

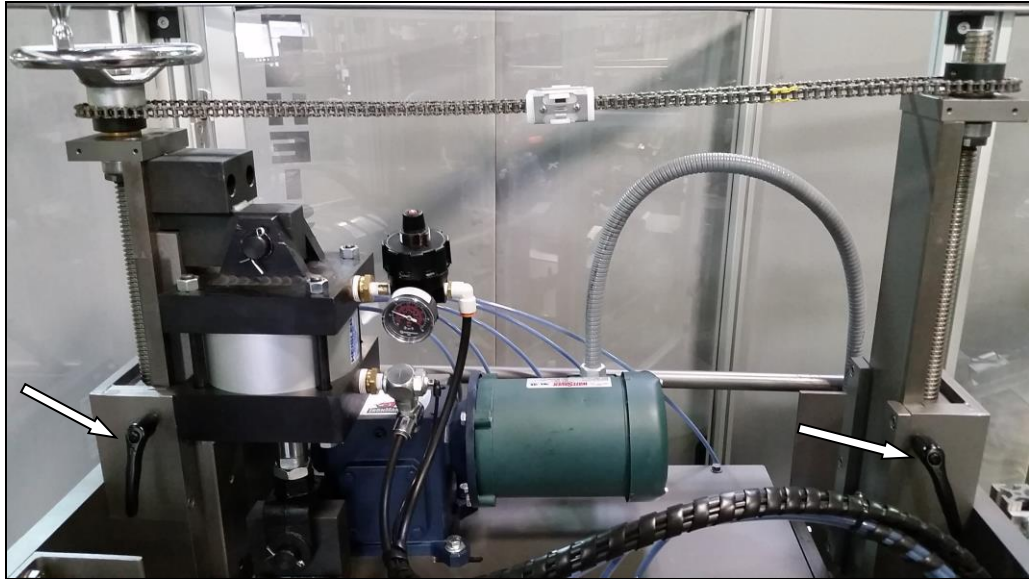
Bulletin No	54	2017-01	Issued: 120717	Revised:	Page 1 of 3
Equipment	Lidplacer with Pail Height Compensating Roller Closer				
Topic	Roller Closer & Pail Height Compensator Setup				

Issues:

1. Initial Entry Roller Height Adjuster Screw Setting.
(Usually a one-time factory setting.)
2. Initial Exit Roller Height Adjuster Screw Setting.
(Usually a one-time factory setting.)
3. Roller Press Overall Height Setting.
4. Compensator Regulator Setting.

Always Follow Lockout / Tagout Procedures to isolate air & electric energy sources.

1. Initial Entry Roller Height Adjuster Screw Setting:



Loosen both lock handles on adjuster slides.

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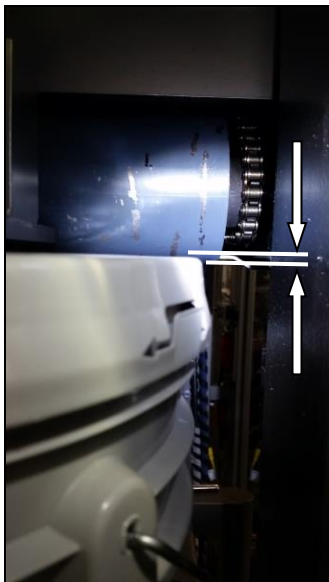


Turn the crank handle to adjust the Entry Roller height adjuster screw.

The bottom of the entry roller should gently rub the top of the lid, when it is loosely nested on the pail, as shown in the picture.

2. Initial Exit Roller Height Adjuster Screw Setting:

- Remove the adjuster chain master link.
- Remove the adjuster chain from the sprocket below the crank handle on the exit roller height adjuster screw.



Turn the crank handle to set the exit roller height adjuster screw.

The bottom of the exit roller should be 1/8" to 1/4" below the top of a lid, when it is fully pressed on the pail.

This must be with the air cylinder rod fully extended downward.

- Re-install the adjuster chain and master link.

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3. Roller Press Overall Height Setting:

Once the initial setup of the entry and exit roller height adjuster screws is done, the roller closer pitch is set. Only the overall height need be adjusted. This should be slightly below the shortest pail.

When setting the roller press height to a new pail, the exit roller should be 1/8" to 1/4" below the top of the lid that is fully pressed on the pail. This is when the air cylinder is fully extended downward.

- Loosen both lock handles on both adjuster slides.
- Turn the crank handle to set the exit roller height.
- Re-tighten both lock handles before operating.

4. Compensator Regulator Setting



Set the air cylinder pressure between 10 and 15 psi. (Avg. is 14 psi.)

If the pressure is too high, it will cause paneling or warping of the pail wall, and the lid would fail to press evenly and seal.

If the pressure is too low, the lid would fail to press fully and seal.

The general rule is to use as much pressure as the pail will allow, without paneling or warping the pail wall.