Orientech
AUTOMATION SOLUTIONS

THE ULTIMATE
CHECKLIST
FOR EFFICIENT
FAT and SAT
TESTING
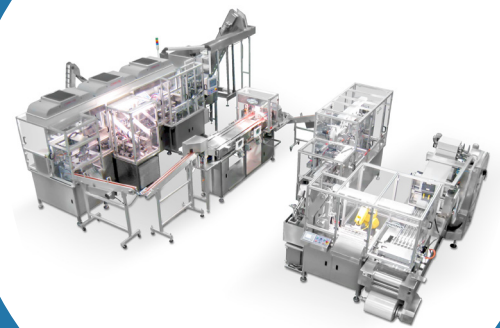
AUTOMATION SYSTEMS APPROVAL

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Date

Manufacturer

Machine Description

Machine Number

Quoted Rate

Timed Rate

Bowl Manufacturer Number

Quoted Rate

Timed Rate

Machine Paint Specially Requested?

VISUAL APPEARANCE

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- [ ] Machine does not have any visible damage

- [ ] All air regulator settings are tagged with name and settings

- [ ] Settings are not attached to removable components that could be replaced

- [ ] Feeder bowl has air jet locations engraved on bowl and air lines tagged with proper regulator location

- [ ] All bowls and motor controllers are tagged with settings

- [ ] All doors open in an operator friendly way as stated in standards

- [ ] Base platform is at an acceptable height

- [ ] Machine paint is acceptable

SAFETY

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☐ All safety circuits are wired where if failure occurs machine will not start

☐ All e-stops work when pressed and machine stops immediately upon pressed

☐ Main power switch is interlocked

☐ There is complete guarding protecting moving components

☐ The machine is free from sharp protrusions which may cause possible injury

☐ Machine stops when any of all guard doors are open

☐ All lower machine guarding is permanently fixed requiring tools or has safety interlocks

ELECTRICAL

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☐ **Level sensors work** (low and high when applicable)

☐ Counter counts every piece correctly and does not overcount

☐ Counter keeps memory if power is lost

☐ No programs are lost when machine is power cycled

☐ All wires are numbered

☐ Breakdown/installation hook-ups indicated

☐ Copy of electrical drawings in electrical enclosure

MACHINE

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- [ ] Tooling is acceptable

- [ ] Everything that is adjustable deemed not necessary should be doweled

- [ ] Spindle does not stick

- [ ] Box diverter working is working acceptable and keeps position if power is lost

- [ ] Box shifter is working acceptable

- [ ] All mechanical designs of machine are acceptable

- [ ] Feeder and machine have consistent feeding and neither out run the other

- [ ] All alarms are properly triggered and displayed within HMIs

DEFECTIVE PART DETECTING

- [ ] Rejected parts are consistent

- [ ] Machine stops after 3 consecutive rejects

- [ ] Reject mechanism is fail proof

- [ ] Parts inspection: sensors are working correctly

VISION

- [ ] Camera bracket(s) supplied are acceptable

- [ ] PLC is programmed for trigger, reject, and inputs

- [ ] Machine has spots on terminal strip for wire connections for vision

RUNOFF CRITERIA

Overall Equipment Effectiveness

Overload stoppages

Low track stoppages

3 reject stoppages

Feeders jams

Runoff start time

Runoff stop time

Scrap parts

Good parts

Scrap%

SIGNOFF

Buyer signature

Vendor print

Print

Date

Date

Signature

SPECIAL NOTES

PRINTABLE CHECKLIST

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NEED ANY HELP WITH YOUR AUTOMATION PROCESS OR PROJECT?
—— Contact Our Specialized Engineers ——