CF SERIES ADDITIVE FEEDERS

Reference Manual (PN: 882.00275.00) for
Complete Operation and Installation Instructions
(Available online at www.acscustomerservice.com)

Quickstart Installation Checklist

(Please refer to operation manual for complete installation instructions)

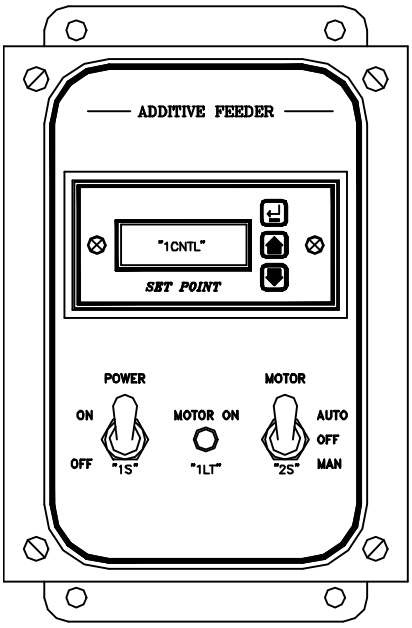
1. Remove hopper from your processing machine.
2. Drill holes in both flanges of the additive feeder main throat so that they exactly match the bolt hole pattern on your processing machine throat. Select a position that allows for easy operator access.
3. Bolt the main throat to the machine and bolt the machine hopper to the main throat with the appropriate bolts, nuts and lockwashers.
4. Mount the control in a position with convenient operator access near the additive feeder. Avoid locations with excessive dust, vibration, moisture and heat.
5. For either Injection or Extrusion applications, calibration of the additive feeder is required for the most accurate results since materials and environments can vary so greatly. (See section 3-4 in the owner's manual. Use the chart on page 56 of the owner's manual for each additive used).
6. For both Injection and Extrusion applications, a control signal is required to ensure that the additive is feeding at the correct rate or only feeding when required. (Refer to sections 4-3 and 4-4 of the owner's manual for a detailed description of what is required).
7. For Extrusion application only: Parameter # 37 requires the installer to program the correct pulses per revolution from the extrusion machine. (See section 4-4 in the owners manual)

Unit Operation

Start Up

1. Turn the power switch **ON**.
2. Set the desired feed rate on the RPM display using the up or down arrows.
3. Flip the motor switch to **AUTO**.

Note: ***If the additive feeder is installed correctly, it should begin operation at the desired RPM when the processing machine screw is in operation.***



Shut Down

1. Flip the motor switch to the **OFF** (center) position.
2. Turn the power **OFF**.

Note: ***For long term shutdown, disconnect power and clean the additive feeder.***

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Part No: 882.00339.00
Bulletin No: BF2-305.01

Calibration

This procedure allows the operator to precisely adjust additive feed rates.

Equipment Needed:

- Scale
- Sample container
- Timer, stopwatch, or clock with second hand

Procedure:

1. Close cleanout and calibration hatches.
2. Fill the additive supply hopper.
3. Weigh the empty sample container.
4. Swing open the calibration hatch near the main throat.
5. Set the controller to a desired RPM.
6. Place the sample container below the calibration hatch.
7. Hold the three-position motor switch in the Manual position for about a minute. This lets the new setpoint stabilize and fills the auger flights with material. Discard the first sample.
8. Position the empty scale container below the calibration hatch and hold the three-position motor switch in the Manual position for exactly one minute.

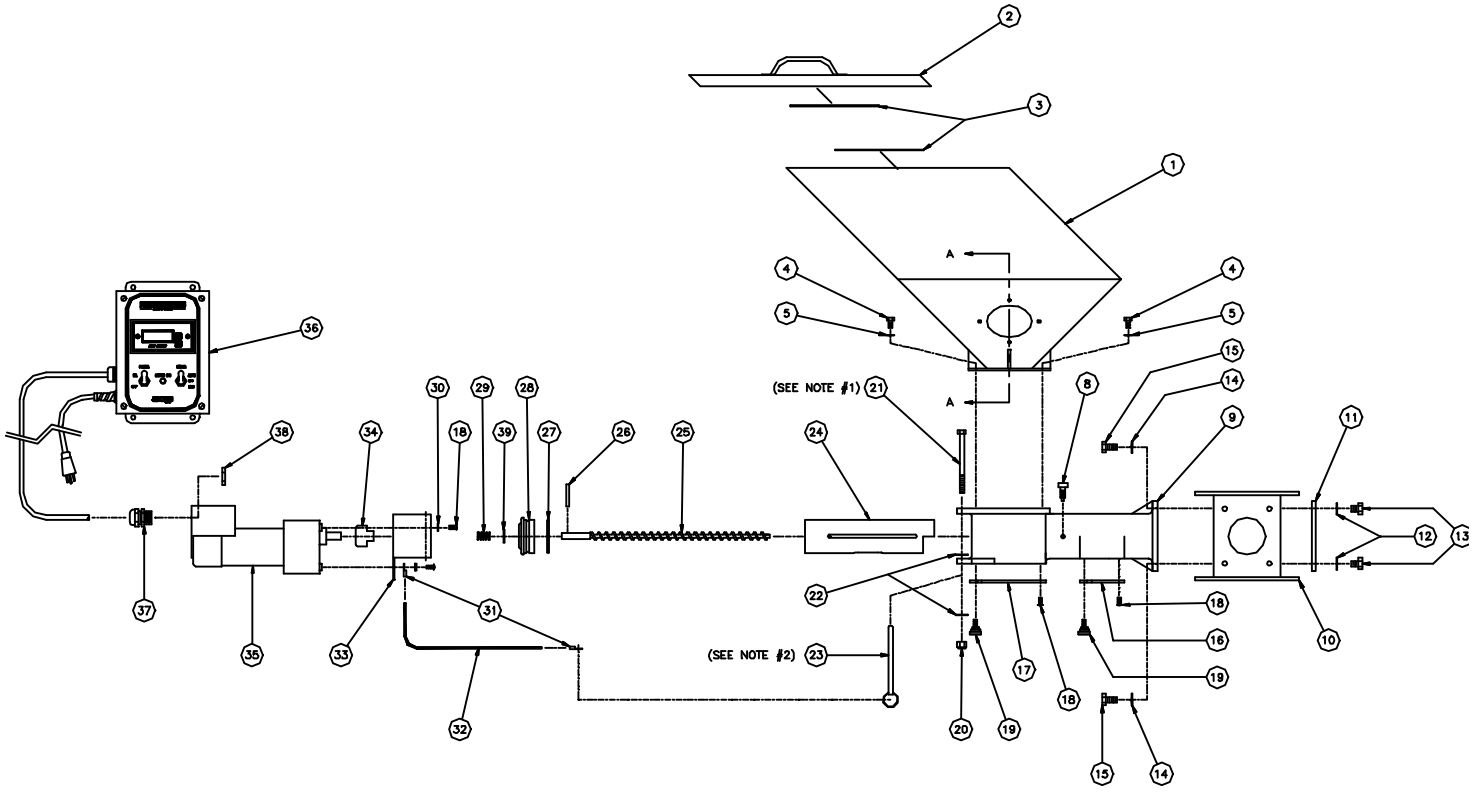
   Note: ***If your additive feeder is equipped with the timer option, set the timer to one minute and put the three-position motor switch in the Manual position. Operation will automatically stop after one minute.***

9. Weigh the empty scale container below the calibration hatch and hold the three-position motor switch in the Manual position.
10. Adjust the auger RPM and repeat the calibration process until the desired feed rate is achieved.

    Note: ***To speed the calibration procedure, reduce trial and error auger rpm settings and zero in on the desired feed rate. Chart the calculated feed rates from a few rpm settings on graph paper. Draw a straight line between the coordinates to establish a customized feed rate curve for the actual operating conditions.***

Spare Parts Location

(See next page for Spare Parts List)



Spare Parts List

(See previous page for Spare Parts Location)

Detail #	Part number	Part/Assembly description
6	A0541206	Supply Hopper Sight Glass
8	W00052210	Plunger Pin, Retractable
11	A0541205	Main Throat Sight Glass
16	A0541216	Calibration Sample Port Plate
17	A0541215	Clean Out Port Plate
19	W00052550	Knob, Knurled
24	A0541277	Quick Release Pin
25	A0541209	Feed Tube Insert, 1/2"
25	A0541210	Feed Tube Insert, 3/4"
25	A0541211	Feed Tube Insert, 1"
25	A0541212	Feed Tube Insert, 1 ¼"
25	A0541213	Feed Tube Insert, 1 ½"
25	A0541214	Feed Tube Insert, 1 ¾"
26	A0541219	Auger, 1/2"
26	A0541220	Auger, 3/4"
26	A0541219	Auger, 1"
26	A0541292	Auger, 1 ¼"
26	A0541223	Auger, 1 ½"
26	A0541224	Auger, 1 ¾"
Assy.	A0541292	Auger Assembly, 1/2" *
Assy.	A0541293	Auger Assembly, 3/4" *
Assy.	A0541294	Auger Assembly, 1" *
Assy.	A0541295	Auger Assembly, 1 ¼" *
Assy.	A0541296	Auger Assembly, 1 ½"
Assy.	A0541297	Auger Assembly, 1 ¾"
27	W00015504	Roll Pin
28	A0541284	O Ring
29	A0541217	Thrust Bearing
30	A0541283	Compression Spring
35	A0541282	Jaw Coupler
36	A0555661	Motor Assembly, 115 VAC, 1/10 H.P.
36	A0541298	Motor Assembly, 115 VAC 1/20 H.P.
36	A0547487	Motor Assembly, 115 VAC, Low RPM 1/20 H.P.
37	XXXXXXX	REPLACE THIS WITH THE PART FOR THE DC DRIVE CONTROL 115VAC
37	XXXXXXX	CONTROL RELAY
37	XXXXXXX	ON/OFF SWITCH
37	A0544795	230 VAC/115 VAC Transformer Control Assembly
Available Option	A0539035	Transition Flange, Feed Throat, 7" to 4" Square

* Auger assemblies include details 26, 27, 28, 29, 30, & 21. Insert is not included. Order the appropriately-sized feed tube insert (Detail 25) if needed.