Bowl feeder changeover

Part settings / Bowl amplitude, main regulator and Airjets 1-15

Setting	6016 Pole A	6016 Pole B	6016 Pole C	6016 Pole D	6016 Pole G	6162
Lane	Outside	Outside	Outside	Outside	Outside	Inside
Bowl amplitude	42.5%	42%	42%	42%	-	44.5%
Main regulator	60 PSI	60 PSI	60 PSI	60 PSI	-	60 PSI
Airjet 1	3	3	3	3	-	3
Airjet 2	2-3	2-3	2-3	2-3	-	2-3
Airjet 3	3*	3*	3*	3*	-	3*
Airjet 4	2	2	2	2	-	N/A
Airjet 5	N/A	N/A	N/A	N/A	-	N/A
Airjet 6	3	3	3	3	-	N/A
Airjet 7	2	2	2	2	-	N/A
Airjet 8	3	3	3	3	-	N/A
Airjet 9	1	1	1	1	-	N/A
Airjet 10	Off	Off	Off	Off	-	2
Airjet 11	N/A	N/A	N/A	N/A	-	2
Airjet 12	N/A	N/A	N/A	N/A	-	4
Airjet 13	N/A	N/A	N/A	N/A	-	2
Airjet 14	N/A	N/A	N/A	N/A	-	1-2
Airjet 15	N/A	N/A	N/A	N/A	-	3

*** Airjet 3.** Dial reference only. Use the part-specific flowmeter photo on page 3 for fine adjustment.

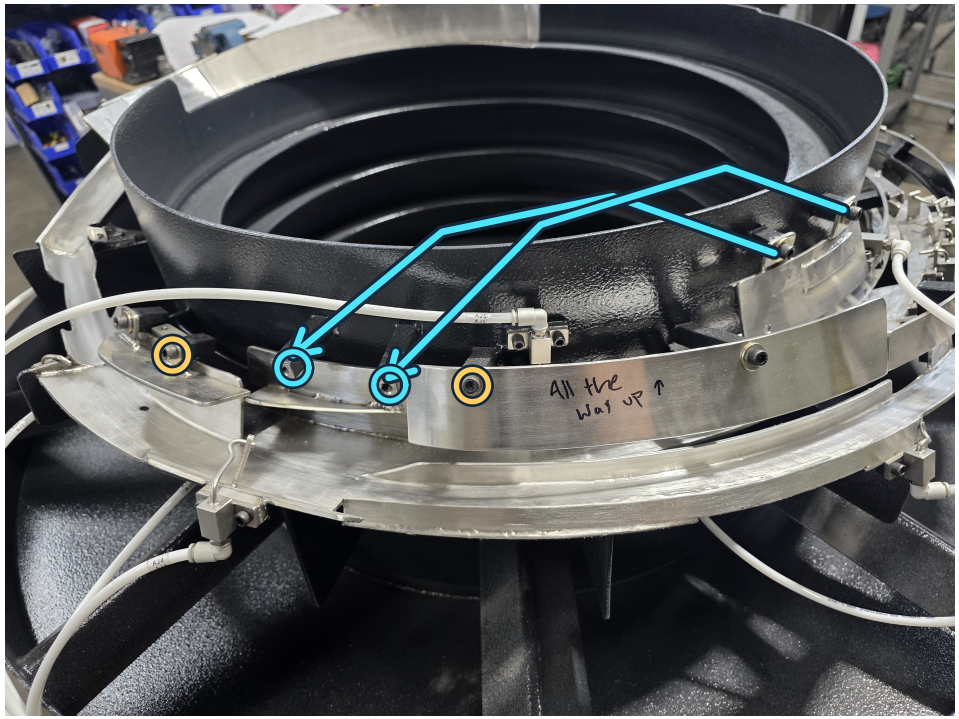
6016 Pole G. Parts were unavailable for setup and testing. Airjet settings may need adjustment when running this part.

Bowl mounting. The listed amplitudes were established with the bowl feeder clamped to a table. Use them as starting points and adjust as needed for consistent feeding once the bowl is mounted in its final location.

Switch the lane tooling

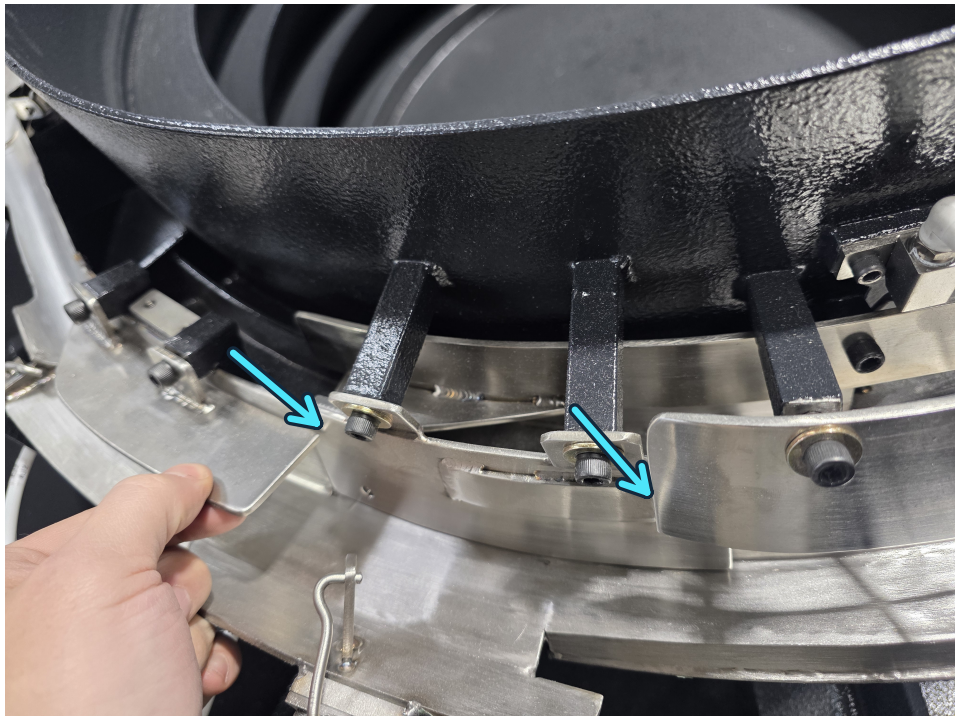
Move the stainless blade between the right-hand holding mount and the two center mounting points.

Outside lane / Blade on holding mount



Amber circles = loosen bolts **Blue arrows = move blade**

Inside lane / Blade at center mounts



Blue arrows = blade ends tucked behind adjacent blades

Outside to Inside

1. Remove the movable blade from its right-hand holding mount.
2. Loosen the two circled bolts. Pull the adjacent stainless blades slightly away from the bowl for clearance.
3. Slide the movable blade behind both adjacent blades, fasten it at the center mounts and retighten the loosened bolts.

Inside to Outside

1. Loosen the same two bolts and pull the adjacent blades slightly away from the bowl.
2. Unfasten the movable blade at the center mounts and slide it out from behind both adjacent blades.
3. Secure the movable blade on the right-hand holding mount and retighten the loosened bolts.

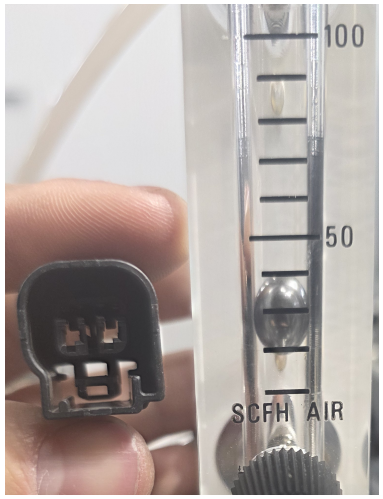
Draft check. Verify that the center-mounted blade is the Inside setup and confirm whether the marked blade must be raised fully during changeover.

Airjet 3 fine adjustment

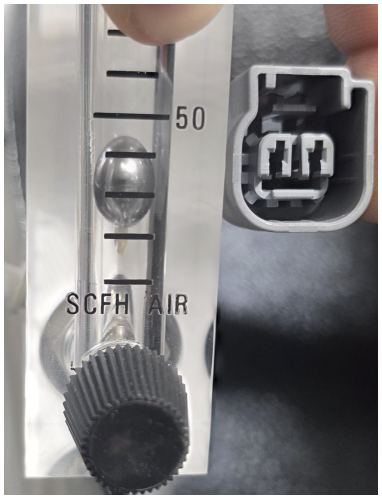
Outside and Inside lanes / Part-specific Dwyer flowmeter photo references

Use dial position **3** as a reference. Fine-adjust Airjet 3 using the flowmeter and the photo for the part you are running. The scale reads in SCFH of air.

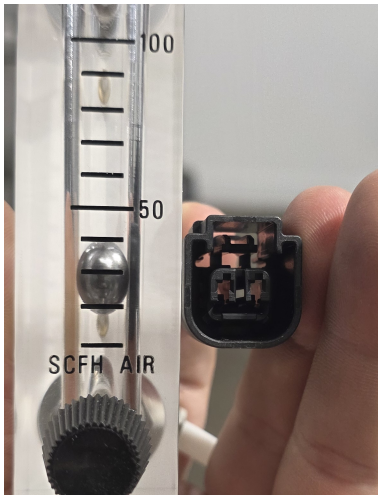
6016 Pole A



6016 Pole B



6016 Pole C



6016 Pole D



6162 (Inside)



Feed rate. One Airjet 3 setting may provide an acceptable feed rate across all parts without adjustment during changeover. The part-specific settings shown gave the highest feed rates observed during setup.

Pending. Flowmeter connection procedure.