

Procedure for Cleaning the Pastillator

Scope: The Four Pastillators at Koster Kuenen

Purpose: To cover the process each Pastillator is cleaned after running a batch of wax

Procedure

Pastillator #1 Cleaning

1. Remove all tools from the pastillating room.
2. Only use plastic scrapers when cleaning the Pastillator.
3. Clean the belt of all wax.
4. Clean and vacuum:
 - a. End of Belt
 - b. Side Rails
 - c. Pastillator Chute
5. Scrape and sweep all wax off the floor of the Pastillator room.
6. Clean all trays, buckets, and waste baskets of previous batch of wax.
7. Remove and completely clean the screen by the Rotoformer
8. Replace the screen and tighten the cover.
9. Place a box labeled “Blowdown” under the chute to collect all wax.
10. Clean as needed:
 - a. Wipers on the reefed bar
 - b. Release pan (Refer to Procedure 709 Pastillator Pan Cleaning)
11. Remove all full/partial bags or boxes of wax from prior batches from the pastillating area.
12. Return any remaining labels from prior batches.
13. Spray all product contact and surrounding areas with an even coating of sanitizer.
14. Allow the sanitizer to dry through evaporation.
 - a. Do NOT recontamination by touching with hands, gloves, packaging, tools, or clothes until dry and ready for production.
15. Have a supervisor inspect the area and sign the batch card is clean-up is complete.

Pastillator #2 Cleaning

1. Remove all tools from the pastillating room.
2. Only use plastic scrapers when cleaning the Pastillator.
3. Clean the belt of all wax.
4. Clean and vacuum:
 - a. End of Belt
 - b. Pin Breaker Hood
 - c. Side Rails
5. Scrape and sweep all wax off the floor of the Pastillator room.

Procedure for Cleaning the Pastillator

6. Clean:
 - a. Cyclone Ductwork
 - b. Hopper Bagging Station
 - c. Trays, Buckets, and Waste Buckets
7. Remove and completely clean the screen by the Rotoformer
8. Replace the screen and tighten the cover
9. Clean the hopper bag by removing and shaking out all wax particles.
10. Place a box labeled “Blowdown” under the hopper to collect all wax from the bagging unit.
11. Completely clean the bagging unit and vacuum all the wax from the previous batch.
12. Remove drums from bagging unit and dispose of wax.
13. Clean as needed:
 - a. Take apart lower blower lines and inspect for wax build up
 - b. Inspect higher blower lines for wax build up with flashlights
 - c. Move the bottom of the hopper bag and inspect chute for wax
 - d. Wipers on reefed bars
 - e. Release spray tank
14. Scrape and clean excess wax from interior hopper feed.
15. Ensure venturi bowl at the release end of the machine is clean and free of wax.
16. Remove all full/partial bags or boxes of wax from prior batches from the pastillating and bagging area.
17. Replace all scrapers and tools in the holder by:
 - a. End of Pastillator
 - b. Rotoformer
18. Return any remaining labels from prior batches
19. Spray all product contact and surrounding areas with an even coating of sanitizer.
20. Allow the sanitizer to dry through evaporation.
 - a. Do NOT recontamination by touching with hands, gloves, packaging, tools, or clothes until dry and ready for production.
21. Have a supervisor inspect the area and sign the batch card is clean-up is complete.

Pastillator #3 and #4 Cleaning

1. Remove all tools from the pastillating room.
2. Only use plastic scrapers when cleaning the Pastillator.
3. Clean the belt of all wax.
4. Clean and vacuum:
 - a. End of Belt
 - b. Side Rails

Procedure for Cleaning the Pastillator

5. Scrape and sweep all wax off the floor of the Pastillator room.
6. Completely clean around the bagging unit.
7. Clean all trays, buckets, and waste baskets of previous batch of wax.
8. Remove and completely clean the screen by the Rotoformer
9. Replace the screen and tighten the cover.
10. Place a box labeled “Blowdown” under the hopper to collect all wax.
11. Completely clean the bagging unit.
12. Vacuum all prior wax from the unit.
13. Clean as necessary:
 - a. Wipers on the feed bar
 - b. Release Pan (Refer to Procedure 709 Pastillator Pan Cleaning)
14. Remove all full/partial bags or boxes of wax from prior batches from the pastillating area
15. Return any remaining labels from prior batches.
16. Spray all product contact and surrounding areas with an even coating of sanitizer.
17. Allow the sanitizer to dry through evaporation.
 - a. Do NOT recontamination by touching with hands, gloves, packaging, tools, or clothes until dry and ready for production.
18. Have a supervisor inspect the area and sign the batch card is clean-up is complete.