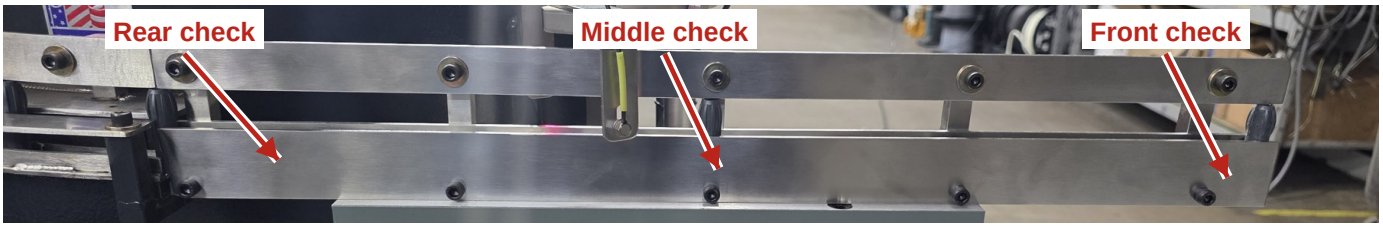
Setup sequence and operating settings

Normal setup adjustments are the top confinement on the inline track and bowl discharge, plus small air-pressure adjustments as needed.

Adjustment	Blue parts - shorter	Grey parts - longer
Air pressure	Approximately 62 psi	60 psi
Inline controller	25.0	25.0
Bowl controller	19.5	19.2
Hopper controller	18.0	18.0

1 Set the inline track first



Place one part at the front, middle, and back of the track. Compare all three as you adjust the top confinement so the clearance stays even.

Use the supplied 0.010-inch shim to gauge the inline track top confinement.

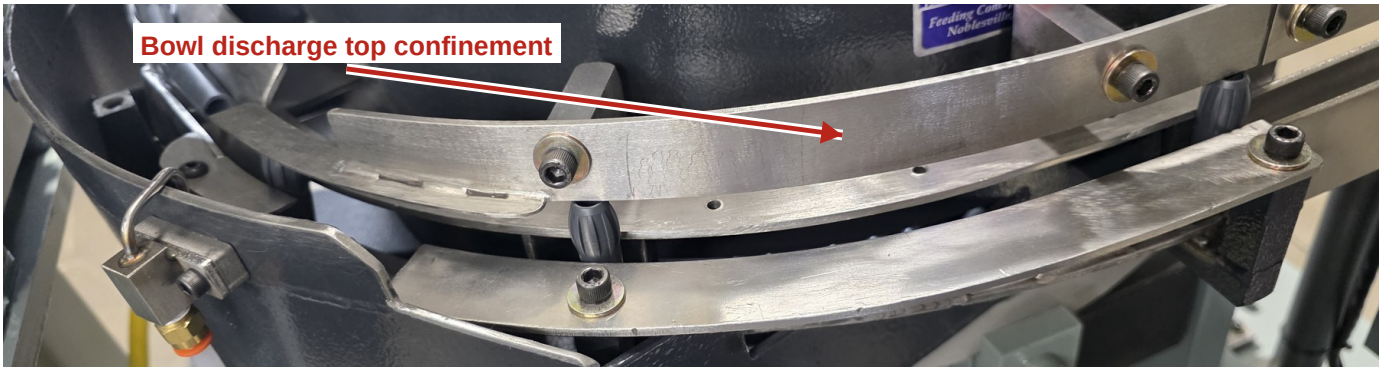
Supplied shim: McMaster-Carr 9722K46, 0.010 inch thick.



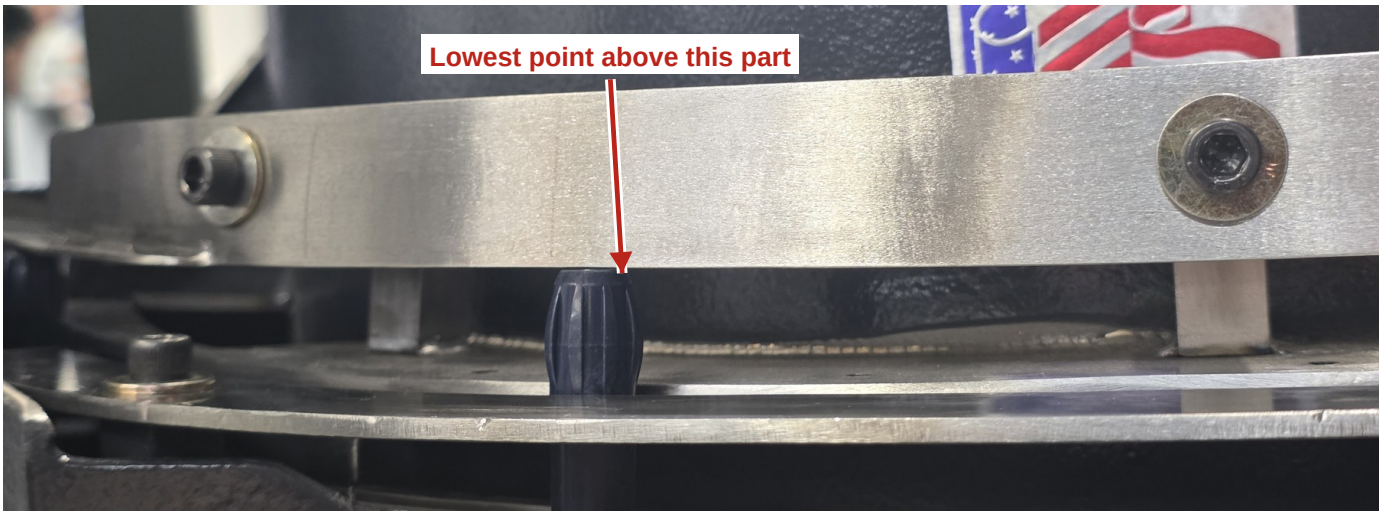
Then set the bowl blade, check the transfer, and confirm smooth feeding. Use the operating settings above as starting points.

Set the bowl discharge blade

The blade follows a radius, so its clearance will not be perfectly even along its full length. The 0.010-inch shim is less effective here.



Bowl discharge blade location

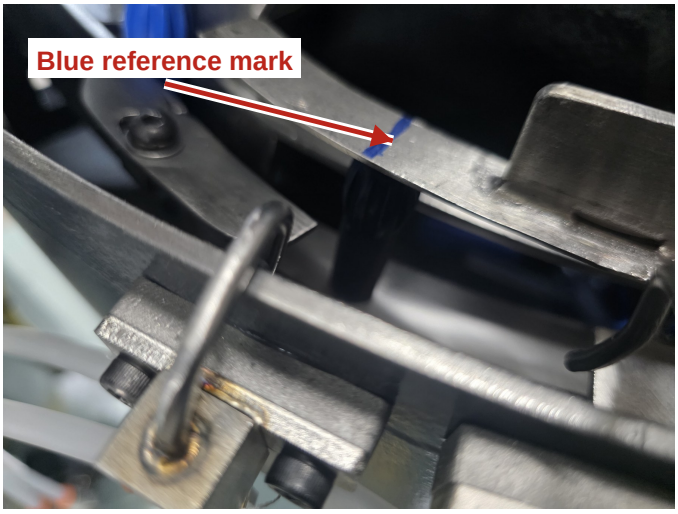


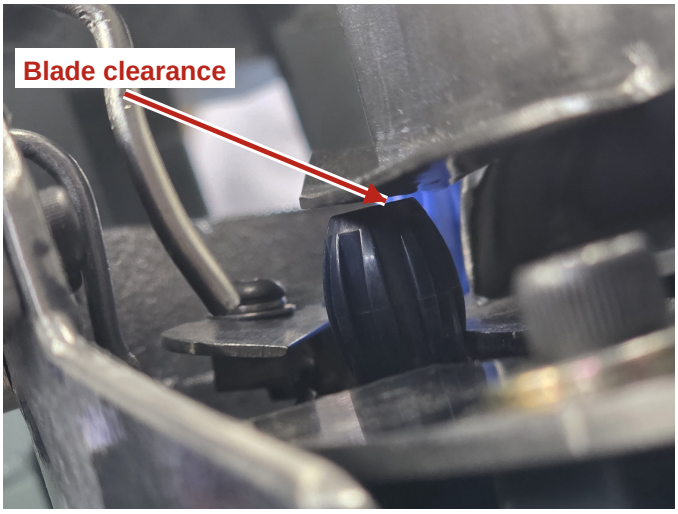
1. Set the lowest point first at the part location shown, midway between the two mounting bolts.
2. Gently rock the blade like a teeter-totter to finish the setting. The front and back will sit slightly higher.
3. A trial run may be needed to confirm the setting. Check feeding and fine-tune as needed.

Bowl blade visual references

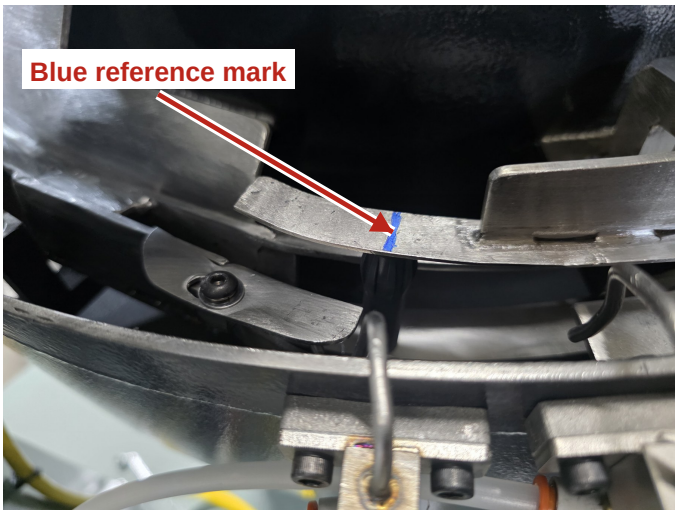
The blue line identifies the same blade location in each photo pair. Use the wider view to locate it and the close view to compare clearance above the part.

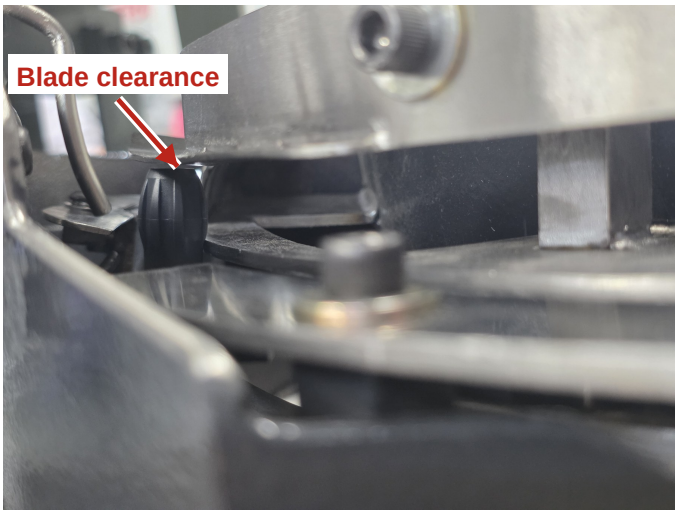
Shorter blue parts





Longer grey parts

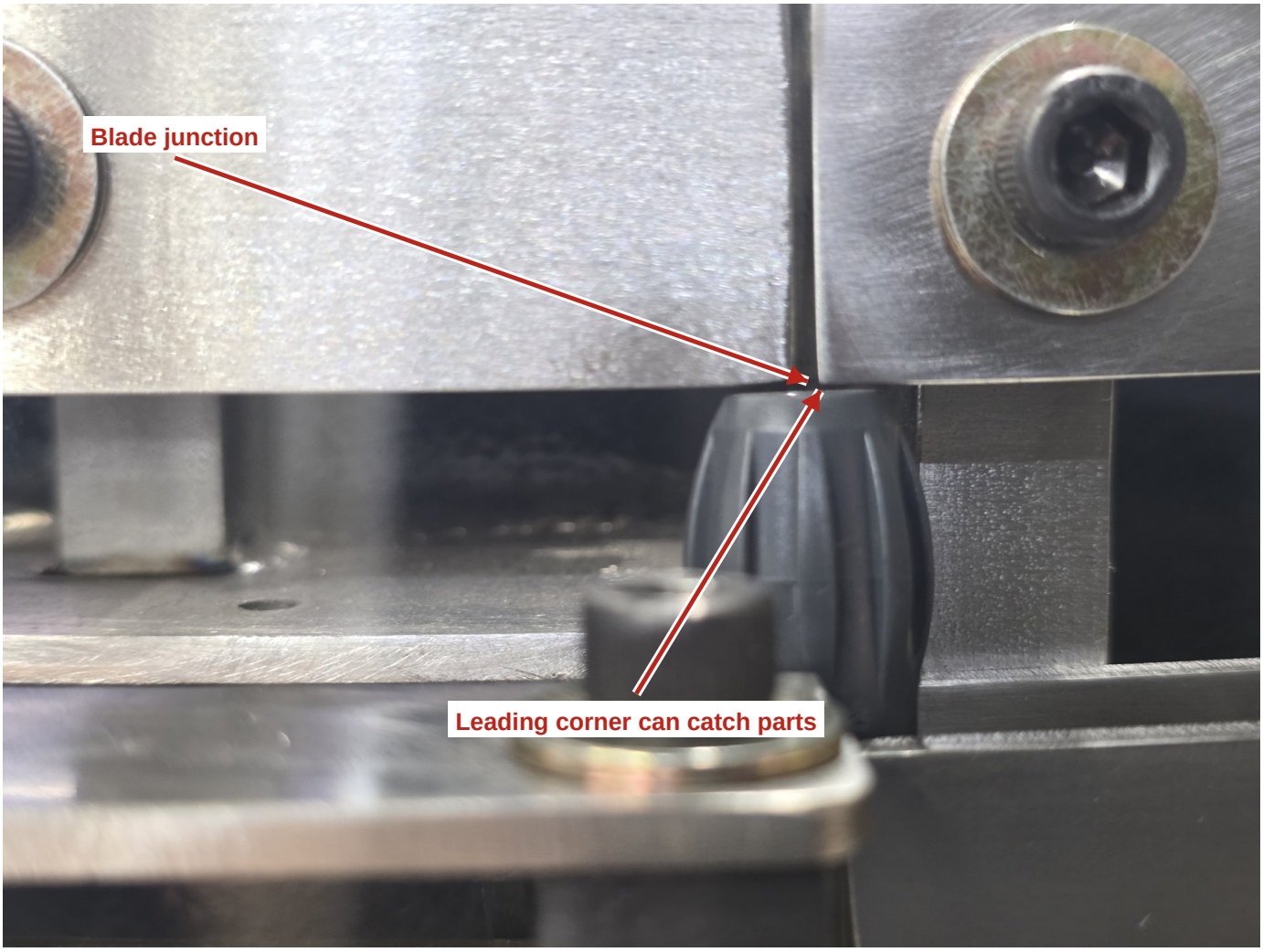




These are visual setting guides. Confirm the final blade setting by checking that parts feed without catching or jamming.

Check the bowl to inline track transfer

Critical: The inline track blade must be at the same height as, or slightly higher than, the bowl blade.



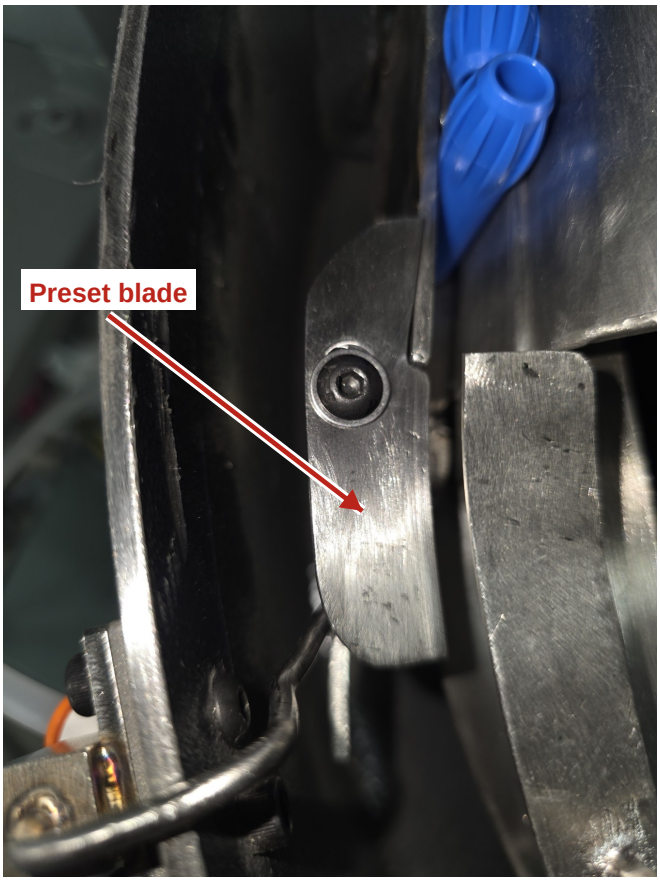
If the inline track blade is lower, parts can catch its leading corner and jam.

Keep both blades low over the parts and their ends close together so parts cannot tip during the transfer.

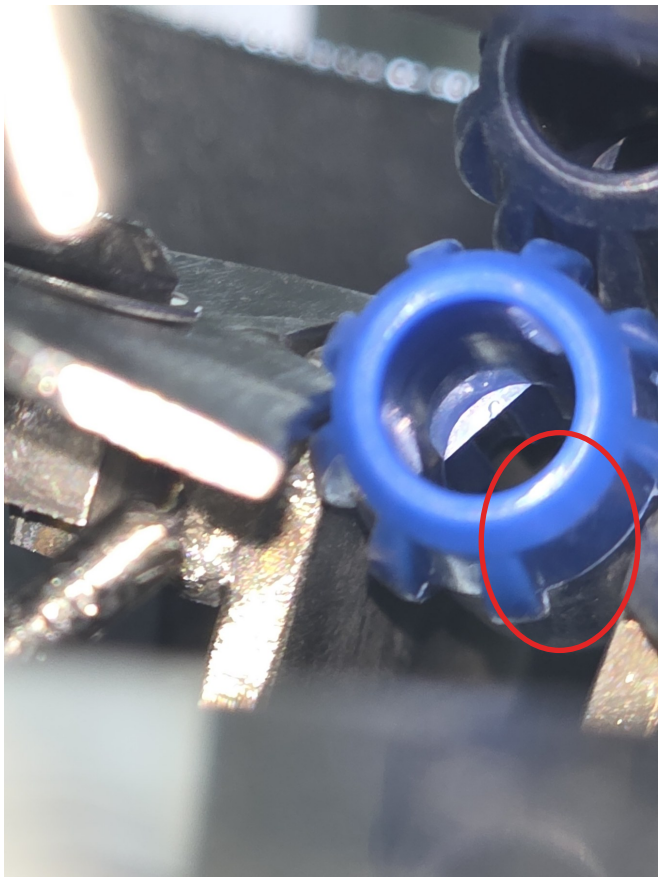
Run parts through the transfer and confirm they pass smoothly without catching or tipping.

Critical preset blade at the parallel rails

This blade should not normally require adjustment. A small 0.010-inch shim washer is currently installed beneath it.



Preset blade location



Missing-rib area circled in red

The parts have external ribs, with one area where a rib is missing. When that area faces the inside of the bowl, as shown, the part sits lower between the parallel blades.

The blade setting must allow parts in this lower position to pass without catching or jamming. If the setting needs to be checked, verify it with the missing-rib area facing inward.

Preserve the installed shim washer if the blade is removed for service.

Air and controller photo references

Use the displayed controller values below. Fine-tune air pressure in small increments as needed for smooth feeding.

Shorter blue parts



Air approx 62 psi



Inline 25.0

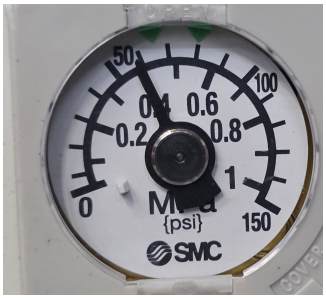


Bowl 19.5



Hopper 18.0

Longer grey parts



Air 60 psi



Inline 25.0



Bowl 19.2



Hopper 18.0

Blue-part air reference: use approximately 62 psi as specified for the shorter parts, slightly above the 60 psi used for the longer grey parts.