

STROMAG FEED SYSTEM CHECKLIST/SETTINGS

Serial # 22-0027

Ship Date 12/22
MM/YY

Customer AV GAUGE

Parts Being Fed LARGE PLASTIC CLIP (One Checklist Per Part)

Controller Brand RODIX Model FC-200-3

Input Voltage 110 V 220 V Feeder Bowl Size 24 Rotation CCW

Feeder Bowl Tuned To 60 HZ 50 HZ Feeder Bowl Pulse 60 VPS 120 VPS
(Vibrations per Second)

Feeder Bowl Coil Gap Settings .03 IN .03 IN Coils Parallel to Pull Face Y N

Controller Settings (Speed) at Shipment: Bowl 50 Hopper 40 Inline 40

Main Air Regulator set to 40 PSI # of Air Jets on Inline 3 Flow Controls Y N
of Air Jets at Nest Flow Controls Y N
of Air Jets in Bowl Flow Controls Y N

Observations Re: Sample Test Parts:

Flash	Y <input type="checkbox"/> N <input checked="" type="checkbox"/>	Burrs	Y <input type="checkbox"/> N <input checked="" type="checkbox"/>
Mold "Tits"	Y <input type="checkbox"/> N <input checked="" type="checkbox"/>	Lubricant, Film, Mold Release	Y <input type="checkbox"/> N <input checked="" type="checkbox"/>
Debris in with Parts	Y <input type="checkbox"/> N <input checked="" type="checkbox"/>	Debris Slots in Bowl	Y <input checked="" type="checkbox"/> N <input type="checkbox"/>
Out of Tolerance/Broken	Y <input type="checkbox"/> N <input checked="" type="checkbox"/>	Part Print Attached	Y <input type="checkbox"/> N <input type="checkbox"/>

Parts Found

Sensors Bowl Level BALLUFF B050178 Track Level IFM OPU702
(Brands & Type) Part in Nest KEYENCE LR-ZB100C3P Taught Y N

Holdback Cylinder Y N Top Side Y N Below Deck Y N

Comments _____

Optimal Part Level in Bowl Marked Y N

Comments _____

Controller Settings

- Timers: Track High Level Delay "ON" 0.5 Seconds Delay "OFF" 5.0 Seconds
Bowl Level Delay "ON" 4.0 Seconds Delay "OFF" 1.0 Seconds
Soft Start Y N N/A

System Filmed In Operation Y N Pictures Taken Pre-Shipment Y N

Straps, Blocks, Braces Used in Shipping Y N (MUST BE REMOVED BEFORE OPERATION)