Refer to FIG4 for feed geometry.

FEEDER TIMING

Re-timing or resetting the feeder can be achieved using the 'HOWDON' hub located on the non-load side of the first tucker disc shaft. Loosening the hub allows the timing plate wheel to rotate freely; therefore the shuttle pushers can be adjusted in alignment with the flight chain pusher lugs.

Setting a Timing Mark

Jog the machine until the shuttle pusher is at the end of its stroke. At this point there is a small amount of dwell before the pusher begins to return to the carton stack. It is crucial that the pushers are stopped just before or after the dwell position. Put some sticky tape onto the carton rails and using a pen and a rule, mark a straight line.

Jog the machine until the Flight chain Pusher lug is 2mm **behind** the marked line.

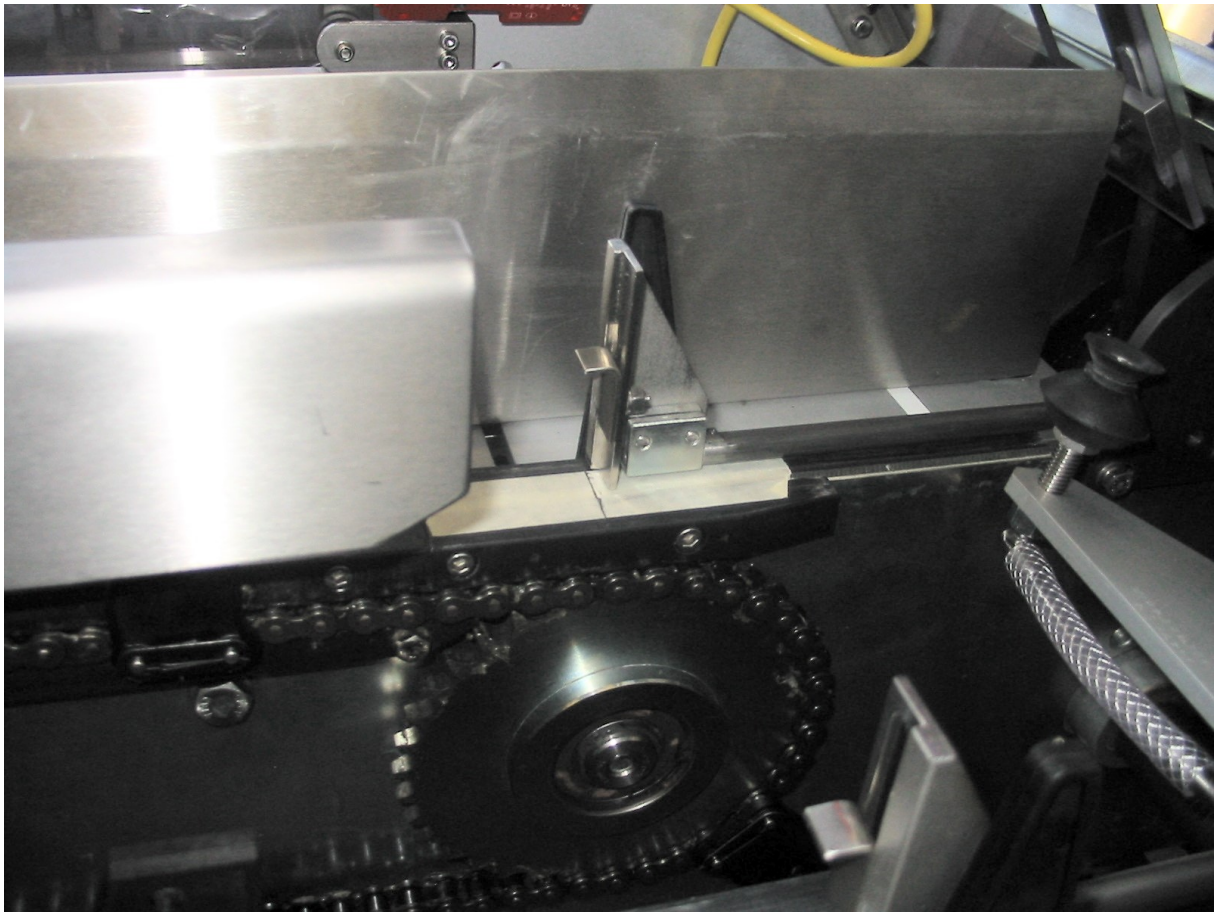

Fig 1 - Shuttle Mechanism.

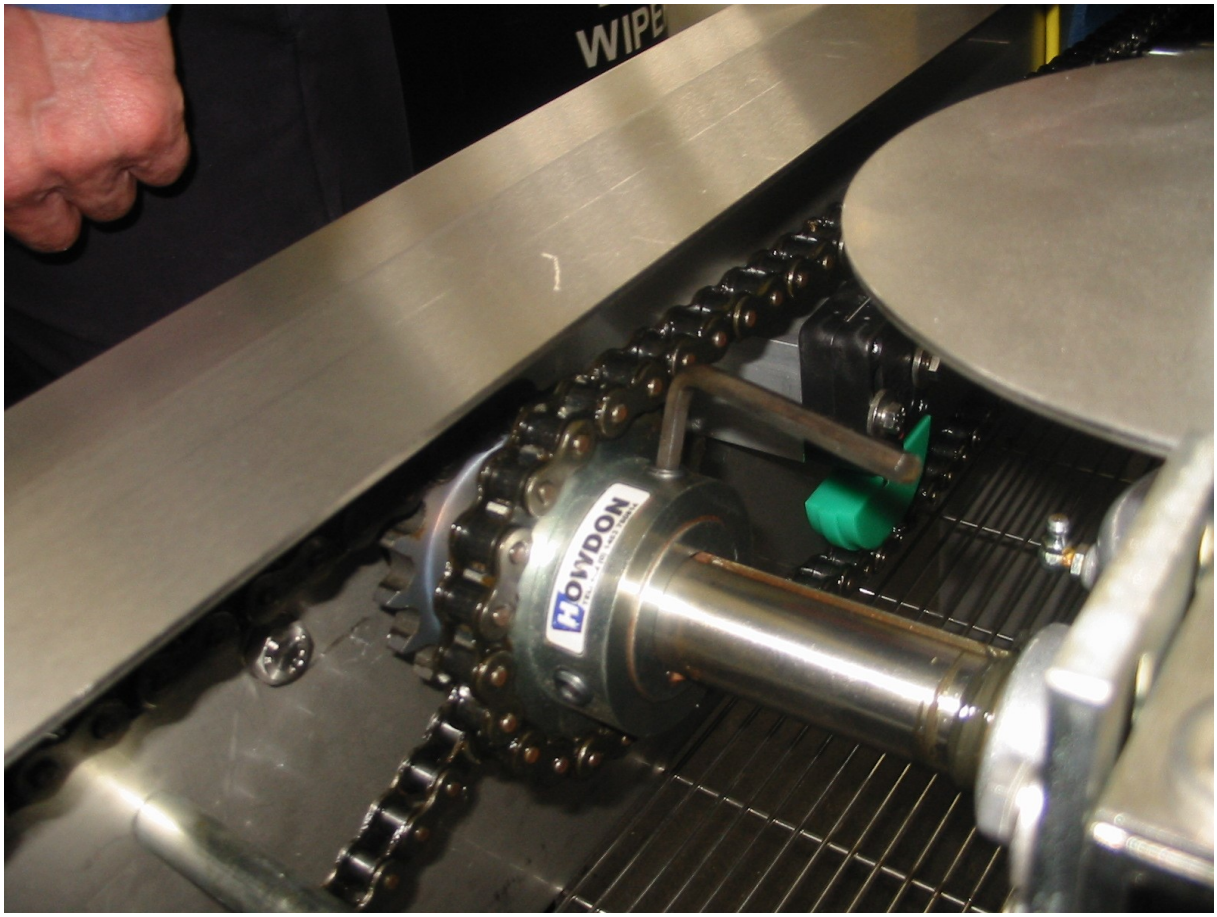

Fig 2 – Howdon Hub.

With the shuttle in the fully forward position loosen the 3 Grub screws clamping the Howdon Hub.

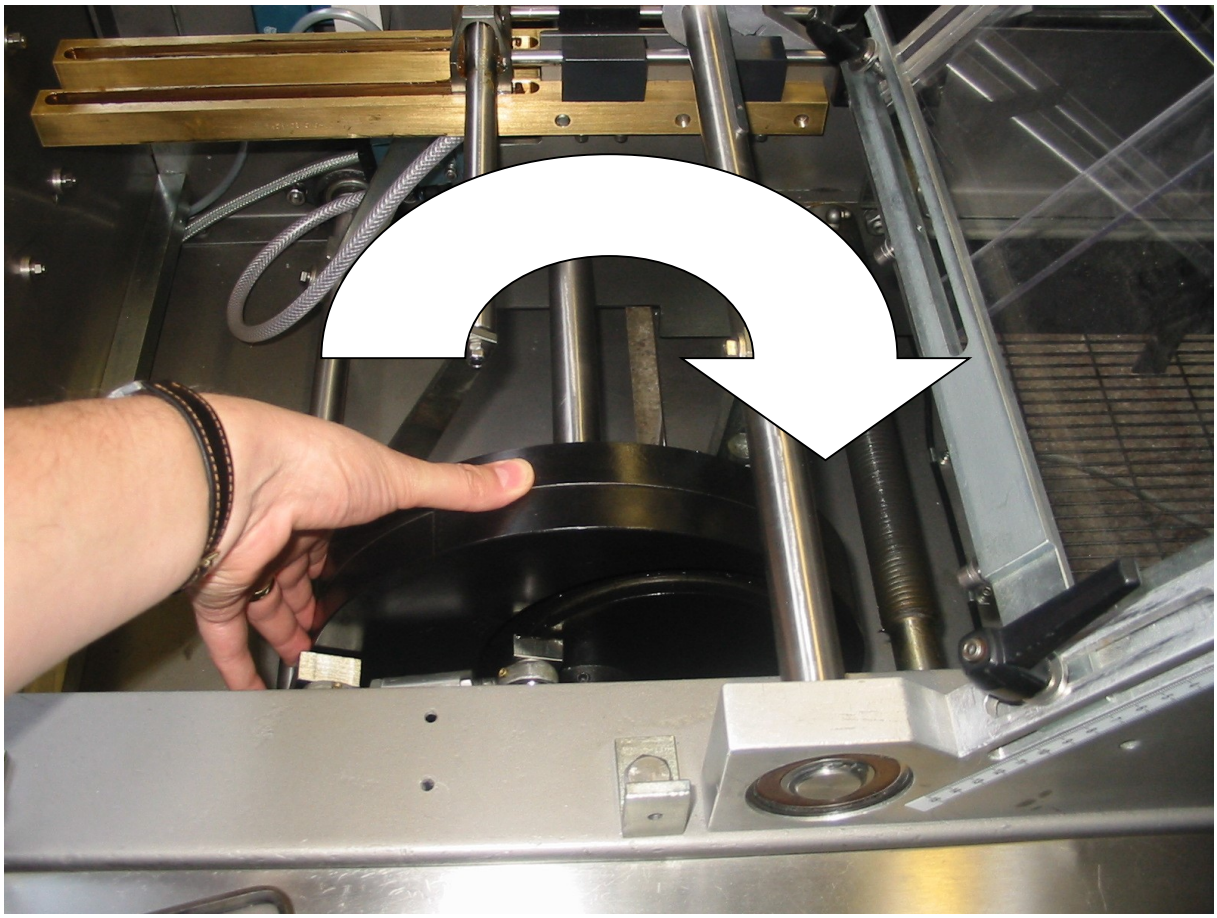

Fig 3 – Box Cams.

The box cams can now be rotated clockwise (see fig 10.5); this will allow the shuttle pushers to move independently of the flight chains. When the shuttle pushers reach the end of their stroke, re-tighten the Howdon Hub. Timing is achieved with the shuttle pusher lugs **2 mm** in front of the flight chain pusher lugs. Correct setting will give a smooth take-over of the carton by the conveyor pusher lugs from the shuttle.

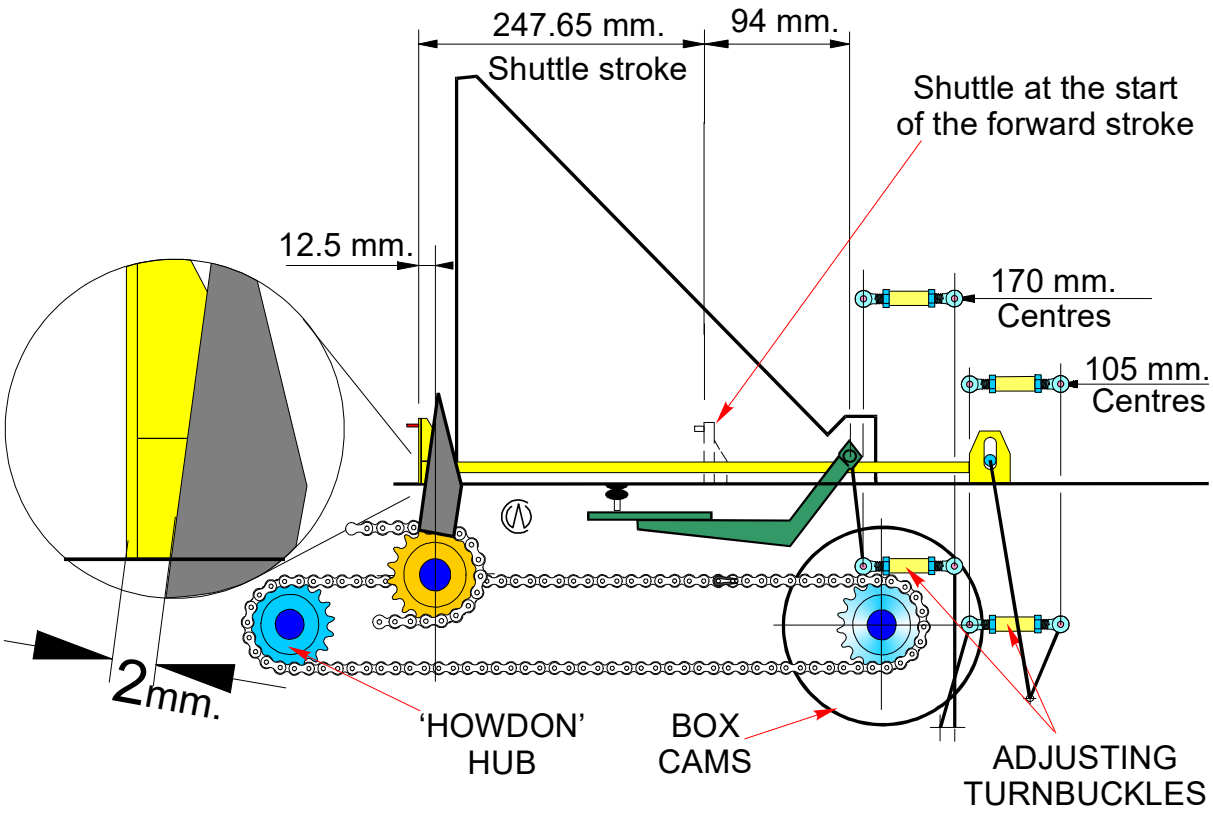

Fig 4 - Feed Geometry