Setup Instructions

Job Serial Number: FC-26-26414
Part Description: Covers
Equipment: Bowl Feeding System

This bowl feeding system utilizes 5 air jets to properly orient and feed the covers correctly.. The correct air jets and flow control settings must be used for the selected shell size to ensure proper part orientation and feeding performance.

Note: Bowl percentage settings may require adjustment once the bowl is mounted down on the machine and there is a full bowl of parts. Some of the parts, FCI only had a small bag full for testing. Any additional configurations of pins may require air adjustment not listed below.

Airjet#2 had to be turned up a little bit for the covers with 4 pins compared to the covers with 0 or 1 pins. The bowl also had to be turned up a little bit for the 4-pin cover.

Cover, 3148-con-4F-0p64s_111110

Uses Inside Line

Run the bowl at 60 PSI, 32.5% on the FC-200 controller.

- Flow Control Settings:
    - AJ1- 2 (Almost to 3)
    - AJ2- 2 (Lower end of 2)
    - AJ3- 2 (Almost to 3)
    - AJ4- 2
    - AJ5- Turn Off

Cover, 6168-00-001A(000)

Uses Inside Line

Run the bowl at 60 PSI, 32.5% on the FC-200 controller.

- Flow Control Settings:
    - AJ1- 2 (Almost to 3)
    - AJ2- 2 (Lower end of 2)
    - AJ3- 2 (Almost to 3)
    - AJ4- 2
    - AJ5- Turn Off

Cover, 6168-00-001A(999)

Uses Inside Line

Run the bowl at 60 PSI, 38.5% on the FC-200 controller.

- Flow Control Settings:
    - AJ1- 2 (Almost to 3)
    - AJ2- 2 (Higher end of 2)
    - AJ3- 2 (Almost to 3)
    - AJ4- 2
    - AJ5- Turn Off

Cover, 3219_CVR_4F_0P64S_KAIZEN

Uses Outside Line

Run the bowl at 60 PSI, 33.1% on the FC-200 controller.

- Flow Control Settings:
- AJ1- 2 (Not used but can leave on)
- AJ2- 2 (Not used but can leave on)
- AJ3- 2 (Not used but can leave on)
- AJ4- 2
- AJ5- 3