Job Serial Number: FC-24-21469

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.

FOR SMALL PART

→ Bowl Controller Settings:

- On Delay:	1.0 Seconds
- Off Delay:	3.0 Seconds
- Frequency:	60Hz
- Amperage:	53.00%
- Soft Start:	1.0 Seconds

→ Hopper Elevator Controller Settings:

Speed on Oriental Motor Driver:	725

→Outfeed Conveyor Controller Settings:

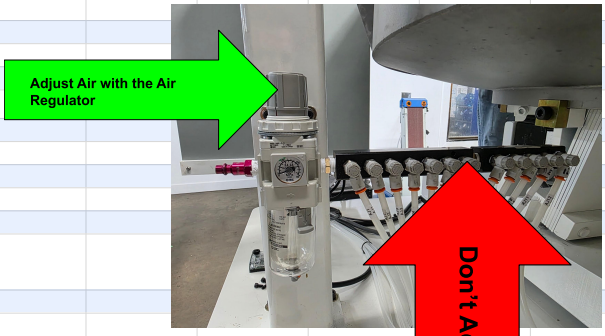
Speed on Oriental Motor Driver	1500

→ Banner Q4X Settings:

- On Delay:	4.4 Second
- Off Delay:	300ms
- Output Logic:	Dark Operate

→ Air Pressure Settings:

Air Regulator Pressure:	47psi
Air Jet #9:	Off
Air Jet #10:	On



FOR LARGE PART

→ Bowl Controller Settings:

- On Delay:	1.0 Seconds
- Off Delay:	3.0 Seconds
- Frequency:	60Hz
- Amperage:	53.00%
- Soft Start:	1.0 Seconds

→ Hopper Elevator Controller Settings:

Speed on Oriental Motor Driver:	725

→Outfeed Conveyor Controller Settings:

Speed on Oriental Motor Driver	1500

→ Banner Q4X Settings:

- On Delay:	4.4 Second
- Off Delay:	300ms
- Output Logic:	Dark Operate

→ Air Pressure Settings:

Air Regulator Pressure:	55-60psi
Air Jet #9:	On
Air Jet #10:	Off

When adjusting air pressure, use the main air regulator. DO NOT adjust the individual flow controls.
