

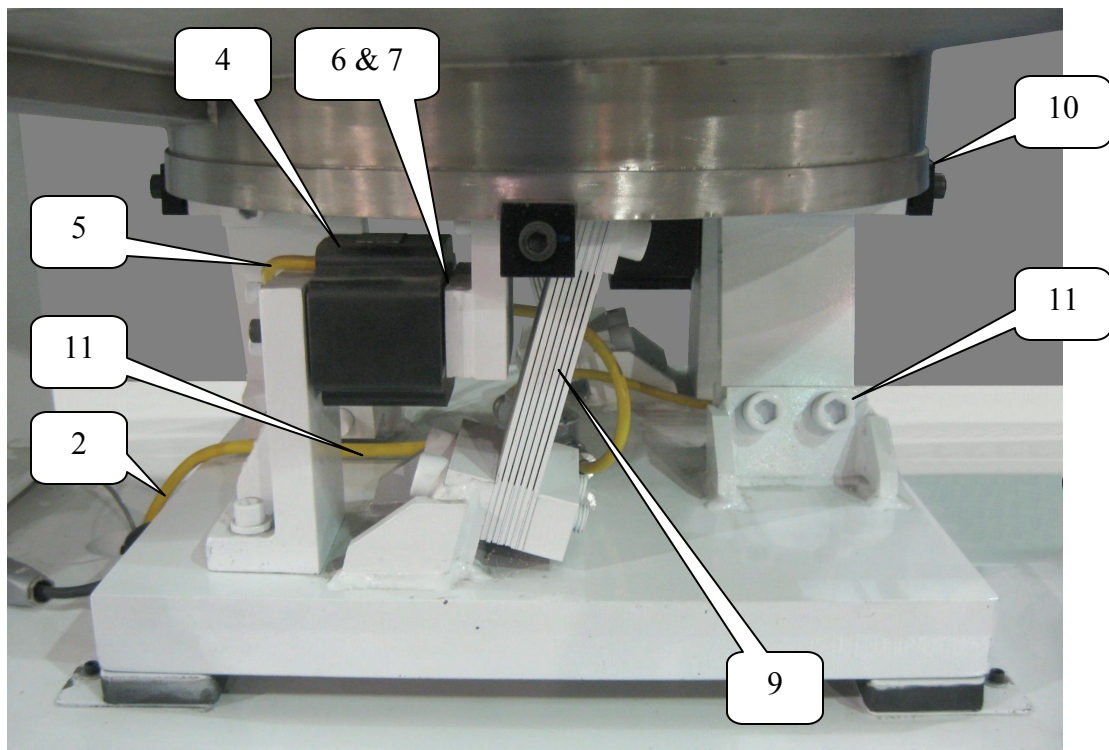


# VIBRATORY FEEDER TROUBLESHOOTING GUIDE

## THE BOWL DOES NOT VIBRATE

When no vibration is present, it is often caused by one of the following reasons:

- 1) The power supply to the electric panel may be inadequate.
- 2) The cord from the feeder to the electric panel may be unplugged or damage.
- 3) A fuse may be blown in the electric panel (or in vibratory control).
- 4) A coil may be shorted out.
- 5) A lead wire may be unplugged at the coil.
- 6) The gap between the coil and striker plate (ilamb) may be closed or damage.
- 7) A part or foreign object may be lodged between the coil and striker plate (ilamb).
- 8) The feeder bowl may have been attached to a rigid track. The bowl , and/or drive unit may be in contact with other equipment.
- 9) One or more springs may be cracked or broken.
- 10) The bowl is improperly fixed on the drive.
- 11) Anchorage bolts of springs are not tight enough.



## THE BOWL HAS FEW VIBRATIONS OR SEEMS TO WORK SLOWLY

If the vibratory feeder has an insufficient amount of vibrations or seems to be running slow, and if it has sporadic or irregular movement of parts, it may be due to one of the following reasons:

- 1) It may be mounted on a base plate that is too thin. If so, it will flex too much, consequence it absorbs the vibrations.
- 2) The base plate may be mounted improperly, lacking rigidity.
- 3) The feeder may be mounted on a sub-base plate that overhangs the machine or table and does not transfer enough vibration for the parts to move.
- 4) The table may not be levelled or lagged down properly.
- 5) The coil gap may be improperly set. The coil and striker plate should be parallel and gap set at 0,030" to 0,060" for A.C. and 0,060" to 0,100" for D.C.
- 6) The machine may be cycling/indexing to sharply, causing the parts to be knocked from the feeder tracks .
- 7) The voltage to the controller may be fluctuating.
- 8) The drive unit may need re-tuning. The power supply is available in this particular area.
- 9) The parts may be bent, warped, have burrs, oil, mold release and/or some type of lubricant on them which will prevent proper movement of the parts.
- 10) The toe clamps that hold the feeder to the cross arms may be loose or the feeder may not be properly seated in the toe clamps. It is very important that the feeder makes contact on all points of the cross arms. If all points are not in contacted the feeder may develop "DEAD SPOTS" because the cross arms cannot transfer the proper amount of vibrations. The feeder could also be too heavy or too light for the spring setup on the spare drive unit.
- 11) The air gap between the coil assembly and strike plate (ilamb) is very important. If the air gap is too little the coil will clatter, too much energy will not be used, and the coil will overheat.
- 12) If all the points below are ok, check for broken welds on the bowl, repair maybe necessary...

\*Note: If repairs are needed and have weld or polishing area to be made... contact **Orientech** at **1-450-562-0745** to have more details, some case may need special tasks or procedure ...