crizaf Automation Systems

Rotating Chute

Easy to set up

- Simply place the rotating chute into position.
- Connect the feeding conveyor to the chute controller.
- Set the containers into place.
- Program container positions, part count, etc., using the easy to program Teaching Pendant.
- Press RUN and you're ready to go.

Features

- Operates on cycle count from the molding machine.
- 300 degree turning angle allows the chute to fill many different sizes and numbers of containers.
- Easy to use Teaching Pendant makes programming simple.
- Feeding conveyor stops when the chute rotates.
- Controller continues to count when the feeding conveyor is stopped and the chute is rotating.
- Visual / audible alarm sounds when the last empty box is being filled.
- Small size allows it to be easily stored when not in use.
- Easy to adjust up or down. No tools needed.
- Adjustable chute angle. No tools needed.

Easy to program teaching pendant

Programming the Rotating Chute

Pendant Functions

1. Emergency Stop ON/OFF
2. LED Display
3. Rotate chute to the left. Decrease values
4. Rotate chute to the right. Increase values
5. Number of parts per cycle / Number of cycles per container
6. Clear settings while programming
7. Number of containers
8. Add setting / Confirm settings / Silence alarm
9. Set alarm for last empty box / Set time delay for feeding conveyor
10. Program (hold down 5 seconds) / Run / Stop

Programming the Pendant

Position containers around the chute. Plug the feeding conveyor into the blue receptacle on the chute support. Turn the main power ON (red knob on the side of the chute stand). Release emergency stop button (1). Press run (10) to synchronize the chute.

- Press run (10) – hold for 5 seconds. LED (2) will show 'Inactive Status'.
- Press number of parts per cycle key (5). Enter number of parts in each cycle with the + or – key (3 or 4). Press OK (8).
- Enter number of parts/box with the + or – key. Press OK. Press OK again to confirm and continue.
- Press number of containers key (7). Press ← (3) or → (4) to determine 1st position. Press OK to confirm. Press ← or → to determine 2nd position. Press OK to confirm. Continue until all box positions have been entered. Press OK twice to continue to next function.
- Press timer (9) – conveyor delay will show in the LED. Press + or – to enter the number of seconds you want the feeding conveyor to continue running after the final cycle count has been received by the controller. This function allows time for the parts to move from under the press to the container. Enter and press OK.
- The LED will automatically ask for a second alarm time. A second alarm will sound to remind the operator to empty the last filled box. Enter the duration in seconds and then press OK. To enter the Active status and start the system, press RUN (10).
- As the chute turns to the last empty container, the alarm will sound. To silence the alarm press MEM/OK (8). The chute will automatically return to the first filling position after the last box is filled.

CONNECTOR WIRING FOR ROTATING CHUTE

DRY CONTACT

FOR USE WITH A DRY COUNT CONTACT WIRE TO TERMINALS # 1 & # 2, OF THE RECTANGULAR CONNECTOR. YOU MUST CUT OFF THE 24V CIRCUIT BOARD FOR THIS APPLICATION.

24 VDC SIGNAL

FOR USE WITH A 24 VDC SIGNAL, WIRE THE PIGTAIL PROVIDED WITH THE CIRCUIT BOARD INLINE, BLUE TO NEGATIVE 24 VDC TERMINAL # 1 AND BROWN TO POSITIVE 24 VDC TERMINAL # 2 OF THE RECTANGULAR CONNECTOR.

24 VDC PROXIMITY SENSOR

FOR USE WITH A 24 VDC PROXIMITY SENSOR, WIRE NEGATIVE 24 VDC TO TERMINAL # 2, POSITIVE 24 VDC TO TERMINAL # 3 AND SIGNAL WIRE TO TERMINAL #1.