

Tunnel 3 Operating Procedure

Efficiently and safely operating the [REDACTED] tunnel

The [REDACTED] tunnel is the only tunnel currently (as of 2019-03-27) without a connection to the rail system. It must manually be loaded using the computer, dumper, and incline conveyor belt.

Safety Warnings

Every person operating the tunnel 3 system must be aware of and understand these dangers, to make sure everyone is safe and unharmed.

1. **Beware of the dumper**, as it is powerful enough to crush someone to death



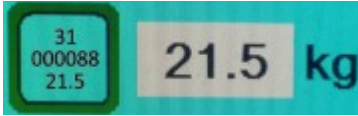
2. **Avoid standing/walking on the incline conveyor belt**, as you may fall off or into the tunnel



3. **Keep your fingers safe, when moving bins**, because bumping is very common

Operating Procedure

1. **Before dumping any linen**, make sure to *ask the supervisor/lead hand* if the customer is OK
2. **Before dumping any linen**, make sure the *category and customer* data is correct



3. **While loading/dumping linen**, prepare 1-2 empty bins, and fill them about halfway with linen, to balance the weights, before continuing
 - This minimizes time wasted from hand-dumping underweight loads or hand-removing overweight loads, and frees up your time to do other tasks

- **Alternate between loads.** After dumping 2-3 pairs of dryer loads (terries, robes, pillowcases, etc), dump 2-3 pairs of bypass loads (sheets), and repeat

- This ensures the dryers are utilized, while also preventing loads from getting stuck waiting for dryers

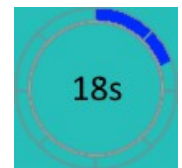
- **Load linen in pairs (groups of 2).** Doing this makes sure linen can be grouped together on conveyor belts, and in dryers and clean side bags for storage.



Pairs of linen loads

4. **Once linen starts falling into the tunnel**, after the tunnel cycle time (blue ring timer) reaches 18s or more, start the dumper for the next bin

- The belt cycle stops at tunnel cycle time of 30s
- The conveyor needs 5s to reset the weight scale
- The dumper takes 18-22s to dump all linen onto the belt
- Therefore, the perfect cycle time to start the dumper is $30s + 5s - 18s = 17s$ (+1s to be safe)



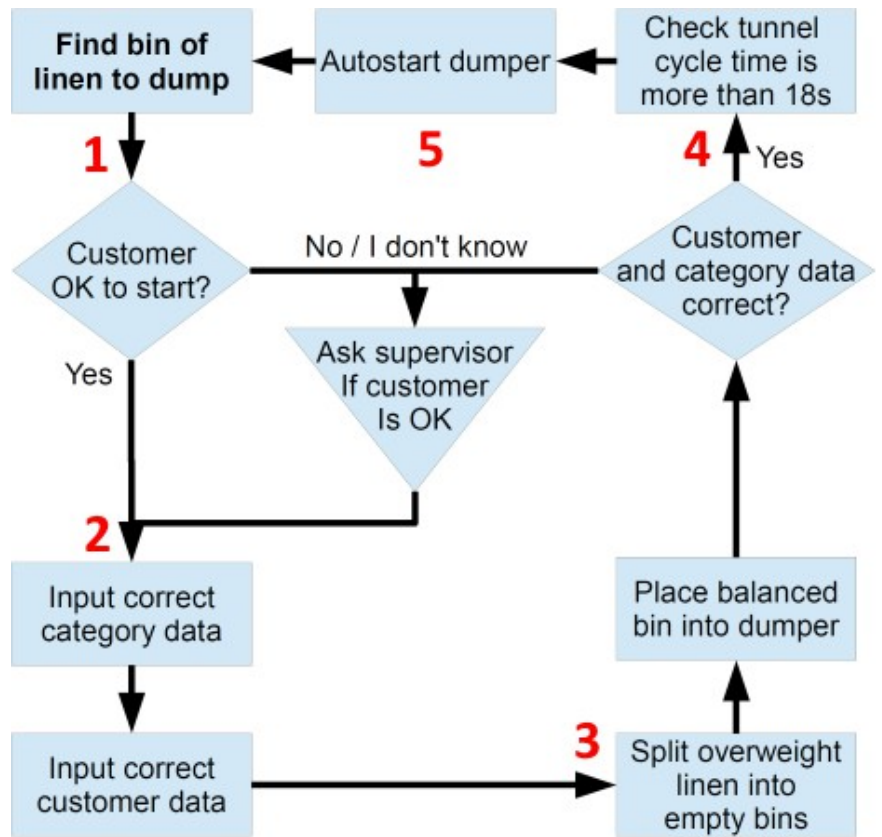
Tunnel cycle time

5. **Balance the next load of linen, while dumper is running**, to maximize efficiency, and make sure the next balanced bin is inside the dumper, ready to go



Balanced loads

6. **Repeat from step 1**, until all customers are finished



The goal is to prepare balanced loads before the next tunnel cycle, to prevent the tunnel from waiting, and maximize production efficiency.

Machine Faults and Problems

Below is a list of common faults and how to fix them. If you're not sure how to proceed, ask someone familiar with the system for help.

Fault	Description	Fix
No loading bag above hopper	Belt is empty; no linen ready to load into tunnel	Prepare linen to load into tunnel
Press not ready for loading	<ol style="list-style-type: none"> 1. Check the press fault by clicking "<i>machine selection > CB1</i>" and reading the fault text at the bottom 2. Go around to the press 3. Ensure press is on 4. Check for cake stuck on press conveyor belt 5. Hold "<i>unl. push plate forward</i>" button until cake moves out <ul style="list-style-type: none"> • If cake doesn't move, check bottom of screen for "<i>basket top not reached</i>" fault • Hold "<i>basket up</i>" button, until basket reaches top • Hold "<i>unl. push plate forward</i>" button until cake moves out 6. Hold "<i>basket down</i>" button until basket hits bottom 7. Stop (lit red button), then start (unlit green button) press 	