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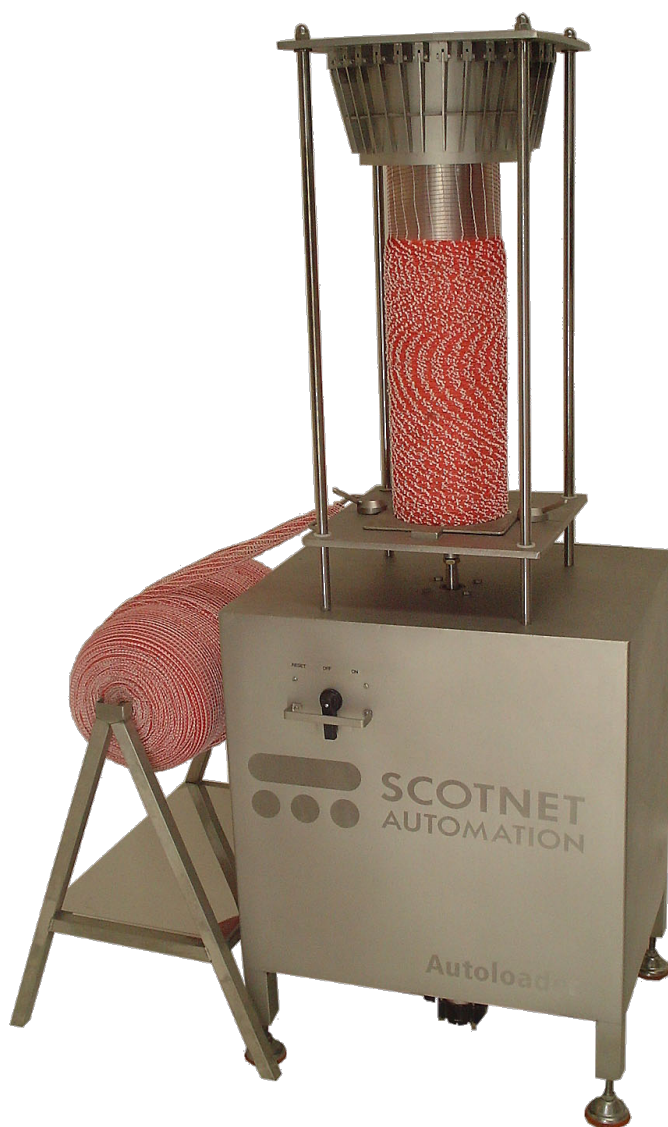


SCOTNET SOLUTIONS 1 SINGER ROAD EAST KILBRIDE GLASGOW G75 0XS SCOTLAND

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Automatic Net Loader with Auto Stop Operation Instructions

For Machines with Festo Pneumatics





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Automatic Loader Assembly Instructions

Most machines come fully assembled, however sometimes for shipping reasons, it is necessary to ship them as a kit. If your machine arrives as a kit, follow the instructions below. If it arrives as a complete machine, skip onto the

In the kit you should find the following parts:

1. Machine chassis complete
2. 4 guide rods
3. 4 Head Insert Collets
4. 4 M12 nylock nuts
5. 4 M12 dome nuts
6. 1 finger head complete (standard or extended, depending on requirement)
7. 4 feet
8. 1 moving platform
9. 1 plomper (standard or extended, depending on requirement)
10. A Frame (Bobbin Dispenser)

Assembly Instructions:

1. Screw the four feet on to the base of the machine, and stand upright.
2. Fit the moving platform to the ram. Take care not to damage the threads on the ram when fitting. Screw the ram fully into the boss on the underside of the moving platform. The moving platform is easily identified as it has 4 bushes fitted.
3. Carefully insert the four guide rods, and bolt from underneath with the 4 M12 nylock nuts. Slide the finger head on from the top fully down on to the locating collets.
4. Slide the four securing sleeves on to the rods.
5. Sit head on top of four guide rods ensuring head insert collets are on the ends of the rods to slot into head.
6. Place head in position and tighten with 4 M12 dome nuts.
7. Finally, sit bobbin dispenser next to machine, and machine is now ready to run.

Note: It is extremely important that the finger head is level on the machine. Take care not to force it into position.

The machine is now ready for use. See the 'setting up' instructions before switching on the machine.

Moving The Machine

To move the Scotnet Automatic Loader once assembled, either use a forklift truck, or a hand pallet truck. Lift the machines from below the chassis. Take care not to damage the ram which protrudes below the base of the machine. If the pallet truck is too wide, the machine can be placed diagonally.

Never move the machine by the upright poles. These will bend, leaving the machine inoperable.



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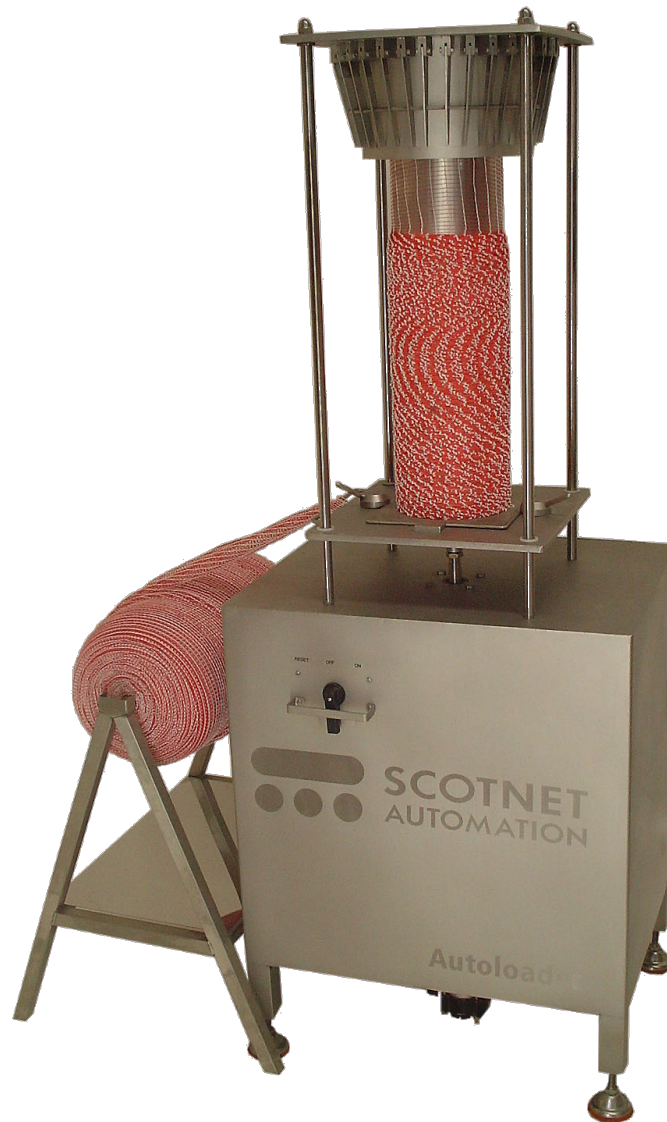


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Assembled Picture

Once assembled the machine should look like this. If the machine is to be used with a Super Bobbin, the Dispenser should be placed along side the machine as shown.





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Setting Up The Machine

General Settings

The machine requires approximately 46 ft³ or 1320 litres of compressed air per minute. The size of the compressed air fitting required is ¼ BSP.

For Maximum durability the air pressure should be set as low as possible. Different nets require different forces to load them, the machine should be set to load the strongest of your nets. Start with the air pressure set to 4 Bar (60 PSI). Insert a tube into the machine ready to load net and turn the machine on. The machine should raise the tube loading net all the way to the base plate. If it stops before this, you need to increase the pressure at the regulator remove the netting and repeat the loading test. You can gradually increase the pressure up to a maximum of 6 Bar.

Adjusting the Stroke Speed

Most nets will load with the machine set at 80PSI. However in some applications it is necessary to adjust the stroke speed of the machine. To slow the stroke down, reduce the air pressure at the regulator. The maximum pressure it is safe to operate the machine is 100 PSI.

Air Supply Failure

The machine is fitted with a safety device that prevents it from restarting if the air supply is interrupted.

If the supply is interrupted, the machine will stop during its cycle. When the supply is reconnected, the machine will remain where it stopped. To reset it, turn the On / Off Switch to the reset position. The machine will return to the start position, with the moving platform at the bottom of its stroke. To restart the machine, simply turn the switch back to the On Position.



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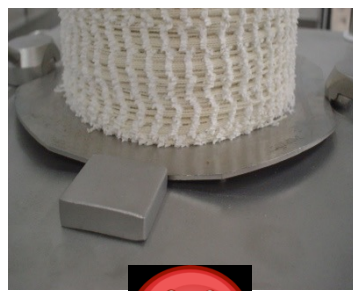
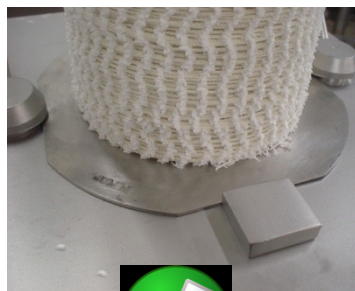
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Loading Net onto the Machine

1. Insert the 'Plomper' (finger opening device) into the finger head.
2. Feed the net from the roll or bobbin underneath the moving platform, and up through the hole. Pull about one meter of net through.



3. Take a tube, and turn it upside down, so the mounting plate is at the top. Drop the net through the tube.
4. Turn the tube back upright again, and insert into the machine, from the side. Make sure the net is not trapped, or caught round any of the upright guide bars.
5. Secure the tube to the moving platform with the cam locks. The cam locks must be locked tight on the tube base plate, if not tube will move around. The tube base plate must be flat, if it is not it cause the tube to lean to one side.





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6. Remove the 'plumper' and check the finger tips are level around the tube. This is especially important with tube diameters below 130mm. If they are not, inspect the tube location, and the tube base plate. Do not start the machine if the finger tips are not level.



7. Ensure hands are clear of the tube area, and start the machine.

When the tube is about $\frac{3}{4}$ full, the machine will stop automatically. Cut the netting near the moving platform, and switch the machine back on for a few seconds, until the cut end appears through the top of the tube, and switch machine to the off position. Reinsert the plumper, loosen the cam locks, and remove the tube. You can now return to step 2, and load another tube.



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Maintenance Procedures

Daily Checks:

1. Lubricate guide rods, and bushes with food safe lubricant.
2. Check auto drain regulator for water collection. Manually drain if required.
3. Check finger spring. Replace if stretched.
4. Check finger action for free movement. Replace if required.
5. Clean machine with an anti-bacterial solution, and rinse with clean water. Do not spray pressure hoses directly onto the machine.

Weekly Checks:

1. Check air pressure setting is at minimum 6 Bar and 8 Bar maximum, or at other setting if stroke speed has been adjusted.
2. Check fingers for wear.
3. Check all nuts and bolts for security, tighten if required.

Service Intervals

After installing the machine, we recommend that it is inspected by the installation engineer after:

- One Week
- One Month
- As required after this. We do not recommend leaving any machine for more than 6 months between services. The daily and weekly checks above must be carried out between services.



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Fault Finding Procedures

Machine Fails To Operate

Check the air pressure at the regulator. It should be set around 80 PSI (See Setting Up the Machine Section)

Check the On / Off Switch is operating correctly.

Check that the filter regulator is free from water.

Machine Cycles Irregularly

Check that the silencers, fitted to the pressure sensors on the top of the pneumatic board (coming out from the top of main valve), are correctly fitted.

Machine Tears Net

Check the finger spring for wear. There should be no over stretched sections.

If the spring is in good condition, check the finger ends for wear.

Check the tightness of the net on the tube. The net should fit the tube comfortably, but should not be excessively tight.

If there are any problems, please contact the Net Loader Service Desk on:
+44 (0) 1355 237041 for assistance.



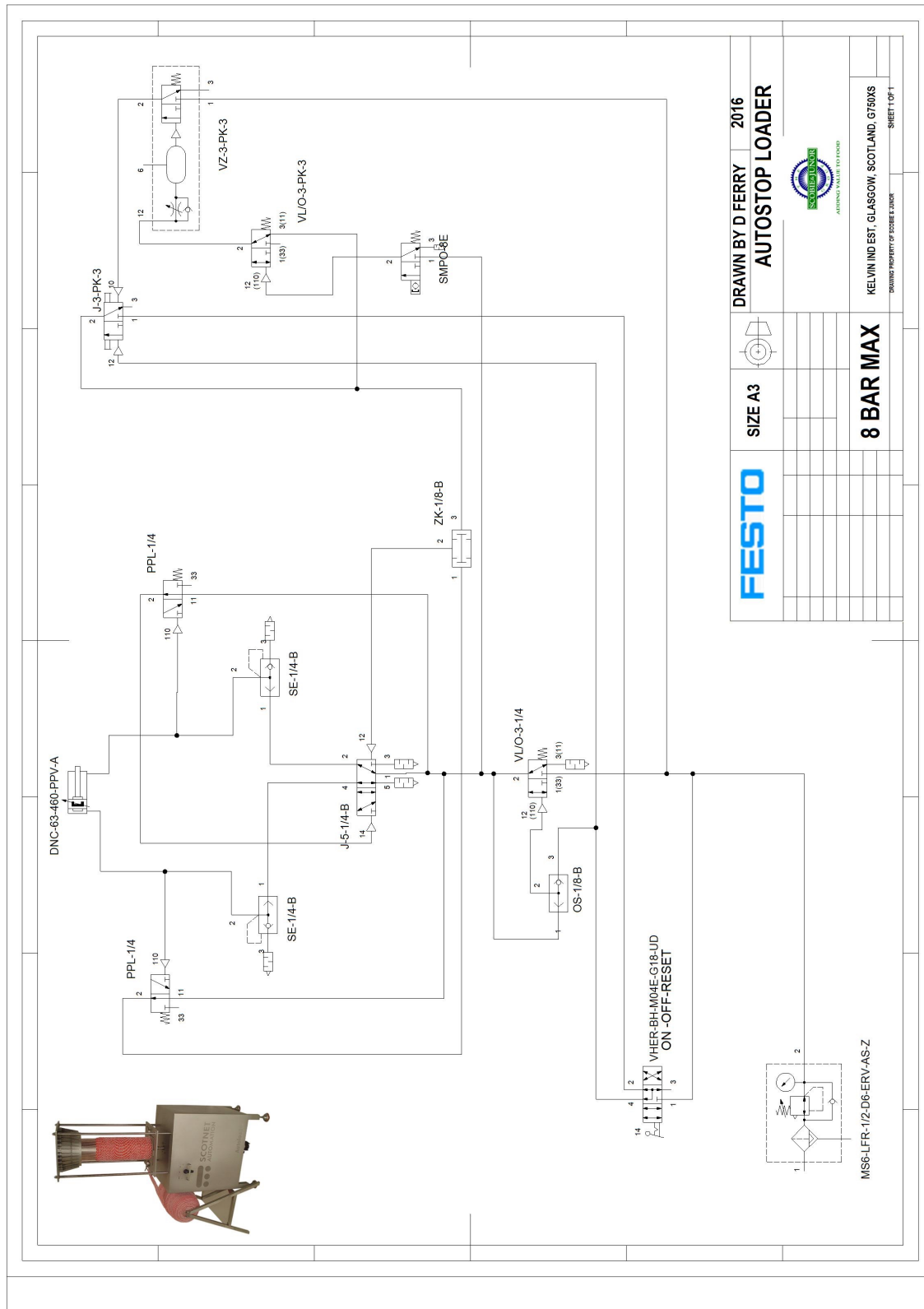
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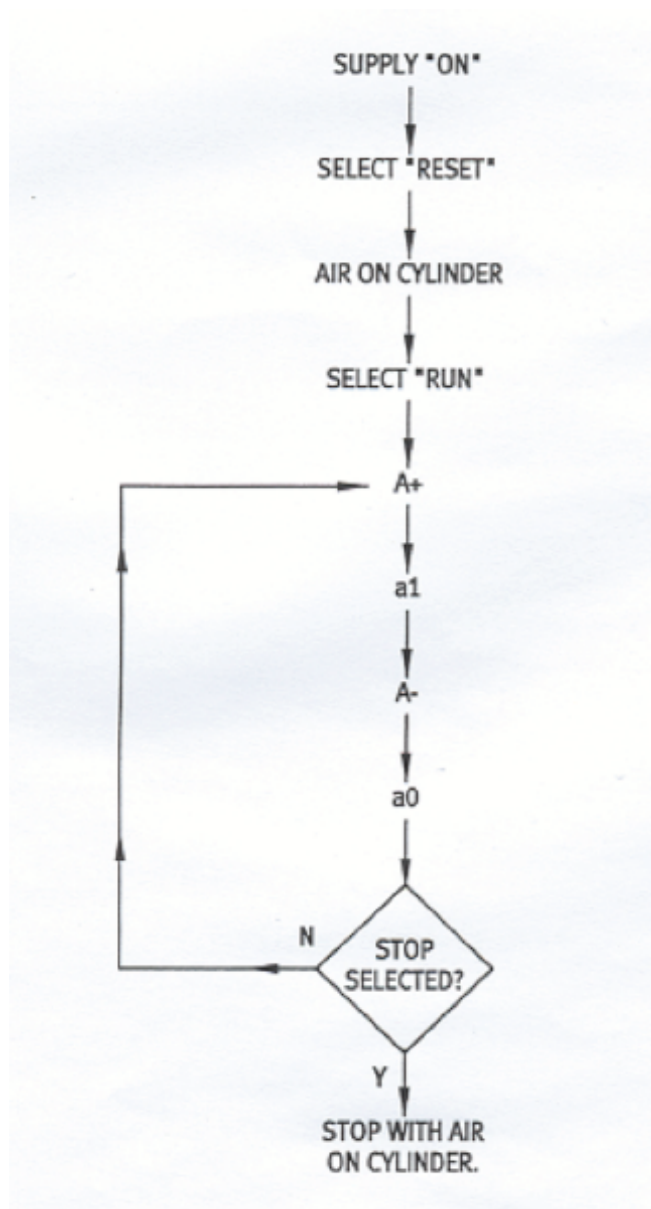




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Cycle Description





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Parts List

Part Code	Description	Description 2	Unit
SA151843	Reset Off On Switch	HSO-4/3-1/8-B	PCS
SA153001	Threaded/Push-in fitting	QS-1/8-4	PCS
SA13363	Cylinder Signal Generator	PPL-1/4	PCS
SA9686	Quick Exhaust Valve	SE-1/4-B	PCS
SA165004	Silencer	UC-1/4	PCS
SA3577	Reducing Nipple	D-1/8 I-1/4-A	PCS
SA153005	Threaded/Push-in fitting	QS-1/4-8	PCS
SA14295	Double Pilot Valve	J-5-1/4-B	PCS
SA6681	Logic Element	OS-1/8-B	PCS
SA9984	Pneumatic Valve	VL0-3-1/4	PCS
SA6680	Logic Elements	ZK-1/8-B	PCS
SA5755	Time Delay Valve	VZ-3-PK-3	PCS
SA178230	Mounting Kit	SMB-8E	PCS
SA178563	Proximity Sensor	SMPO-8E	PCS
SA12255	Threaded nipple fitting	CN-M5-PK-3	PCS
SA153128	Push in T Connector	QST-4	PCS
SA153135	8-6mm T Piece	QST-8-6	PCS
SA153041	6-4mm Stright Reducer	QS-6H-4	PCS
SA153045	Push in Elbow 4mm Fitting	QSL-1/8-4	PCS
SA153026	Push In Connector	QSF-1/4-8-B	PCS
SA153049	Push in Elbow 8mm Fitting	QSL-1/4-8	PCS
SA10772	Pneumatic Valve	J-3-PK-3	PCS
SA4233	Pneumatic Valve	VL0/0-3-PK-3	PCS
SA163400430	430mm 63 Cylinder	DNC-63-430-PPV-A	PCS
SA529183	Filter Regulator with Integral Guage	MS6-LFR-1/2-D6-ERV-AS-Z	PCS
SA1526075	Mounting Bracket for MS6 Filter Regulator	MS6-WR	PCS
SA532188	Nut For MS6 Filter Regulator	MS6-WRS	PCS
SA195280	Plastic tubing 4mm	PLN-4x0,75-SW	M
SA195282	Plastic tubing 8mm	PLN-8x1,25-SW	M
SASQL	Square Loader Kit		PCS
SAFEET	Loader Feet		PCS
NL61010	Cam Locks		PCS
NL60005	MOVING PLATFORM BUSH	4 REQUIRED PER MACHINE	PCS
NL60004	Finger Spring		PCS
NL60009	32 Finger Net Loading Head		PCS



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Autoloader Equipment Training Programme

This programme is designed for the engineers that are going to maintain the Scotnet Automation range of equipment.

Company Name:

Training Date:

Contact Name:

Instructors Initials:

1) Operation Instructions

Explain all sections from instruction booklet

2) Installing and setting-up machines

Explain minimum requirements for supply, which is the end users responsibility. Any adjustments to run machine

3) Machine Operation / safety precautions

Explain the operation fully; test the trainee let them operate to see if they understood.

4) Machine Maintenance – Daily, Weekly and Service Reports

Explain what maintenance is required from on site maintenance teams. How to fill in service report.

5) Fault Finding

Explain fault finding procedure. Put a fault in machine and let trainee find

6) Ordering Spares

Explain what information is required, who to contact.

7) Pneumatic Diagram

Run through circuit showing each component.

8) Spare Parts List

Explain the spare parts & any items that the customer should carry

9) Service Intervals

Explain what service intervals are needed which is dependent on customer usage

I confirm that I have received and understood the above training.

Signed:

Print:

Position:

Date: