTY STRAWS:**

- ◆ Environmentally Friendly Straws from Eco-Products
  - [https://www.ecoproductsstore.com/7\\_75in\\_clr\\_straw\\_unwrapped.html](https://www.ecoproductsstore.com/7_75in_clr_straw_unwrapped.html)
- ◆ Also Available from [AnthonysBeehive.shop](http://AnthonysBeehive.shop)



## ADJUSTABLE LENGTH

If you want to make shorter straws, you will need to turn the end of each tube **CLOCKWISE**, so that they are all the same. Next, **CUT** the straws to the new length. If they are not cut to the desired length, then they will protrude inside the hub and won't fill,



## CLEANING STRAWS

*No matter how skilled you become at using the machine, there will be some stickiness, especially with honey. We have found that warm water does a great job. Place the finished straws in a perforated basket of some kind and run under warm water. Spread them out afterwards on paper towels and they will air dry quickly. **Hint for the Bold: Try a dishwasher without any soap or other additives.***





There are 2 ways to clean the machine. Necessary *when switching flavors, or when it has sat too long and and is full of cold sticky honey.* Method A is quicker and easier, but you must be **VERY CAREFUL** not to damage the plastic pieces by over-tightening the screws

## **CLEANING the MACHINE - Method A**

### **(This is the Preferred Method)**

#### **DESIGNED TO BE QUICK AND EASY TO CLEAN!**

Models shipped AFTER 1/15/20 are no longer glued. That means you can remove the ring (10 screws) and the HUB (4 screws). Use a ¼ inch nut driver. Take the entire ring to the sink to clean. If you cannot get the tubes clean by spraying warm water, then turn the tubes in, forcing any honey or product out. **MAKE SURE TO RETURN THE TUBES BACK TO THEIR FULL LENGTH** before attempting to make more straws, You can also remove and clean the center hub.

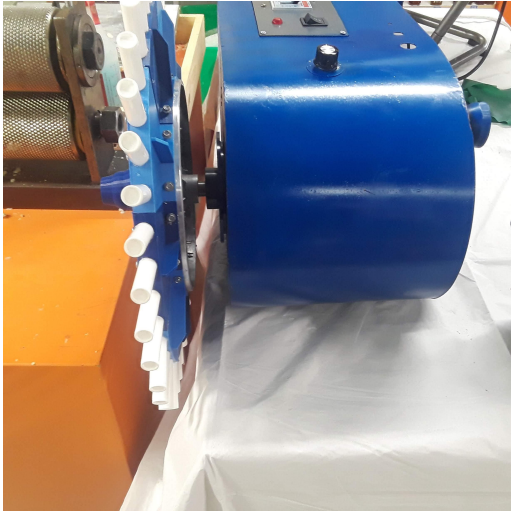
When replacing the parts after cleaning, simply line up with the holes and put the screws back in,

- DO NOT OVER-TIGHTEN!
- RE-INSTALL SCREWS IN AN ALTERNATING, NOT ADJACENT SEQUENCE.

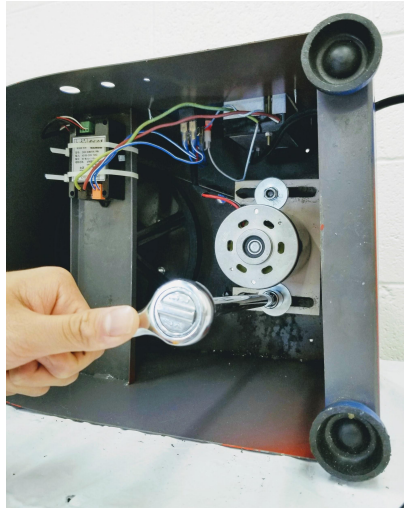


# CLEANING the MACHINE - Method B

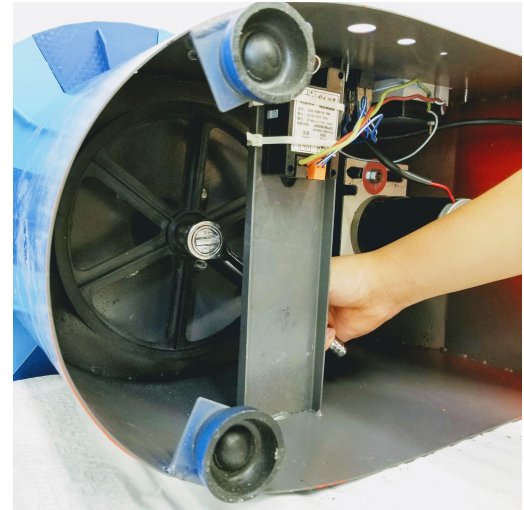
*Remove the entire wheel intact.*



Lie the machine on its side, AVOIDING ANY PRESSURE ON THE TUBES. We suggest using the edge of a table as a way to protect the tubes.



LOOSEN the nuts that hold the motor and the belt, then slide the motor forward to loosen the belt. Remove the belt, but NOT the motor.



REMOVE the nut that holds the pulley, then remove the pulley. Keep track of which side was up!



Now you can easily remove the entire assembly and carefully take it to the sink.



Wash under warm running water.

# Honey Straw Recipes

- Nothing beats a honey straw filled with pure, local honey – but it's still great fun to **experiment** with different flavors (and increase sales). Here are some guidelines. It's a lot of fun to experiment and create your own flavors, colors, and names.
- **EXPERIMENT to get the flavors and colors you like best!**
  - Strawberry, Blue Coconut, Mango, Almond, Vanilla, Cherry, etc....
    - Add one ounce pure **extract** and 20 drops of food coloring per QUART of honey
    - A QUART makes about 200 straws
  - Citrus Flavors – use OIL (it's all natural). About 5 ml per quart.
  - Cinnamon
    - Add 3 ml cinnamon oil per quart of honey
  - Mint
    - Add 8 ml of mint extract per quart of honey
- CITRIC ACID can be added in small amounts to create a sour flavor. Experiment starting at about ½ teaspoon per quart.
- Extracts and oils can usually be purchased at your local grocery store
- Coloring
  - FDA food colorings work well and last great. Experiment to get the shades you like best
  - **NATURAL COLORINGS** – these are a great selling point, but are a little trickier, especially as far as shelf life and heating are concerned.
    - RED – use BEET JUICE. Does a nice job, but tends to dissipate with heat. Start at about 1 tablespoon per quart. Work at as low of a temperature as possible and don't add until the last possible moment. Never reheat.
    - YELLOW - use TURMERIC. Boil in water first and then strain out the extra powder. Try ¼ cup ground turmeric and ¼ cup water. Add about ½ of the strained liquid and experiment from there.
- When making flavored and colored sticks, follow these steps
  - Heat the Honey FIRST
  - Add ½ of your ingredients, then stir with an empty straw
  - Dip the straw in the honey, place your thumb over the open end, and remove to sample. This will show you the resulting color IN the straw.
    - Add more flavoring from this point as needed

# Included:

Machine Base & Motor  
Outer Ring with Tubes  
Hub

Bag with 14 Screws

Instruction Sheet

2500 Straws

Basic Impulse Sealer

Large Straw Holder w/Stop

Small Straw Holder - w/o Stop

## **Bonus - Deluxe Model**

Perforated Baskets (3)

Baby Nose Aspirator

¼ inch Nutdriver

Both Hub Styles

Extra Ring

Superior Sealer USA Made

# Warranty:

90 days on all plastic parts

30 days on electric parts (sealer and motor)



# ACCESS THE INSTRUCTIONS ONLINE

Go to: <https://anthonyshive.com/honey-stick-machine>

And Scroll to the **BOTTOM OF THE PAGE** (see below)

NEW IMPROVED MODEL DEVELOPED IN RESPONSE TO COPYCATS!

## HONEY <sup>Butter</sup> <sup>Thin</sup> STRAW FILLER

**NEW & IMPROVED**

**PRICE—\$699  
ON SALE FOR  
\$599**

Pay \$300 deposit  
(the balance is due  
When ready to ship)  
(approx. 14-21 days)

**FREE  
Shipping  
(limited time)**

**Patent Pending**

From the Original Inventor, Anthony's Beehive

— CLICK HERE TO LEARN MORE ABOUT THE RECENT IMPROVEMENTS (INCLUDING OUR VIDEO) —

SEE OUR MACHINE IN ACTION!

ORIGINALLY Invented and Manufactured by Anthony's Beehive

Anthony's Beehive Honey Stick Filling Machine NEW & IMPROVED

**STEP 5:  
REMOVE  
THE  
FILLED  
STRAWS**

MORE IN

**Helpful Link:**

[Instruction Manual for New Machine](#)

Are your customers raving about you on social media? Show their great reviews to help turn potential customers into loyal ones.

# Important Note:

Our Straw Supplier (Sam's Club online) has been out of stock on unwrapped straws. We don't know if this is COVID-19 related. In order to keep shipping, we have substituted a box of 3000 WRAPPED straws instead of the standard 2500 Un-Wrapped. Meanwhile, you can watch Sam's website and try to order your own at:

[https://www.samsclub.com/sams/jumbo-unwrapped-straws-2500-ct/155875.ip?xid=plp\\_product\\_1\\_6](https://www.samsclub.com/sams/jumbo-unwrapped-straws-2500-ct/155875.ip?xid=plp_product_1_6)

The 7 <sup>3</sup>/<sub>4</sub>" Jumbo Translucent Wrapped straws are carried in stock at Sam's, but you have to remove the wrapper. See Below:

