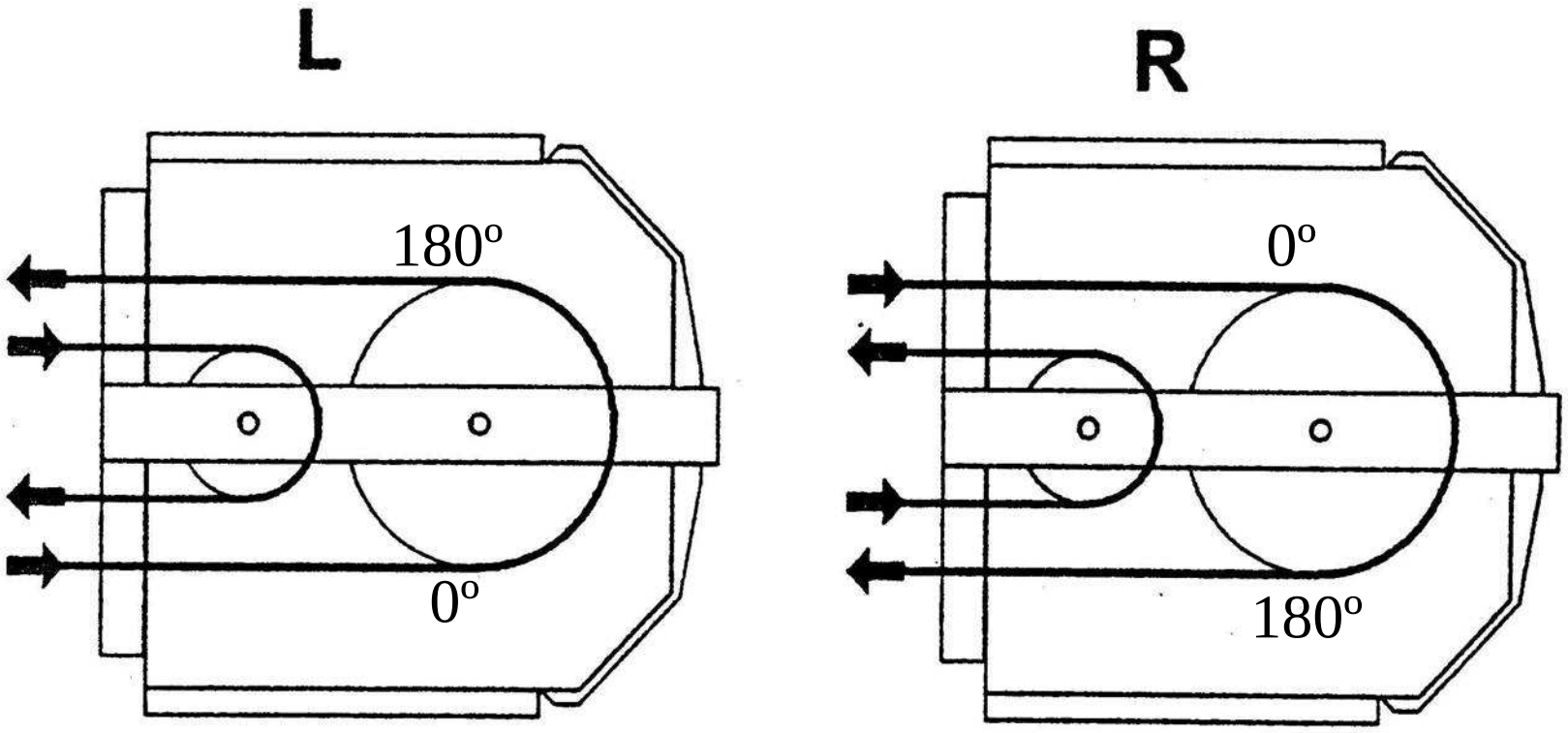
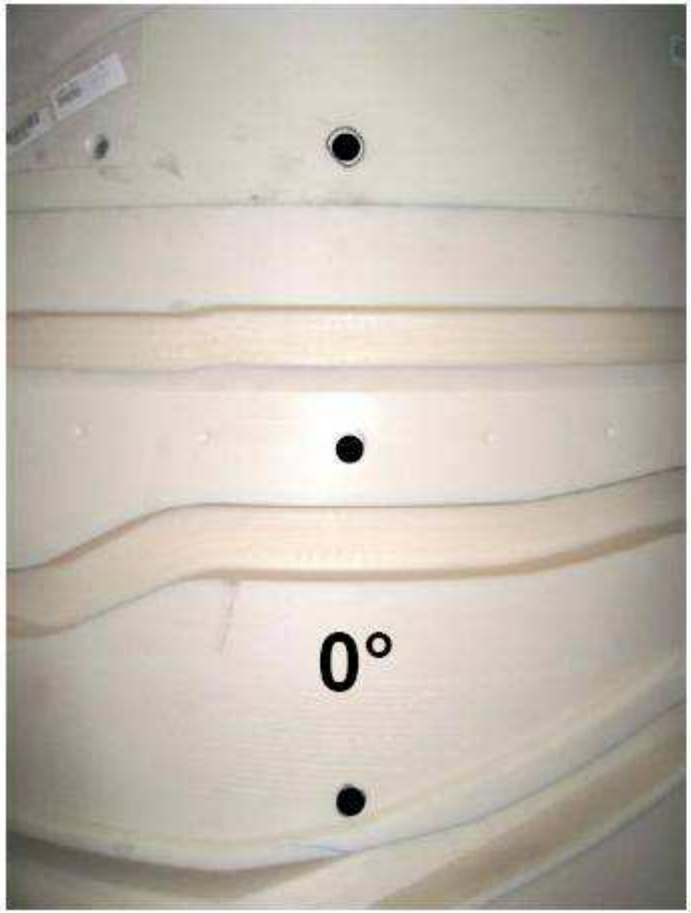
Machine layout

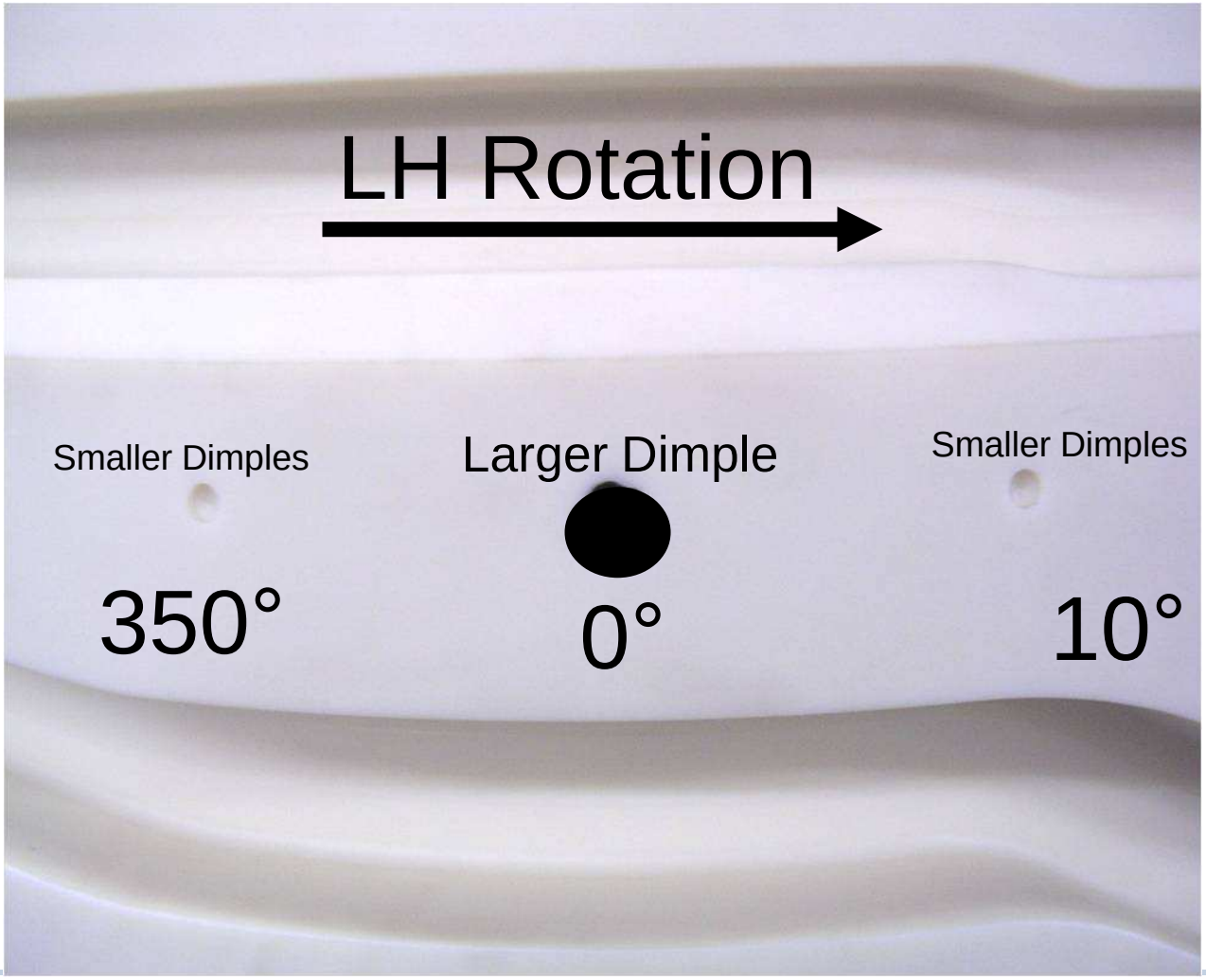


Cam markings

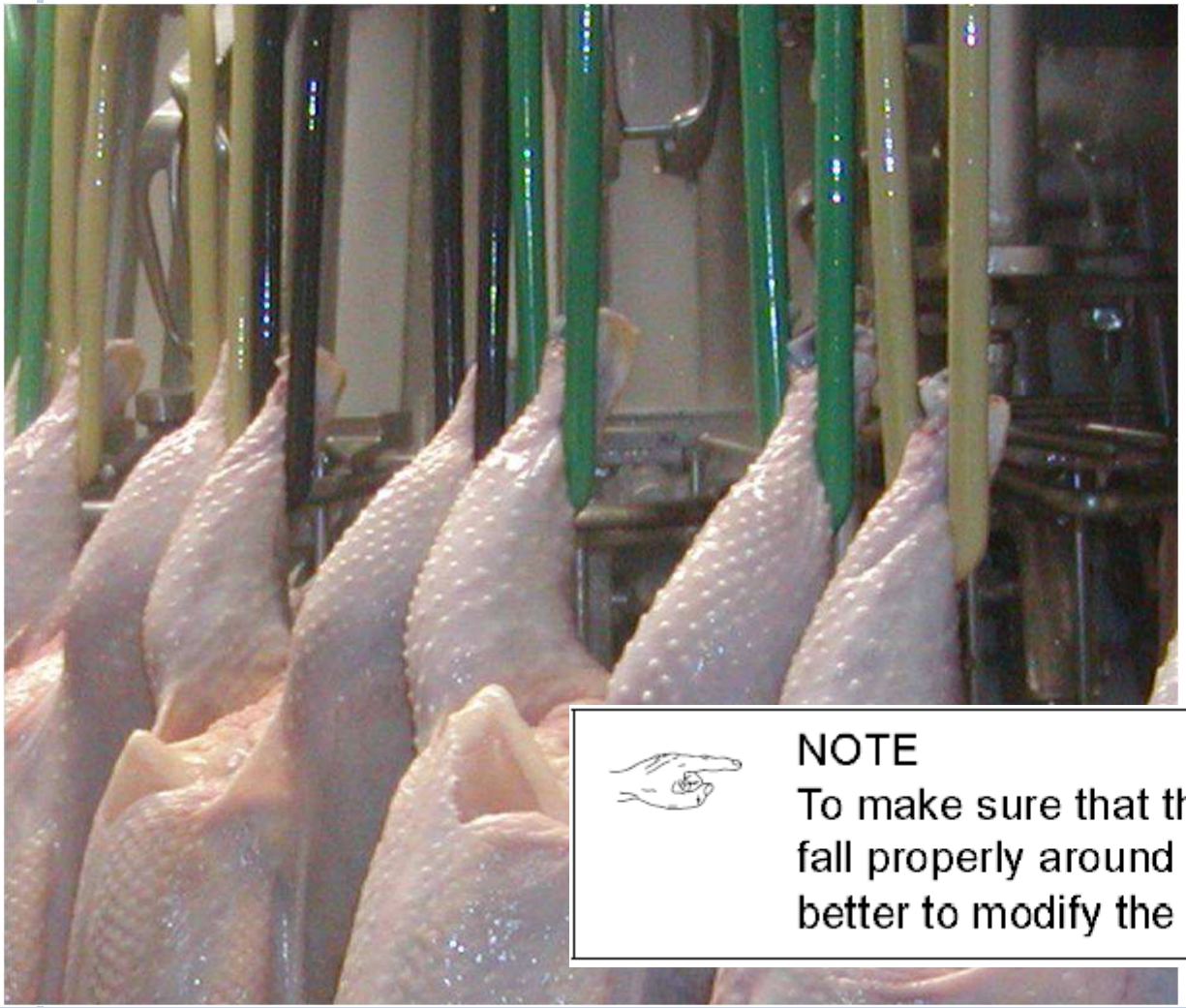


0º is designated by a dimple placed in the upper and lower cams

Cam marked in 10º increments



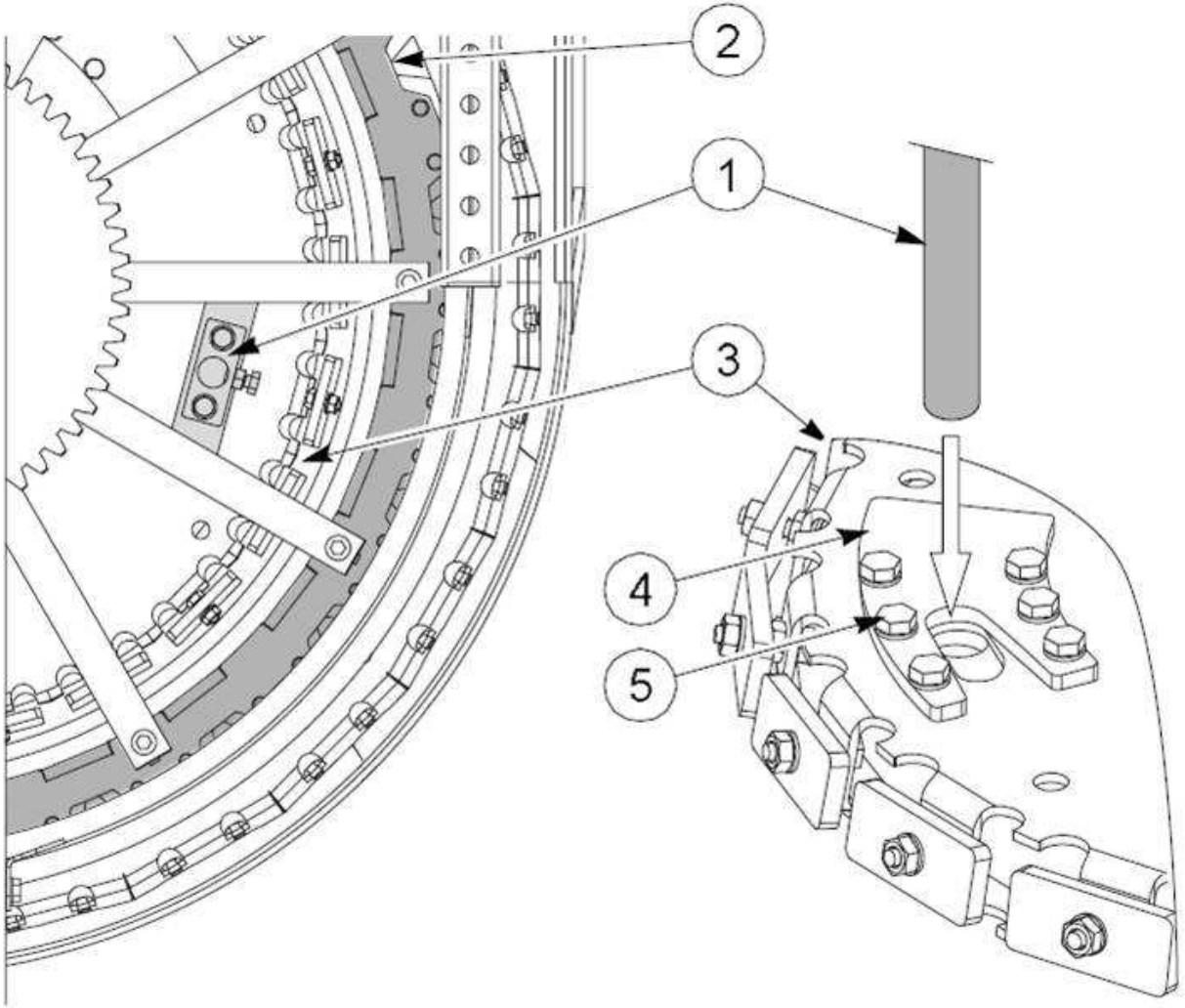
Timing machine to shackle



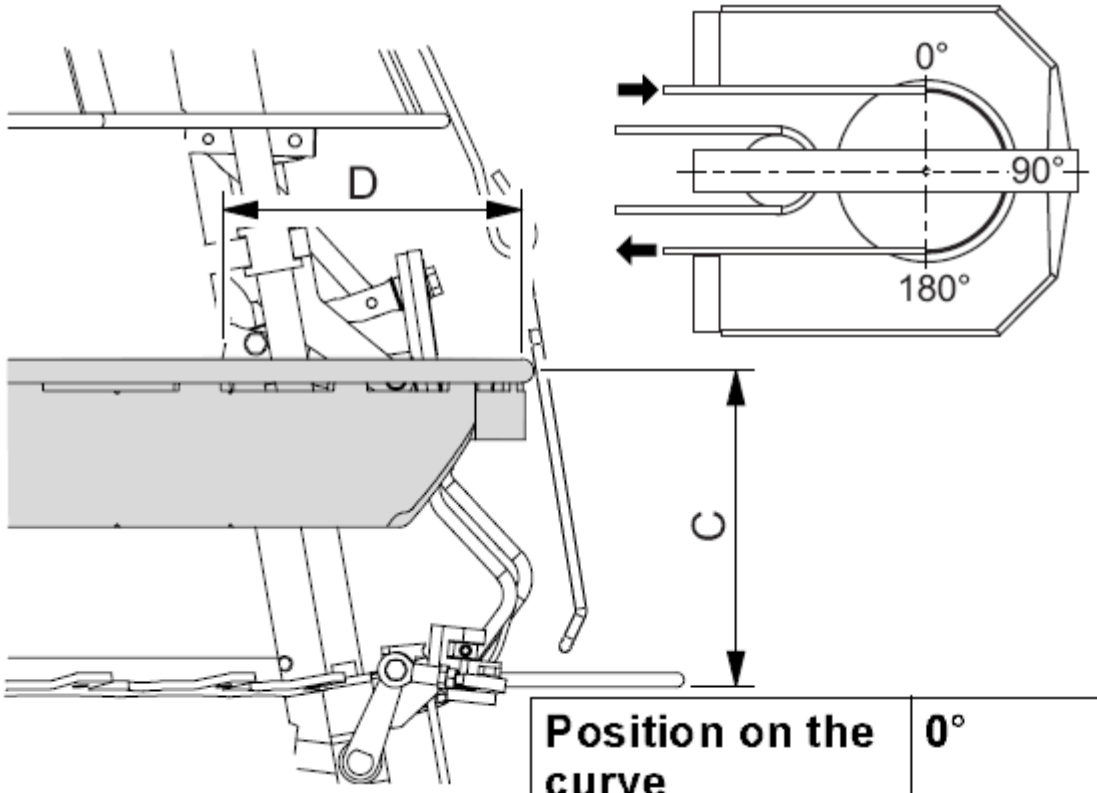
Center shackle on the unit to achieve proper infeed with the leg loop going in between the legs of the bird without interference.

NOTE
To make sure that the legs of the product fall properly around the spread clamp, it is better to modify the settings of the guides.

Timing machine to shackle

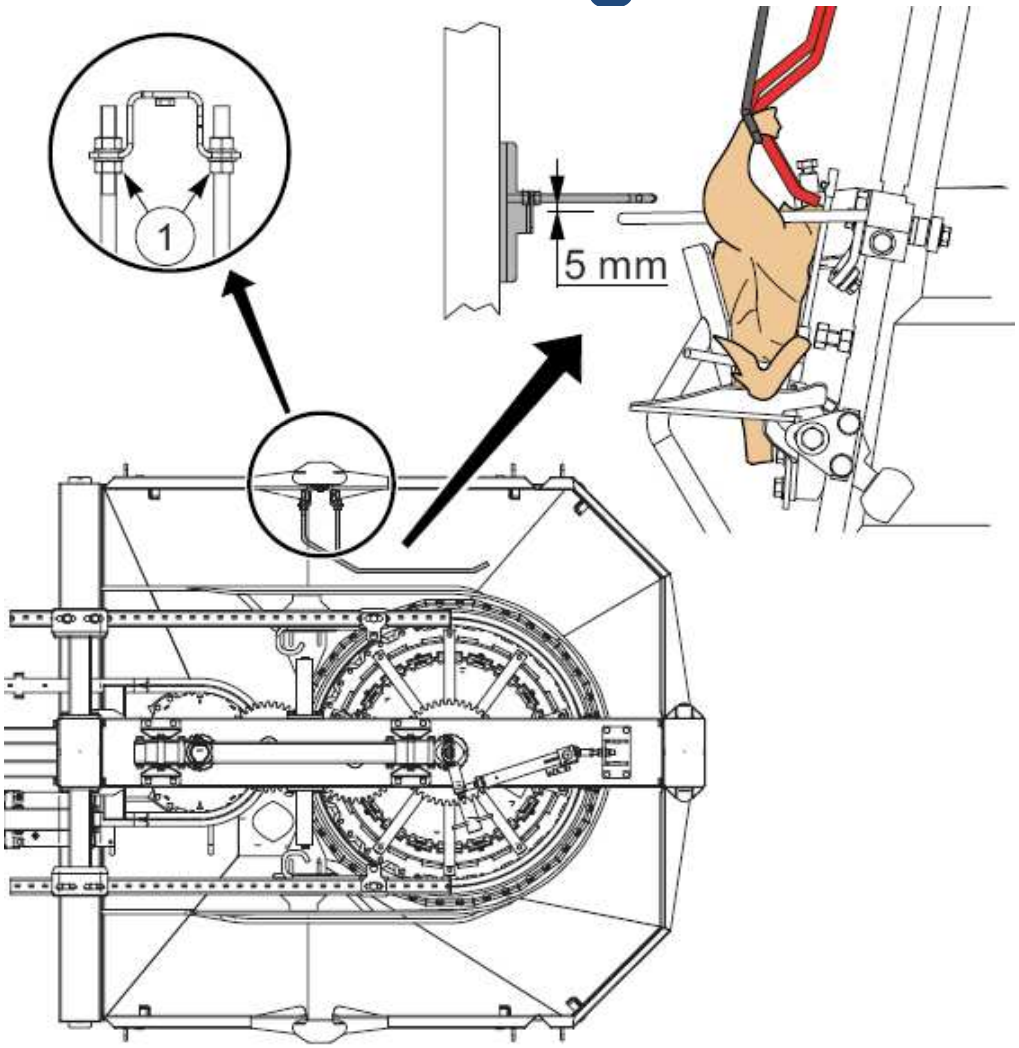


Shackle guide

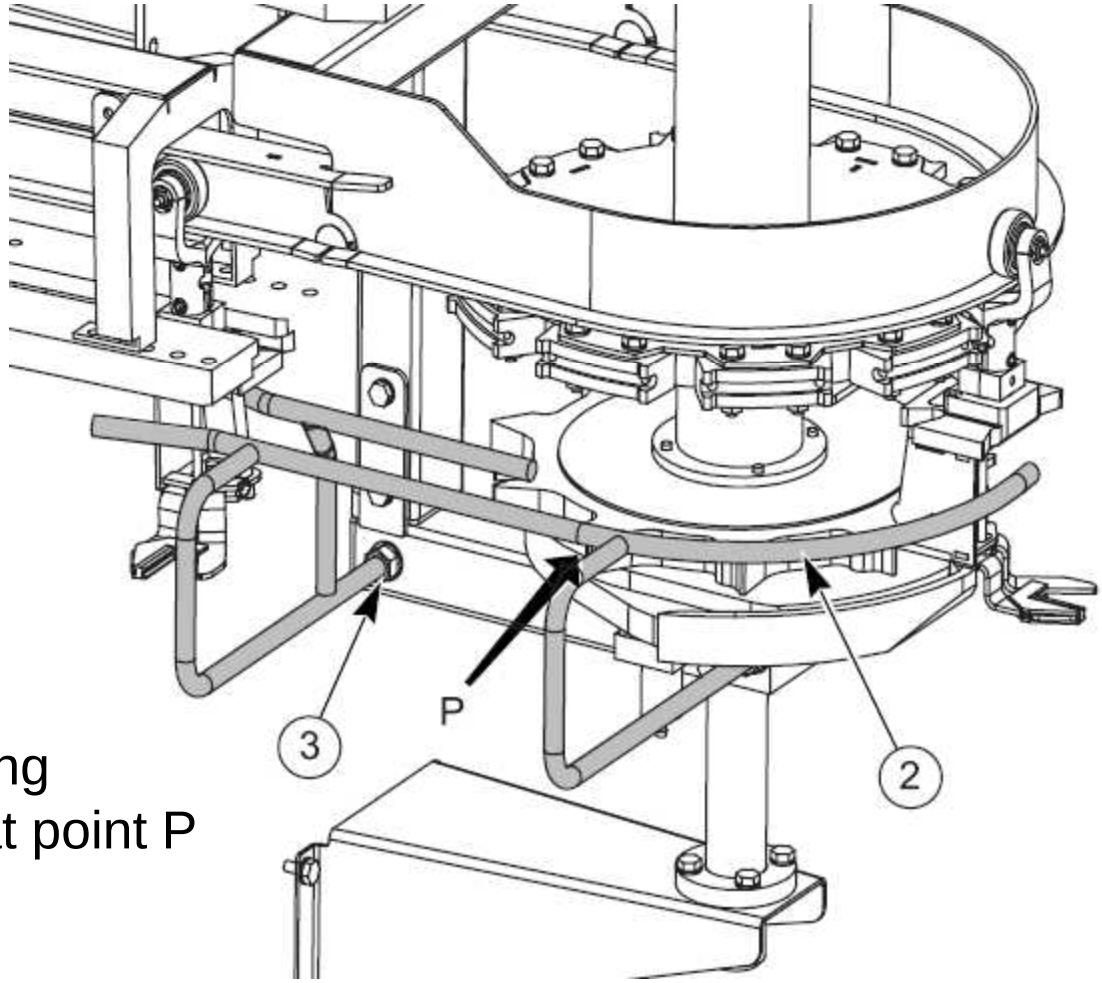


Position on the curve	0°	90°	180°
C	250	250	250
D	220	200	240

Infeed guide

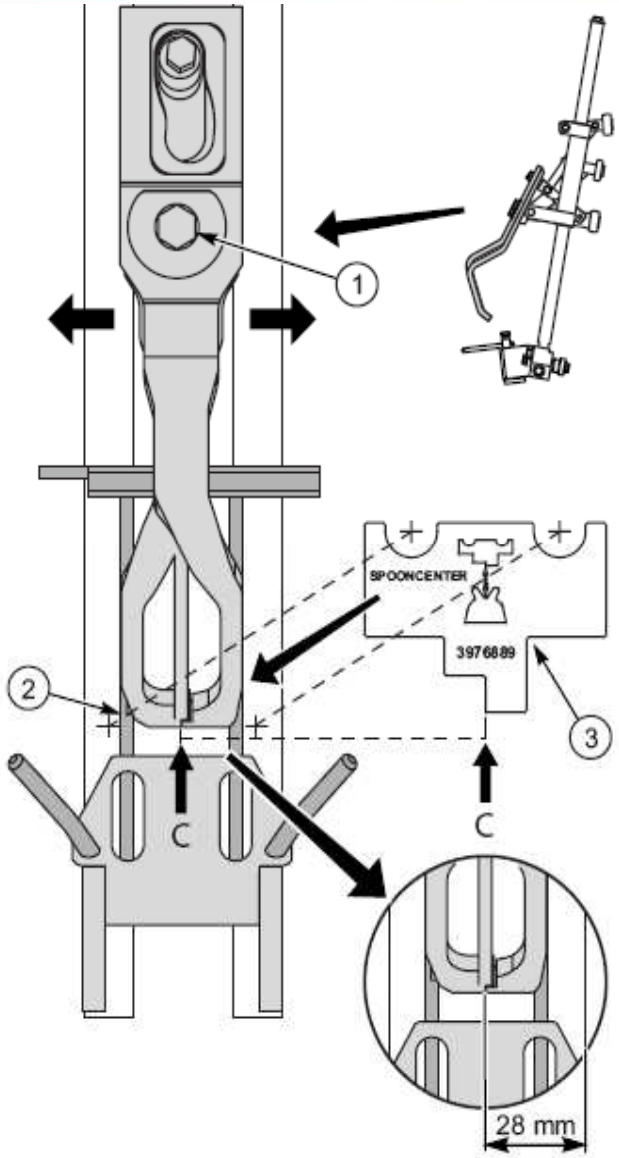


Viscera shackle guide



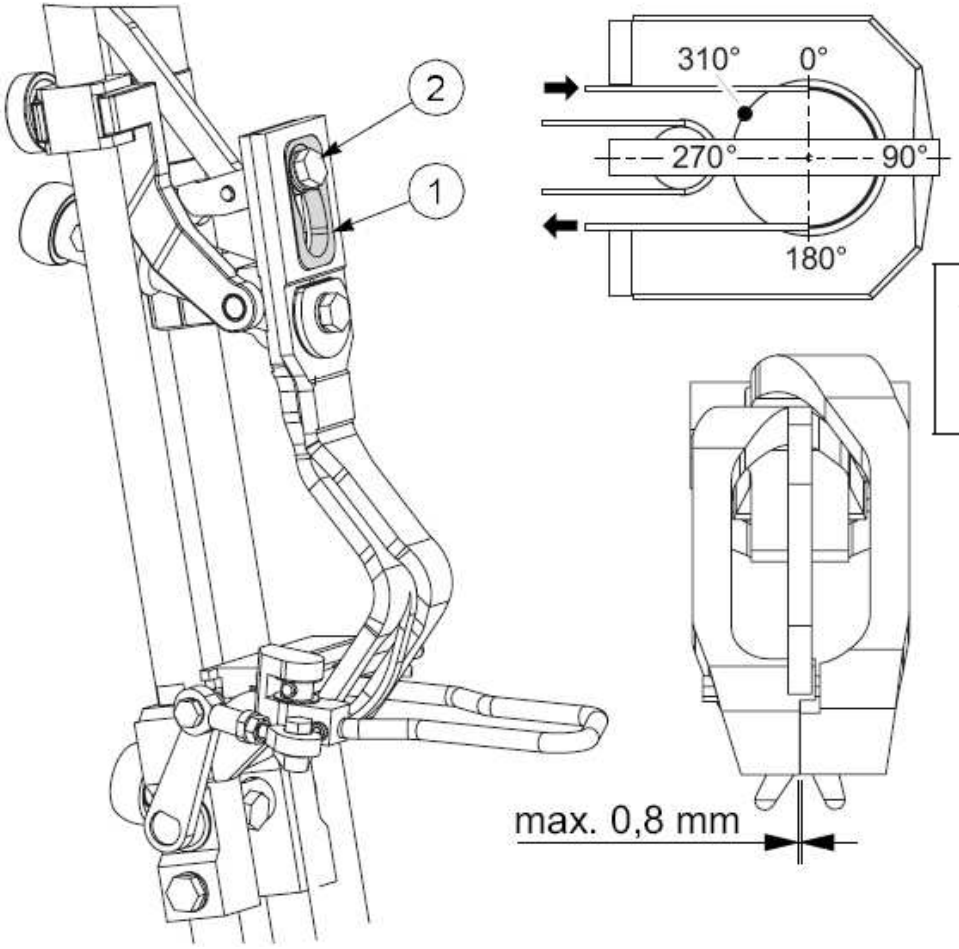
Guide just touching
viscera shackle at point P

Center arm (Spoon to unit) @115º



Center arm (Spoon to unit)

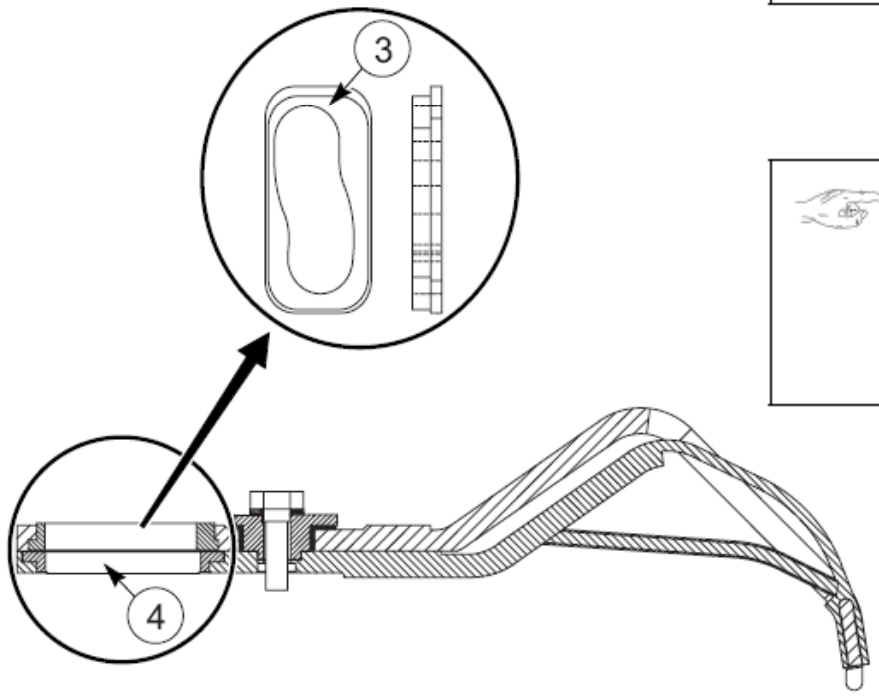
Check clamping force @ 310º



NOTE
Note in Appendix 3: EXTRACTOR BLADES DATA which curve plate belongs with which extractor blade.

Check clamping force @ 310º

NOTE
Overhaul the extractor blade if due to the falling of the shaft **2** a greater opening than 0.8 mm is created between the blade halves.
See fig. 40.



NOTE
The extractor blade consists of two halves which are marked with the same number.
Note this number in Appendix
3: EXTRACTOR BLADES DATA.
Blade halves are not interchangeable!

Arm (spoon) adjustment

1) Loosen attachment bolt

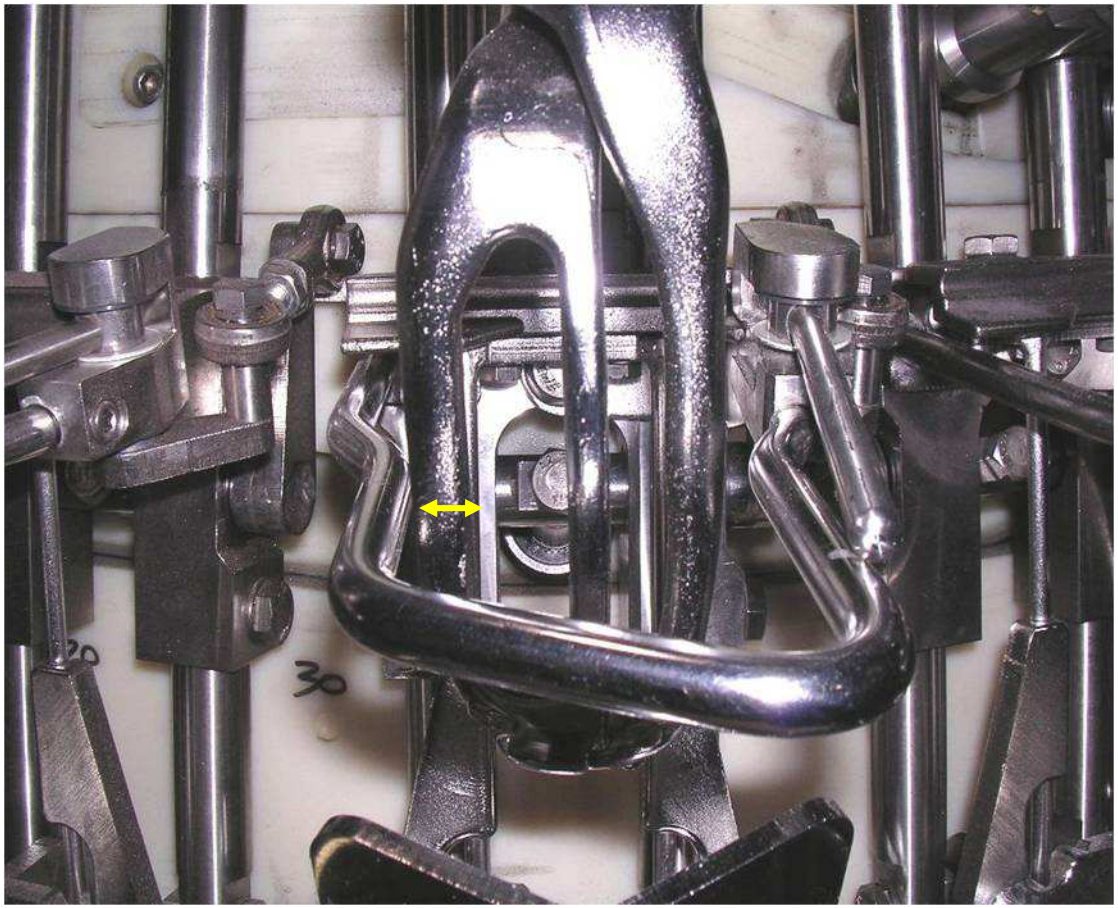
2) Backside of Spoon is notched

3) Adjust spoon by sliding back and forth

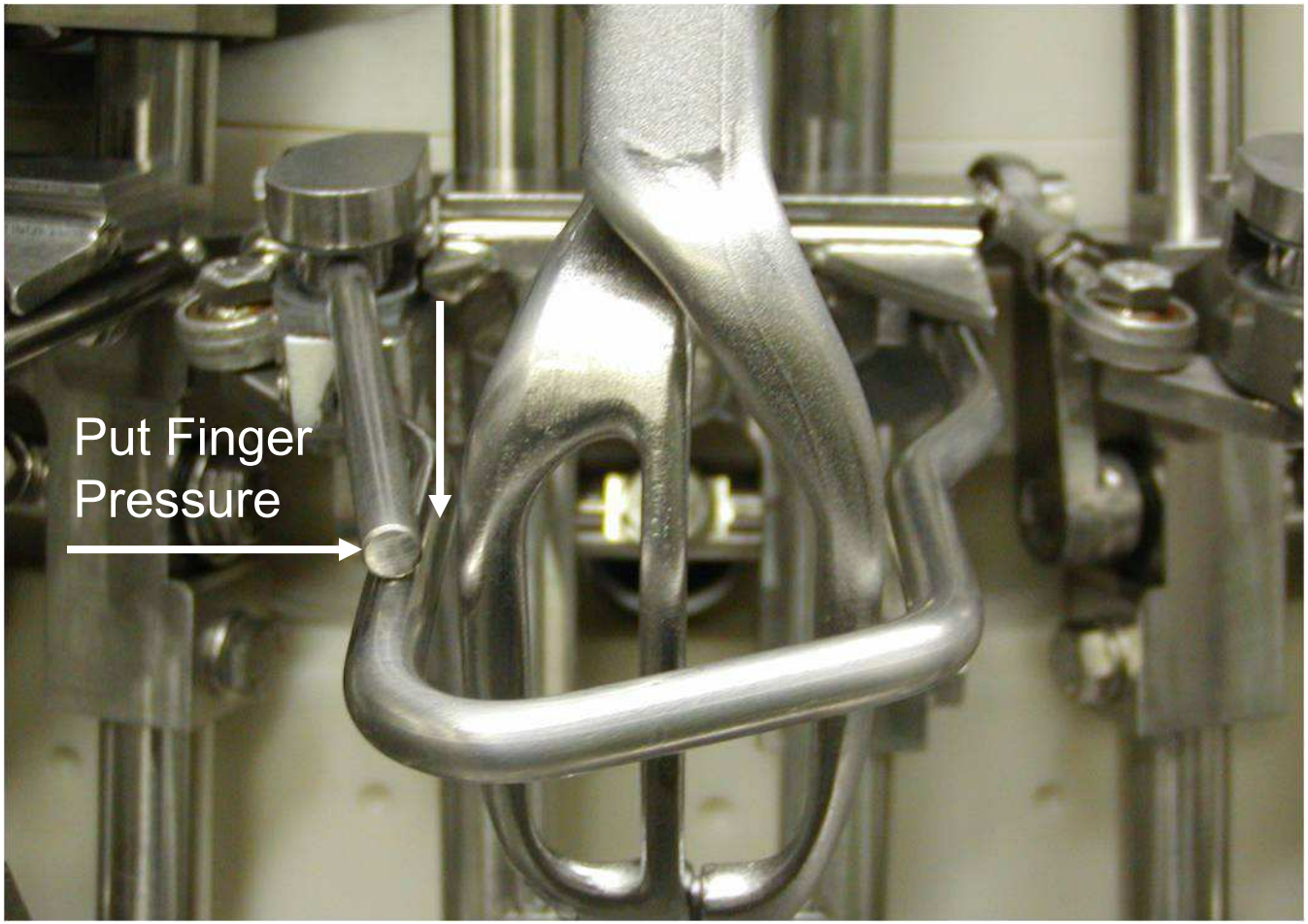
4) Tighten bolt

Arm (spoon) adjustment

With small bird spoons leave the leg loop offset to allow for spoon clearance.



Set gut clamp @ 40°



(b) Bar stays even with inside edge of leg loop

(Insure bar doesn't go into leg loop opening)

(Insure bar doesn't go into leg loop opening)

1) Loosen jam nut

2) Remove Rod end securing bolt

3) Adjust rod end length

Apply Pressure With Finger

4) Put pressure on gut clamp and secure rod end bolt and jam nut

Set arm (spoon) to back plate @ 95º

(turn machine until spoon just closes)

Gauge Starting Points:

Small Bird:

Up to 2 Kg (4.5 lbs) - 8 mm

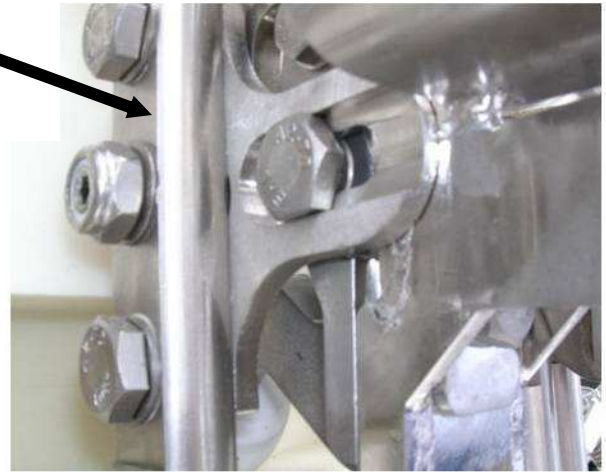
Big Bird:

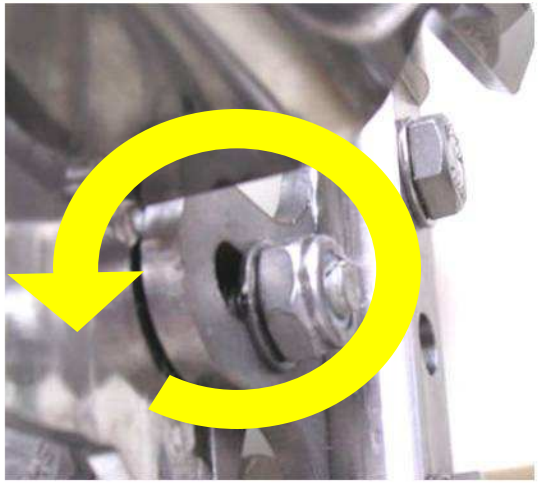
Above 2 Kg (4.5 lbs) - 10 mm

(Settings above are just starting points. Final settings will be dependent upon your actual bird size.)

Measurement E:	LD	Norm	HD
Template 5	6 mm		
Template 6		8 mm	
Template 7			10 mm

Bolt head is locked in slot

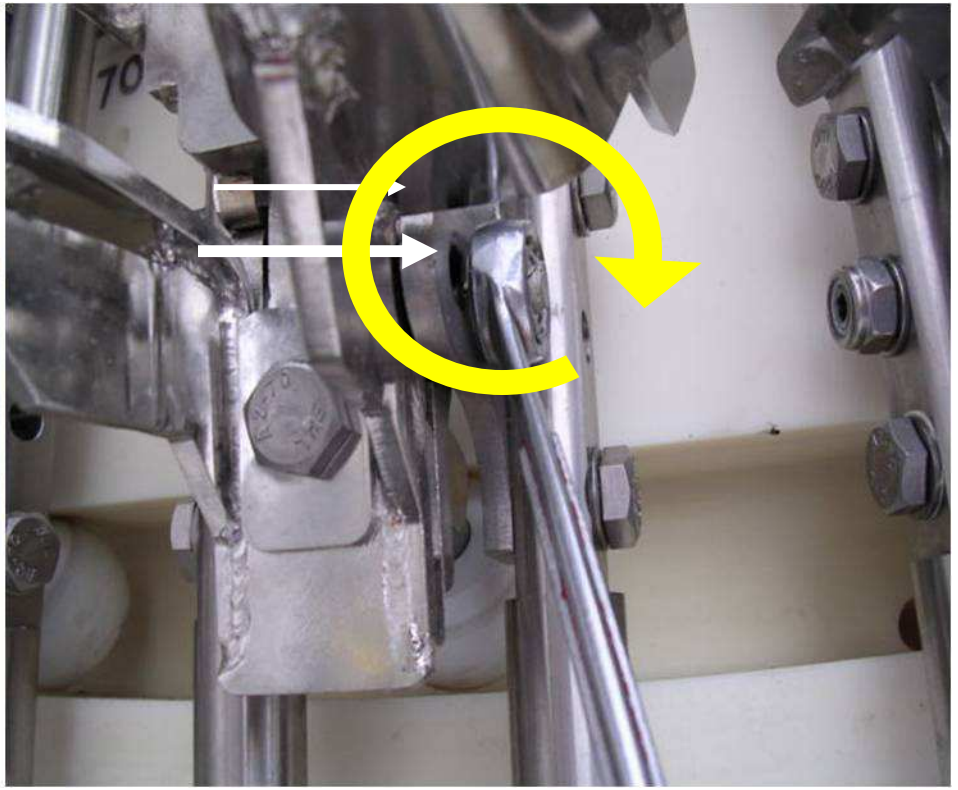




1) Loosen back plate adjustment bolt by loosening nut.

2) Insert gauge between arm and back plate when spoon just closes.

a) Set arm (spoon) with gauge (cont)



3) Pull back plate forward in slot to engage spoon against gauge tightly.

4) Tighten adjustment bolts

Set lifters @ 95º

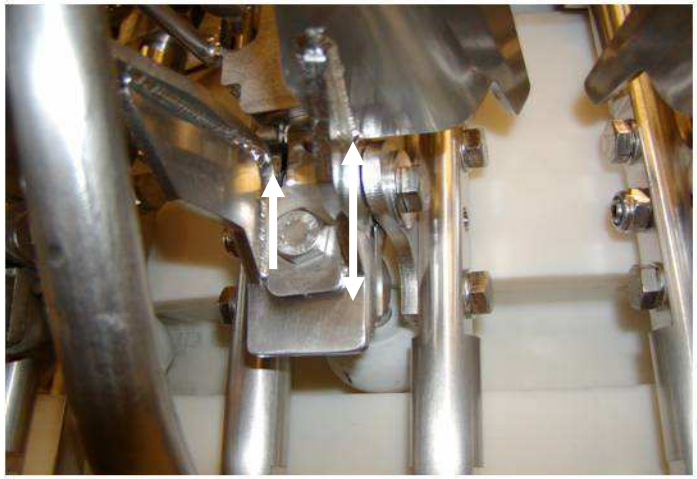
Rotate machine and stop when the spoon closes.

<u>Gauge Starting Points:</u>
Small Bird:
Up to 2 Kg (4.5 lbs)- 24 mm
Big Bird:
Above 2 Kg (4.5 lbs)- 26 mm

(Settings above are just starting points. Final settings will be dependent upon your actual bird size.)

Measurement G:	LD	Norm	HD
Template 4		22 mm	25 mm
Template 5	18 mm		

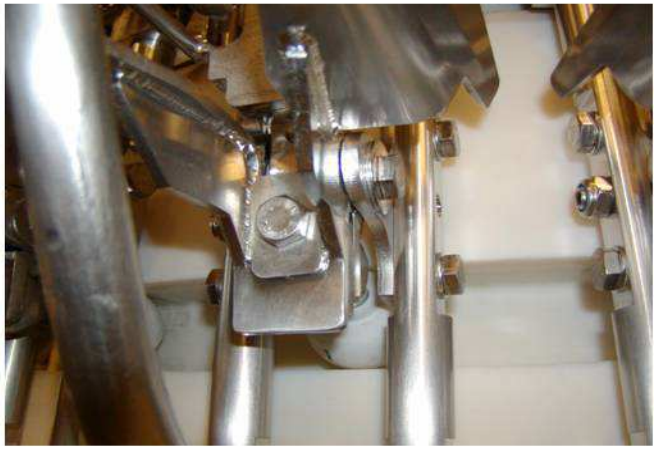
Set lifters @ 95º



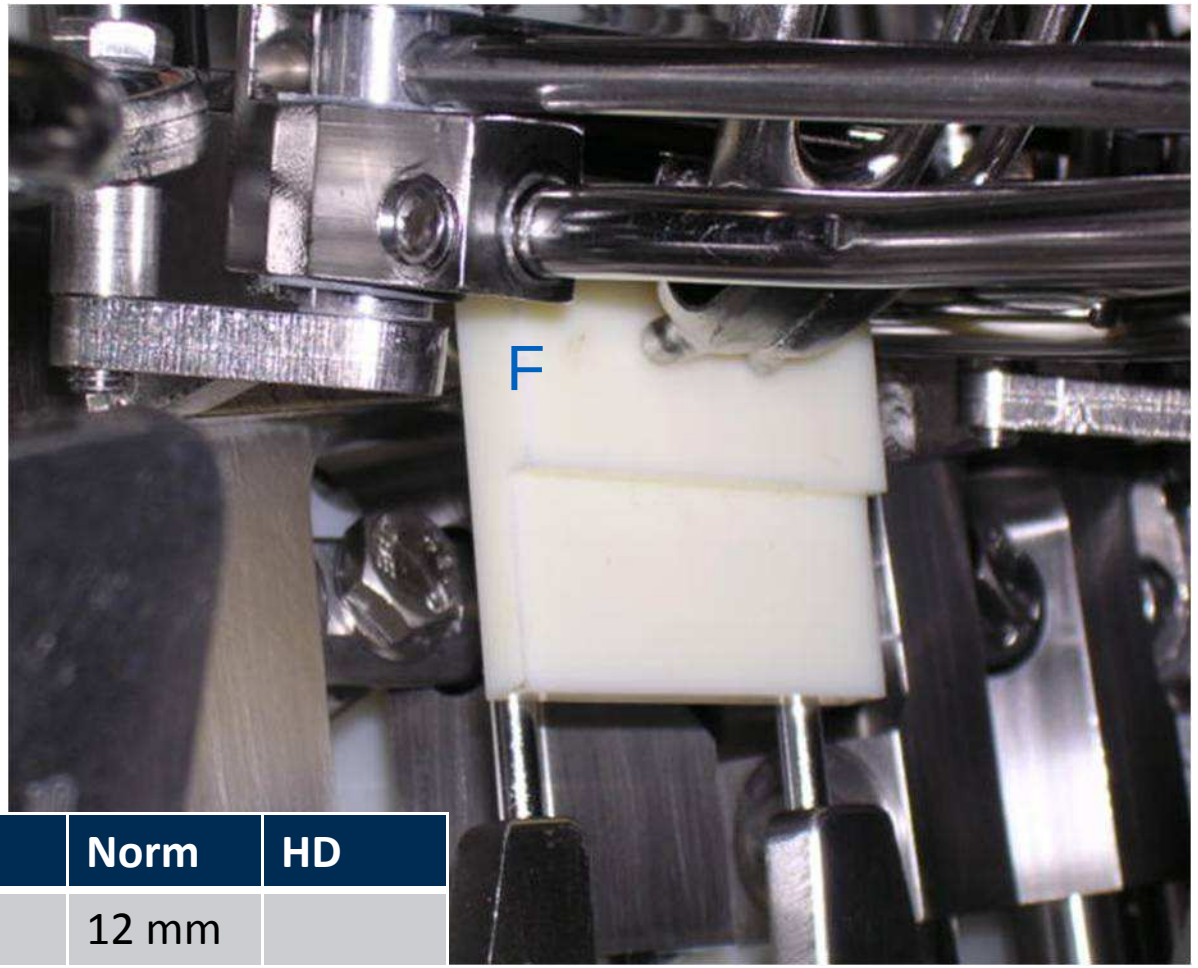
(a) Loosen bolt so lifter moves up and down

(b) Insert gauge between spoon and top edge of lifter plate

(c) Push up lifter, secure bolt and recheck measurement

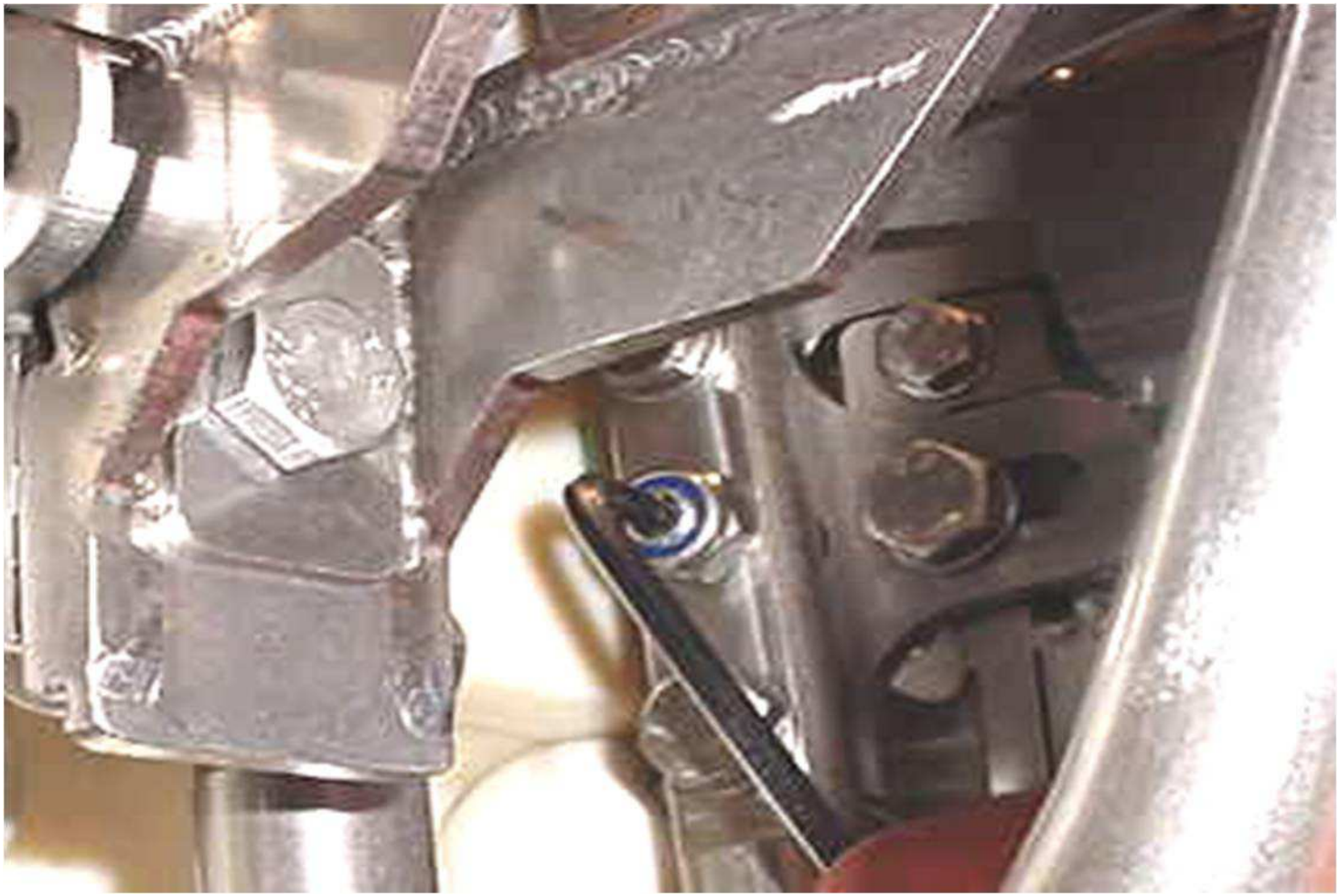


Check and or set back plate @ 140º

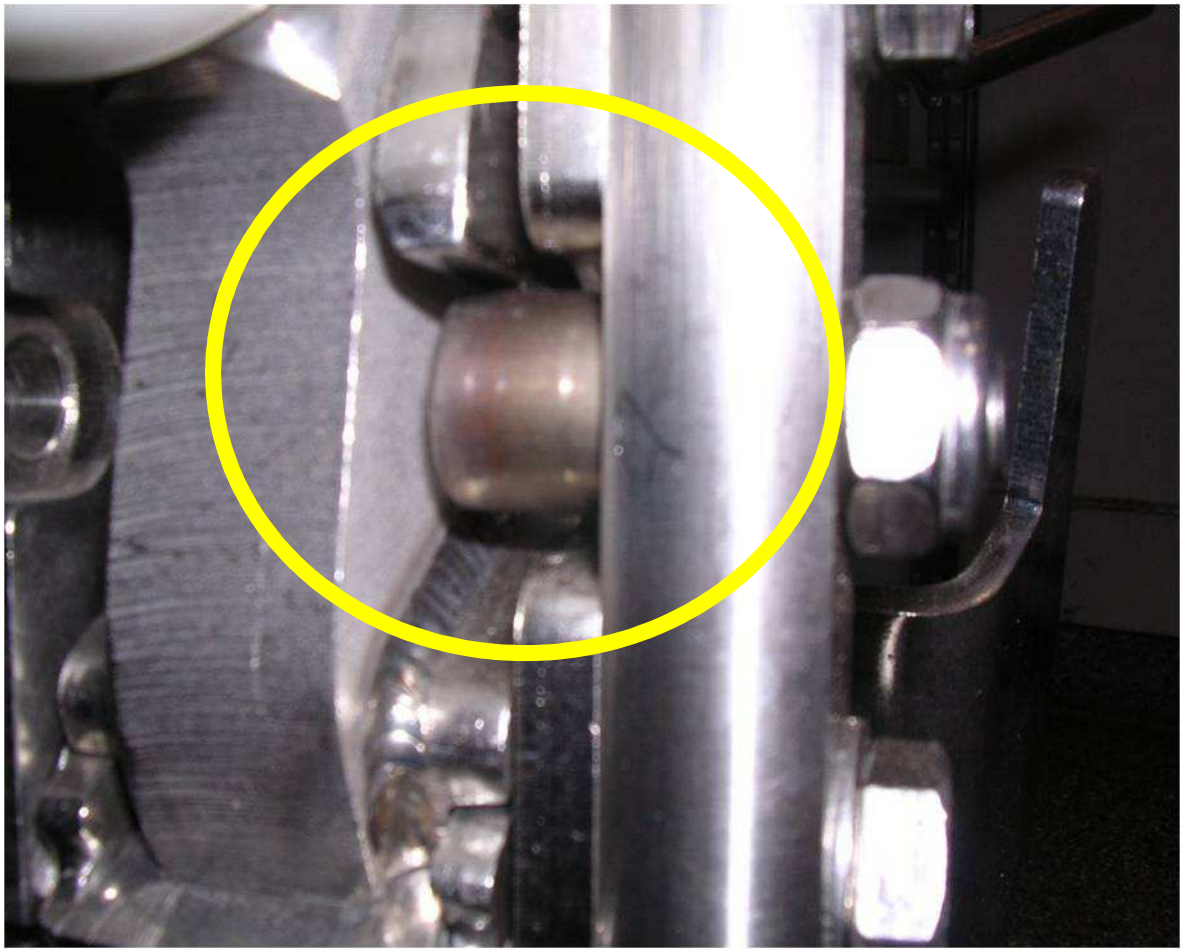


Measurement F:	LD	Norm	HD
Template 13		12 mm	
Template 14	10 mm		16 mm

Check and or set back plate @ 140º



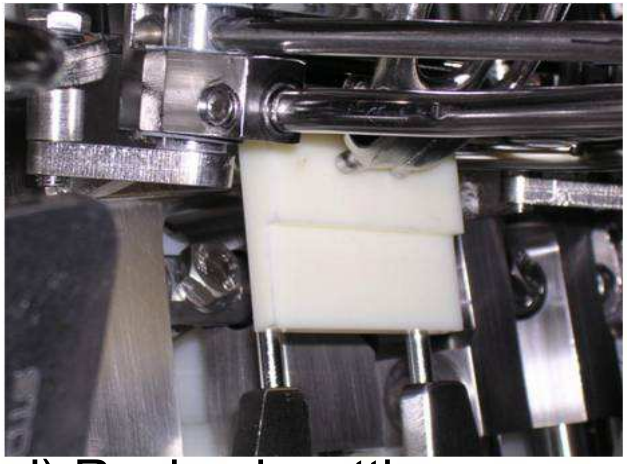
Check and or set back plate @ 140º



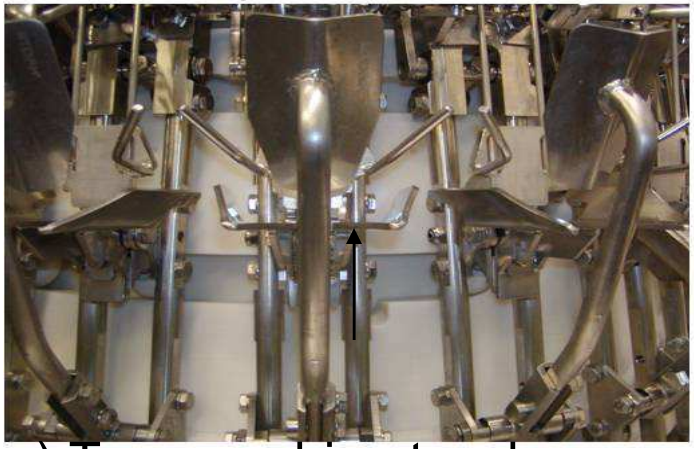
By turning inner screw, eccentric cam rotates against back plate stop, moving the back in and out.

Check and or set back plate @ 140º (cont.)

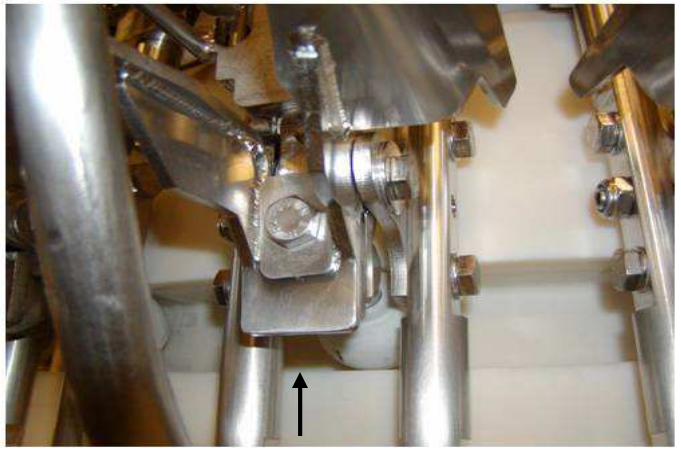
c) Tighten lock nut while holding inner screw



d) Recheck setting

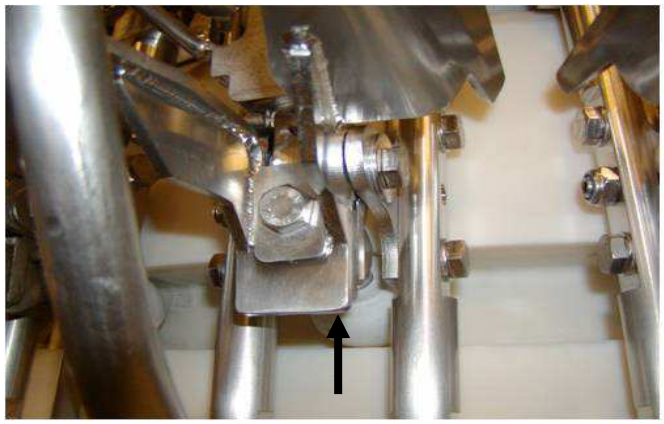


e) Turn machine to where lifter is in full up-right position

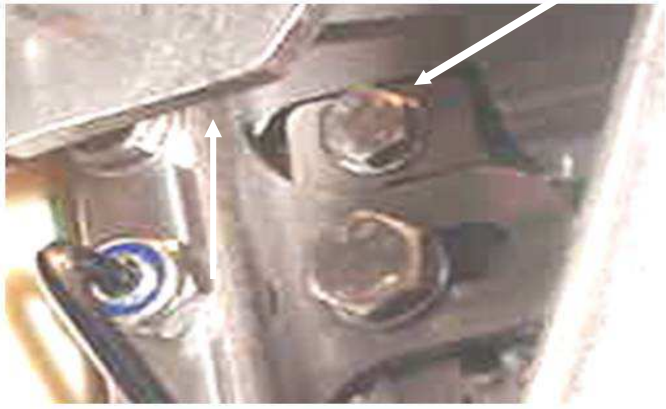


f) Insure roller turns freely

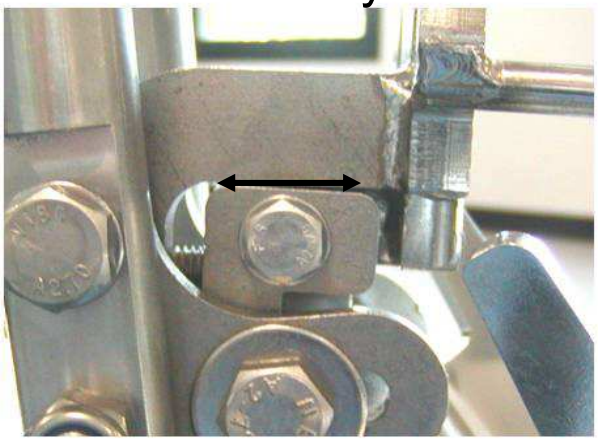
Check and or set back plate @ 140º (cont.)



g) If roller is locked down or turns very hard



h) Loosen “stop tab” holding bolt



i) Adjust tab until rolleris free turning

j) Tighten bolt and insure roller turns freely

Check back plate/spoon clearance

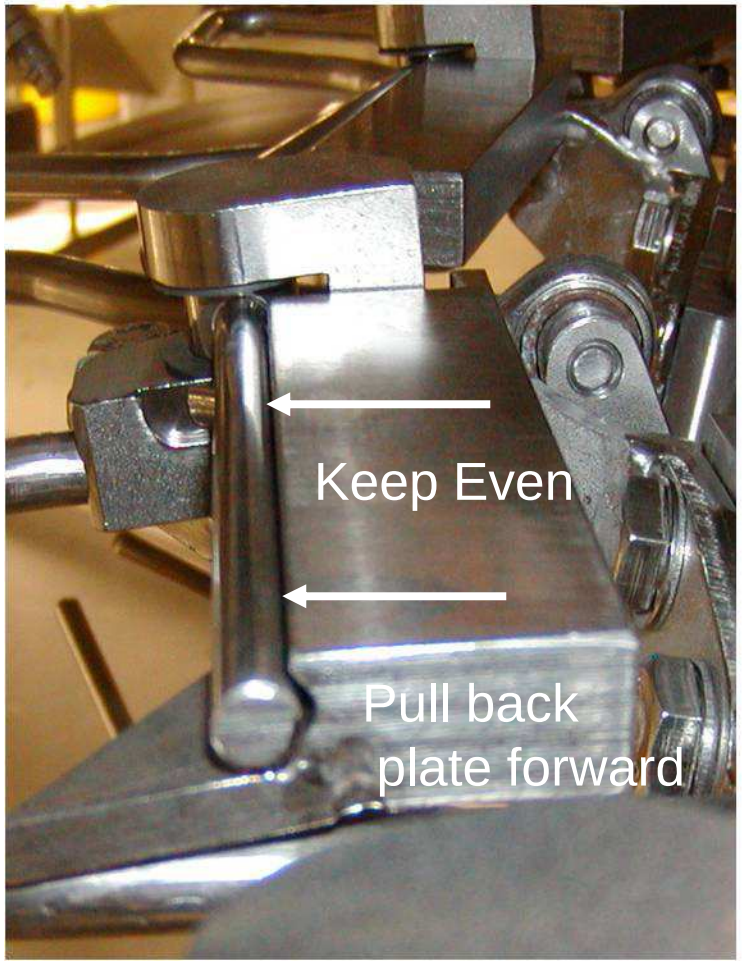
k) Insure lung rakes pass freely by gut clamp back plate

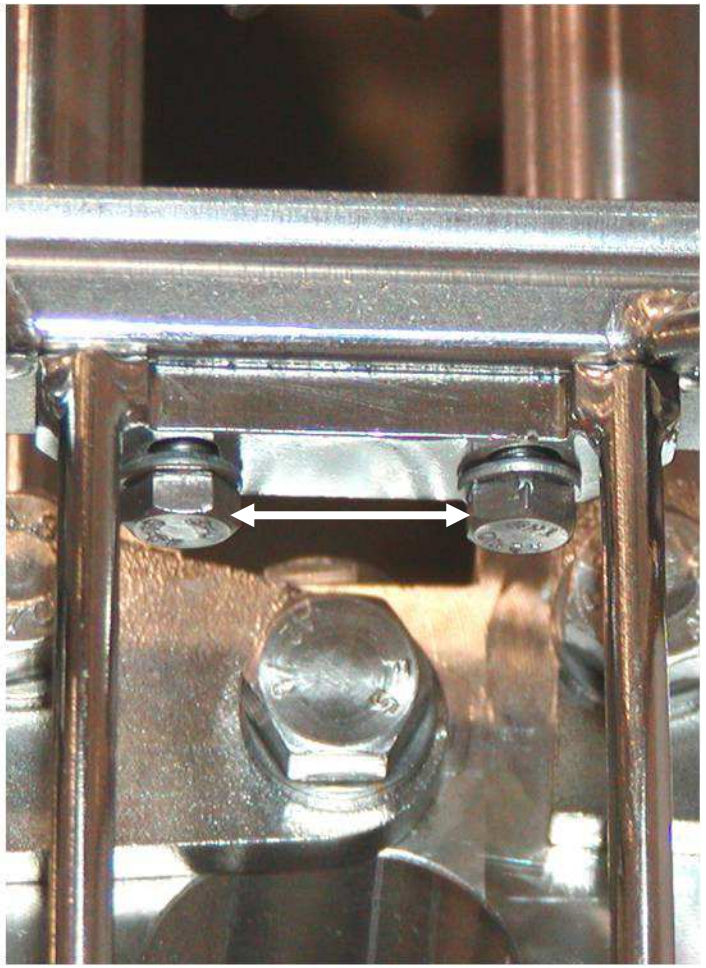
After adjusting the previous setting **Recheck This setting**
Set arm (spoon) to back plate @ 95º

(turn machine until spoon just closes)

Recheck This setting to insure it hasn't moved.

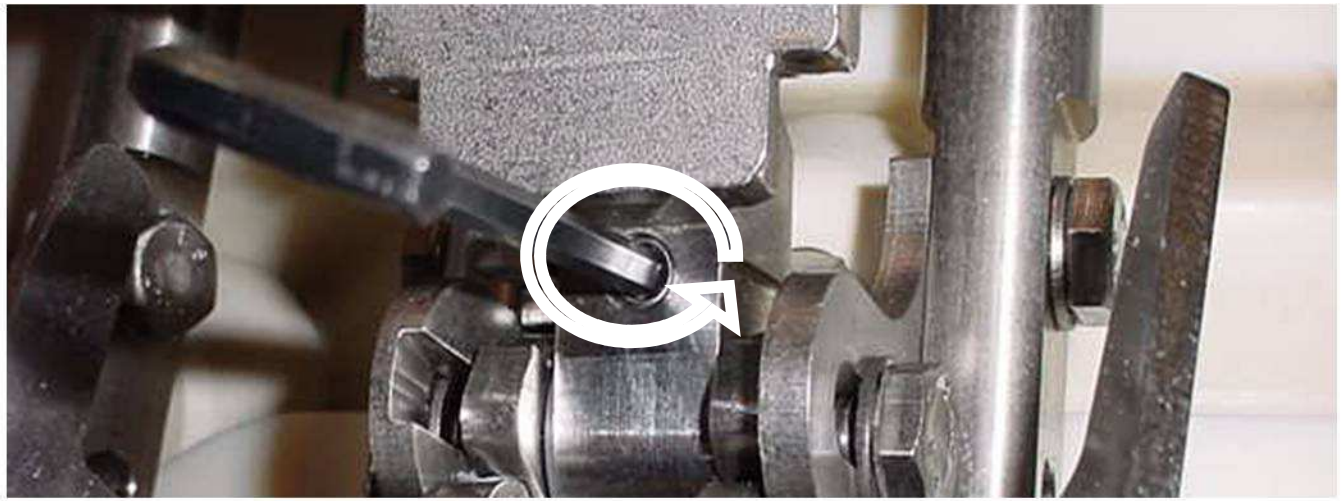
Align gut clamp with clamping plate @ 210º

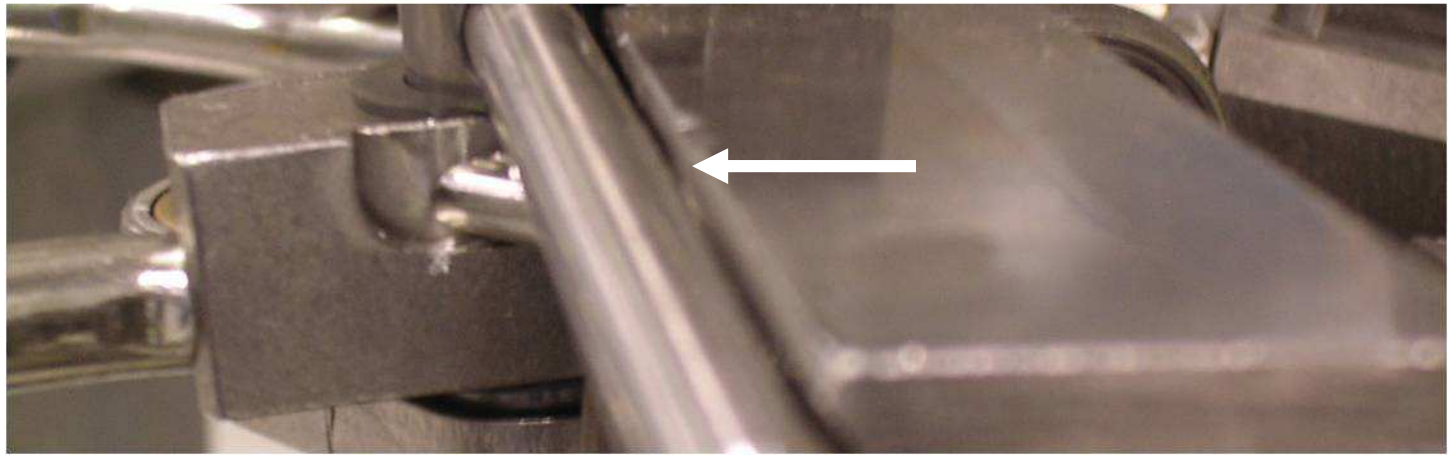




a) Adjust clamping plate with two 6 mm bolts

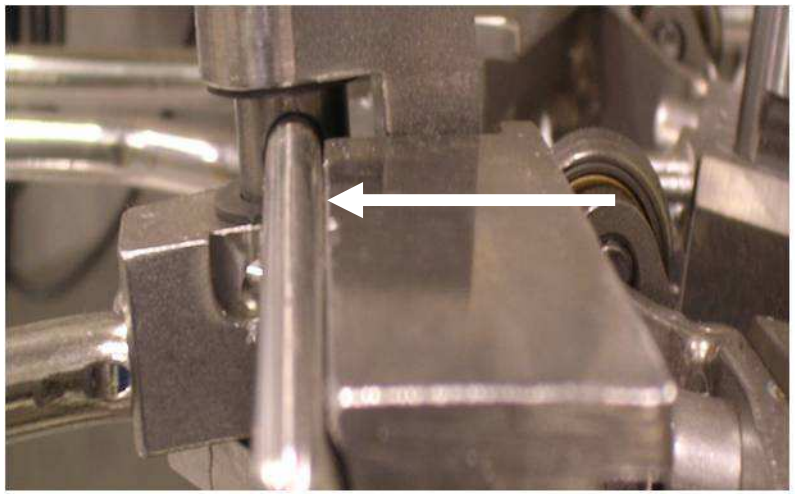
Set gut clamp back plate spring pressure @ 210º





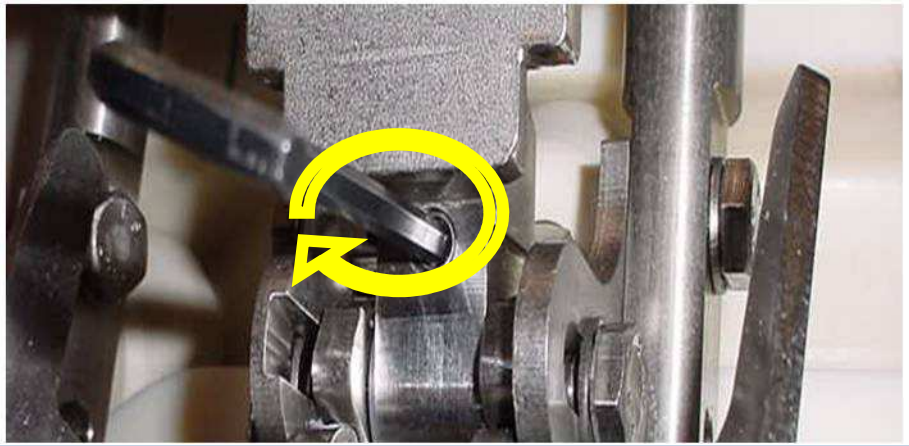
a) Loosen set screw until clamp rod disengages block

Set gut clamp /back plate spring pressure @ 210º

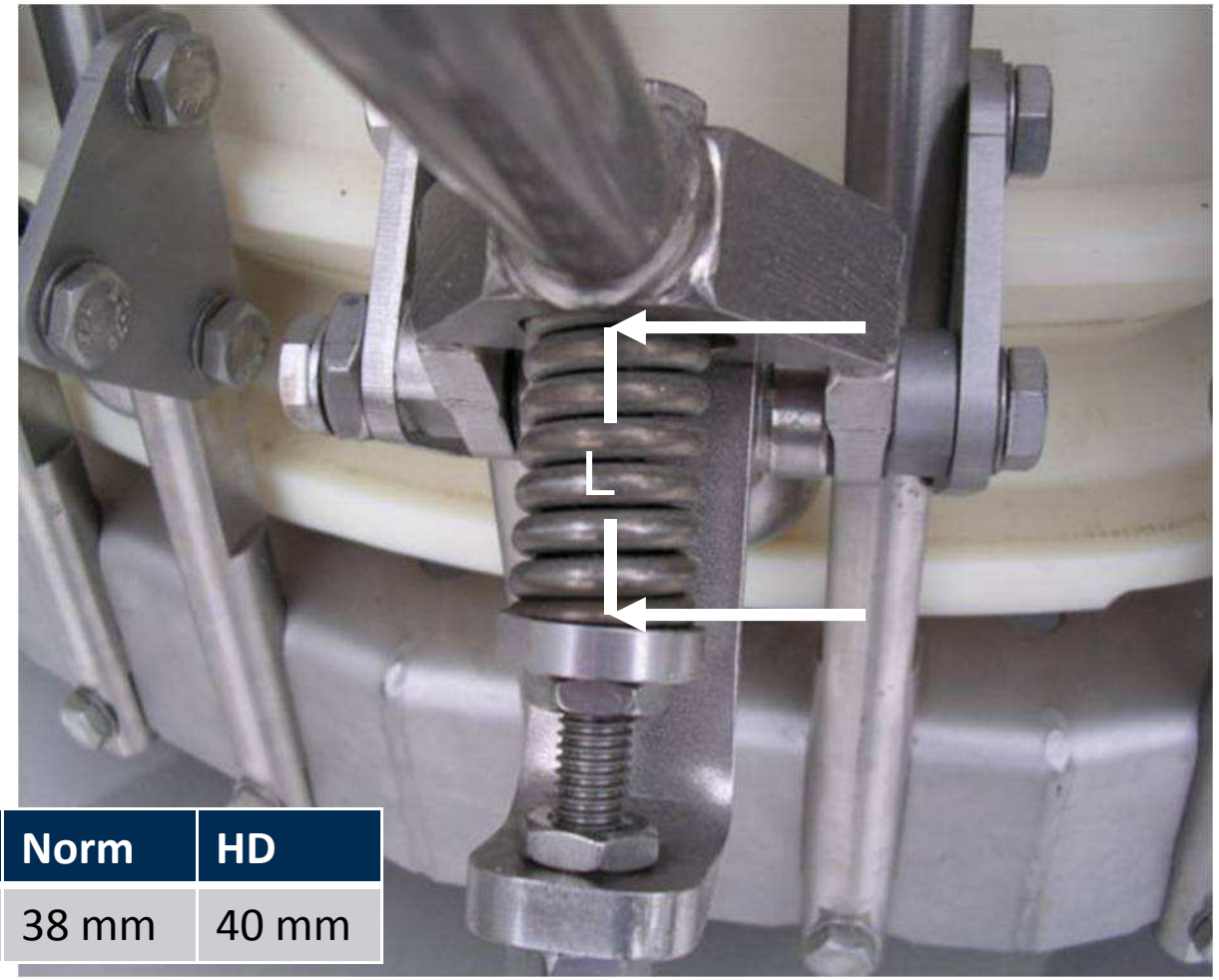


a) Turn set screw until clamp rod engages block

b) Adjust pressure (12-15 lbs) by tightening set screw 1/4 turn more.

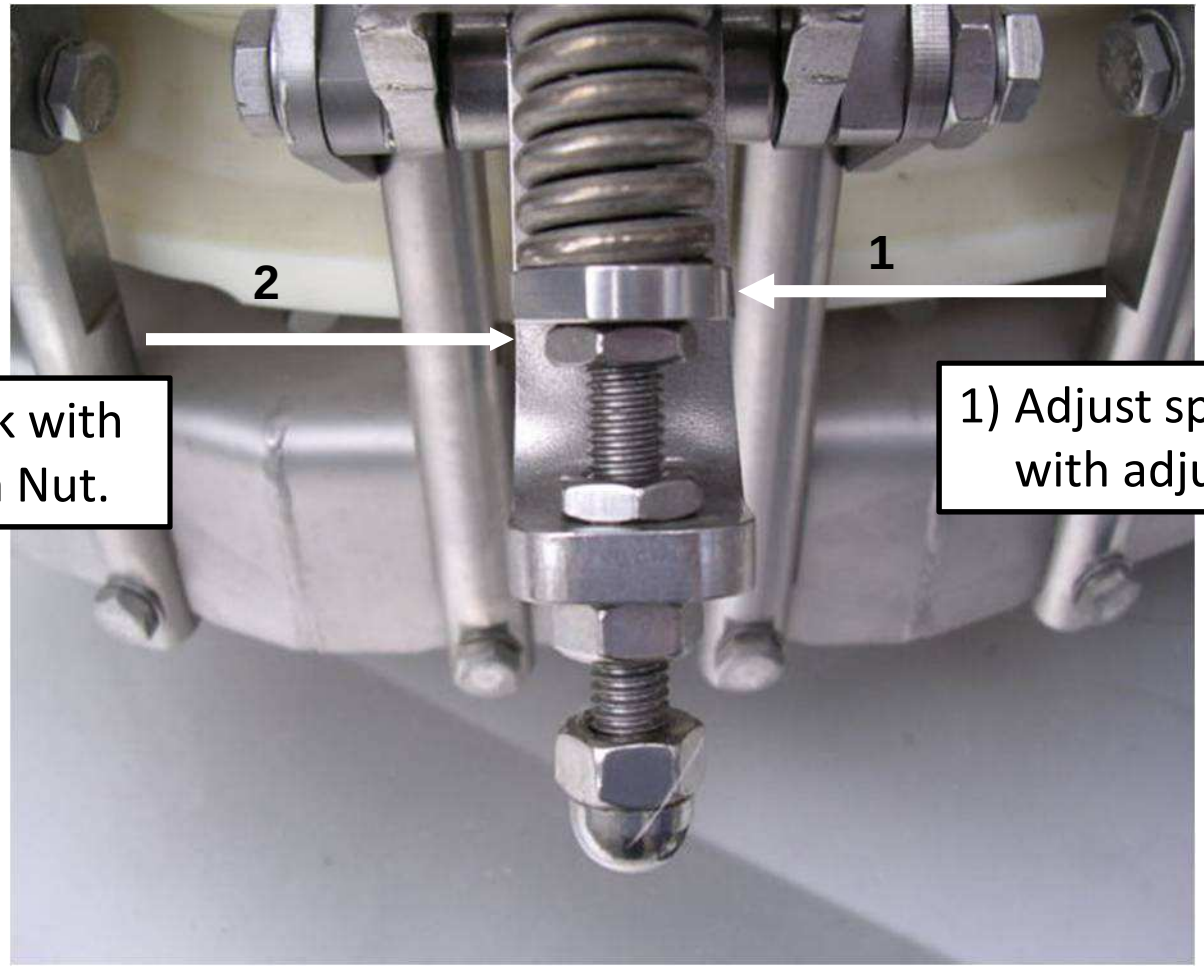


Set breast presser @ 60º



Measurement F:	LD	Norm	HD
Adjust to:	35 mm	38 mm	40 mm

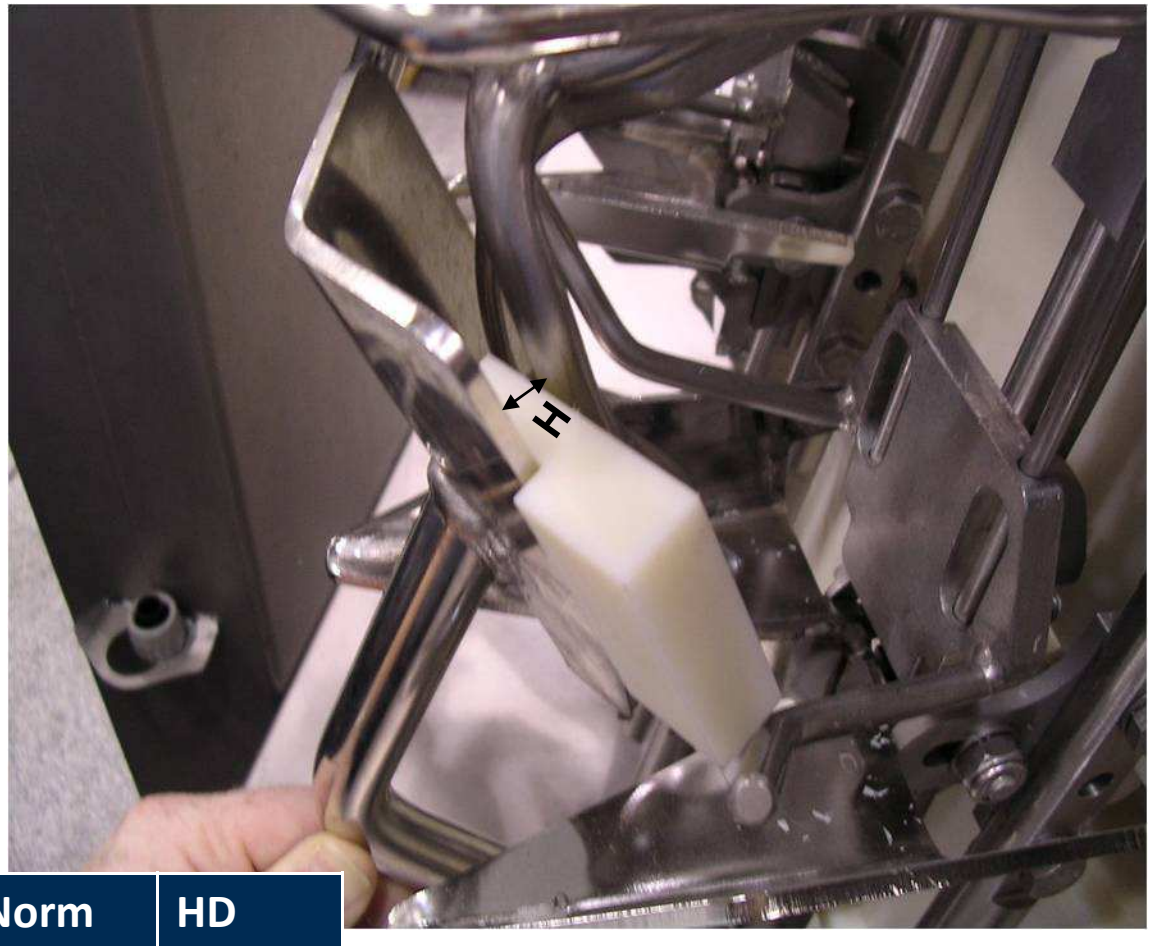
Set breast presser @ 60º



Spring Adjustment

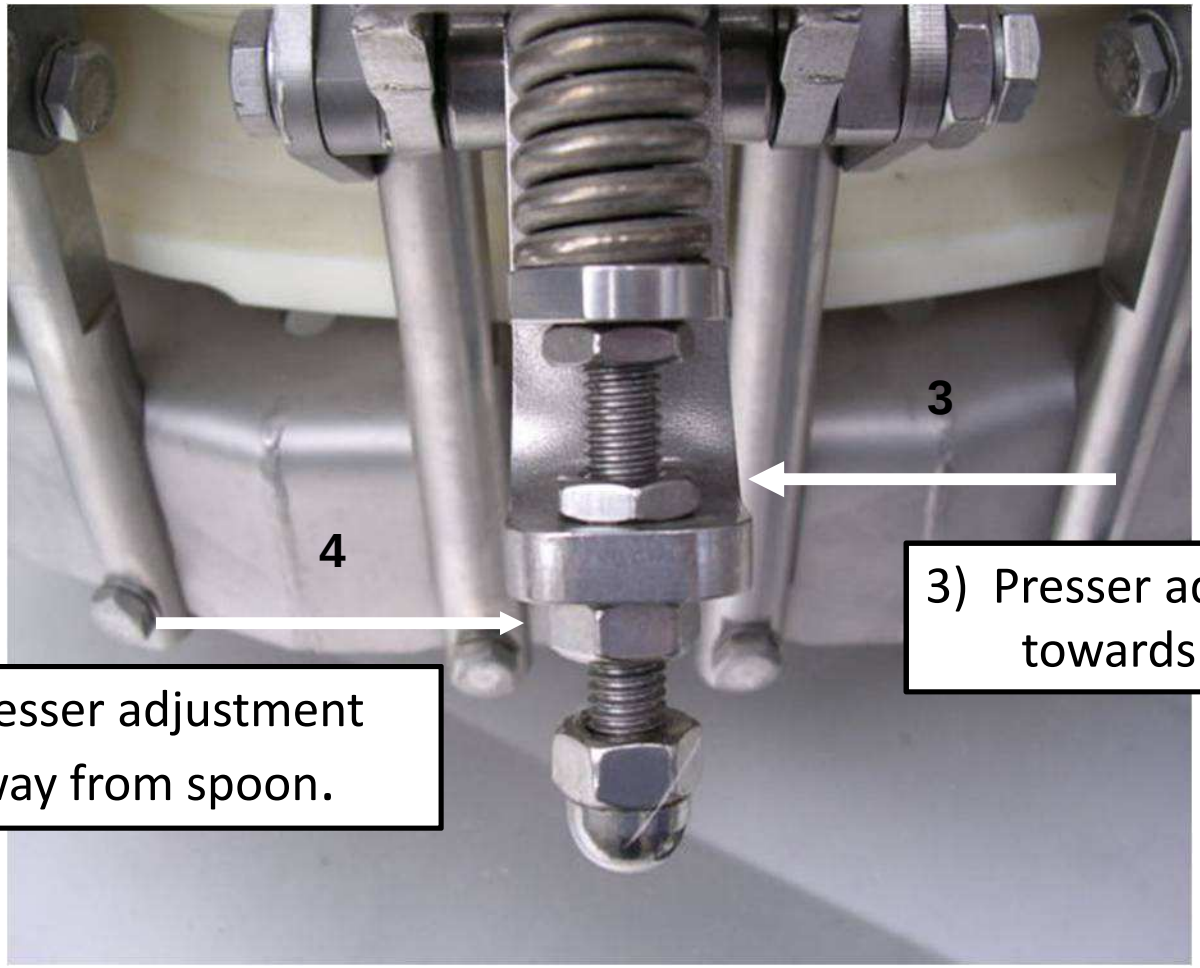
Set breast presser @ 60º

a) Insert gauge between breast presser and spoon on both sides of breast presser.



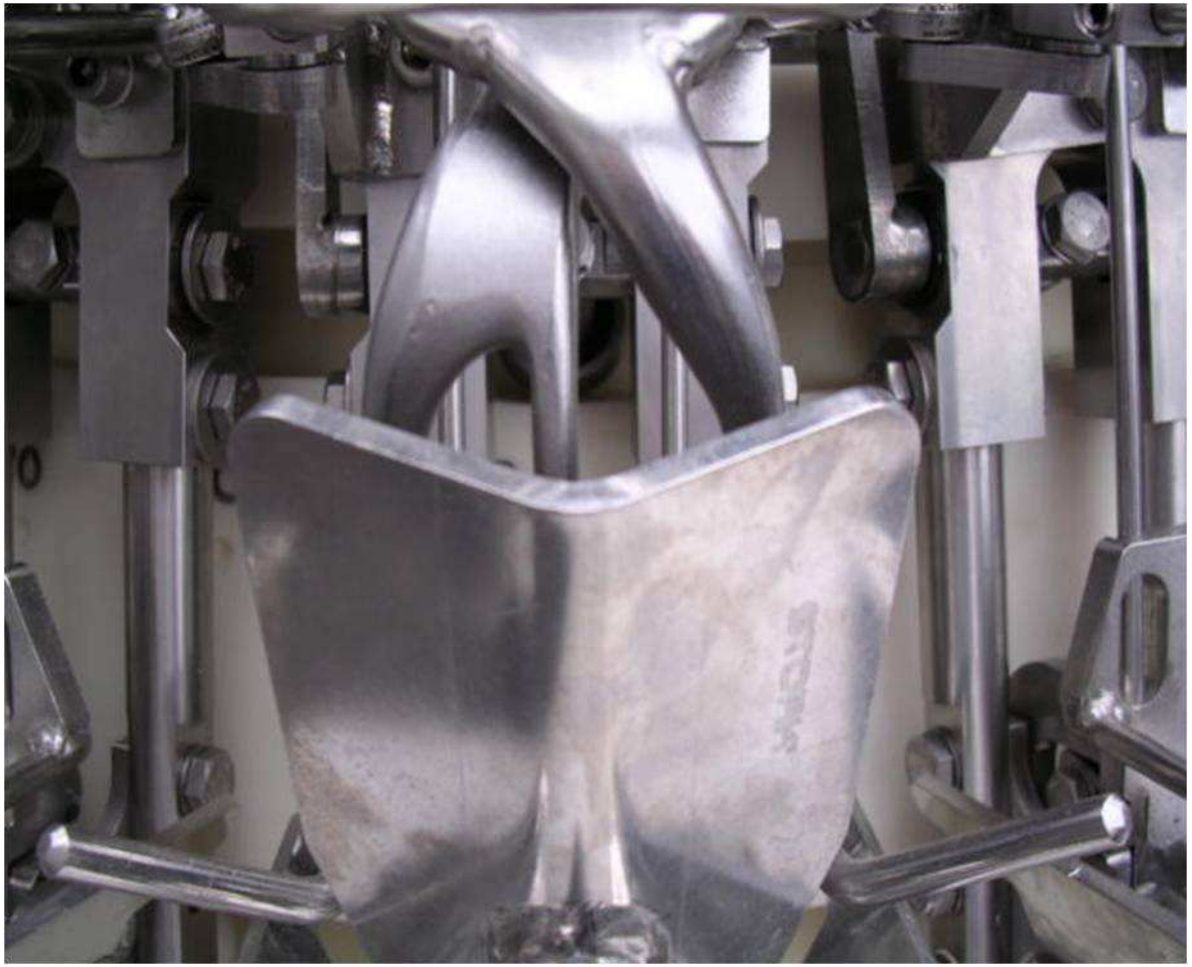
Measurement H:	LD	Norm	HD
Template 15	6 mm	6 mm	10 mm

Set breast presser @ 60º

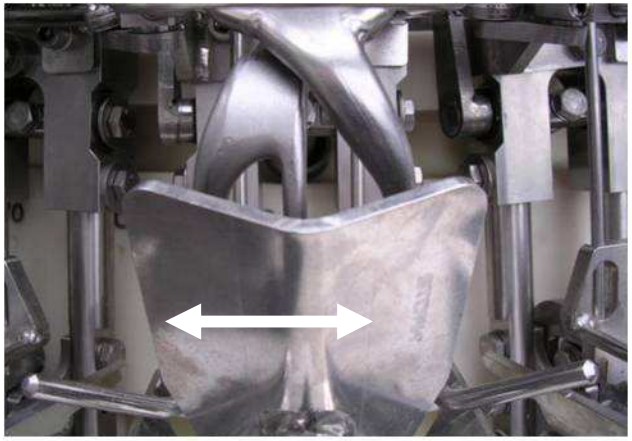


Spring Loaded Presser Adjustment

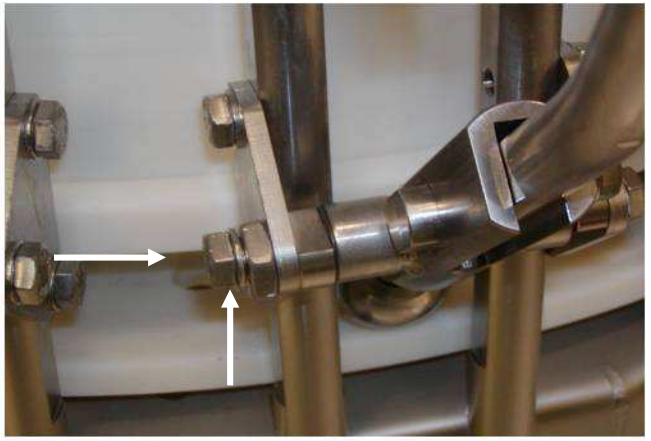
Center breast presser on unit @ 60º



Center breast presser @ 60º

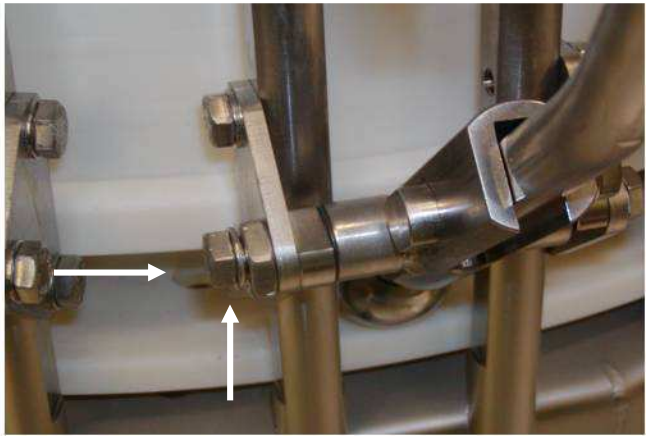


a) Check breast presser for centering on spoon



b) Loosen both bolt and jam nut

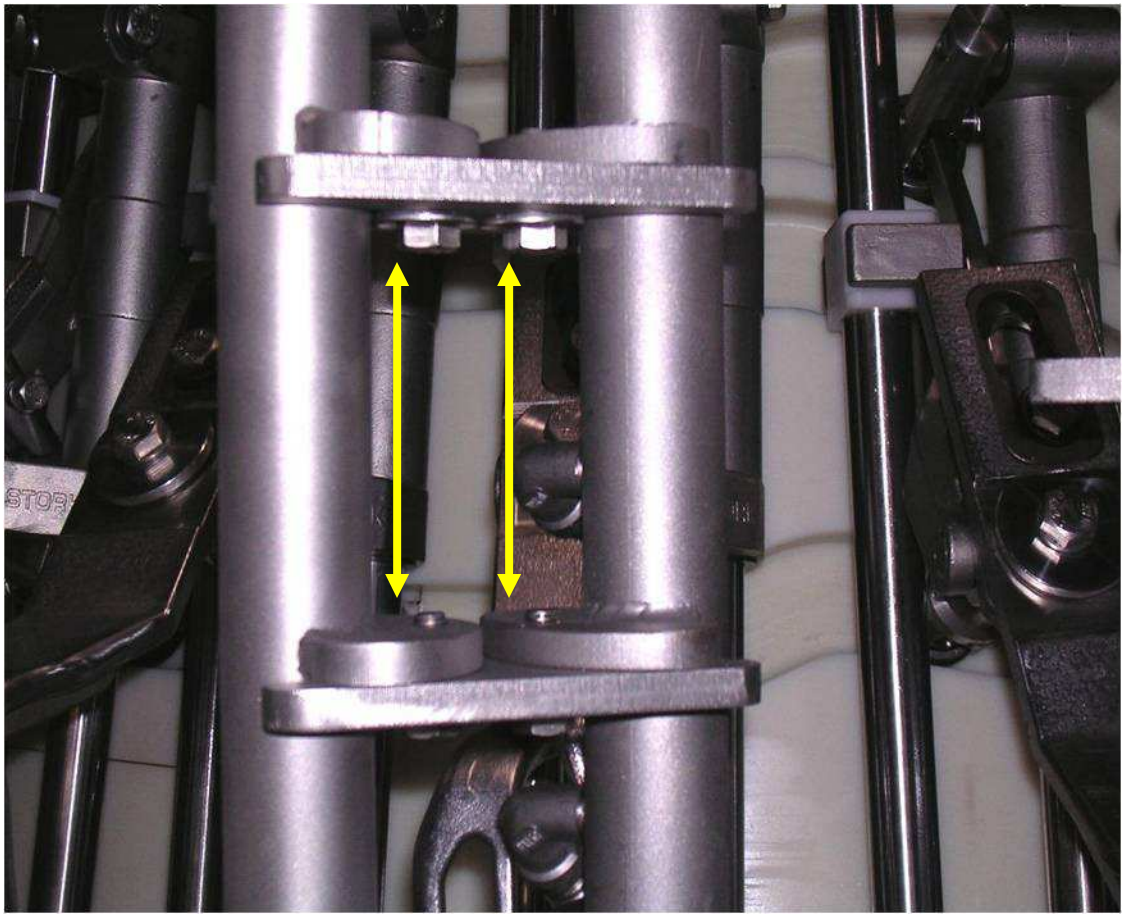
c) Adjust eccentric cam



d) Tighten both bolt and jam nut

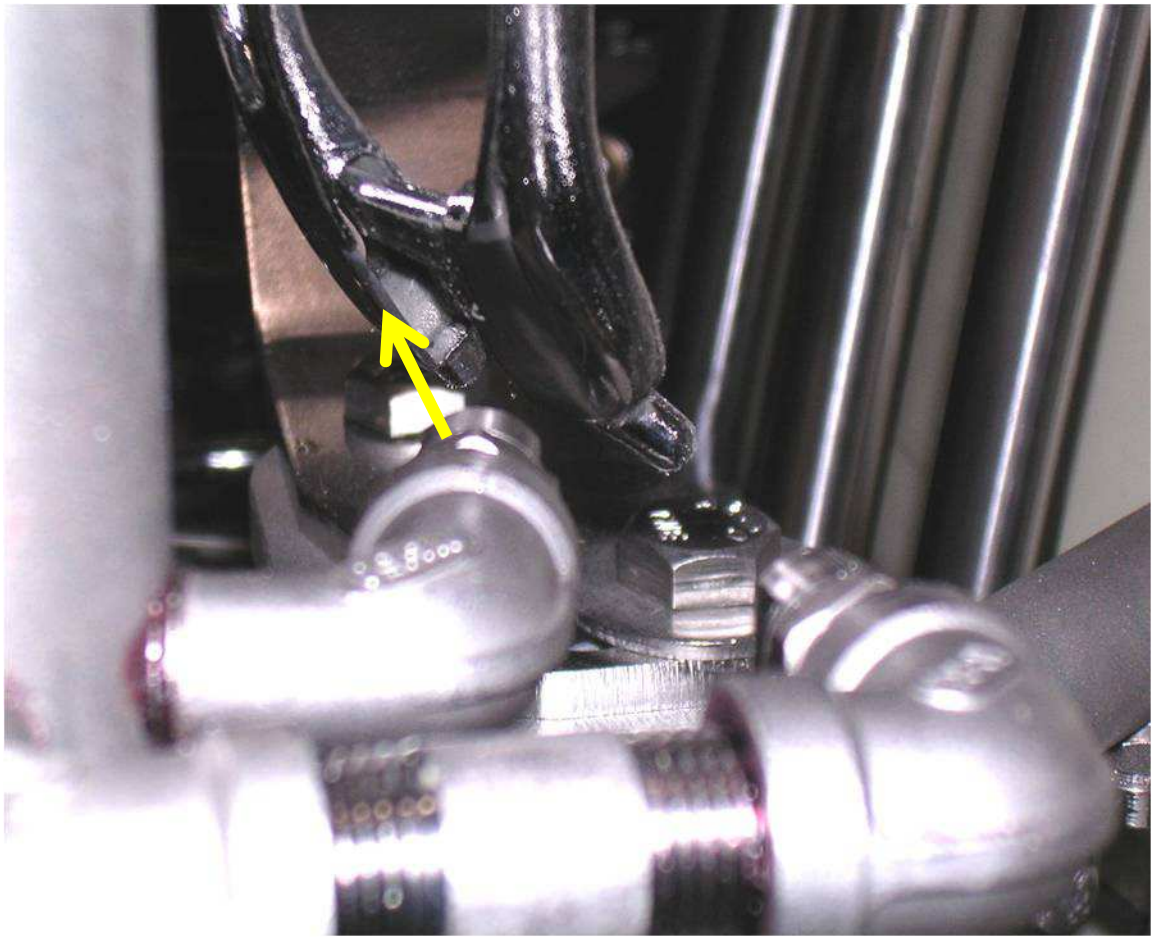
Set water sprayers

Set water sprayers



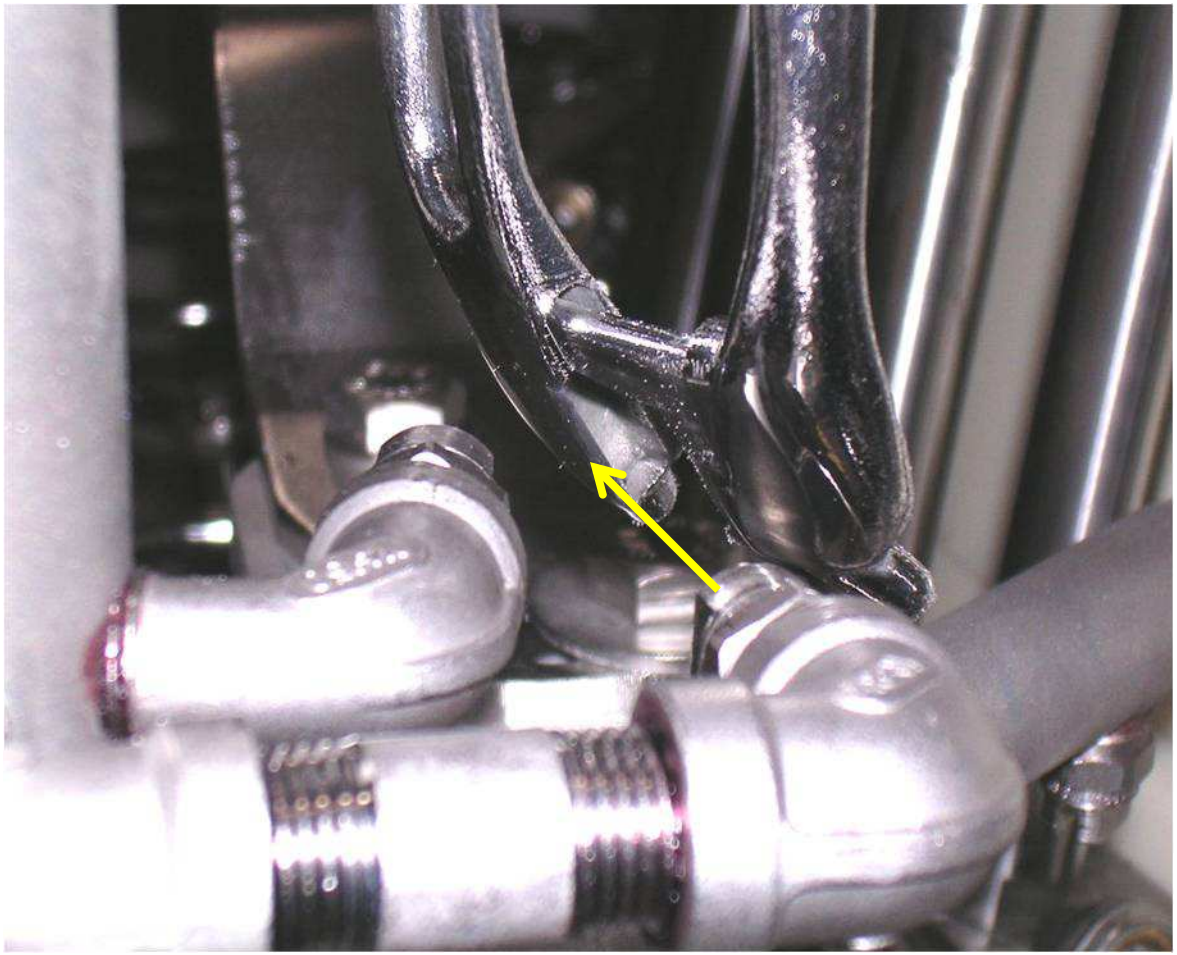
Sprayer Shafts pivot independently of each other

Set water sprayers



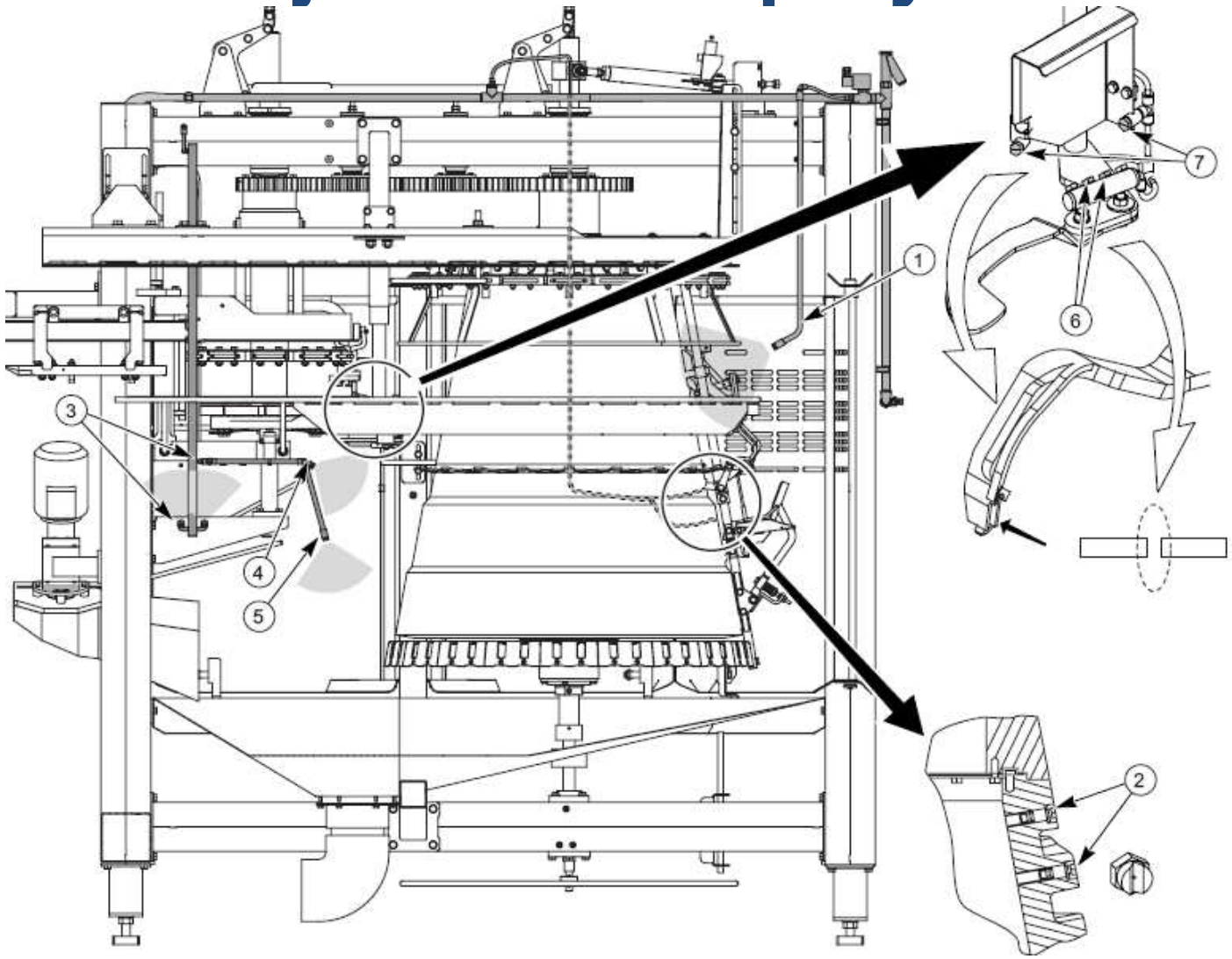
Align nozzles to spray out the spoon opening

Set water sprayers

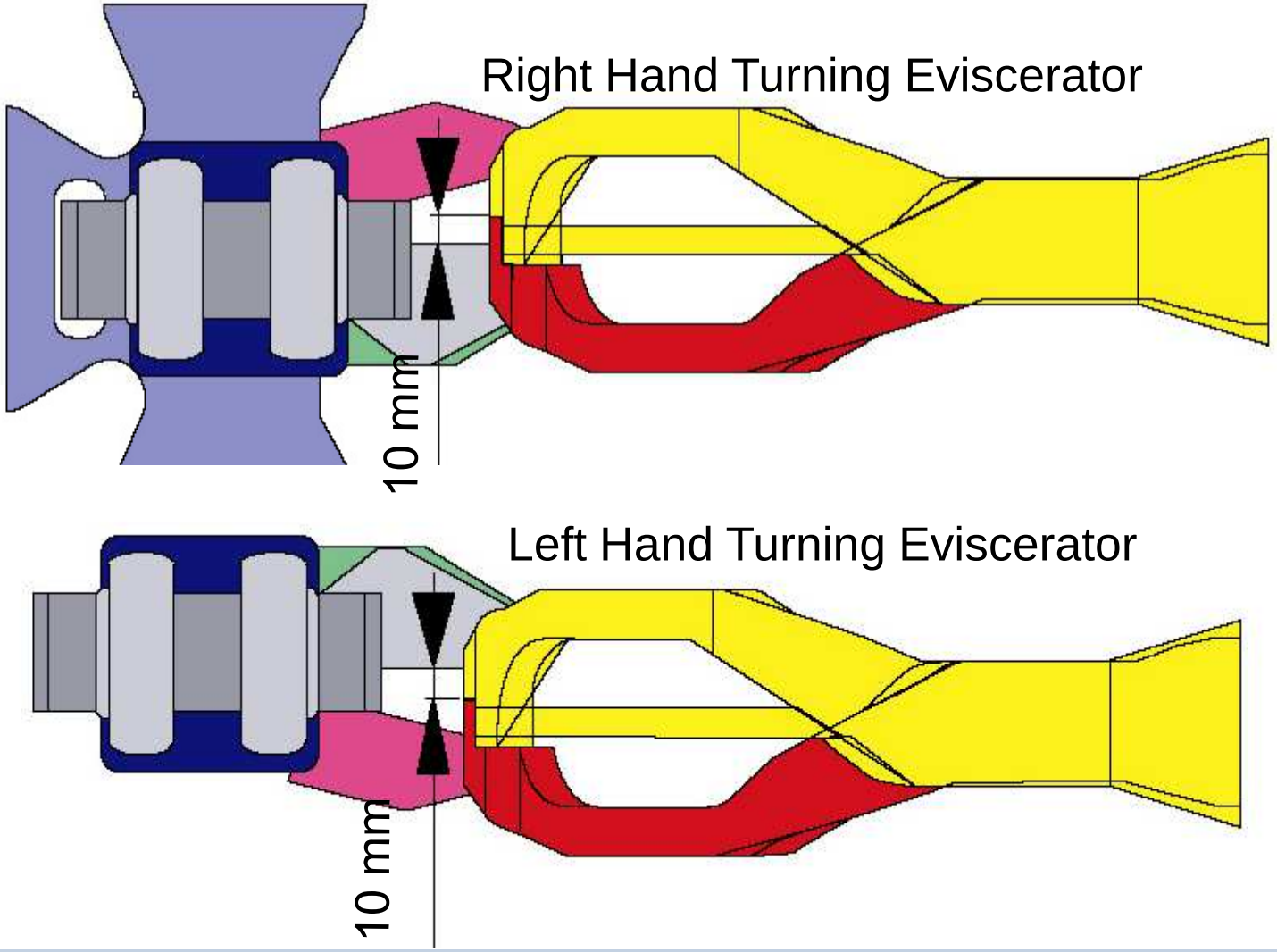


Align nozzles to spray out the spoon opening

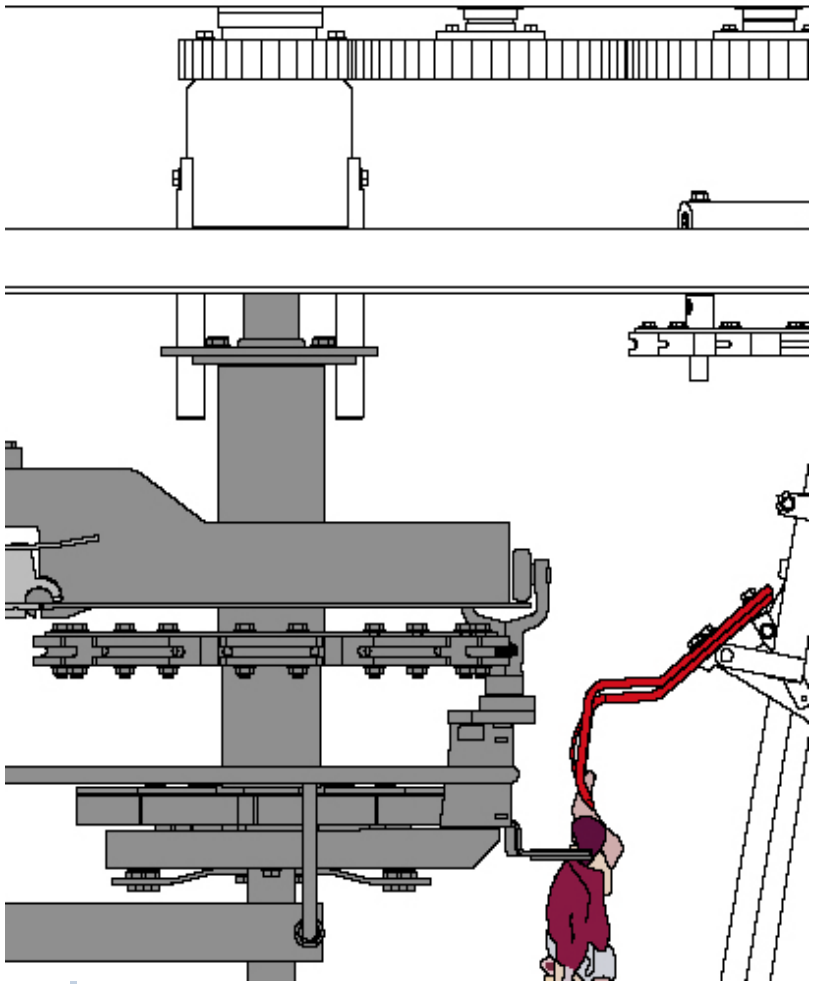
Adjust water sprayers



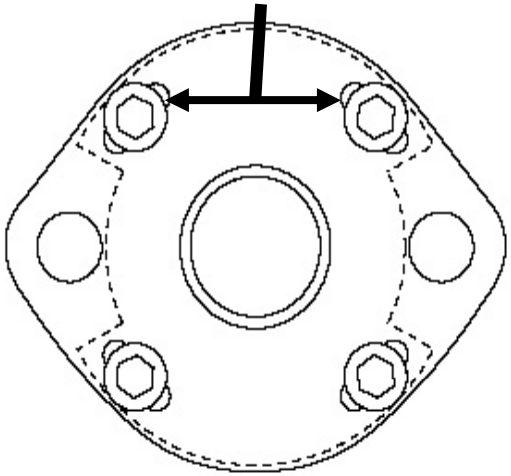
Set pack transfer timing

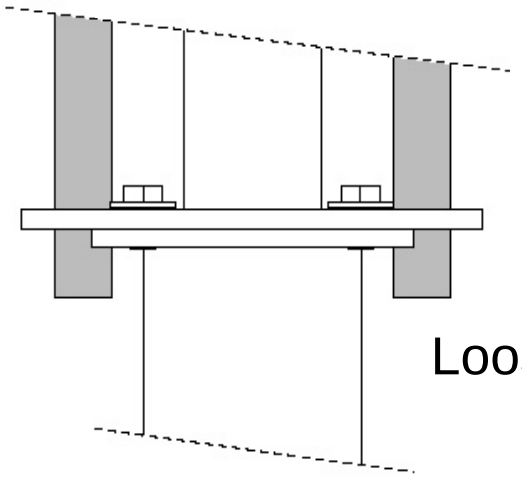


Set pack transfer timing



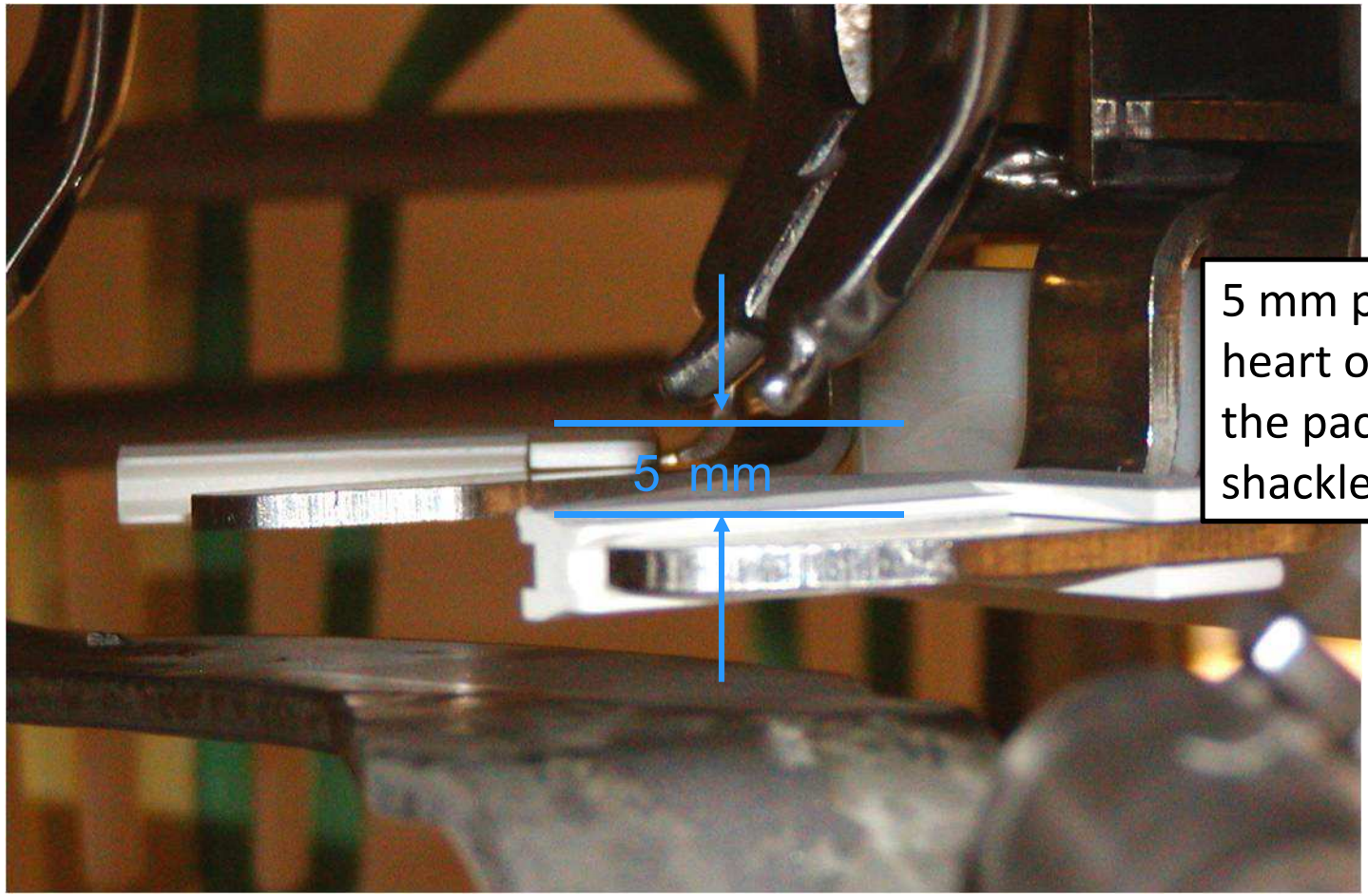
Unit rotates in slots.





Loosen Bolts
x 4

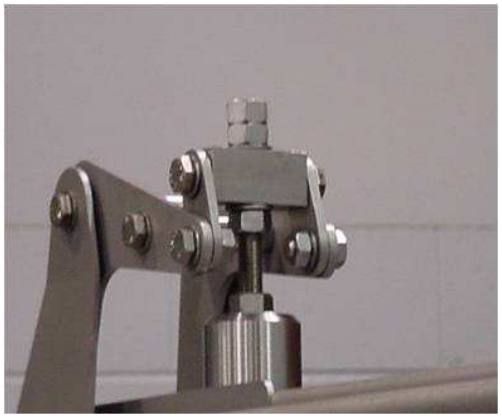
Set pack transfer height

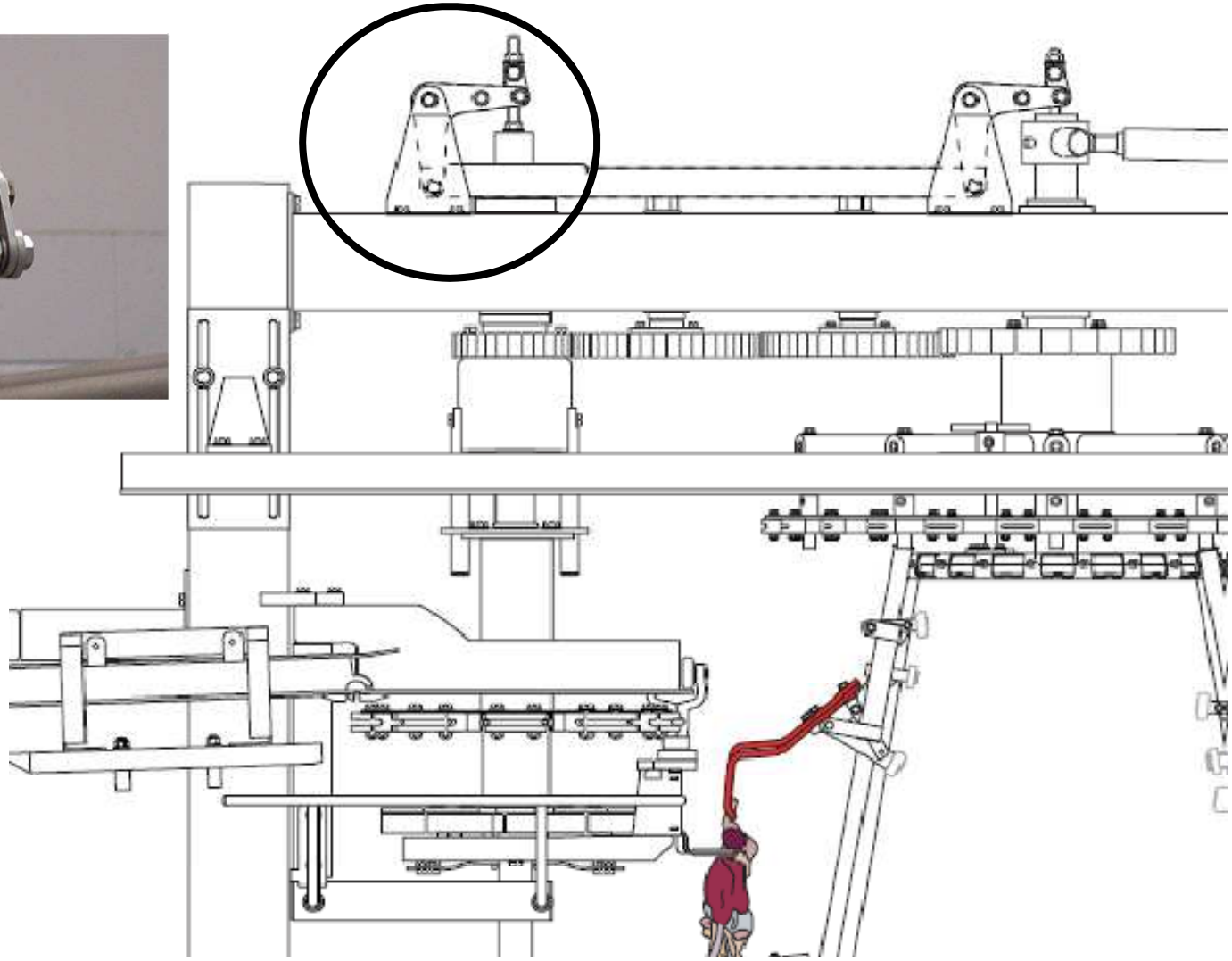


5 mm puts the heart on top of the pack shackle.

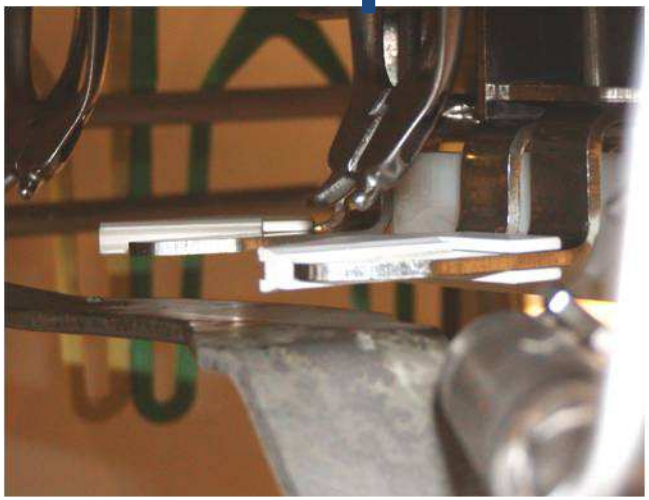
Raise or lower the pack transfer unit to achieve optimal clamping position.

Set pack transfer height

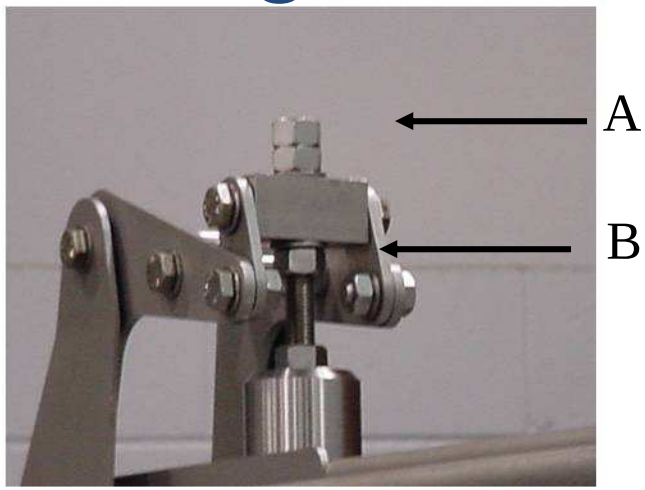




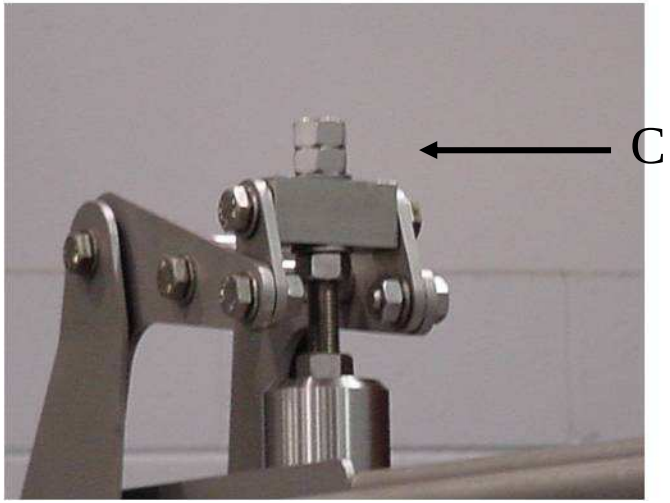
Set pack transfer height



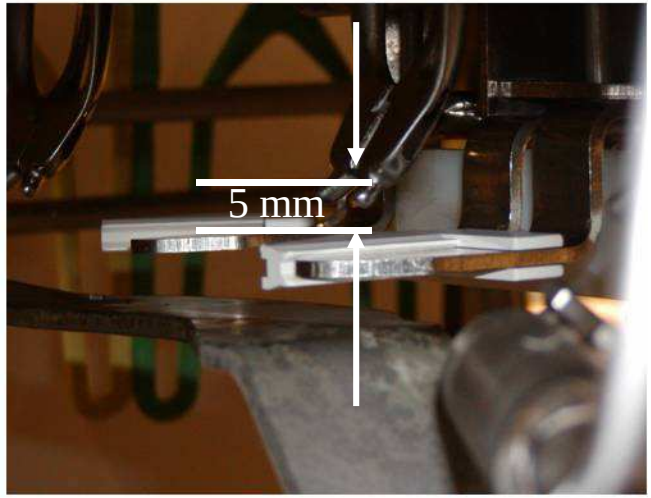
a) Position spoon over pack shackle



b) Loosen Jam nuts A & B

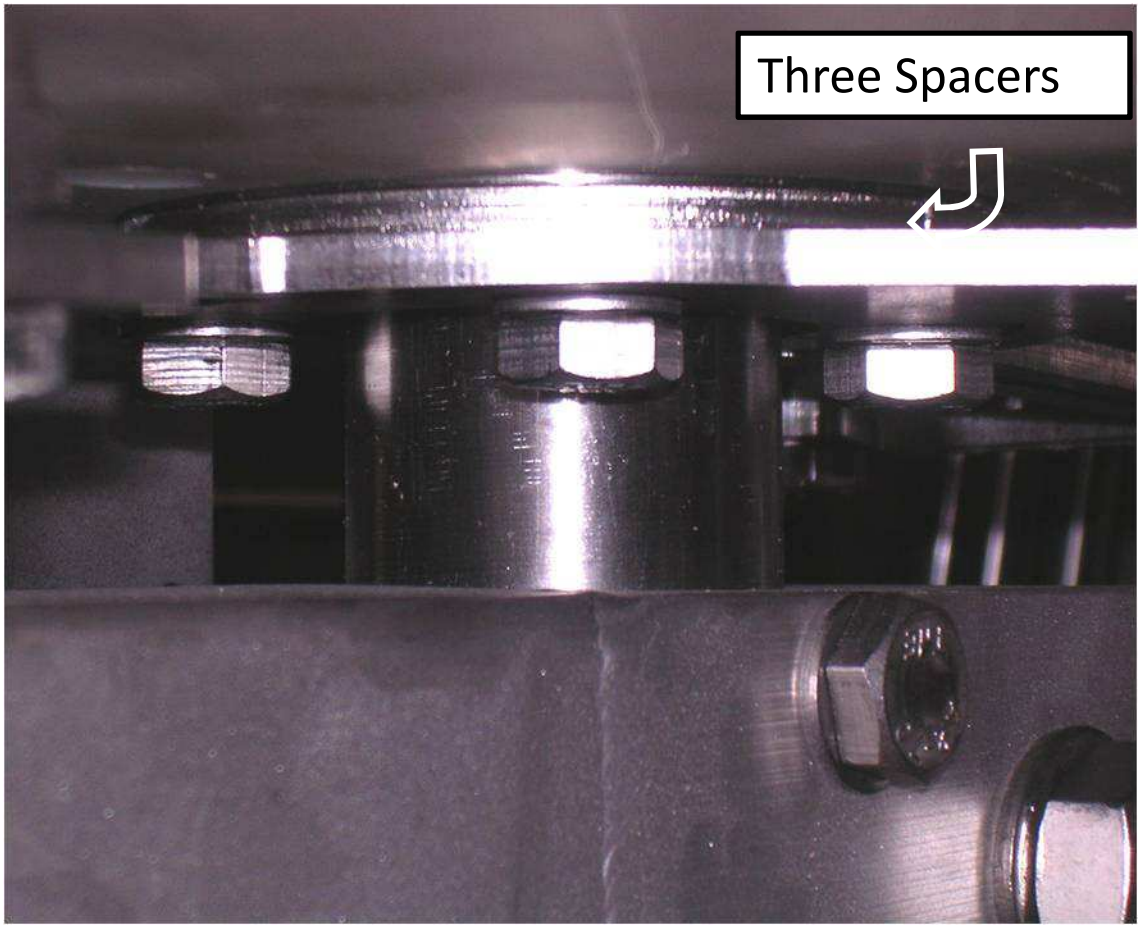


c) Raise/Lower Unit with nut C



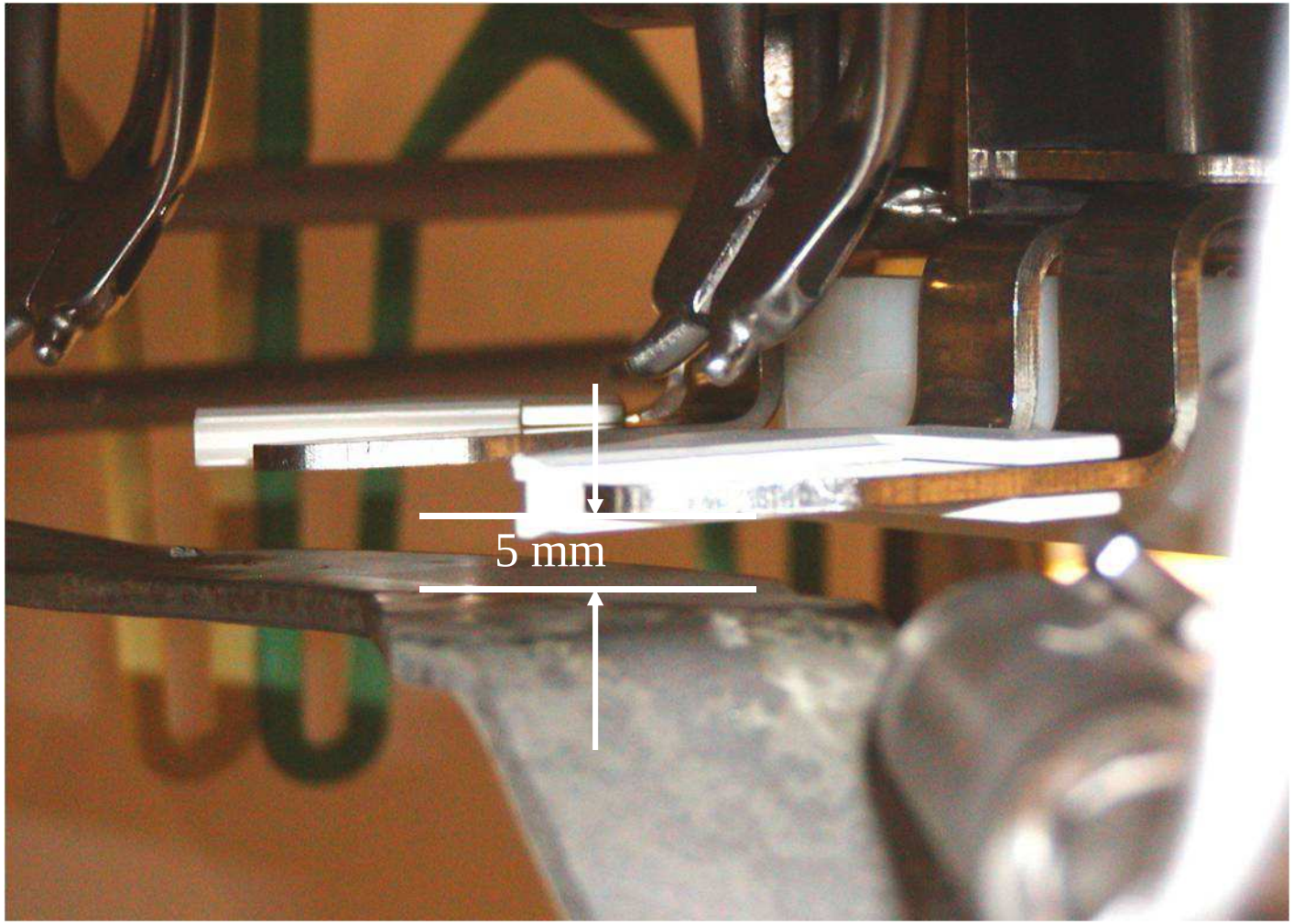
d) Check gap and tighten A & B

Set pack transfer torque tension



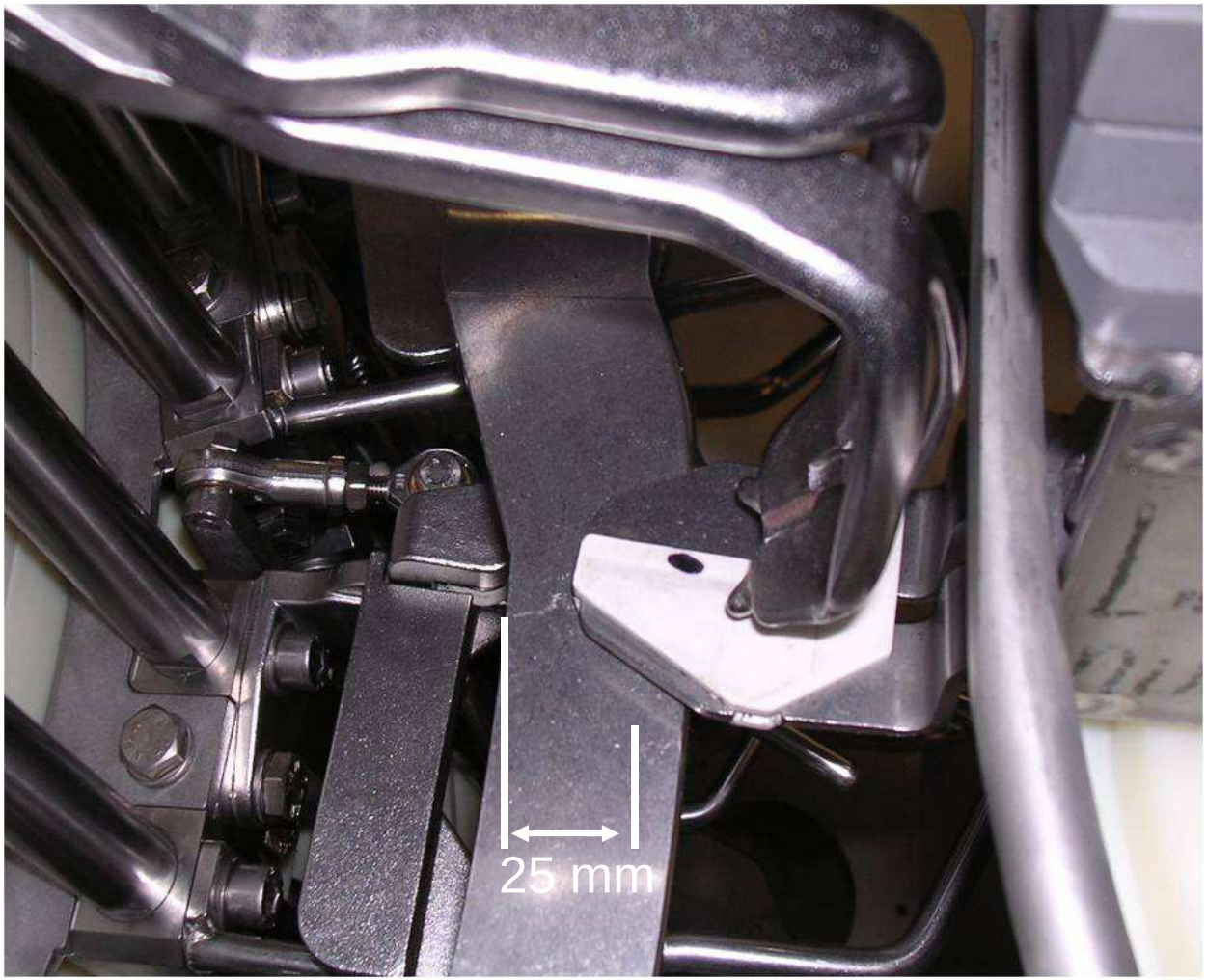
Use the amount of spacers needed to achieve proper tension with out nuisance torque trips.

Viscera pack guide

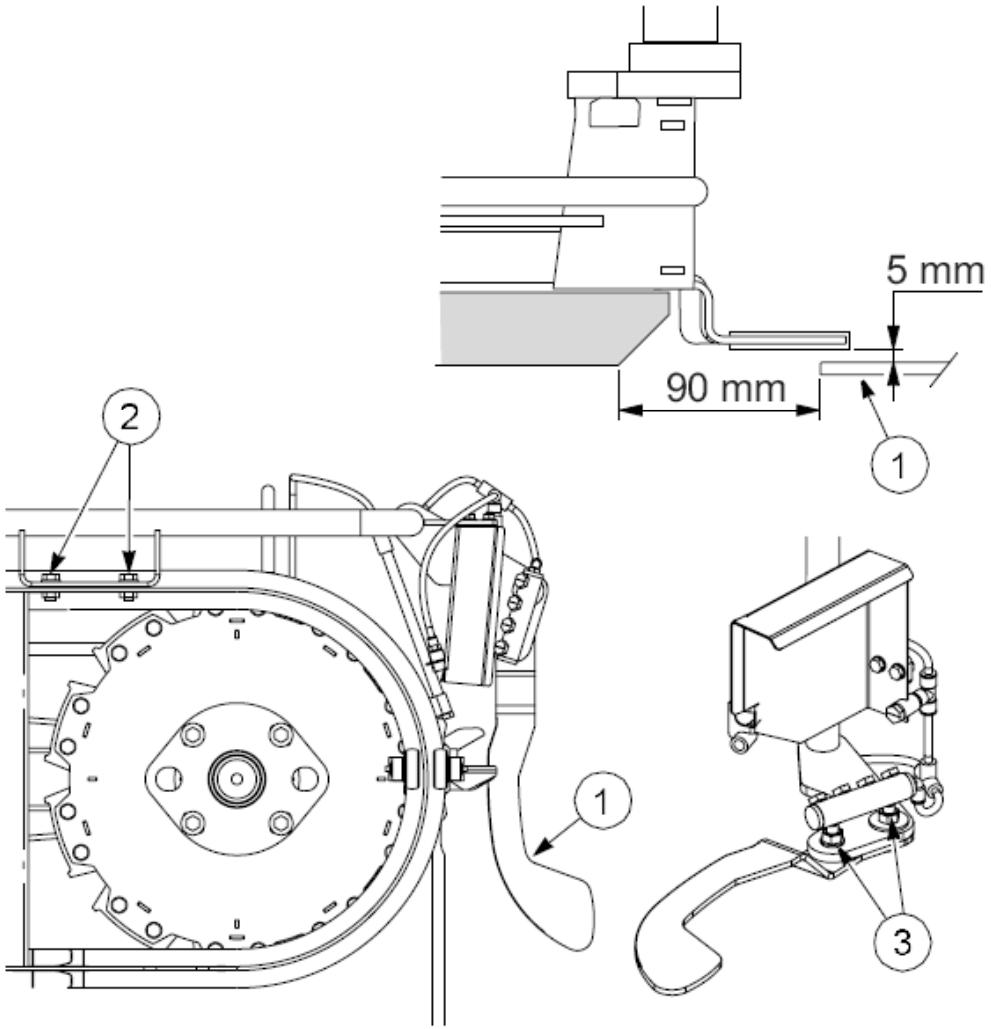


a) Put guide 5 mm below pack shackle

Viscera pack guide (cont.)



Viscera pack guide (cont.)



Viscera pack guide (cont.)