



### **SETUP FOR DENGENSHA NUT FEEDERS**

1. LEVEL NUT FEEDER; THIS ENSURES PROPER OPERATION OF THE VIBRATORY BOWL, (FEEDER COMES WITH LEVELING BOLTS).
2. ADJUST LIMIT SWITCH; THIS LIMITS THE AMOUNT OF NUTS IN THE BOWL. THERE SHOULD BE A VOID OF NUTS IN THE CENTER OF THE BOWL, (THIS HELPS WITH PROPER SELECTION OF THE WELD NUTS).
3. ADJUST THE BULK HOPPER DOOR; THIS SHOULD BE ADJUSTED TO ALLOW A GOOD FLOW OF NUTS TO BE DROPPED IN THE BOWL, NOT TOO MANY AT ONE TIME.
4. THE BEST ANGLE TO SET THE FEED UNIT IS 45 DEGREES; YOU CAN SET THE UNIT BETWEEN 30 DEGREES AND 60 DEGREES DEPENDING ON THE SIZE OF THE NUT BEING FED.
5. MAKE SURE THAT THE VINYL TUBE HAS A GOOD FLOWING SET UP. WE SUGGEST A MINIMUM RADIUS OF 300mm. AVOID ALL SHARP BENDS IN THE VINYL TUBE.
6. SET THE HEAD ASSEMBLY ON THE FEED UNIT SO THAT THE NUT COMES IN FROM AS VERTICAL A POSITION AS POSSIBLE. THIS HELPS THE NUT TO BE DELIVERED AND TO SIT PROPERLY AGAINST THE NUT STOPPER.
7. AIR PRESSURE SHOULD BE ADJUSTED BETWEEN THE TWO GREEN ARROWS ON THE AIR PRESSURE GAUGE LOCATED UNDER THE MACHINE. THIS PROLONGS THE LIFE OF THE NUT STOPPER.
8. ADJUST THE VIBRATION FOR OPTIMAL SELECTION OF THE NUTS, NOT TOO HIGH AND NOT TOO LOW. USUALLY BETWEEN 2 AND 4 ON THE VIBRATION CONTROL DIAL. LOOK FOR GOOD MOVEMENT AND SEPERATION IN THE BOWL, (APPROX 10% OF NUTS IN PROPER ORIENTATION SHOULD ALSO FALL OFF THE SELECTION TRACK).



9. KEEP ABOUT 4 OR 5 NUTS IN THE HEAD ASSEMBLY, (THIS DOES NOT APPLY TO FLANGE NUTS). THIS ENSURES THAT THE LAST NUT IS PROPERLY ALIGNED WITH THE SPINDLE (LIZARD TONGUE) AND WILL BE DELIVERED TO THE WELD PIN WITHOUT A MISFEED. THIS ALSO PROLONGS THE LIFE OF THE NUT STOPPER.
  
10. SET UP THE SPINDLE (LIZARD TONGUE) WITH THE WELD PIN FOR PROPER DELIVERY OF THE WELD NUT. IT SHOULD NOT TOUCH THE WELD PIN.
  
11. MAKE SURE THAT THE TIME (DURATION) THAT THE AIR IS BLOWING TO SEND THE NUT TO THE HEAD ASSEMBLY IS NOT TOO LONG. THE NUT SHOULD FALL THE LAST FEW INCHES BY GRAVITY. THIS PROLONGS THE LIFE OF THE NUT STOPPER.
  
12. THE SET SCREW MUST BE USED TO KEEP THE VINYL TUBE INSERTED IN THE TUBE HOLDER OF THE HEAD ASSEMBLY. IF THE SET SCREW IS MISSING THE TUBE CAN WALK OUT AND A NUT COULD FLIP IN THE TUBE HOLDER AND BE DELIVERED UPSIDE DOWN TO THE WELD PIN.
  
13. KEEP THE BOWL CLEAN AND FREE OF DEBRIS; THIS ENSURES FOR THE PROPER SELECTION OF THE NUTS IN THE BOWL. THE BOWL SHOULD BE CLEANED OUT AS REQUIRED AND CLEANED USING ELECTRICAL CONTACT CLEANER AT LEAST **ONCE A WEEK**.
  
14. A DROP OF MACHINE OIL SHOULD BE PLACED ON THE SPINDLE (LIZARD TONGUE) **ONCE A WEEK** TO LUBRICATE THE BRONZE GUIDE BUSHING AND THE SPINDLE.
  
15. CHECK THE WEAR OF THE GUIDE BUSHING AND NUT STOPPER AT LEAST **ONCE A MONTH**.
  
16. RAISING THE NUT FEEDER ON A PLATFORM IS NOT RECOMMENDED. WHEN A NUT FEEDER IS ELEVATED ON A STAND IT CAN EFFECT THE VIBRATION OF THE BOWL AND THE SELCETION PROCESS FOR THE NUTS.