

R0015336 Pneumatic Output Testing

Details for manual pneumatic output testing on module

 Difficulty **Medium**

 Duration **1 hour(s)**

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Comments

Introduction

Tools Required

PCL airline connection

12mm blanking ports

Valve Manual over ride tool

Standard screwdriver set

Additional colleague when setting regulator pressures for outputs

Parts required

R0015040 completed module

Step 1 - Safety

Output testing will require valve operation with no e/s circuit

Ensure the following

Work area is clear from all components not required for testing

All colleagues are aware of the procedure being undertaken

No additional colleagues are working on the module

PCL coupling is accessible to release pressure in case of emergency

Testing procedure is fully adhered to



Step 2 - Machine Lubrication

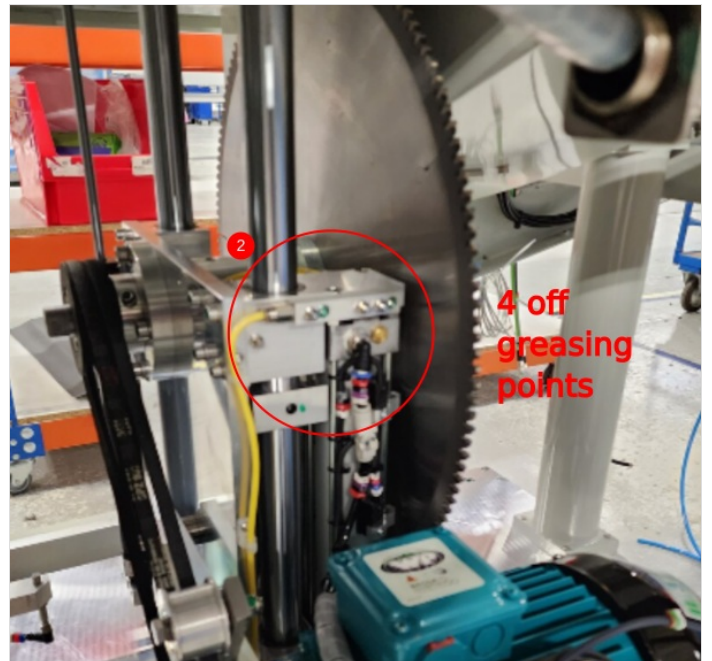
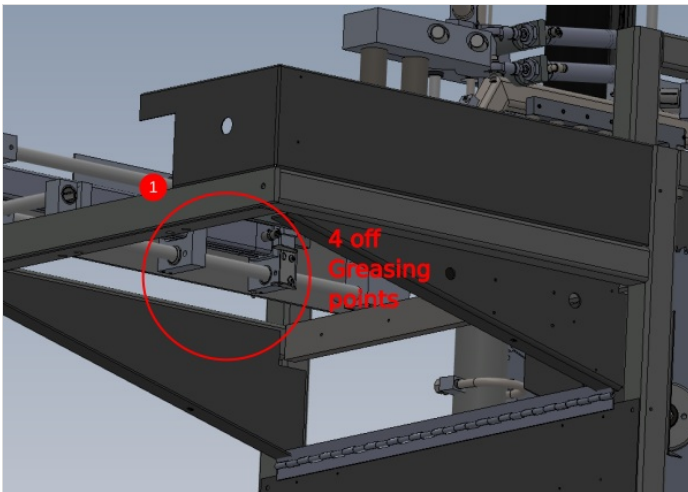
Machine lubrication must be completed before operation of mechanical components

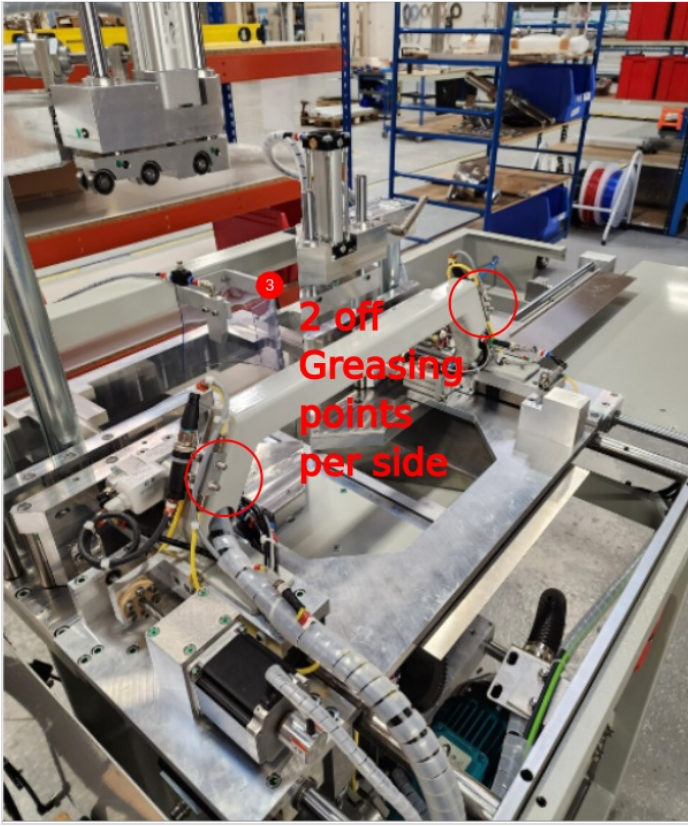
Grease following points with grease gun

1 Eject bearings. 4 off grease nipples. Apply grease until it starts to exit bearing

2 Saw head bearing. 4 off greasing nipples. Apply grease until it starts to exit bearing

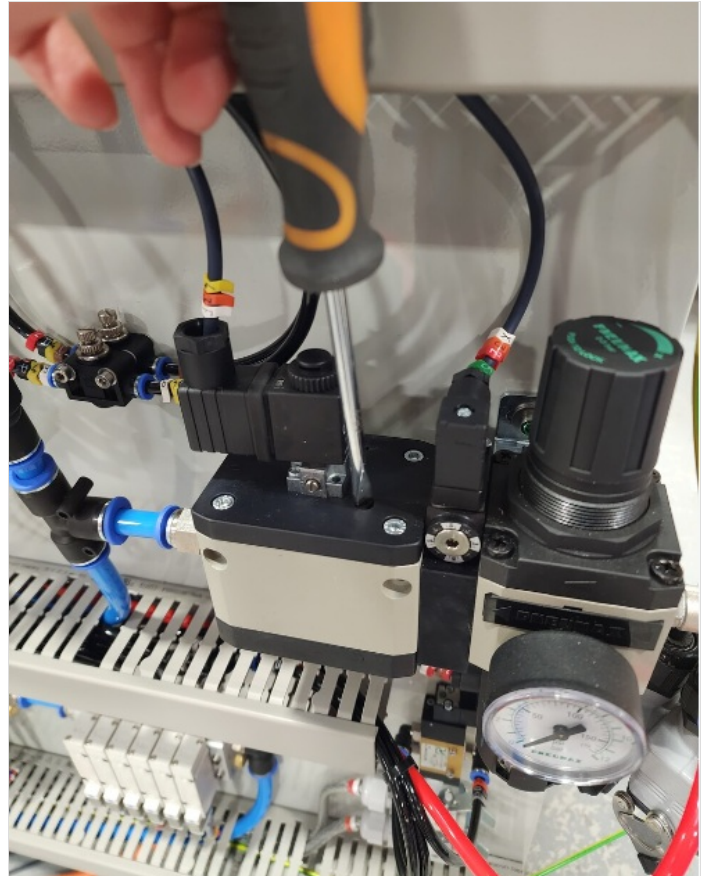
3 SY Axis bearings. 4 off greasing nipples. Apply grease until it starts to exit bearing





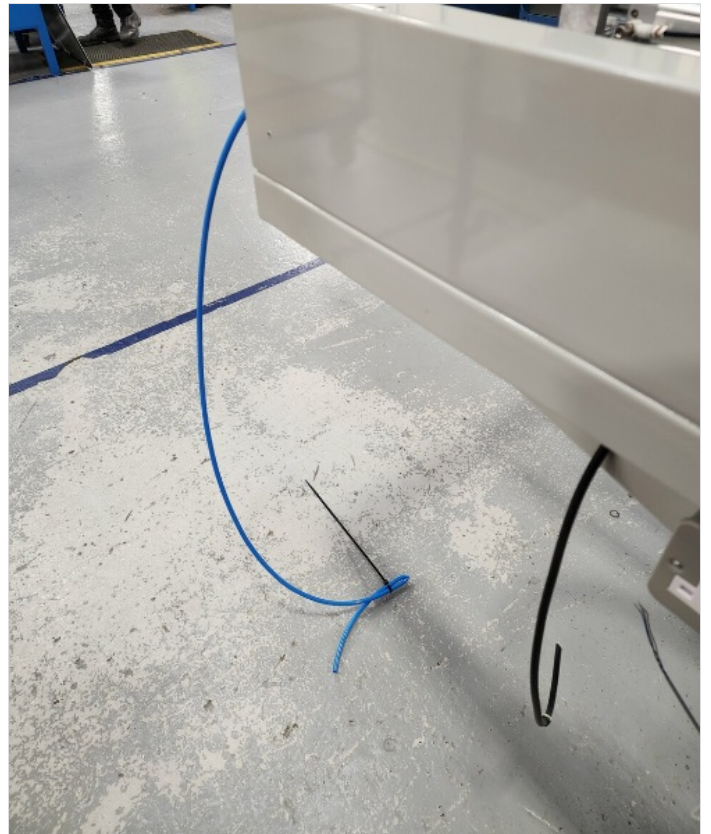
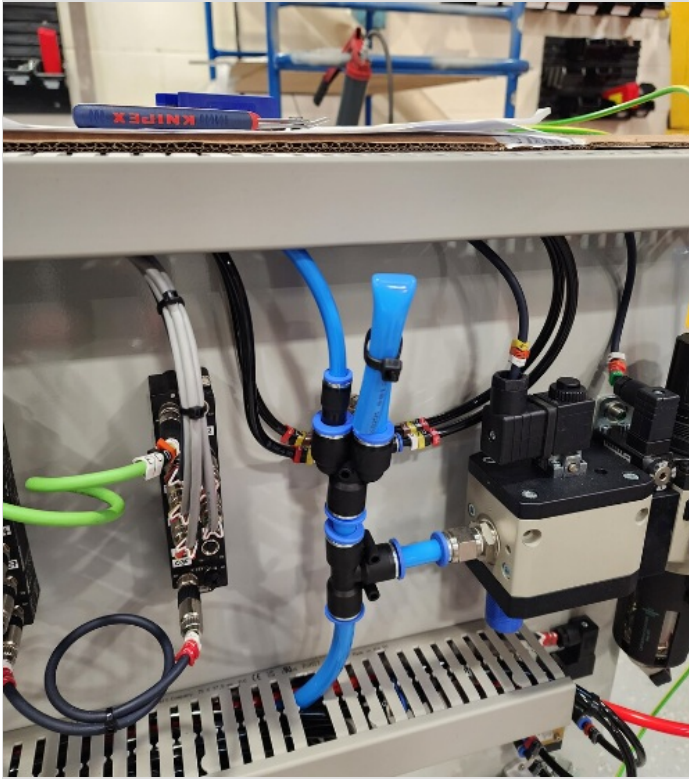
Step 3 - Set Air service unit soft start

Wind fully out soft start screw situated on top on main air service unit



Step 4 - Check all open ports

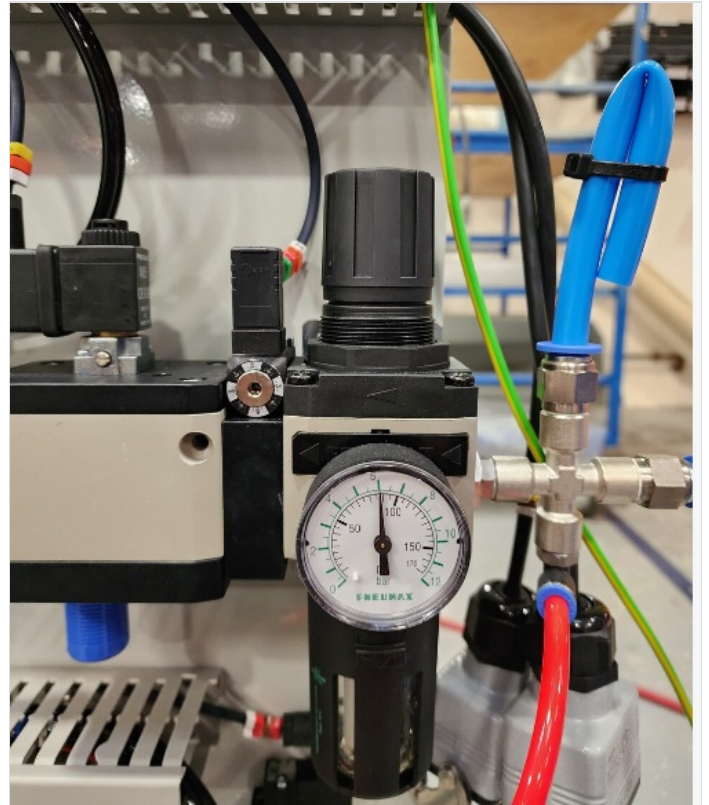
Ensure all open ports and trailing pipes are suitably blanked



Step 5 - Connect main PCL

Connect main pcl air feed to air service unit

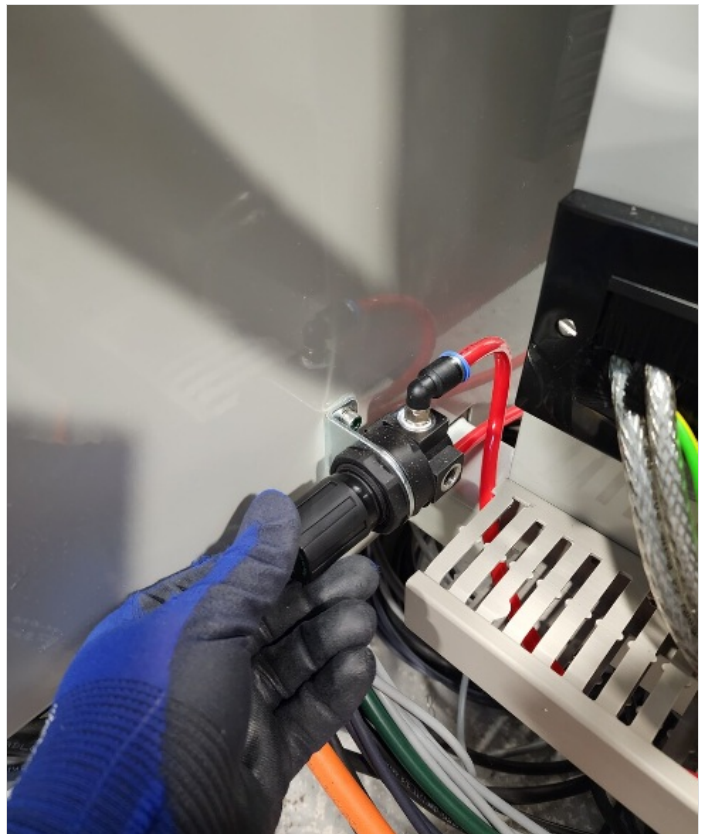
Increase Air service unit pressure to 6.0bar



Step 6 - Check for leaks

Check for audible leaks on the red pipe lines installed and correct if found

Check air gun regulator functions properly . Fully open the regulator (2 bar limited) and test air gun assembly



Step 7 - Manual override

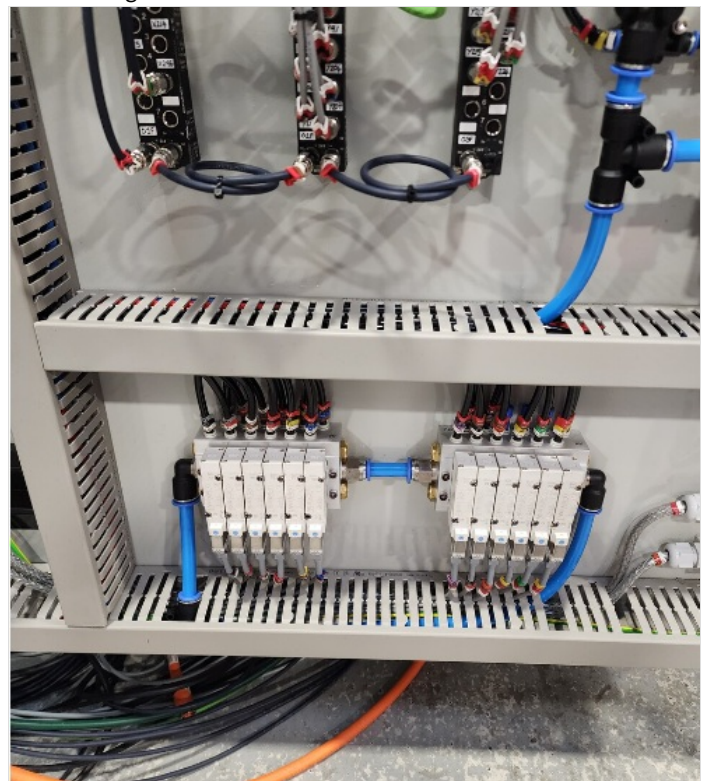
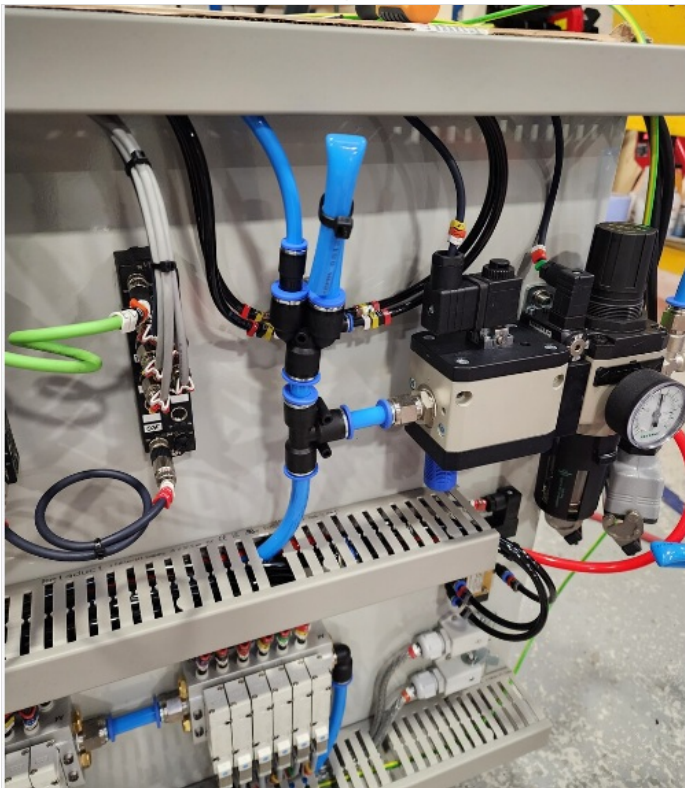
Enable the manual over ride on the main air service unit

This will purge the system with air.



Step 8 - Check for leaks

Check for audible leaks on blue Pipe line, and active control pipes to cylinders and regulators





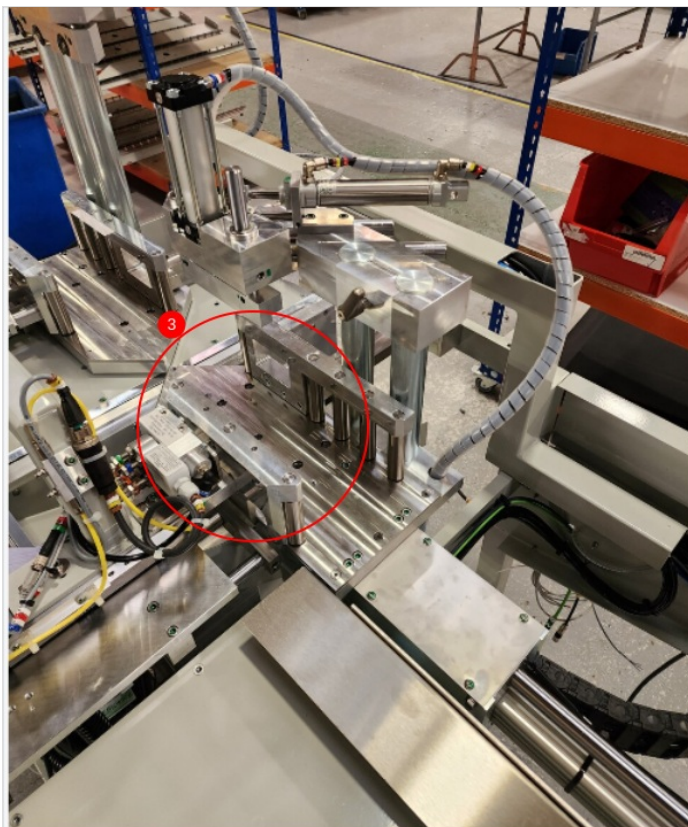
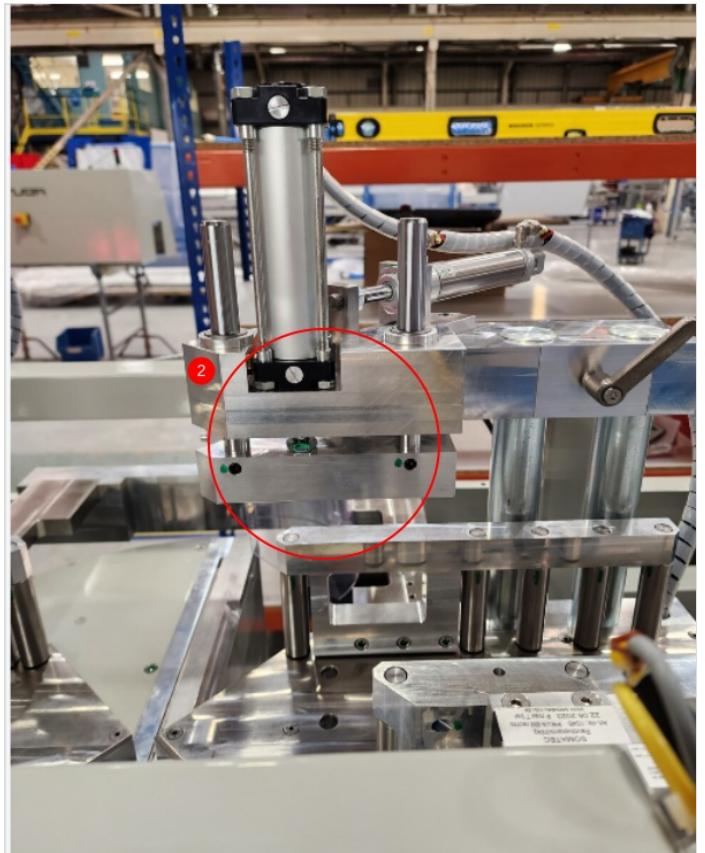
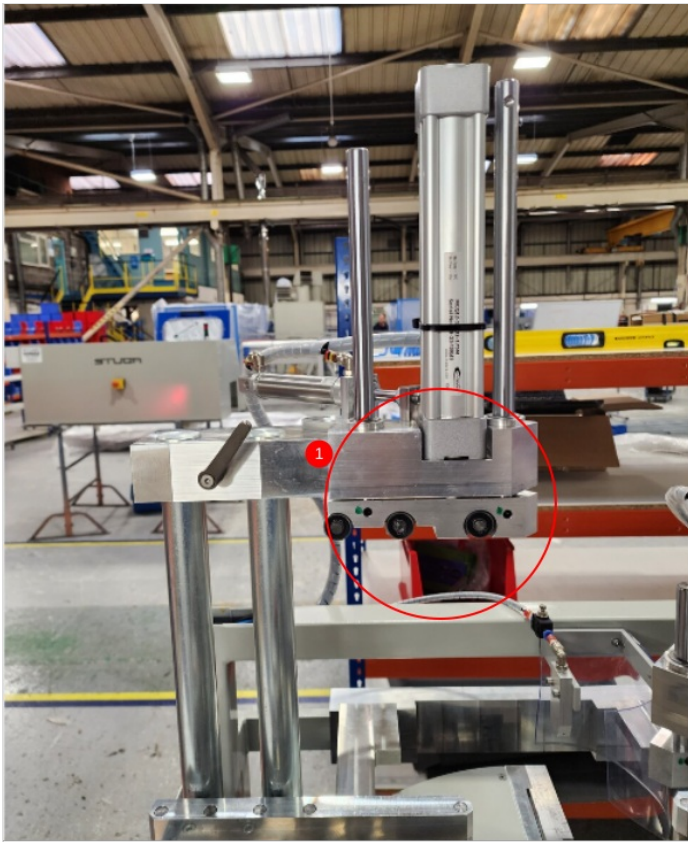
Step 9 - Check home positions

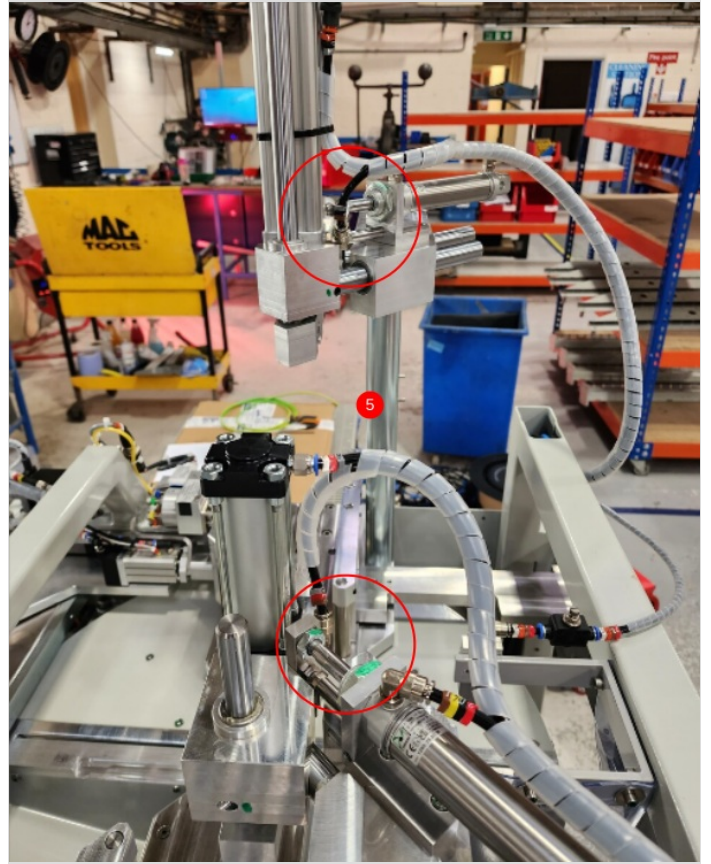
With the system in the natural state when over ridden, the following cylinder positions should be confirmed



Step 10 - home positions for outputs

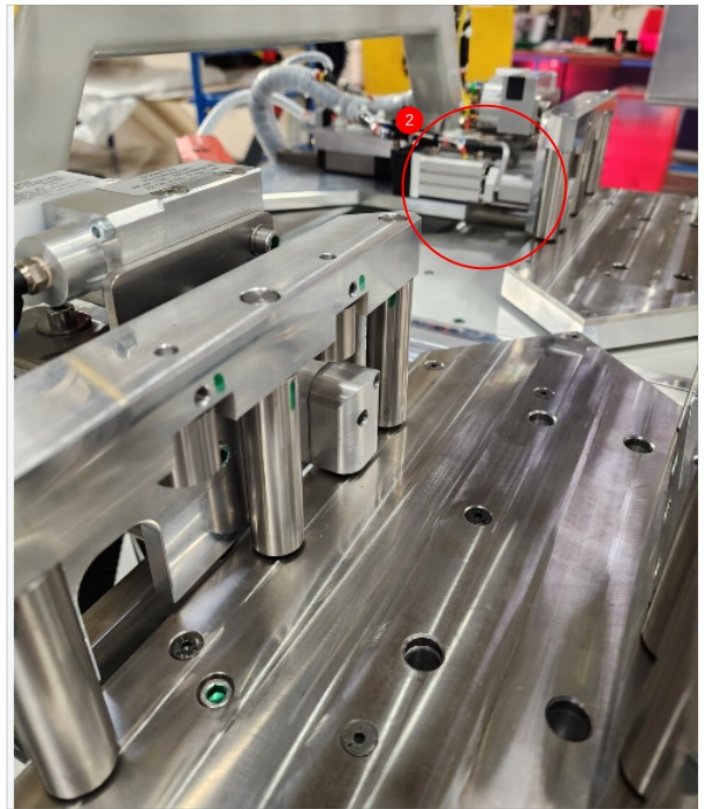
- 1 Y80 Infeed Top clamp contracted
- 2 Y82 Outfeed top clamp contracted
- 3 Y91 eject cylinder contracted
- 4 Y202 clamp infeed side extended
- 5 Y204 Clamp pos contracted
- 6 Y206 Centralise contracted



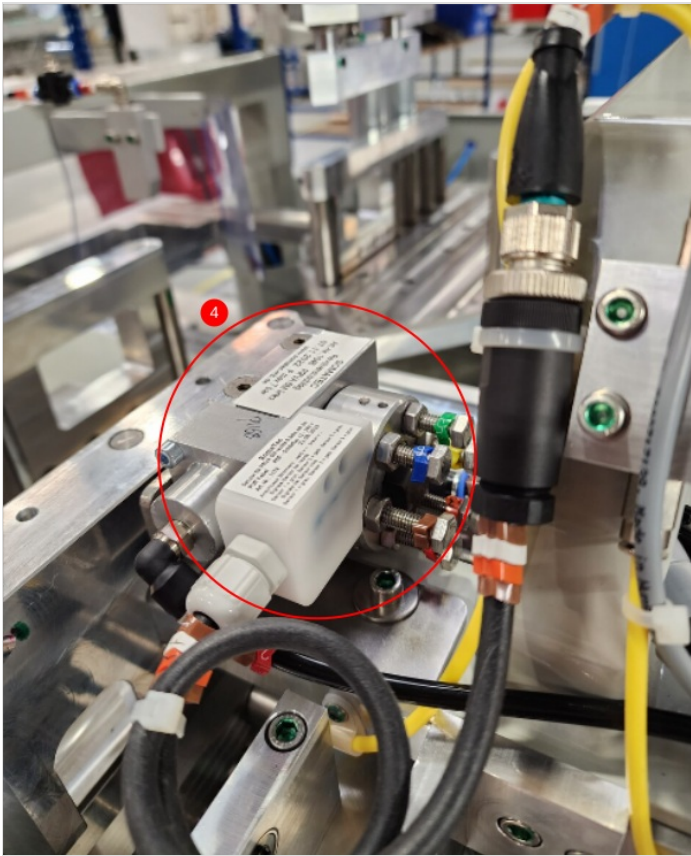


Step 11 - home positions for outputs

- 1 Y207 Saw cut contracted
- 2 Y210 Z support infeed contracted
- 3 Y213 Saw blowers switched off
- 4 Y214 Z turret infeed Not moving
- 5 Y215 Z turret outfeed . Not moving
- 6 Y224 Z support outfeed contracted







Step 12 - If any deviation from the above

If any deviation from the above check pipe connections to incorrect output



Step 13 - Manual valve over ride

Each valve can be manually fired from the over ride button. Pressing this will activate the valve and fire the cylinder /output

when a valve is over ridden, ensure attention is paid to any new air leaks that could become present in the active line when fired



Step 14 - Y80 Clamp infeed top

Fire and hold valve

Adjust regulator to 0.2 M.P.A

Cylinder should extend

Should retract when valve released



Step 15 - Y82 Clamp outfeed top

Fire and hold valve

Cylinder should extend

Should retract when valve released



Step 16 - Y91 Eject

Fire and hold valve

Eject table should move away from saw head

Should retract when valve released



Step 17 - Y202 Side clamp

Fire and hold valve

Set regulator to 0.2 M.P.A

Side clamp should move towards backfence rollers

Should retract when valve released





Step 18 - Y204 Clamp position

Fire and hold valve

Clamps should move towards from of machine.

If movement is slow/not present check flow restrictors on back of electrical cabinet identified as 2049

Should retract when valve released

