



FEEDERS & ACCESSORIES

AIR FEEDER

OPERATION –INSTRUCTIONS

SKI AUTOMATION PVT LTD

NEW DELHI, INDIA

[**www.skifeeder.com**](http://www.skifeeder.com)

[**www.striplubricator.com**](http://www.striplubricator.com)

Compliment

First of all, thanks for kindly choosing SKI product as peripheral equipment for press machine. We hope that this machine will bring great contribution for your production.

SKI is a professional manufacturer of press machine peripheral equipment. With strong technical strength, excellent technical equipments, strict test instruments and perfect quality management system, we will make sure that our products meet your need.

Our products are tested and inspected strictly before sending out our company. But in order to make sure safety, safe running and durable usage, so before you use this machine ,please must read this operation manual, we will inform you that all kinds of features, installing, operations ,running, maintaining and so on

If you have any questions about this operation manual, please contact our company directly, we are glad to serve for you.

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Technical Specification

Item	:
Model	:
Max. Strip Width	:
Max. Feeding Length	:
Material Thickness	:
Mold Line Height	:
Max. Feeding Speed	:
Release method	:

SAFETY INSTRUCTIONS FOR ALL EQUIPMENT

The enclosed information and instructions must be forwarded and distributed to the Plant Safety Director, Plant Manager, Production Manager, and all Operators of SKI Equipment. Operators of Durant equipment must have a minimum of (3) three years operating experience with similar Durant press room equipment or a minimum of (3) three years experience with identical equipment manufactured by other press room equipment manufacturers.

WARNING

Never operate, install, or maintain this machine without understanding the complete and safe operation thereof.

It is the employer's responsibility to provide proper safety devices and equipment to safeguard the operator from harm and to safeguard this machine at all times to meet all current government safety codes and standards.

CAUTION

All Durant equipment must be securely fastened to the floor. This will prevent the machine from tipping. Failure to follow the above instructions could cause harm to the operator or machine.

ATTENTION

If any danger points are observed:

1. Immediately stop machine.
2. Do not run machine until danger point is eliminated.
3. Report danger point in writing to your employer.
4. Keep a copy of your report for your records.
5. Do not run machine again until danger point has been corrected.
6. It is your employer's responsibility to safeguard this machine to meet all government safety codes and standards.
7. There are U.S. companies that specifically specialize in safe guarding machines to plant requirements and government codes. The safe guarding companies are located throughout the United States, Canada, and foreign countries. Representatives will visit your site to advise and recommend safe guarding procedures for your company.

IMPORTANT

Before the first use and monthly thereafter, all nuts, screws, and bolts should be checked for tightness. Gears, sprockets, chains, and belts should also be checked for tightness.

Grease and oil fittings and reducers monthly. ***Section I Features***

1. High precision feeding: to meet the comming of hi –tech industry , controlled by mechanical feed system, keep precision degree within accuracy of +/-0.02 mm
2. High efficiency release device ,match with adjustment of cam signal
3. Roller cam for pilot release setting : a new cam device giving great precision in adjustment of the fixed gripper
4. Setting of feeding length ;directly with the Stud reffering to precision SKI Scale

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5. They are actuated by the press shaft via a reverser with alignment coupling. The rotary motion is transformed into alternative rectilinear motion by a connecting rod system.
 6. Pincer opening can be regulated according to the thickness of the sheet, and the pincers can be set up to work with pilot dies

Section III Installation

1. Located in the side of the pressworking table, setting the position.
2. Hang up the main part forward to the key between sliding plate and installation board. The main part is fixed to installation by 2 screws. - An adjustable mounting transition bracket with 2 jack screw for changing pass line height
3. When the feeding level is not consistent with the press tool, you can adjust from the sliding plate, then you can release the 2 screws on the sliding plate. Adjust the screws on the installation board to change the feeding level until ideal position.
4. Hardened and adjustable roller stock edge guides

Section IV. Adjusting of the machine

1. Start the straightener and uncoiler ,let coil roll out slowly.
2. Adjust the width guiding rollers according to the strip width.
3. Release the moving & fixed clamp by the locking handle device to put the coil strip into the die.
4. Now adjust the thickness of the strip with screw on the moving clamp at the position of the Press is 200° -270 ° .

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5. After setting the feed length
 6. When the pilot pin comes into the pilot hole, adjust releasing stick to touch the gear of releasing rack until releasing completely.
 7. Feeding is adjusted by the cam in the press, so the feeding is subject to the angle of the crank shaft in the press. The feeding angle should be 240-90 degree.
 8. After finishing the setting, you should test the punch tool and adjust it.

Section V. Maintenance

1. The gear should be put the lubricating grease and the grease very often.
2. Clean out the dirty things between the guide slides & gears.
3. All parts should not be damaged or deformed.

Section VI. Regular Inspection

If the machine has worked for 6 months or 1000 hours, you should inspect:

1. Inspect the outside body and see if it was damaged.
2. Check the Rubber Coupling & Connecting shaft linkage hub.
3. Check for the play in the gear box connected with the press crank shaft.
4. Tighten the nut & bolts
5. The dirty and dusty things should be cleaned out on the slides.

Section VII. Trouble Solutions

Trouble	Reason	Solution
Feeding error and only a fixed direction	1. Pressure is not enough from	Increase pressure
	2. Feeding length is too long.	Shorten the feeding length
	3. Feeding material is not enough.	Inspect material width and position of guiding rollers on the mould. Feeder and punch tool should be in line.
	4. There is some waste on the punch tools	See if inputting board and outputting board has waste.

The coil become bend.	1.Coil width doesn't match with the position of clamping wheel.	1.Readjust
	2.The pressure is not even.	2.Readjust
	3.Sliding	The guiding slot on punch tool should be in line with Feeder
	4. roller pressure is big enough	Readjust

Notes