Feeding Concepts, Inc. Job #FC-23-20021



Tooling Adjustment Instructions

Rich and Rare Berry Cap



Air Jets Used	**3**
Blade A	Up to fit part
Blade B	Up all the way
Blade C	Up to fit part
Blade D	Down
Blade E	Down
Blade F	Down
Blade G	Down to fit part
Blade H	Out to fit part
Track Blades	Use gauge blocks to set track

Percentages used during testing. These may need to be changed up or down a little bit based on production needs and how long the machine has been running.

Machine Serial Number	**Inline**	**Bowl**	**Hopper**
FC-23-20021-1-CW	38%	35%	40%
FC-23-20021-1-CCW	14%	53.4%	25%
FC-23-20021-2-CW			
FC-23-20021-2-CCW			

Large Crown Cap



Air Jets Used	8
Blade A	Up to fit part
Blade B	Up to catch parts standing up
Blade C	Up to fit part
Blade D	Down
Blade E	Up
Blade F	Down
Blade G	To fit part
Blade H	To fit part
Track Blades	Use gauge blocks to set track

Percentages used during testing. These may need to be changed up or down a little bit based on production needs and how long the machine has been running.

Machine Serial Number	**Inline**	**Bowl**	**Hopper**
FC-23-20021-1-CW	26%	36%	40%
FC-23-20021-1-CCW	17%	55%	25%
FC-23-20021-2-CW			
FC-23-20021-2-CCW			

Small Crown Cap



Air Jets Used	9
Blade A	To fit Part
Blade B	Up
Blade C	Up to fit part
Blade D	Down all the way
Blade E	Down
Blade F	Down
Blade G	Down to fit part
Blade H	Out to fit part
Track Blades	Use gauge blocks to set track

Percentages used during testing. These may need to be changed up or down a little bit based on production needs and how long the machine has been running.

Machine Serial Number	**Inline**	**Bowl**	**Hopper**
FC-23-20021-1-CW	26%	36%	40%
FC-23-20021-1-CCW	17%	25%	25%
FC-23-20021-2-CW			
FC-23-20021-2-CCW			

Small Round Cap





Air Jets Used	4
Blade A	Down to knock off doubles stacked on top of one another
Blade B	Up to catch parts standing up
Blade C	To fit part
Blade D	Down all the way
Blade E	Down
Blade F	Down
Blade G	To fit part
Blade H	To fit part
Track Blades	Use gauge blocks to set track

Percentages used during testing. These may need to be changed up or down a little bit based on production needs and how long the machine has been running.

Machine Serial Number	**Inline**	**Bowl**	**Hopper**
FC-23-20021-1-CW	22%	34%	40%
FC-23-20021-1-CCW	15%	49%	25%
FC-23-20021-2-CW			
FC-23-20021-2-CCW			

Large Round Caps



Air Jets Used	5
Blade A	Down to knock off doubles stacked on top of one another
Blade B	Up to catch parts standing up
Blade C	Up to fit part
Blade D	Down
Blade E	Down
Blade F	Down
Blade G	To fit part
Blade H	To fit part
Track Blades	Use gauge blocks to set track

Percentages used during testing. These may need to be changed up or down a little bit based on production needs and how long the machine has been running.

Machine Serial Number	**Inline**	**Bowl**	**Hopper**
FC-23-20021-1-CW	30%	33%	40%
FC-23-20021-1-CCW	25%	50%	25%
FC-23-20021-2-CW			
FC-23-20021-2-CCW			

Large Black Caps



Air Jets Used	1 and 6
Blade A	Up all the way to knock off parts stacked up on top of one another
Blade B	Down to catch parts standing up
Blade C	All the way up
Blade D	All the way up.
Blade E	Down
Blade F	Down
Blade G	Up all the way
Blade H	To fit part
Track Blades	Use gauge blocks to set track

Percentages used during testing. These may need to be changed up or down a little bit based on production needs and how long the machine has been running.

Machine Serial Number	**Inline**	**Bowl**	**Hopper**
FC-23-20021-1-CW	23%	38%	40%
FC-23-20021-1-CCW	15%	56%	25%
FC-23-20021-2-CW			
FC-23-20021-2-CCW			

Small Black Caps



Air Jets Used	2 and 7
Blade A	To knock off parts stacked on top of one another.
Blade B	Up to catch parts standing up
Blade C	To fit part
Blade D	Up to let sideways parts fall but low enough for good parts to stay.
Blade E	Down
Blade F	Down
Blade G	To fit part
Blade H	To fit part
Track Blades	Use gauge blocks to set track

Percentages used during testing. These may need to be changed up or down a little bit based on production needs and how long the machine has been running.

Machine Serial Number	**Inline**	**Bowl**	**Hopper**
FC-23-20021-1-CW	26%	37%	40%
FC-23-20021-1-CCW	25%	53.4%	25%
FC-23-20021-2-CW			
FC-23-20021-2-CCW			

Other Notes

- Make sure all the rubber leveling feet are solid on the ground and the table is level. This bowl drives hard and if the table is wobbly then it will decrease rate and performance.

- For blades G and H you can leave about an 1/8” of play in between the parts and the blades. The parts will drive a lot better if they have some room to move around. If they are too confined, they may stall or even start going backwards.

- For blade A, it is important to let parts on their sides still make it through. You only want to knock off the parts that are stacked. See picture below for example.

