Setup Instructions

Job Serial Number: FC-25-22825
Part Description: Cores
Equipment: Bowl Feeding System

Overview

This bowl feeding system utilizes five (5) air jets. The correct air jets must be enabled depending on the core size being run to ensure proper part orientation and feeding performance.

Air jets not listed for the selected core size should remain OFF.

Flow controls with number indicators were added to the system. The current settings are listed below and do not need to be changed between part sizes:

- **AJ1 – Set to 3**
- **AJ2 – Set to 3**
- **AJ3 – Set to 3**
- **AJ4 – Set to 2**
- **AJ5 – Set to 2**
- **AJ6 – Set to 4**

Note: The flow control indicators have some mechanical play. The adjustment dial may need to be turned approximately 3–4 full rotations before the indicator value changes to the next number.

Note: Bowl percentage settings may require adjustment once the bowl is mounted down on the machine.

Air jet Configuration by Core Size

Small Core

Enable the following air jets:

- **Air jet 3**
- **Air jet 4**
- **Air jet 5**

Ensure Air jets 1 and 2 are OFF.

Run the bowl at 60% on the FC-200 controller.

Medium Core

Enable the following air jets:

- **Air jet 2**
- **Air jet 4**
- **Air jet 5**

Ensure Air jets 1 and 3 are OFF.

Run the bowl at 60% on the FC-200 controller.

Large Core

Enable the following air jets:

- **Air jet 1**
- **Air jet 4**
- **Air jet 5**

Ensure Air jets 2 and 3 are OFF.

Run the bowl at 67% on the FC-200 controller.