FEEDING CONCEPTS INC.
VIBRATORY FEEDER BOWLS & AUTOMATIC PARTS FEEDERS

Bowl Feeder Changeover Instructions

Machine FC-25-22545 | Parts BL3, BL4, BL5, BL7

Pick the correct catch blade, set the guides for the new part, then run parts into the nest to check the setup.

1 Pick the catch blade

Part	Use this blade
BL3	Blade 2
BL4	Blade 2
BL5	Blade 2
BL7	Blade 1

2 Set the catch blade height

Install the correct catch blade from the table above. Mount the unused blade on the storage mount below it on the bowl. Loosen the two bolts on the installed blade and move it up or down. The part lying back must tip onto the blade and stand upright. Tighten the bolts and check several parts.

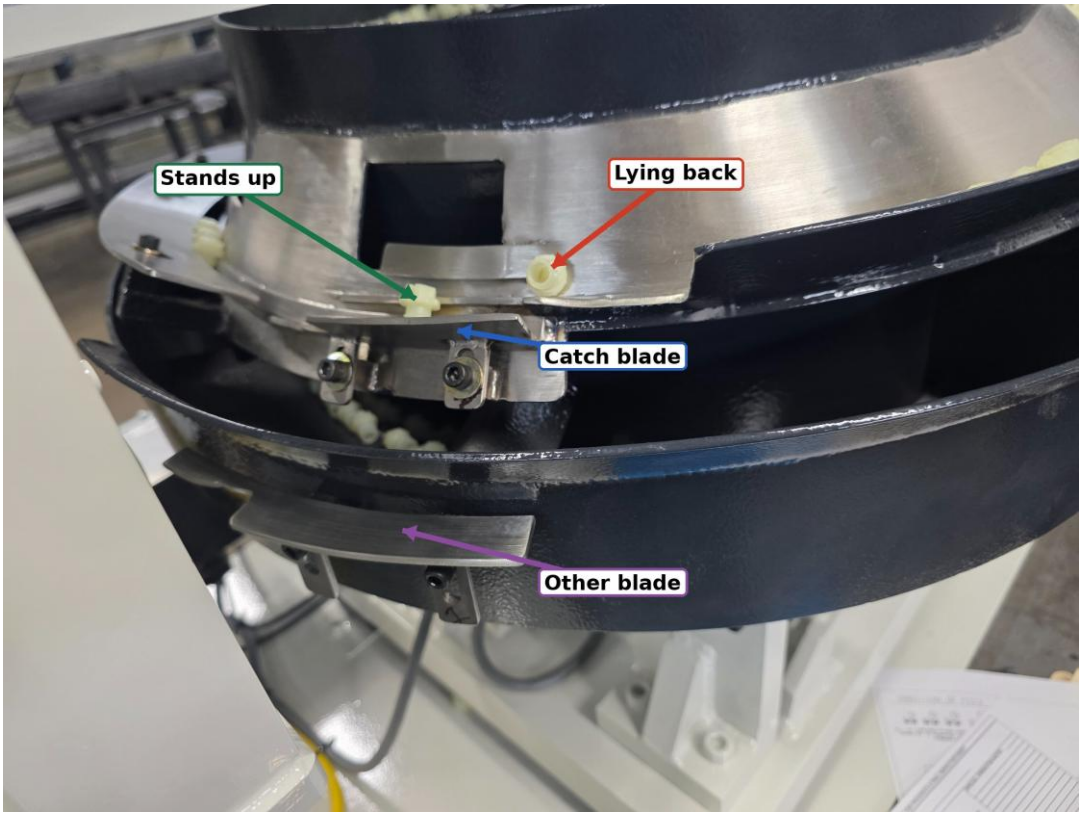


Photo 1 The blade catches a part as it tips upright.

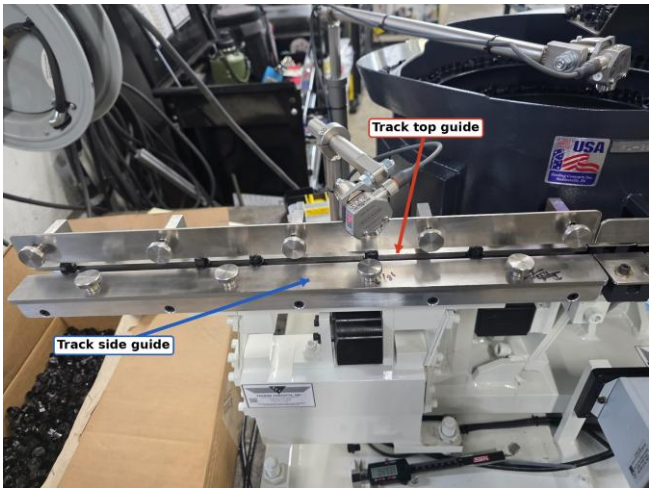
3 Adjust the guides

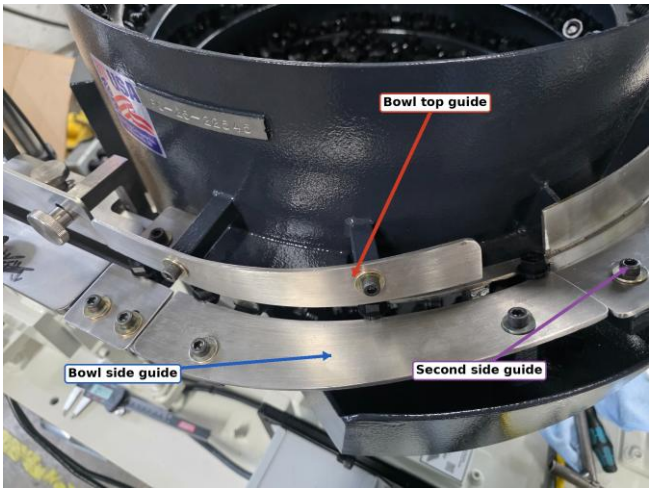
Adjust the outside blades on the linear track and bowl. If that alone does not let parts feed correctly into your nest, adjust the inside blades on both the track and bowl too. Use the steps below for every blade you adjust.

A. Set the side blades first. Start at the discharge end of the linear track and work back into the bowl.

B. At each guide, loosen its fasteners. Put one part near each end and one in the middle. Push the guide in against the parts, lightly snug the fasteners, then pull the guide back a little so parts can pass. Tighten the fasteners.

C. Do the same for the top guides. Start at the discharge end of the track and work back into the bowl. Give the parts enough room to pass without rubbing. Tighten all fasteners.





Photos 2 and 3 Track guides and bowl guides.

4 Run and check

Run several parts. Check that they stand upright, pass without jams, and enter the nest correctly. If the inline runs poorly, check the track thumb screws. Tighten them by hand first. If they still loosen, carefully give them a little extra torque with vise grips or another tool. Do not damage the screws or move the guides.