

Bottom Bump Feeder Basic Operation Instructions

Step #1

Install appropriate gear sets to match operation:

	Pocket Size	Minimum Length	Maximum Length
One-Up	42" Pocket	5"	40"
Two-Up	21" Pocket	5"	19"
Three-Up	14" Pocket	5"	12"

NOTE: If blank is less than 50% of maximum pocket length, use the 70/30 cam.

Step #2

Align the belt carriers to correspond with the box type. Do not run the belts directly under the window if possible. This will cause the vacuum to pull the next box into the machine, resulting in jams.

Step #3

Jog the bump-feeder so that the cam is stopped on the high spot. Move and adjust the bumpers in the up-position using the gauge block against the feedgate to set the height of the bumpers to the belt.

Step #4

Adjust the valve lash using the tappet to give a clearance of .005" to .010" between the rocker arm and the valve. This prevents vacuum from leaking from the valve. Leakage can cause boxes to be pulled into the machine prematurely.

Step #5

Position the feedgate directly over the belt. This should be approximately halfway up the tapered end of the bumper. Using the box that you are running as a feeler gauge, adjust the feedgate so that only one blank at a time is fed into the system. Be sure the feedgate is square and carton fits under the edges of the carbide tip equally.

Step #6

Adjust the side guides to allow minimal room between the guides. Allowing too much room will cause the blanks to twist causing possible jamming. Too little room may cause the blanks to bind and feed sporadically.

Step #7

Adjust the make-ready support shoes at the rear of the blank (front of the feeder). Keep the shoe angle the same as the angle of the feedgate. Raise the rear of the box 1/2" or more so that the front 1/3 of the box makes contact with the belt.

Step #8

Adjust the pull wheels (orange, rubber) directly in line with the belt carriers whenever possible. Pressure on these wheels should be kept at a minimum; their function is to pull the box.

Step #9

Adjust the timing of the feeder to the machine:

A: Loosen the four bolts on the drive sprocket and move the feeder in time with the machine.

B: Retighten the four bolts.

C: Test the machine to see if it works properly. Make any necessary adjustments.

Step #10

To turn the vacuum on and off, pull or push the knob on the PIAB™.

Step #11

Clean the filter under the front of the feeder after every shift.

Step #12

Problems? Call the Western Slope Industries Service Department – 1-800-338-1455.