



**MACROPLASTICS**  
Inventing Fresh Ideas.

# Bin Repair & Foot Replacement Procedures

**MacroBins<sup>®</sup> & ProBin<sup>™</sup> Solids**



## Disclaimer

Before starting any repair work on your MacroBin® or ProBin™ Solid containers, please carefully review the following Bin Repair Procedure Manual. This instructional manual has been written to guide you through the bin repair process so that you may extend the useful life of your Macro Plastics containers. **The bin repair process is recommended only for repairs to the side lip, center foot, side, or fork pokes of your MacroBin or ProBin Solid containers.** Goggles, protective gloves, and other personal safety equipment are required when making repairs and all repairs should be made in strict accordance with the procedures set forth in Bin Repair Procedure Manual.

Please do not attempt to repair cracks or damage to the corner columns of your MacroBin or ProBin Solid containers. **Macro Plastics containers with cracked or damaged corner columns must be immediately retired from service since such containers, or containers with improperly repaired columns, can collapse and create a risk of serious injury to personnel or property if they fall.**

Macro Plastics, Inc. makes no warranty, express or implied, regarding the quality or integrity of any welding repair or other repair performed on Macro Plastics containers. The customer assumes any and all risks of loss or damage to person or property, arising from or connected in any way to repaired Macro Plastics containers and/or continued use of a Macro Plastics container that is not repairable. Further, any repair made to Macro Plastics containers voids any and all Macro Plastics, Inc. warranties as to such repaired containers, regardless of who performs the repair and regardless of the nature, manner and workmanship of the repair.



## **Bin Repair Procedures**

Macro Plastics suggests using these guidelines when repairing cracked or damaged MacroBin and ProBin Solid containers.

- Use this information as a starting point when building your bin repair program.
- Adjust or fine-tune your repair technique to fit your operation's needs as you gain experience.



## **Bin Welding: Voids Warranty**

Macro Plastics has no control over the quality or integrity of any welding repair performed on a Macro Plastics container. Therefore, all Macro Plastics' warranties are void after a bin has been welded.

## **Hot Air Welding Kits: Leister Triac S and AGR 6000**

The procedures within this presentation can be used with both of these welders.



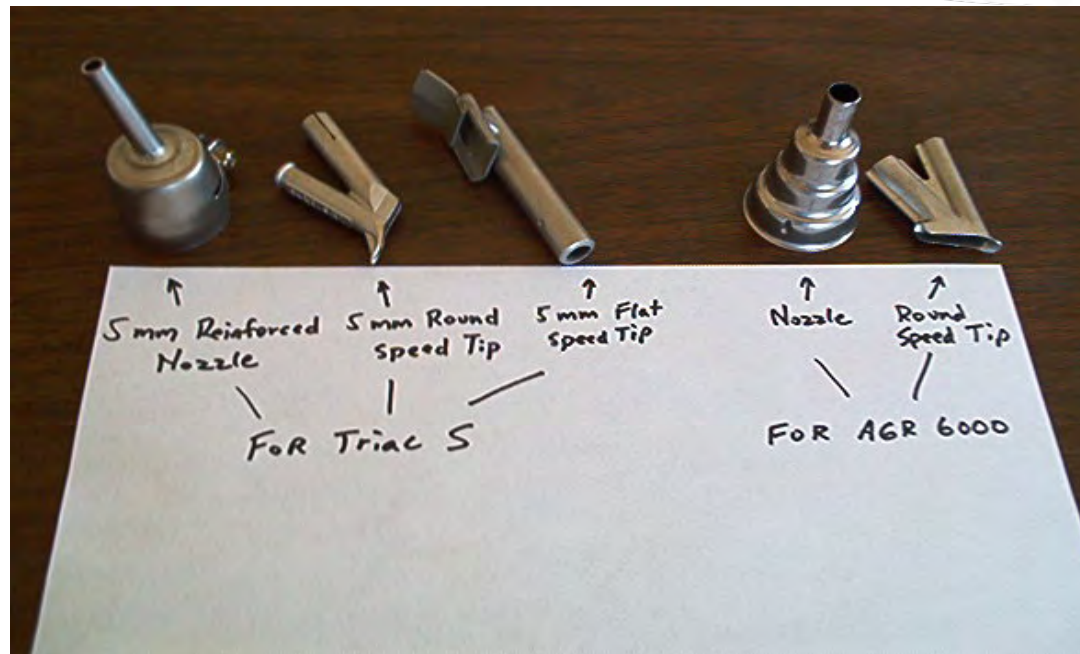
## → **Leister Triac S and AGR 6000**

On/Off and temperature settings for both welders are easy to set and are located at the back of the units. It is very important that both welders are allowed to cool prior to shutting off.



## → Welding Tip Options

Use the same tips when welding either HDPE (high density polyethylene) and PP (poly propylene) materials. Tips that can be used for both the Triac S & AGR 6000 welders are shown below.





## **Welding Ribbon Options**

- We offer welding rods and ribbons made from the identical plastic that our bins are made from, so you can produce the best and longest lasting welds possible.
- Our HDPE and PP welding rods are available in both 3/16" round and 5/8" flat ribbon configurations.



## **Personal Safety Equipment**

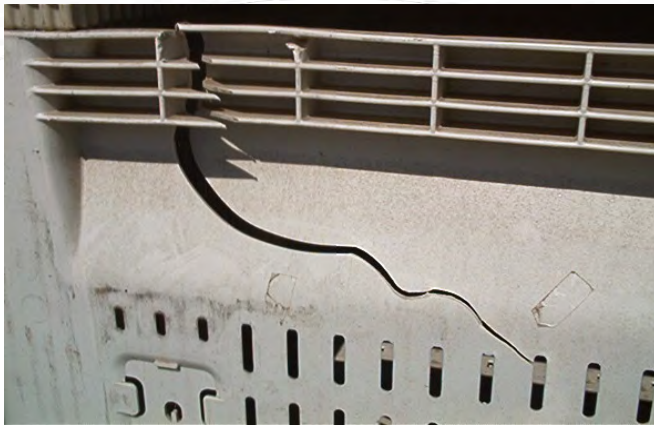
- Wear protective gloves because welder tips are HOT.
- Goggles should be worn when welding or grinding because plastic pieces can be thrown during either operation.
- Ear protection is recommended when grinding.



 **Repairable Side Lip and Center Foot Damage**



 **Repairable Side Damage and Fork Pokes**





## → Non-Repairable Inside and Outside Corner Damage

We do NOT recommend repair of the corner columns. Such repairs may fail and stacked bins could collapse.





 **Non-Repairable Floor Damage**



## **Bin Repair Process**

Step 1: Thoroughly clean bins prior to repair procedures.



## **Route Out the Bin Crack**

Step 2: Drill a hole at the end of the crack using a router tool.

Step 3: Drill out the crack using the router tool to make room for the welding rod.



## The Proper Router Tool

This tool requires pressurized air to operate. A double-fluted 1/8" carbide tip is best for working with Macro Plastics containers.

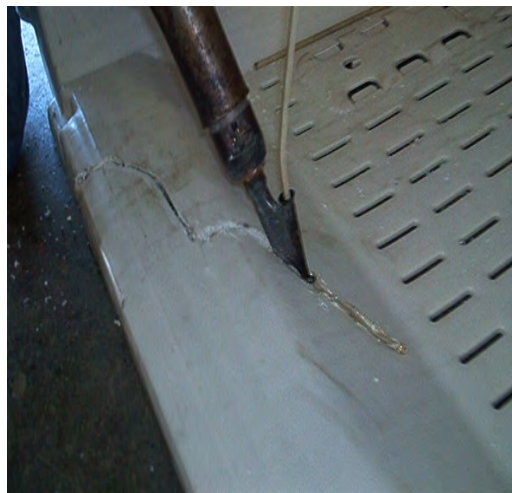




## Weld Using a 3/16" Rod

Step 4: Put the rod through the tip of the welder and place against the crack until the bin begins to melt. Then, push the rod through the tip until the bin and the rod melt together. Draw the gun toward you to fill in the crack, being sure not to move too quickly.

When using the Leister Triac S, start with the temperature set at 6.  
For the AGR 6000, start at 10. Adjust the temperature as needed.



## **Cross Stitch Using 5/8" Ribbon**

Step 5: Using the 5/8" flat tip and flat ribbon rod, cross stitch the weld to add additional strength to the repaired area. (This procedure is optional.)





## **Never Intermix Plastics**

- **HDPE and PP should never be welded together.**
  - PP bins must be welded only with PP rod or ribbon.
  - HDPE bins must be welded only with HDPE rod or ribbon.
  
- **Intermixing materials will cause weld failures.**



## Never Intermix Plastics

MacroBins made of Poly Pro material are marked with **PP**. HDPE bins are not marked. Repair rod and ribbon materials are clearly marked on the packaging.



## Use Grinding Tool

Step 6: After allowing the weld to cool, use a grinding tool to smooth the welded area, both inside and out.



## **Foot Replacement Procedure**

Bin needing foot replacement - foot does not stack safely.



Broken Foot

## → Foot Replacement Procedure For Bin Models 26, 32, and 34.

Step 1: Use a power drill with a 7/8" flat wood bit and drill out the lugs on MacroBins or ProBins with round tabs that hold the feet.



## **Foot Replacement Procedure For Bin Models 26, 32, and 34.**

Step 2: After drilling out the lugs, pry out and remove the feet. Insert new feet into the MacroBin or ProBin.







## Foot Replacement Procedure For Bin Models 12, 14, 24, 44, and 48.

To remove feet on MacroBins or ProBins with square tabs you need at least four thin flat pry bars, and a thicker bar (as shown below).

Step 1: Insert flat bars between the foot and the bin at each tab on one end of the foot and hammer into place.





## Foot Replacement Procedure For Bin Models 12, 14, 24, 44, and 48.

Step 2: Once all of the flat bars are between the tabs and the bin, pound out the foot with the thicker bar until foot separates from the bin.

Step 3: Go to the other end of the foot and repeat the process.



## **Foot Replacement Procedure** **For Bin Models 12, 14, 24, 44, and 48.**

Step 4: Gently pull each foot out of the bin and insert a new replacement foot.





## → Contact Us

We keep a full inventory of welding rods in stock and can give you information on where the welding kits can be purchased. If you have questions or need supplies, contact your local Sales' Representative or call us Monday - Friday, 8:00 am to 5:00 pm PST.

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