GRAINPRO® TRANSAFELINER™

INSTRUCTION MANUAL

(Magnet Method)

MA4079RAD1219-00

GRAINPRO
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1. PREPARATION

1.1. PREPARATION

1.1.1. Check the moisture content of the commodity using GrainPro Moisture Meter (MM5) (available for sale from GrainPro, Inc.) to ensure the MC is at a safe level for storage.

Recommended Moisture Content:
Coffee – 11.5-12%
Cocoa – 6-7%
Rice – 13-14%

1.1.2. Workers should not wear shoes with spikes that might cause damage to the TSL.

1.1.3. Ensure that container floor is free of any sharp objects that may damage the liner.

1.1.4. Place a mat or thick cardboard on the floor as additional protection for the TSL.

1.1.5. Place the TSL box at the back end of the container.

1.1.6. Pull the top portion to unfold the TSL, make sure that the GP logo is facing up for proper orientation.

2. INSTALLATION USING MAGNET METHOD

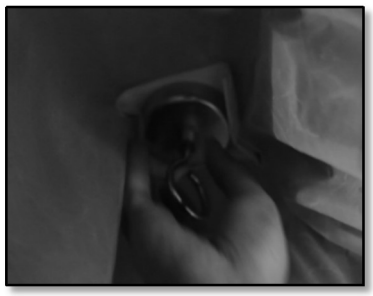
2.1. INSTALLATION PROCESS

2.1.1. Use magnets with at least 50kg lifting capacity. The magnets must be procured locally.

2.1.2. With the magnet method, the installation of magnets are done inside and from the back towards the container door. At least 2 persons are needed for ease of installing the TSL. Prior to installation of TSL, the location of the broken lines needs to be determined first.

2.1.3. The first magnet is placed 125cm from the end and inside of the TSL. Then attach the TSL and magnet to the corner at the back of the container.

NOTE: *Magnets usually have sharp edges and may cause the liner to shear when in direct contact. Ensure that magnets are covered or wrapped with soft fabric/plastic sheets to prevent liner from tearing.*



2.1.4. The second magnet is attached on the same side and about one meter from the first one.

2.1.5. Do procedures 2.1.2. to 2.1.3. to the opposite side. Installation is done by twos and alternating (left to right/right to left side) fashion to give workers easier movement inside the TSL.

2.1.6. Succeeding magnets are positioned 100cm from each other and alternately on opposite sides until the end of the container is reached. As standard procedure, use 12 magnets for 20 ft container and 24 magnets for 40 ft container.

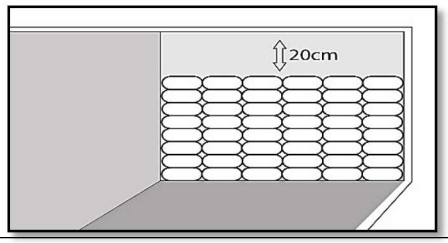
2.1.7. Secure excess liner material near the door perimeter by folding and sticking it on the sides of the door using tapes to prevent possible damage and to make it more accessible during loading.

2.1.8. Place card boards on the TSL floor and along the walls for added protection;

2.1.8.1. **For Manual Loading** - workers should not wear shoes with spikes that might cause damage to the liner.

2.1.9. The magnets are removed as the container is loaded. Remove the magnets on the sections of the container that is already loaded.

2.1.10. When stacking bags make sure to leave at least 20cm distance between the roof of the container and top of the stacks to prevent condensation.



3. SEALING

3.1. USE OF DESICCANTS/DRY BAGS (REQUIRED)

Desiccants are commonly used to protect goods against moisture damage. Hygroscopic commodities, such as cocoa, coffee, and various nuts and grains are particularly susceptible to mold and rot when exposed to condensation and humidity.

3.1.1. Requirement:
   a. One-thousand two-hundred (1200) grams or 6 bags of GrainPro Dry Bags per 20-footer.
   b. Two-thousand four-hundred (2400) grams or 12 bags of GrainPro Dry Bags per 40-footer.

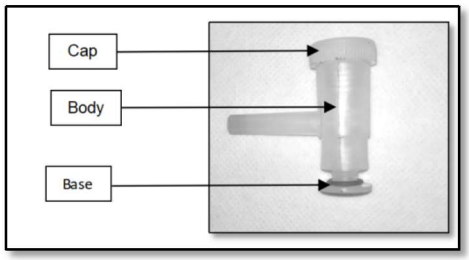
Note: 1 GrainPro Dry Bag contains 200 grams of calcium chloride and can absorb grams of moisture.

3.1.2. Place the GrainPro Dry Bags in perforated bags or sacks to prevent direct contact with commodity.
3.1.3. Cardboards/cartons may be placed on top of the stack (Cardboards/cartons provide increased water absorption. Then put the desiccants on top of the cardboards/cartons.

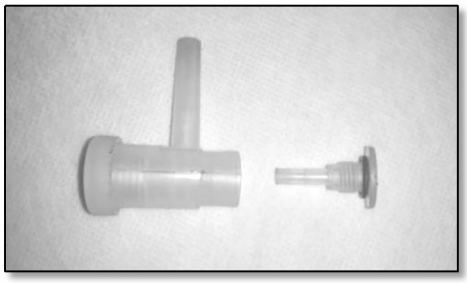
3.2. PLASTIC VALVE INSTALLATION FOR PRESSURE DECAY TEST (PDT), CO_2 OR O_2 READING

Install plastic valve before sealing or zipping the liner. Conduct PDT after sealing. CO_2 or O_2 reading (optional) is taken upon arrival of the container to verify the integrity of the TSL's hermeticity. After use, close the plastic valve.

3.2.1. Plastic valve components:
   A. Cap – To open and close the valve
   B. Body – Where tube or hose is inserted for Pressure Decay Test (PDT) and CO_2 or O_2 reading
   C. Base – Use for piercing the liner

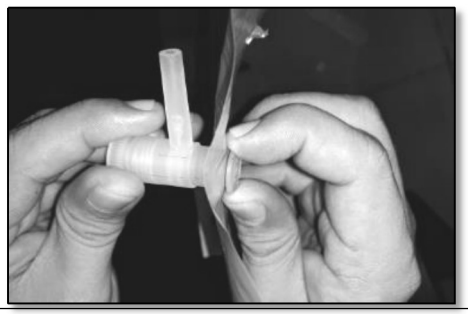


3.2.2. Dismantle the plastic valve by unscrewing the base.



3.2.3. Pierce the TSL using the plastic valve. Piercing is done from the inner side of the TSL (approximately 20 cm from the zipper).

3.2.4. Screw the plastic valve body. The cap of the plastic valve should be positioned outside the loaded TSL. Firmly tightened the body into the base to prevent leakage.



3.3. SEALING OF 2-TRACK PE ZIPPER

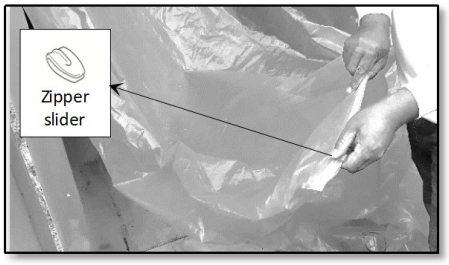
3.3.1. After loading, remove the remaining magnets near the container door.

3.3.2. Remove the tapes and unfold the excess liner from the door perimeter and let it loose.

3.3.3. Hold the 2-track zippers together. Aligned for proper sealing.

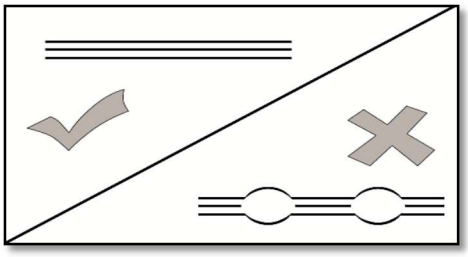
3.3.4. Manually zip a few centimeters on the end of the zipper enough to initially engage the slider.

3.3.5. Position the slider on the manually zipped portion of the zip lock.



3.3.6. For ease of zipping, two are persons required, one person does the zipping and the other person holds the other end steadily, making sure both sections of the zipper are in a straight line to avoid the zipper length being misaligned. Moving the slider while the zipper or slider is curved forces one of the zipper sections to elongate.

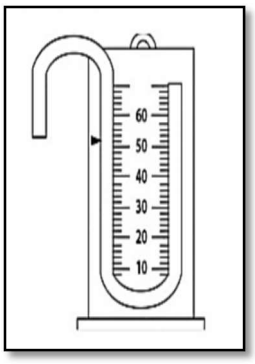
3.3.7. If uneven zipper ends are observed, slightly stretched and redo the zipping from end to end.



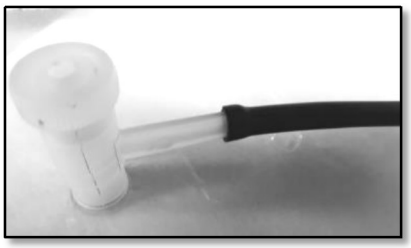
3.3.8. Fold extra liner and tape it against the stack. Ensure that no liner is stuck in-between doors.

3.4. PRESSURE DECAY (VACUUM) TEST

3.4.1. After zipping, perform a pressure (vacuum) decay test (PDT) to ensure gas-tightness. With this test a manometer, vacuum pump and stopwatch are needed. A digital manometer of a commercially available or improvised U-tube manometer can be used to monitor the pressure.

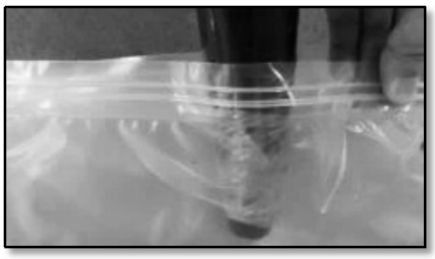


3.4.2. Connect the manometer hose to the plastic valve previously installed in the TSL.



3.4.3. Twist the plastic valve cap to open.

3.4.4. Using a vacuum pump with at least 2.3 cubic meters of suction capacity per minute. Create at least -250 Pascals (Pa) or -25 millimeters' water (mm H_2O) vacuum inside the TSL by partially opening a portion of the zipper and insert the vacuum pump suction port.



3.4.5. For TSL to be considered sufficiently airtight, the initial vacuum should not be decreased by more than one-half (½) of the final vacuum (created by the vacuum pump) within five (5) minutes.

3.4.6. If the PDT test failed, check for holes/tears and poorly sealed zippers then repeat the PDT procedures.

3.4.7. After conducting PDT, twist the plastic valve closed.

3.5. INSTALLING THE FLEXIBLE ADAPTER HOSE FOR CO_2 OR O_2 READING

To ensure gas-tightness, instead of PDT as an alternative the container with TSL can be checked using the CO_2 analyzer or O_2 analyzer.

3.5.1. The flexible adapter hose is included in the GrainPro Carbon Dioxide Analyzer or the user can find equivalent flexible hose from local hardware using the specifications as shown:

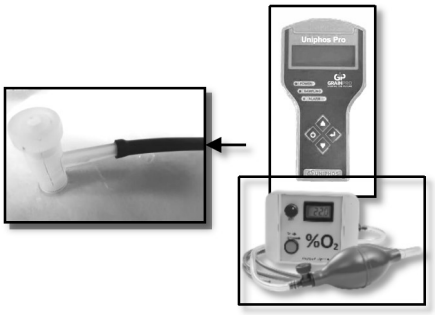
Inside Diameter	4 mm (0.16 in.)
Length	>5 cm (2 in.)

3.5.2. When taking the carbon dioxide or oxygen reading, connect the flexible adapter hose to the plastic valve.

3.5.3. Twist the plastic valve cap to open.

3.5.4. Connect the O_2 or CO_2 analyzer to the flexible adapter hose and the reading. Take readings of CO_2 and O_2 using the available analyzer.

Acceptable Values:
For O_2 analyzer, 3% or below after 15 to 30 days.
For CO_2 analyzer, 10 to 15% after 15 to 30 days.



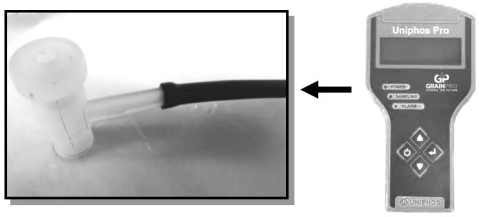
3.5.5. After taking the oxygen or carbon dioxide reading, twist the plastic valve cap to close.

3.6. USING CARBON DIOXIDE ANALYZER FOR MONITORING (WITHOUT CO_2 FLUSHING) - OPTIONAL

The GrainPro CO_2 analyzer uses a non-dispersive infrared radiation (NDIR) sensor for the detection of carbon dioxide. When a sensor encounters a target gas, voltage signal is generated in proportion to the gas concentration. This voltage signal is amplified, digitized and displayed on the instrument's OLED display.

3.6.1. When taking the carbon dioxide reading, connect the flexible adapter hose into the plastic valve.

3.6.2. Using the analyzer, carbon dioxide level can be checked through the plastic valve with flexible adapter hose before unloading. Increased carbon dioxide level indicates absence of any source of leaks from punctures, holes or damages. CO_2 level of ambient air is 0.04%.



3.6.3. Monitoring of carbon dioxide level is recommended to ensure control of insect infestation. Details of using CO_2 analyzer are discussed in the analyzer's instruction manual.

4. CARBON DIOXIDE PURGING

4.1. CARBON DIOXIDE (CO_2) SAFETY

4.1.1. Carbon dioxide does not support life. It can act as a simple asphyxiant by diluting the concentration of oxygen in air below the levels necessary to support life. As it is heavier than air it will tend to concentrate at lower levels.

4.1.2. Avoid breathing gas. Do not get in eyes, on skin, or on clothing. Wear leather safety gloves and

safety shoes when handling cylinders.

4.1.3. Protect cylinders from physical damage. Do not drag, roll, slide or drop. While moving cylinder, always keep the removable valve cover in place. Never attempt to lift a cylinder by its cap; the cap is intended solely to protect the valve. When moving cylinders, even for short distances, use a cart (trolley, hand truck, etc.) designed to transport cylinders.

4.1.4. Never insert an object (e.g., wrench, screwdriver, and pry bar) into cap openings; doing so may damage the valve and cause a leak. Use an adjustable strap wrench to remove over-tight or rusted caps. Slowly open the valve. If the valve is hard to open, discontinue use and contact your supplier.

4.1.5. Close the cylinder valve after each use; keep closed even when empty.

4.1.6. Never apply flame or localized heat directly to any part of the cylinder. High temperatures may damage the cylinder and could cause the pressure relief device to fail.

4.2. CALCULATION OF CARBON DIOXIDE REQUIREMENT

4.2.1. Carbon dioxide requirement formula:

a. Total Volume – Volume Occupied by the Commodity.

b. For every 2.0 kg CO_2, 1 cubic meter of air is replaced.

c. Formula: (1 minus bulk density) x Volume (in m^3) x 2

Recommendations:

- If commodity temperature is at 15 deg Celsius or below, there is no need for TSL.
- If commodity temperature is 15-20 deg Celsius, use TSL without carbon dioxide flushing but fumigation should be conducted upon arrival.
- If commodity temperature is above 20 deg Celsius, use TSL with carbon dioxide flushing.

CARBON DIOXIDE REQUIREMENT BASED ON COMMODITY

COMMODITY	BULK DENSITY MT/m^3	AMOUNT OF CARBON DIOXIDE (CO_2) FOR PURGING, kg		
		TSL 20	TSL 40	TSL 40 High Cube
		33	66	76
Barley	0.62	25.1	50.2	57.9
Cashew nuts	0.50	33.0	66.0	76.2
Chia seeds	0.68	21.1	42.2	48.8
Chickpeas	0.74	17.2	34.3	39.6
Cocoa beans	0.56	29.0	58.1	67.1
Coffee beans	0.59	27.1	54.1	62.5
Cotton seed	0.40	39.6	79.2	91.4
Cowpea	0.75	16.5	33.0	38.1
Maize	0.72	18.5	37.0	42.7
Millet	0.63	24.4	48.8	56.4
Mung bean	0.75	16.5	33.0	38.1
Oats	0.43	37.6	75.2	86.9
Paddy	0.60	26.4	52.8	61.0
Paddy, rice bran	0.55	29.7	59.4	68.6
Peanuts, shelled	0.64	23.8	47.5	54.9
Rice, milled	0.80	13.2	26.4	30.5
Rye	0.72	18.5	37.0	42.7
Sesame	0.59	27.1	54.1	62.5
Sorghum	0.72	18.5	37.0	42.7
Soybean	0.75	16.5	33.0	38.1
Sunflower	0.41	38.9	77.9	89.9
Wheat	0.77	15.2	30.4	35.1

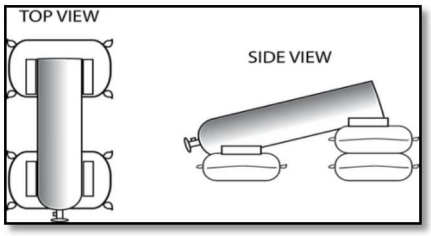
Coffee beans	0.59	27.1	54.1	62.5
Cotton seed	0.40	39.6	79.2	91.4
Cowpea	0.75	16.5	33.0	38.1
Maize	0.72	18.5	37.0	42.7
Millet	0.63	24.4	48.8	56.4
Mung bean	0.75	16.5	33.0	38.1
Oats	0.43	37.6	75.2	86.9
Paddy	0.60	26.4	52.8	61.0
Paddy, rice bran	0.55	29.7	59.4	68.6
Peanuts, shelled	0.64	23.8	47.5	54.9
Rice, milled	0.80	13.2	26.4	30.5
Rye	0.72	18.5	37.0	42.7
Sesame	0.59	27.1	54.1	62.5
Sorghum	0.72	18.5	37.0	42.7
Soybean	0.75	16.5	33.0	38.1
Sunflower	0.41	38.9	77.9	89.9
Wheat	0.77	15.2	30.4	35.1

4.3. PROCEDURE FOR PURGING WITH CARBON DIOXIDE (CO_2)

4.3.1. Make sure that enough CO_2 is available on site. The weight of the CO_2 in the cylinder is supplied by the industrial companies (i.e. 22kg standard capacities which may be used to calculate the number of cylinders required). CO_2 cylinders are available with or without siphon (dip tube). For rapid flushing, the cylinder without siphon should be inverted.

4.3.2. For rapid flushing, the cylinder should be inverted using mechanical inverter. However, the cylinders with siphon should be in upright position during flushing.

4.3.3. If a mechanical inverter is not available, a makeshift inverter can be made using sandbags or other improvised technique. The cylinder should be inverted with its top resting on one sandbag and the bottom end resting on pile of two or three sandbags high.



4.3.4. A standard high-pressure hose (available only as separate item) should be connected to the cylinder. This hose should be guaranteed to withstand a pressure of 88 atmospheres (1,300 psi, or 92 kg/cm^2). Ensure that all connections are made properly, and gaskets are in place where they are required. The high-pressure hose should have a length of about 2-meter and have matching coupler at cylinder.

4.3.5. Open a section of the zipper and insert the pressure kit. This serves as outlet to discharge O_2 when flushing.

4.3.6. Open the cylinder valve. Adjust opening of the valve until sound of liquid passing through the hose is heard. The liquid CO_2 flushes into the TSL and evaporates inside, it pushes the air upward, acting as a piston, until the air is totally replaced. The opening through the zipper serve as an outlet for the displaced air.

4.3.7. Ice formation along the pressurized hose and the pipe connector during CO_2 flushing:

4.3.7.1. During this procedure, some ice may form around the gas inlet and high-pressure hose.

4.3.7.2. Flushing (emptying of the cylinder) depends on the amount of CO_2 to be applied. Emptying one 22kg cylinder should only take about 20 to 30 minutes. If the pressure hose or the inlet valve gets blocked with ice, this is an indication that the CO_2 is being released too quickly. If this happens the cylinder should be closed until the ice melts, and then the cylinder valve should be re-opened and adjusted to reduce the flow.

4.3.7.3. An additional indication that the gas is being released too quickly is when the liner begins to balloon out because pressure begins to build-up inside. If this happens, the gas flow should be decreased at the cylinder valve until the rate of air being expelled through the outlet port is about the same as the rate of CO_2 entering the liner.

4.3.7.4. If necessary, for small scale applications and the cylinder is not inverted, weighing scales may be used to control the weight of the gas delivered. In this case the gas is released slowly through a pressure gauge which can be adjusted to control the flowrate.

4.3.8. Since CO_2 is heavier than air, the air in the TSL displaces upwards and is lifted out of the container through the outlet port. Complete displacement is not possible as there is always some mixing at the interface between the air and the CO_2. However, if the final CO_2 concentration reaches 80% then the O_2 concentration in the remaining air amounts to 4%. This mixing of the CO_2 with the remaining air, and absorption of CO_2 by the commodity, takes 12-24 hours depending on temperature. This is the time to determine the initial concentration of CO_2.

4.3.9. After the required weight of CO_2 has been flushed, immediately:

4.3.9.1. Close the CO_2 cylinder valve.

4.3.9.2. Close the zipper thoroughly using the slider.

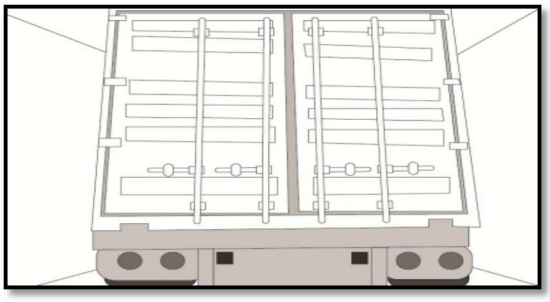
4.3.10. For controlling stored-product insects, maintaining CO_2 above 50% for 10 days, or CO_2 above 35% for 15 days is sufficient to provide complete control, after which the liner may be opened. In addition, temperature accelerates treatment. Effective insect control may be achieved in as little as three days at 25° and less at higher temperatures.

4.3.11. Although CO_2 is not toxic, it is an asphyxiant. It is advisable to unzip the TSL and wait until most of the CO_2 has dispersed.

4.4. CLOSING AND OPENING OF THE SHIPPING CONTAINER

4.4.1. Close the shipping container carefully and be sure not to pinch/squeeze the excess liner material between the container doors.

4.4.1. Care should be taken when opening the shipping container considering shifting of loads while on transit. It is advised to open one side of the door first to check the loads.



5. MAINTENANCE AND CARE

5.1. REPAIRING PUNCTURES AND OTHER DAMAGES

5.1.1. Use an ordinary 2” wide plastic adhesive tape:
Clean the surface of the damaged area with damp cloth and allow the surface to totally dry before applying the plastic tape.

5.1.2. Protective maintenance:

5.1.2.1. Check the plastic tape occasionally and replace or re-patch if necessary.

6. RECYCLING

6.1. RECYCLING

GrainPro TSL is made of polyethylene with barrier layer.

6.1.1. The products can be delivered to the nearest recycling facilities in the area.

6.1.2. Plastic #4 – LDPE (Low Density Polyethylene) can be recycled into compost bins, paneling, trash can liners and cans, floor tiles, and shipping envelopes.