



6R25 HOPPER OPERATING MANUAL

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1. HOPPER INSTALLATION

1.1 Hopper Installation

The capping machine must be installed and connected to the other components in the line by conveyor transfer. The hopper is usually the next item to be installed. Install the hopper in the following manner (*Figure 1*):

1. Set the hopper for either standard model machine or gallon model. The hole is stamped "G" for gallon. It is very important to have the hopper in the proper hole location. Mount the hopper onto the capper. The hopper support should be mounted onto the hopper post (*Figure 2*). The hopper assembly must be mounted in position on top of the hopper support, aligning the four holes (*Figure 2*). This is bolted together with four #3/8-16x1-1/2 hex head cap screws (*Figure 3*).
2. Swing the hopper into position. Use existing hole.
3. Attach any turnover at the top of the hopper discharge plate. Secure the bottom end of the turnover to the bottom connecting plate with pin. Position under the capper cap chute and secure with "C" clamps. Remove turnover and try remaining turnovers to insure correct alignment. Transfer the two holes in the cap chute plate and secure with (2) #10-24x1/2 flat head screws.
4. Cut the turnover side guides to the proper length.
5. Attach transfer plate with #10-24x1/2 flat head screw.
6. Adjust drum height by loosening the knob until the key is free. Turn the drum to the proper key slot and lock.
7. Adjust the hopper top guide for 1/16" maximum clearance over cap.
8. Position the guide opposite of the strip off guide in marked hole to suite cap size.
9. Adjust the strip off guide for approximately 1/16" cap clearance.
10. Adjust the cap metering slot in top of the drum to suit cap output.
11. Mount the electrical box-wire leads on top. Clamp the sensor flush with the cap chute plate. Excess sensor wire should be in the electrical box.
Note: Sensitivity and time delays have been adjusted.
12. Wiring diagrams are in the electrical box.
13. Fill the cap chute. Set the switch to the manual position. When caps back up past the sensor, switch to the automatic position.

1. HOPPER INSTALLATION

14. The drum RPM should be minimum to keep up with the line.

Example: 14 RPM should deliver 300 58RTO caps per minute. 9RPM should deliver 100 110mm caps per minute.

15. DTO cap adjustments.

16. Insert the return guide. The blade should be flat on the disc. Locating screws must be tight.

17. Loosen the thumb screw. Adjust to proper setting and tighten, for cap return gate.

18. Unlock the diverter. The diverter must be free.

19. Adjust the pin wheel to the height shown.

20. Top and side guide adjustments are the same as items 6,7,8, and 9.

1. HOPPER INSTALLATION

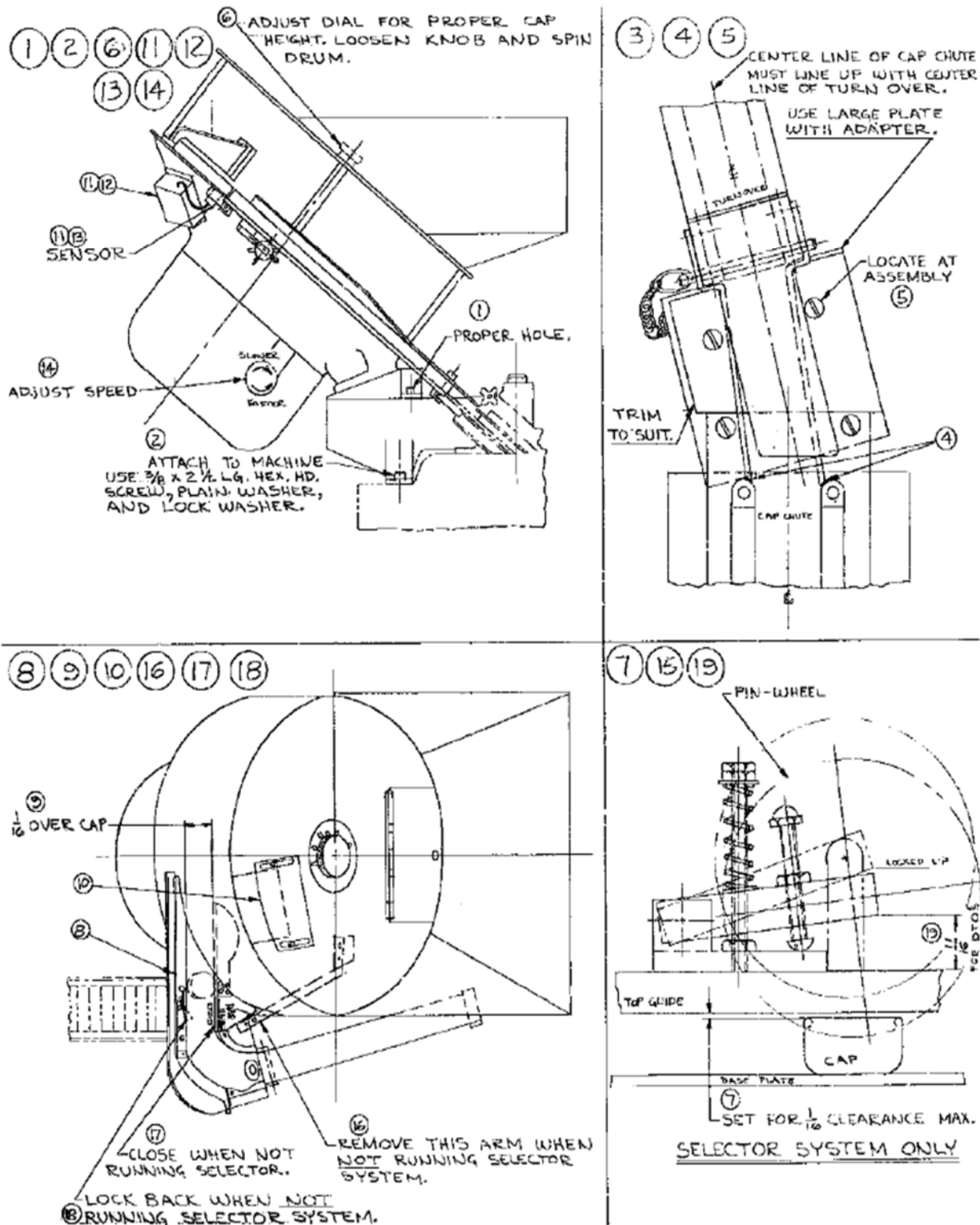


Figure 1: General Installation Diagram

1. HOPPER INSTALLATION

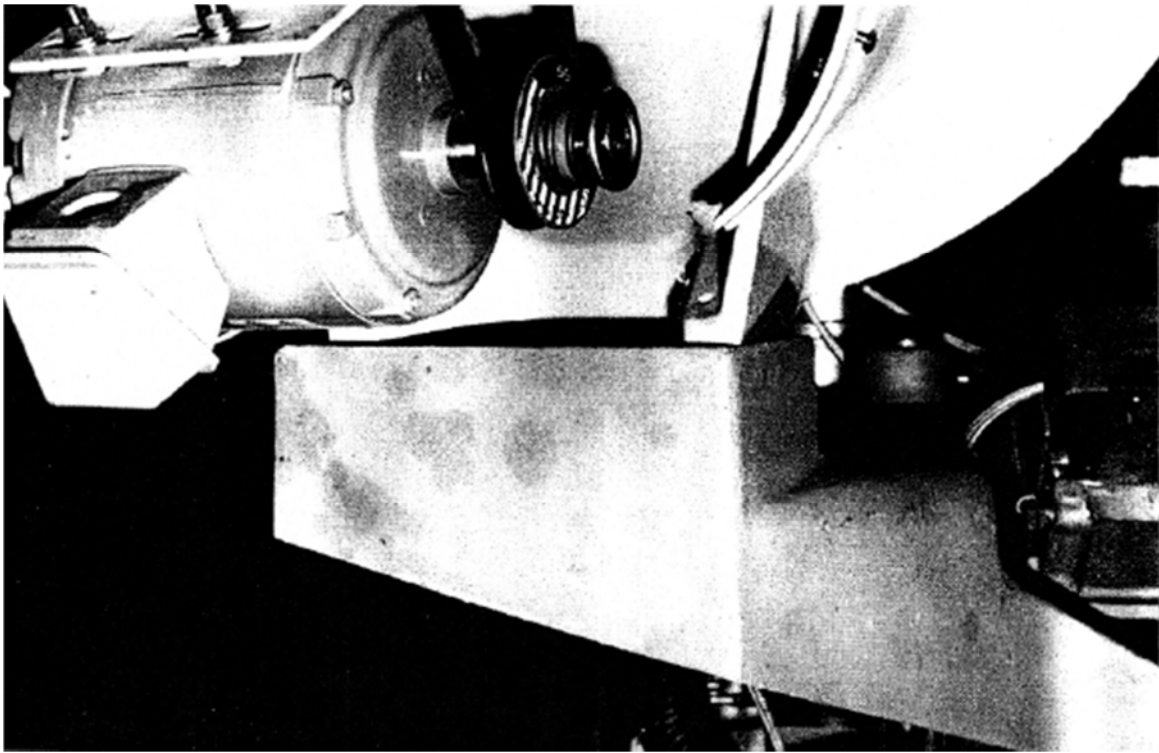


Figure 2: Mounting the Hopper

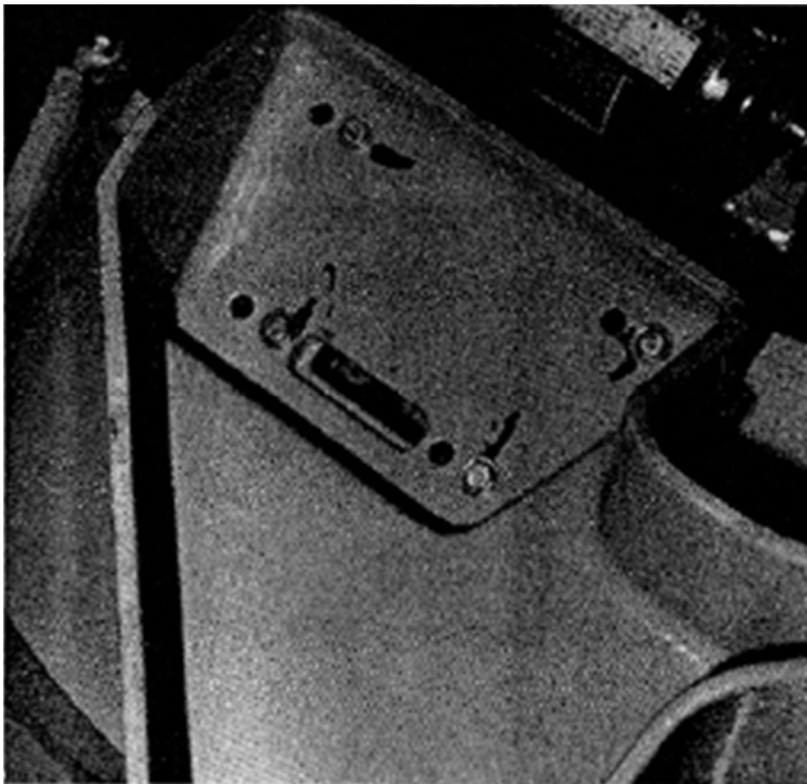


Figure 3: Fastening the Hopper to the Support

2. TURNOVER INSTALLATION

2.1 Turnover Installation

Assemble the connecting tie plate to the exit end of the turnover. Position the entrance end of the turnover with the rod assembly provided under the chute base. Using contact with the rod and turnover connecting block as a pivot, swing the turnover into position with the machine chute and mark the screw holes from the chute plate to the connecting plate of the turnover. Tap 10-24 threads and attach with two 10-24x1/2 flat head screws (*Figure 4*).

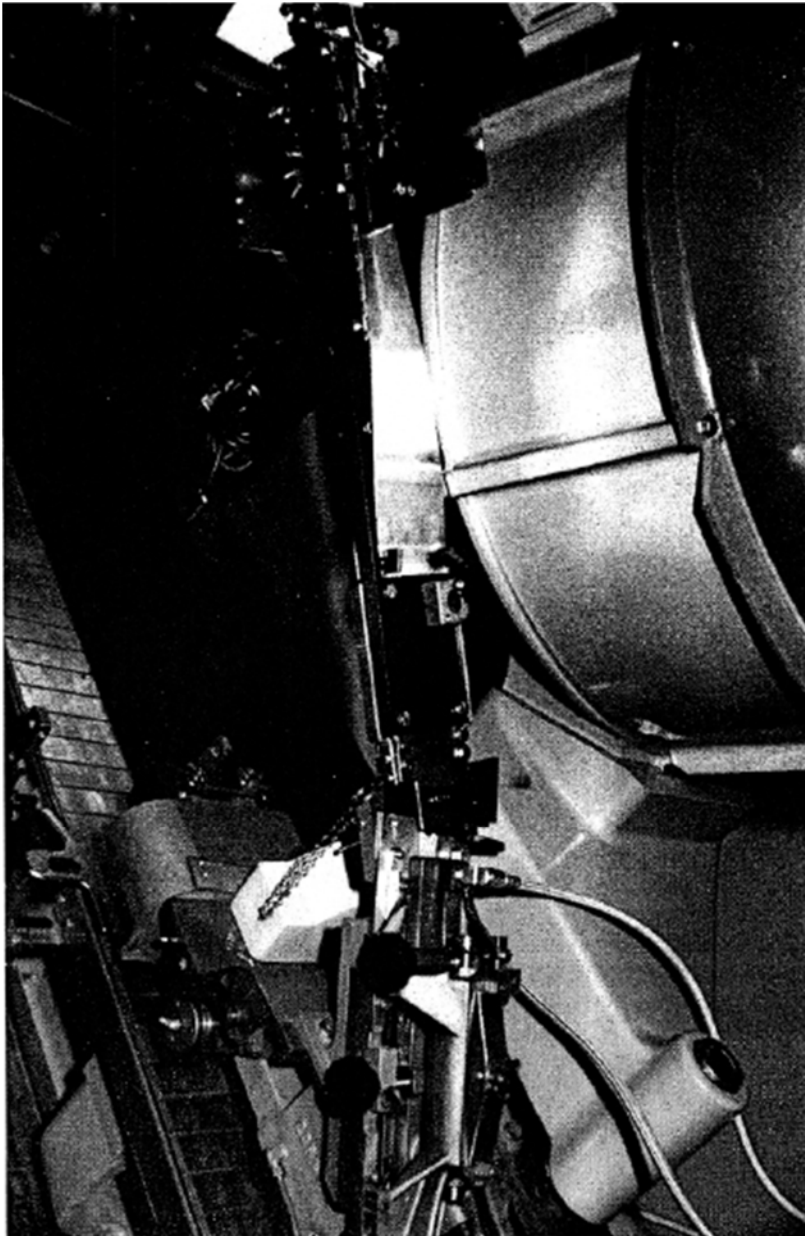


Figure 4: 6R25 Hopper with Cap Chute & Turnover in Place

3. MOTION CONTROL INSTALLATION

3.1 Motion Control Installation

Use the following instructions to install the motion control unit.

1. Mount the control box on the rear casting of the hopper, or in some other convenient location.
2. Bring the leads from the hopper motor starter to the box. Enter through the open connector provided. Connect the starter leads internally to the terminal block screws 5 and 6 (*Figure 5*).
3. Determine the available receptacle voltage (115 or 230 VAC) and set the PC Board Toggle Switch accordingly.
Note: This is a locking lever type switch and requires PC board removal for switching.
4. Plug the power cord into the AC outlet.
5. Plug the sensor into the sensor mounting block on the turnover, or in the underside of the 6R25 hopper chute, or in the top of the 6R24 hopper chute.
6. Gather the excess sensor cord and fasten at a convenient place.

Use the following instructions to make the required adjustments.

1. The sensor mounting block on the lower cap chute has a detent pin. Adjust the tension to hold the sensor in place.
2. The hopper control may be operated in the **HAND** or **AUTO** position. The **HAND** position allows manual hopper control. The **AUTO** position provides an adjustable time delay (0.5 to 10 seconds) between caps before the hopper drive is interrupted. On initial power up (with no caps in chute) the **AUTO** position provides up to a 15 second time delay. If caps are seen by the sensor within this 15 second interval, the control automatically switches to the time delay interval as manually set on the PC board adjustment. The red light on the box cover will be **ON** with the hopper control is in the **AUTO** position.
3. With the hopper and line running, adjust the sensitivity so that the red light on the PC board blinks as each cap passes the sensor.
4. Adjust the time delay (stop adjustment) to suit line conditions. A 3-4 second delay before the hopper stops is a good average setting.

3. MOTION CONTROL INSTALLATION

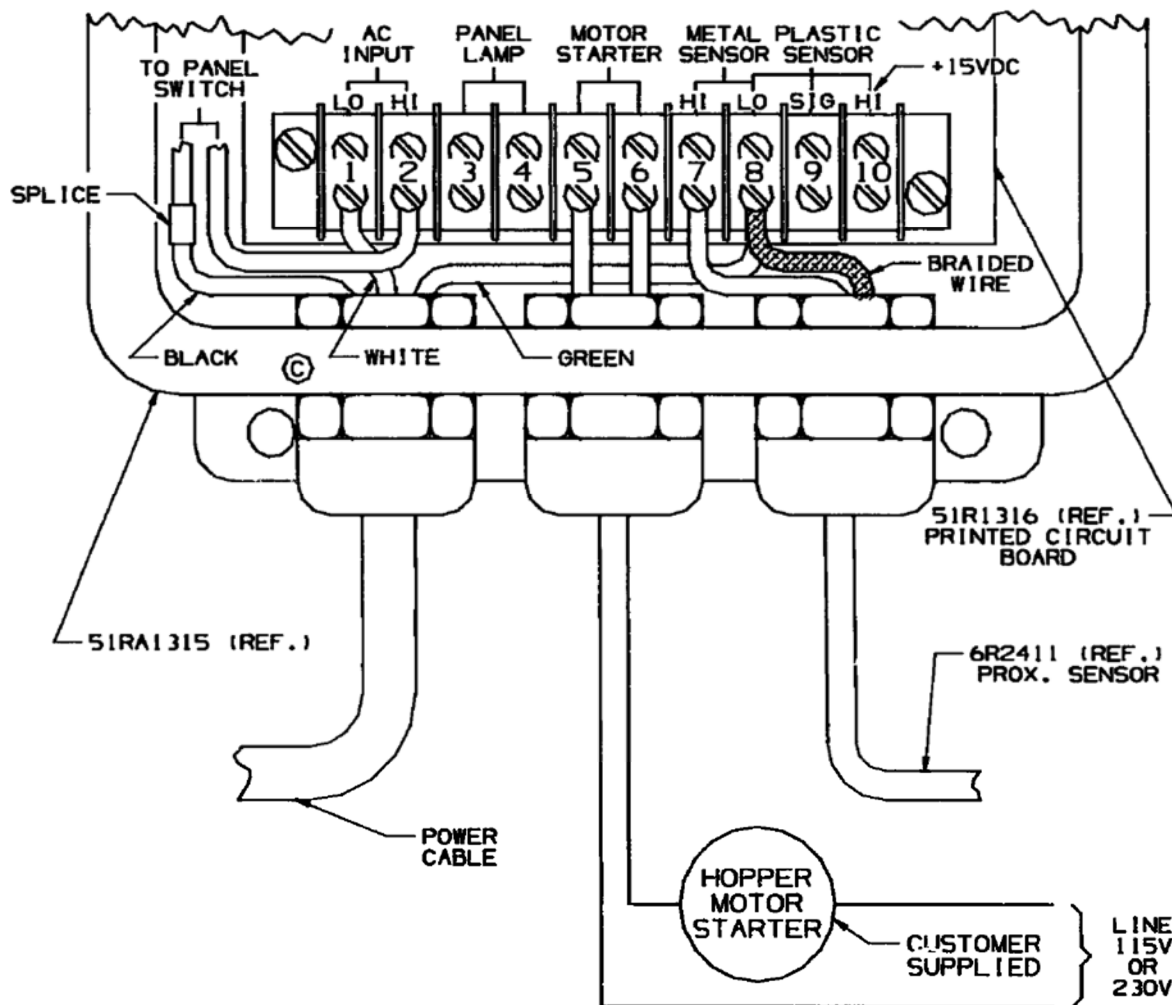


Figure 5: 6R25 Installation Instructions

3. MOTION CONTROL INSTALLATION

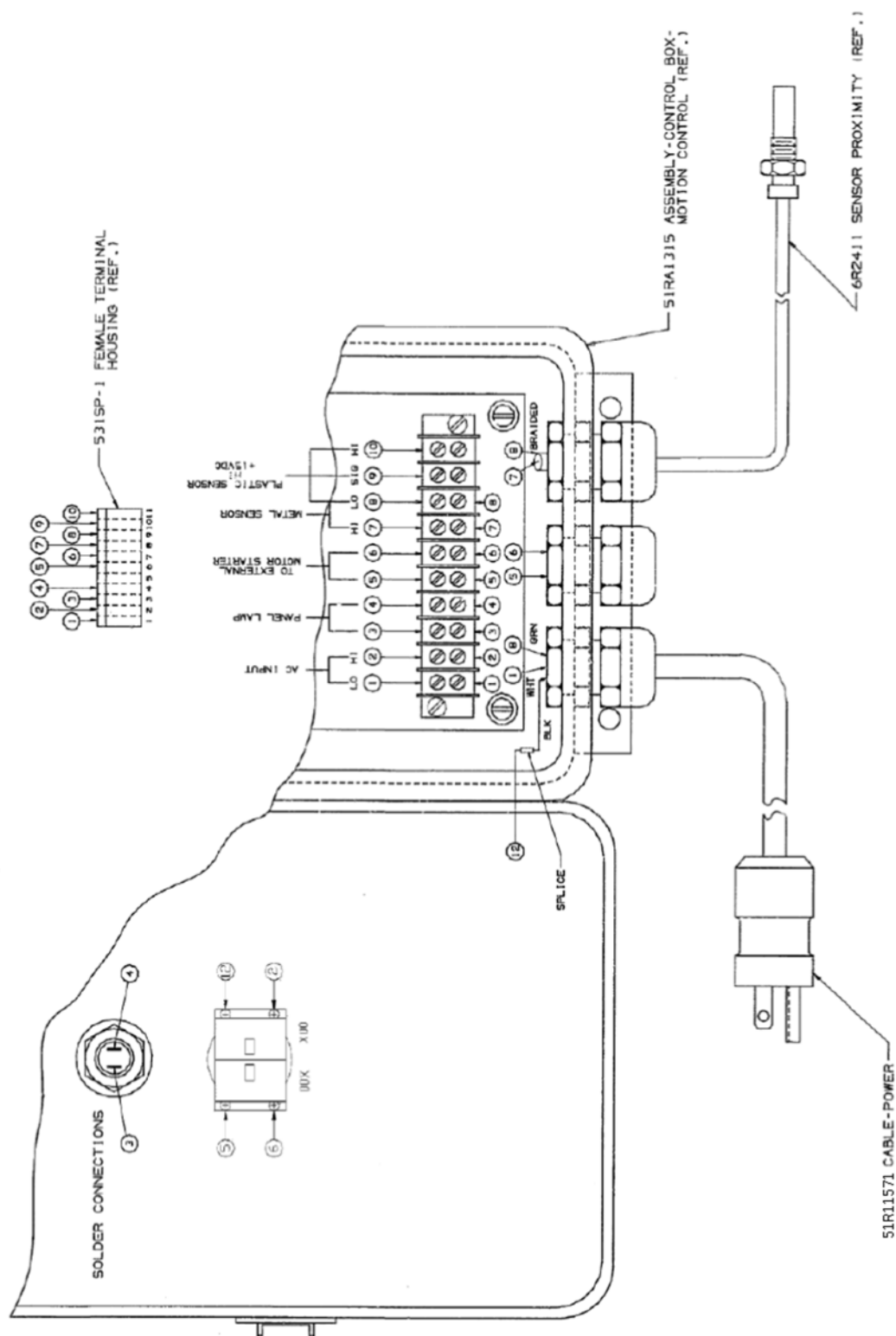


Figure 6: 6R25 Installation Instructions

4. WIRING DIAGRAM

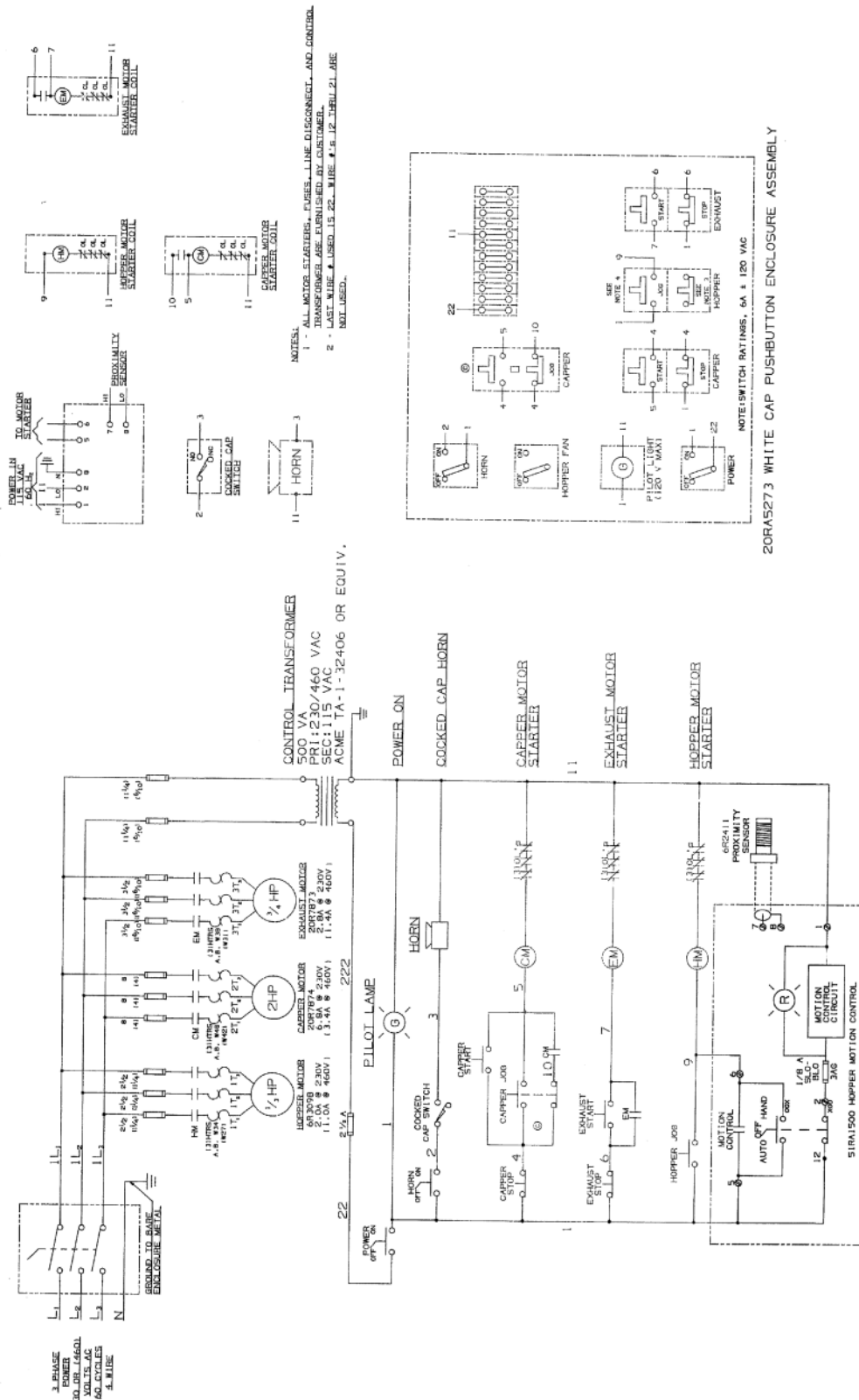


Figure 7: 6R25 Wiring Diagram

4. WIRING DIAGRAM

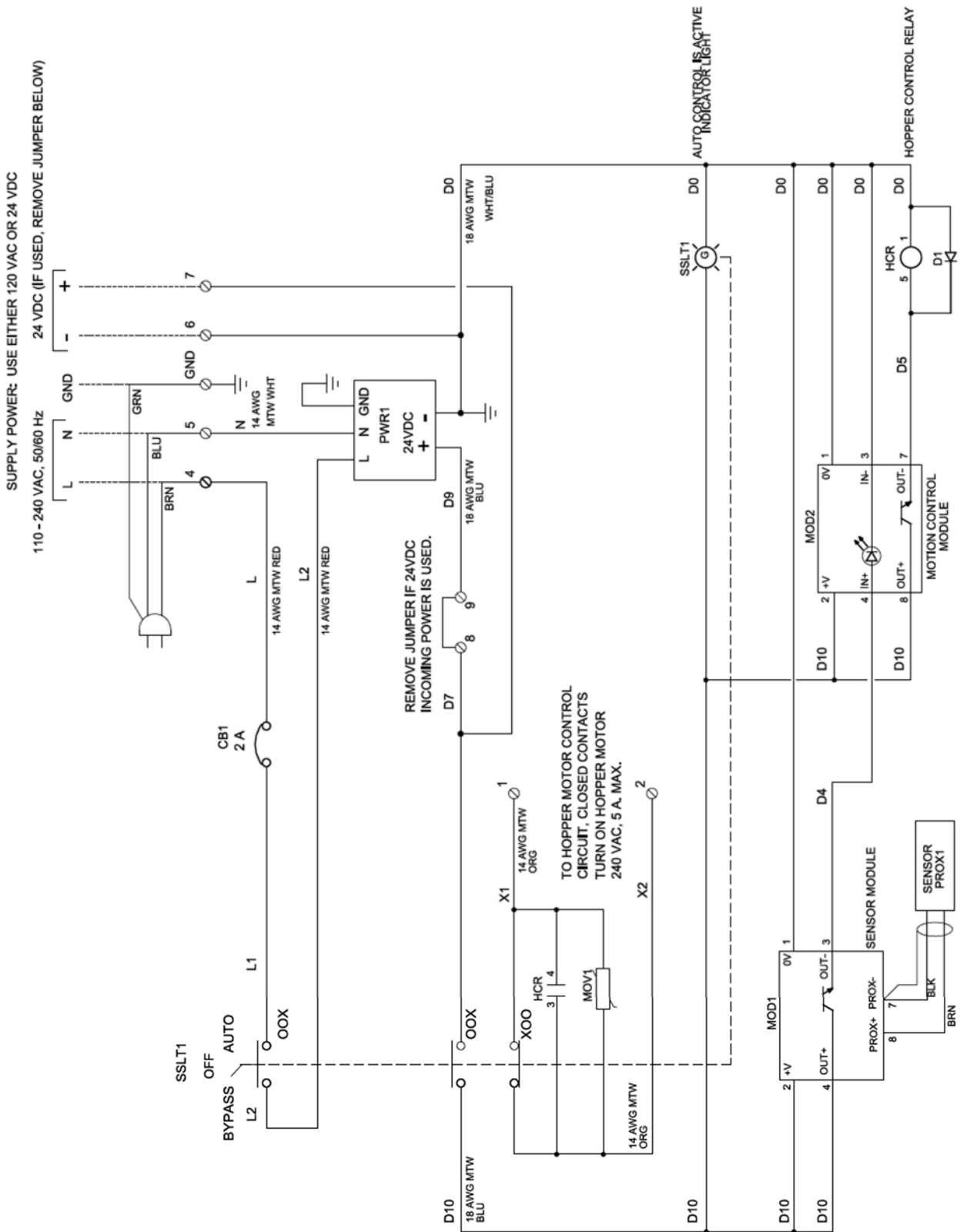


Figure 7: 51R10909 MOTION CONTROL WIRING DIAGRAM