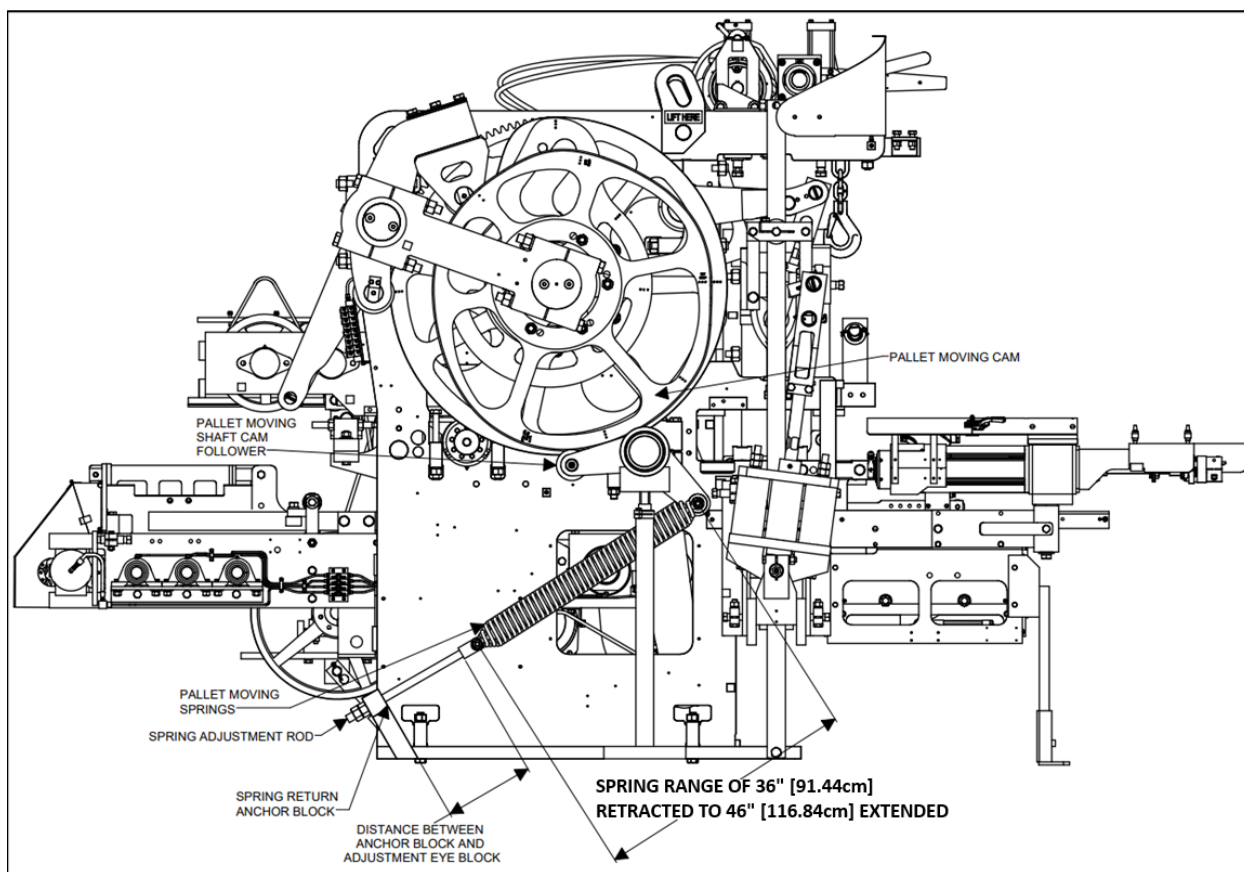


V3-12 Pallet Feeder Spring Adjustment

Installation

The pallet feeder springs need to be tensioned so the pallet moving roller is always in contact with the pallet moving cam. To achieve this, move the machine to 2nd Stop and measure the distance between the center of the two rod eyes. A starting setup distance should be approx. 36" [91.44cm]. This distance can be altered using the adjustment rod. Setting the distance between the rod eyes will ensure there is no unnecessary load on the bearings, cam, or roller. Once this measurement is achieved, cycle the machine at production speed and verify that there is no skip between the cam follower and cam. If a skip is observed, tighten springs in small increments until there is no skip. Once there is no skip of the cam follower, move the machine to 3rd Stop and measure the distance between rod eyes. If this measurement is greater than 46" [116.84cm], then this may cause reduced life of the spring and premature failure. If the measurement at 3rd Stop is greater than 46" [116.84cm] wear parts need to be examined surrounding the springs to see if this is causing measurements outside of the recommended range. Also, it should be noted that the anchor block and the adjustment eye block need to be parallel with one another to prevent any twist or interference between the two springs.

- Any deviation outside of the recommended range may result in premature failure of the springs.
- Any twisting or interference between the springs may result in premature failure of the springs.



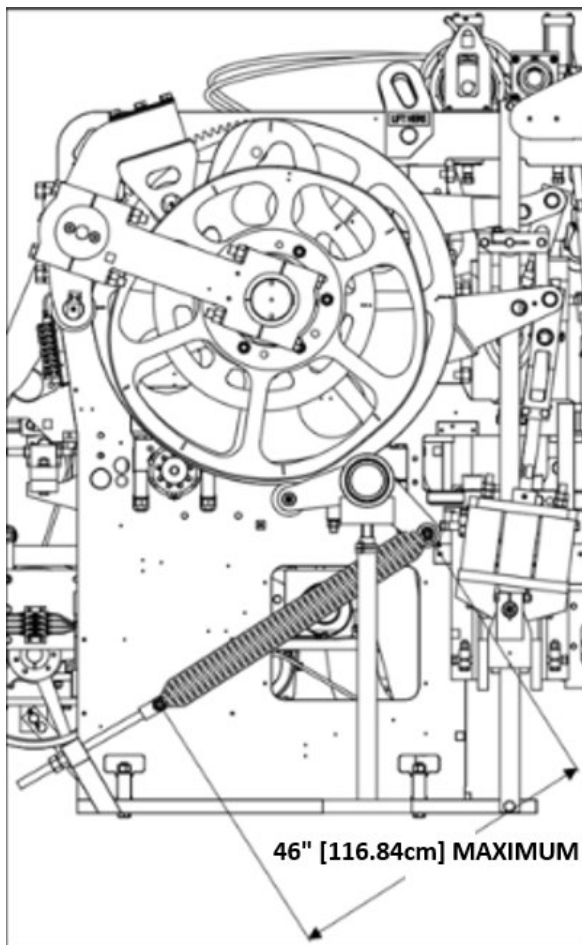
V3-12 Pallet Feeder Spring Adjustment

Example

Below is an example of the cam positions where the spring measurements would be taken for proper adjustment. The ideal position to start the adjustment of the spring tension is the position the spring slacks the most at 2nd stop of the machine around encoder position 180°, measuring greater than 36" between the spring attachment eyes while maintaining cam follower contact on the cam. The spring is tensioned the most at 3rd stop around encoder position 25°, measuring less than 46" [116.84cm] between spring attachment eyes while maintaining cam follower contact with the cam.

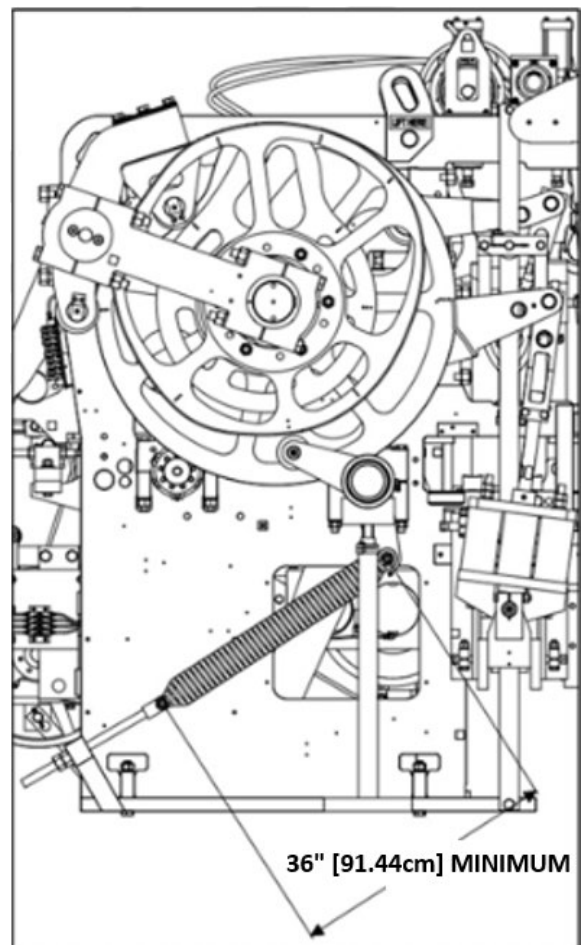
3RD Stop

(ROTARY SENSOR POSITION – 25°)



2ND Stop

(ROTARY SENSOR POSITION – 180°)



V3-12 Pallet Feeder Spring Adjustment

SAFETY BULLETIN

This notice is issued to advise you that some previously accepted shop practices may not be keeping up with changing Federal and State Safety and Health Standards. Your current shop practices may not emphasize the need for proper precautions to ensure safe operation and use of machines, tools, automatic loaders and allied equipment and/or warn against the use of certain solvents or other cleaning substances that are now considered unsafe or prohibited by law. Since many shop practices may not reflect current safety practices and procedures, particularly regarding the safe operation of equipment, it is important that you review your practices to ensure compliance with Federal and State Safety and Health Standards.

IMPORTANT

The operation of any machine or power-operated device can be extremely hazardous unless proper safety precautions are strictly observed. Observe the following safety precautions:

ALWAYS:

- ✓ Be sure proper guarding is in place for all pinch, catch, shear, crush, and nip points.
- ✓ Be sure that all personnel are clear of the equipment before starting it.
- ✓ Be sure the equipment is properly grounded.
- ✓ Turn the main electrical panel off and lock it out in accordance with published lockout/tagout procedures prior to making adjustments, repairs, and maintenance.
- ✓ Wear appropriate protective equipment such as safety glasses, safety shoes, hearing protection, and hard hats.
- ✓ Keep chemical and flammable material away from electrical or operating equipment.
- ✓ Maintain a safe work area that is free from slipping and tripping hazards.
- ✓ Be sure appropriate safety devices are used when providing maintenance and repairs to all equipment.

V3-12 Pallet Feeder Spring Adjustment

NEVER:

- ✓ Exceed the rated capacity of a machine or tool.
- ✓ Modify machinery in any way without prior written approval of the Besser Engineering Department.
- ✓ Operate equipment unless proper maintenance has been regularly performed.
- ✓ Operate any equipment if unusual or excessive noise or vibration occurs.
- ✓ Operate any equipment while any part of the body is within the proximity of potentially hazardous areas.
- ✓ Use any toxic flammable substance as a solvent cleaner.
- ✓ Allow the operation or repair of equipment by untrained personnel.
- ✓ Climb or stand on equipment when it is in operation.

It is important that you review Federal and State Safety and Health Standards on a continual basis. All shop supervisors, maintenance personnel, machine operators, tool operators, and any other person involved in the setup, operation, maintenance, repair or adjustment of Besser-built equipment should read and understand this bulletin and Federal and State Safety and Health Standards on which this bulletin is based.