


Gripper Push Speed on Flowline and ZX

How to adjust the Grip Push speed on a flowline and the consequences if it is too fast

 Difficulty Easy

 Duration 15 minute(s)

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Introduction

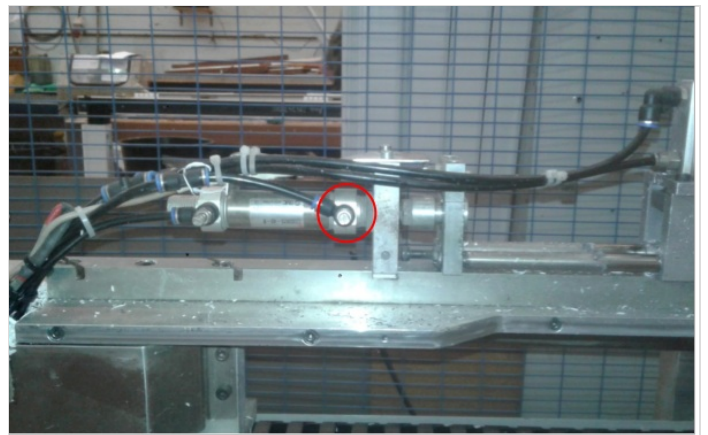
There is a cylinder called Grip push, when bar is moved to its unload position the Gripper Comes OFF then Grip push is activated to push the profile of the gripper to clear ready for the Eject push onto transfer Table.

The video shows what happens if the grip push is set too fast. The speed of the cylinder is Far too Fast and is Throwing/punching back down machine. -- This needs to be slowed Down.

Step 1 - Adjust flow control

You can adjust the Flow control and Slow down the cylinder speed. The one you need to wind IN (clockwise) to slow down is the one nearest to the MH side - Not the Extractor side.

 ...Note, the photo is from a Right to Left feed machine, the video is from a Left to Right feed machine



Step 2 - Test

Adjust and slow down - Get someone to operate the Grip push output whilst you slow it down so you can see the change, an ideal speed is 1.5 seconds for it to move to full stroke when activated.