Job Serial Number: FC-24-21740-6

The following settings are changes made from default settings on the controllers and sensors. If the settings is not listed below, we did not change it.

→ Bowl Controller Settings:

- On Delay:	0.5 Seconds
- Off Delay:	0.5 Seconds
- Frequency:	120Hz
- Amperage:	21.60%
- Soft Start:	1 Second
CFR Setpoint:	40.0 %
Sensor Logic	Normal

→ Hopper Controller Settings:

- Frequency:	60Hz
- Amperage:	33.0 %
- Soft Start:	1.0 Seconds
Off Delay	0.2 Seconds
On Delay	3.5 Seconds
Sensor Logic	Invert

→ Banner Q4X Settings:

- On Delay:	1 Second
- Off Delay:	200ms
- Output Logic:	Dark Operate

→ Keyence FS-N41C Settings:

• Full Track Switch	
Setpoint:	4900
Output Logic:	Light Operate
Drop Confirmation Array Sensor	
- Detection Mode:	Falling Edge
- Saturation Cancel:	Execute this Function
- Output Timer:	One Shot
- Duration 1:	200ms

Hold the Set Button to Zero Out/Teach this Sensor while in Falling Edge Mode

→ Keyence LRX Settings:

Escapement Part Present	
NPN/PNP	PNP
Set Point	2.5

You must re-initialize the LRX to change the NPN/PNP setting

Air Pressure Setting:

Air Pressure should be set to 0.4mpA on the air regulator guage.