

INSTRUCTION MANUAL

ADR-50C

UNIVERSAL CLOSURE MONITOR

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WARRANTY

The manufacturer warrants each unit for a period of one year to be free of defects in material and workmanship under normal use and service, the obligation of the manufacturer under this warranty being limited to replacing at the factory of manufacture any part of said unit found to be defective.

This warranty is expressly in lieu of all other warranties and representations, expressed or implied, and all other obligations, liabilities, and consequential damages which might arise out of the utilization of this equipment.

1 THEORY OF OPERATION

1.0 CIRCUIT OPERATION

This section is extremely simplified in order to present a basic description of circuit operation without getting bogged down in complex pulse timing, forming and phase relationships. The purpose is to familiarize the operating personnel with the function of controls and adjustments.

There are two separate sensing functions for the ADR-50C, proximity sensing of the container end and position sensing of the container in relation to the proximity sensor.

1.0.1 The proximity sensing is the heart of the ADR system. The ADR functions by measuring the distance of the center of the lid in relationship to a fixed point above the lid, and comparing that distance to a standard set into the instrument (with the Calibrate Control).

If that distance in a container under test is less than that of the standard, then the absolute pressure in that container is greater than in the standard (vacuum is less than standard). As the internal pressure of the container drops in relation to atmospheric pressure, the closure will be forced in by the atmospheric pressure and the measured distance will increase.

To make this proximity measurement, we use the sense probe mounted on the reference strip (see Simplified Block Diagram). The sense probe, together with the reference probe located under the housing, make up a differential transformer. These two probes are driven by the 3200 hz. Oscillator (I.C.-115). Each primary is exactly equal to the other so that the driving signal is divided equally between the two. The secondaries are also equal to each other so that the output of each secondary is equal when the field is not disturbed. The two secondaries are wired series opposed so that when the top of the reference probe is going positive, the bottom of the sense probe is going positive and the sum of the outputs is 0 volts.

This balance condition will remain stable until metal is brought near the face of the sense probe. When this occurs, the electromagnetic field is altered and the coupling of energy between the primary and secondary is changed in the sense probe. Therefore, the output of that secondary is different and the sum output voltage is no longer zero. As metal draws nearer to the face of the probe, the difference voltage increases and the output of the differential transformer becomes proportionally higher.

The A.C. output of the transformer is fed through the Calibrate Control to a detector where it is converted to a D.C. voltage proportional to the A.C. voltage level.

This proportional voltage is applied to the control terminal of the Voltage Controlled Oscillator (I.C.-104, Q-101). The output frequency of the V.C.O. is proportional to the D.C. voltage applied to the control terminal of the V.C.O.; as the applied D.C. control voltage increases, the V.C.O. frequency increases.

- 1.0.2 The enable pulse is the signal that a container is centered under the probe and ready to be measured. When a container passes between the light source and photosensor it blocks the light until the container clears. At that time the photosensor switches to the ON condition. When the photosensor switches ON, that triggers the V.C.O. timer (I.C.-113) which applies a pulse to the enable terminal of the V.C.O.

While the pulse appears on the enable terminal, the output of the V.C.O. is fed to the Counter (I.C.-102) which counts the pulses from the V.C.O. for the duration of the enable pulse. When the pulse ends, the total count is held and will not reset until the next enable pulse is applied. This count is also displayed on the large L.E.D. display.

- 1.0.3 The total V.C.O. pulse count for the container under test is then fed to the Upper Limit Comparator (I.C.-210, 218) and the Lower Limit Comparator (I.C.-211, 217). This information is compared to the limit information set in on the upper limit and Lower Limit Generators. If the lid is closer to the sensor than the preset limit, a reject pulse will be initiated by the Lower Limit Comparator. If the lid position is within acceptable limits, neither comparator will initiate a reject pulse and the container will be passed.

NOTE: A setting of 99 on the Upper Limit will Disable the Upper Limit function; a setting of 00 on the Lower Limit will disable the Lower Limit function.

- 1.0.4 When a reject condition exists, a pulse from the Upper or Lower Limit Comparator coincident with a pulse from the Reject Pulse Timer (I.C.-114) causes an output from the Reject Gate (I.C.-111, 112). This signal is fed to the Reject Control System.

The circuit consists of a clock (I.C.-1002), a shift register (I.C.-1004) and interfacing devices.

NOTE: If the system is equipped with the VRR-1 Variable Rate Rejector, this signal is fed to the Variable Rate Reject Control instead. The Reject Control System is disabled.

The clock controls the rate at which information passes through the shift register. The clock is a variable (23hz-25khz) oscillator controlled by the Reject Delay Control. The clock signal is continuously applied to the 128 stage shift register which causes the register to step 1 stage for each clock pulse.

When a reject signal is received from the ADR, it is fed to the pulse shaper (I.C.-1001) where it is converted to a short pulse and fed to the pulse synchronizer (I.C.-1003). There it is stored until the next clock pulse when it is fed to the input of the shift register. After 128 clock cycles, a corresponding pulse is fed to the reject pulse shaper (I.C.-1005, Q-1001, 1002).

The shift register output pulse initiates the reject pulse, whose duration is controlled by the Pulse Width Control. The 18 V.D.C., five to fifty-five millisecond pulse is then fed to the reject valve solenoid where it actuates the solenoid and allows air into the reject cylinder.

The only error that can be introduced into the system is introduced in the pulse synchronizer. This error can be no more than \pm one-half clock cycle ($\pm 1/256$ of the total delay).

There are two theoretical limits on the maximum delay possible. Each can be expressed in terms of container diameters of travel during the delay period. The first limit is the shift register capacity. If the rate of container flow is greater than 128 per total delay period, than two consecutive reject containers could fall in the same clock period and there would be only one reject pulse out for the two defective containers.

The other limit is the possible error introduced by the pulse synchronizer. If the delay is set at 128 container diameters of travel, then there would be a possibility of \pm one-half container diameter, which means that the reject ram could hit anywhere from the leading edge to the trailing edge of the container. As a practical matter, if the rejector hits anywhere within the center one-fifth of the container, it should do the job. Therefore a delay of twenty five container diameters would probably work.

The minimum delay possible is approximately fifteen milliseconds, determined by the maximum clock frequency plus mechanical delay in the rejector. At 1,000 c.p.m. the minimum delay is one-fourth container diameter.

We recommend that the rejector be installed at a point between one-half and five container diameters downstream from the point at which the container is centered under the ADR probe.

DESCRIPTION OF OPERATION

In setting up and calibrating the equipment, care must be exercised to follow the mechanical set-up instructions (pages 3-1 through 3-6), before attempting to calibrate the equipment.

The Sense Probe "looks at" an area about the size of a half dollar. If either guide rail or light and photosensor adjustments are incorrect, the measurement will be made off-center where there is less excursion of the closure for a change in internal pressure, and discrimination will be proportionally reduced.

If the reference strip does not contact the container top firmly, the mechanical "reference point" for comparative measurements will be constantly shifting with line vibration and reliable results will not be achieved.

Now, let's run through a calibration procedure so that we can see what's going on. The mechanical set-up is correct, because it has been checked by you. The line is operating and containers are passing under the ADR-50C.

Set the Disable Switch to the Disable position. This allows the ADR-50C to function normally but blocks the reject pulse to the rejector.

Set the Upper Limit Display to 75 and the Lower Limit Display to 25. Set the Calibrate control fully counterclockwise. Under these conditions you will see a reject flash on the Reject light with each flash of the Position Sense light. (The Position Sense light comes on after each container passes through the light beam and stays on until the next container breaks the beam.) Because the Calibrate control is at 0, there is no A.C. input to, and therefore a zero output from the 0-99 counter. The Lower Limit Comparator says this is below 25, and is therefore a reject. A reject pulse is generated and the Lower Limit Red Reject Light comes on. This light will remain on until an Upper Limit reject occurs. It does not extinguish when there is no reject pulse.

As you increase the Calibration Control setting, the amount of A.C. from the probe is increased at the detector, and the V.C.O. oscillates at a higher frequency, feeding a count into the 0-99 counter. Until the count reaches 25 cycles in the count period, each container will continue to indicate a reject. When you reach the point where you are in excess of 25 counts in the count period, the Lower limit comparator will stop initiating reject pulses and the reject light will not flash.

As you continue to increase the Calibrate control setting, you will continue to increase the A.C. at the input to the detector, the V.C.O. frequency and the count in the counter and comparators.

Eventually you will reach the point where the A.C. voltage level at the detector input will yield a count in excess of 75 cycles from the V.C.O. and the Upper Limit comparator will initiate a reject pulse.

At that point the Reject light will flash, the Lower Limit indicator will extinguish and the Upper Limit indicator will come on. As you continue upward in the Calibrate Control readings all containers will become Upper Limit rejects.

When the unit is in use, the operator sets the calibration control so that the relative deflection (large L.E.D. display) is varying about 50. After observing the normal range of lid deflection, the operator then sets the upper and lower limits as required.

2 INSTALLATION

2.0 INTRODUCTION

Installation of the ADR-50D has been made as simple as possible, to reduce your installation costs and line down time. By following the procedure outlined, installation will be completed quickly and painlessly.

2.1 LOCATION

Select the position on the line where the ADR-50D is to be installed. On lines coming from the closing machine, the ADR-50D should be located at a point where the containers have cooled as much as possible. This will allow the containers to achieve a fairly uniform internal pressure. Variation in temperature will change the internal pressure of the can, reducing the validity of test results. Also, with greater time after closing, more leakage will occur in defective containers with a better chance of detection.

Where containers are drawn from the warehouse for labeling and shipment, the only consideration is convenience of handling. Most installations are made just before the labeler.

The location selected should be close to a leg or support on the conveyor, at a point of maximum conveyor stiffness. Since the unit is supported from a single point on the conveyor side, any vibration or movement of the conveyor bed will be transmitted through the support pipe to the sensor housing. Therefore, care should be used in locating the ADR-50D at a point of minimum movement in the conveyor. Do not mount the ADR-50D support pipe on an adjacent wall or building structural member, since the sensors must move with any motion of the conveyor bed. If excess vibration is encountered, it will be necessary to stiffen the conveyor at the point of attachment.

The ADR-50D requires about sixteen inches of clear line space. It will be necessary to remove guide rail from one side of the line where the containers are being rejected.

2.2 POWER REQUIREMENTS

The ADR-50D is wired to accept the power supply of the country of installation. It requires single phase power, 50 or 60 hertz at 1 amp. Standard voltages are 100-120 volts or 200-240 volts. Other voltages are available on special order. Check your unit to determine that it is wired for your required voltage before installation. A bright orange sticker at the point of power connection will show the correct power supply for your unit. If this sticker is not in place, be certain to verify power requirements.

NOTE: If the unit is supplied with the RIT-800P Regulating Isolation Transformer, the RIT-800P input will be wired for the correct voltage and frequency, and the ADR will be wired for 100-120 volts, regardless of supply voltage.

Power for the ADR-50D should not be taken from a line used to power heavy motors or motor controllers where electrical "noise" is likely to be present on the line.

Compressed air at 2 cfm, 60 to 120 p.s.i. (4-8 atm) is required to operate the reject mechanism. For line speeds in excess of 500 c.p.m., the air supply line should be one half inch i.p.s. minimum.

A filter, regulator and oiler must be installed prior to the ADR rejector.

2.3

PRELIMINARY

Unpack the unit and inspect for damage. Observe the arrow on the Delrin reference strip at the bottom of the line sensor housing. This indicates the direction of container flow.

Connect the 9 pin connector on the cable emerging from the top of the blue housing to the line connector emerging from the short end of the candy cane mounting pipe.

Be sure that the tapered side of the lower clamping ring (1) atop the housing mates with the half ball (2) on the candy cane. Feed the three studs at the top of the housing through the holes in the upper clamping ring, and secure with the three lockwashers and 1/4-20 nuts provided. DO NOT INSTALL NUTS OR WASHERS BETWEEN UPPER AND LOWER CLAMPING RINGS. (See Figure 2.1)

BALL JOINT ASSEMBLY

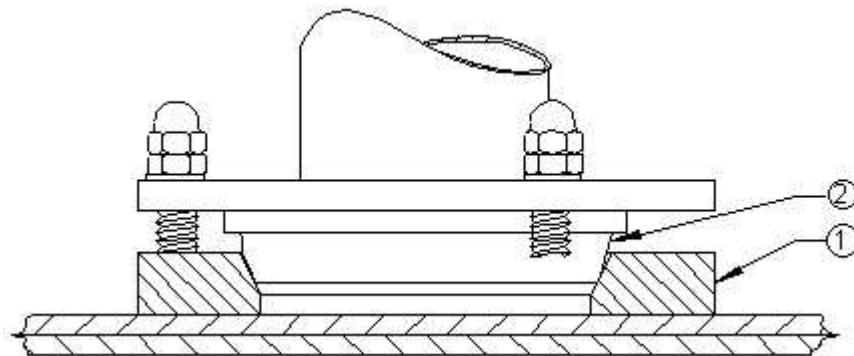


FIGURE 2.1

Position the housing over the line at the point where the containers are to be checked. Swing the candy cane around until the cane lifter assembly is flat against the conveyor side and temporarily clamp the mounting plate to the conveyor, so that the pipe is perpendicular to the conveyor bed.

NOTE: The support pipe may be mounted upstream or downstream from the housing on either side of the conveyor. If the control and indicator lights fall on the wrong side of the line, loosen the ball joint and rotate the housing so that they are where you want them. Then check the Delrin reference strip for correct line flow direction. If this is wrong, remove the screws along the lower edge of the housing, slide the chassis pan out and turn it around to align the arrow with flow direction.

With the cane lifter mounting bracket clamped to the conveyor, make a preliminary adjustment for container height. Crank the cane lifter to its highest position. Loosen the four nuts clamping the cane lifter to the candy cane pipe and raise the candy cane so that the ADR will clear the tallest container to be checked. Snug, but do not tighten, the pipe clamping ring nuts. Place the tallest container to be checked under the ADR reference strip probe. Adjust the position of the candy cane pipe in the cane lifter so that the reference strip clears the top of the container by at least one inch. Rotate the centerline adjust (crank at the lower center of the line housing face) so that the reference strip is at the center of its travel.

Lower the housing with the cane lifter crank until the reference strip just touches the top of the container. Swing the ADR housing across the line so that the top of the container is centered under the red crosslines on the reference strip. Tighten the four nuts to lock the pipe in the cane lifter, and tighten the four acorn nuts to secure them.

Remove the tallest container to be tested from the line and replace with the shortest container to be tested. Crank the cane lifter down to see that the height adjustment will cover the full range.

Position the container so that it is centered under the crossline on the Delrin reference strip. Check to see that the rejector can be mounted on one side of the line and provisions for rejected containers can be made on the other side. If everything is clear, proceed with permanent installation.

2.4 PERMANENT INSTALLATION

- 2.4.1. **EQUIPMENT MOUNTING:** Attach the cane lifter assembly to the conveyor bed permanently. If there is insufficient stiffness when the unit is attached, stiffen with bolts and spacers to the other side of the conveyor, or as required.

- 2.4.2. **ELECTRICAL INSTALLATION:** Bring power line with ground into the conduit junction box at the lower end of the pipe. Wire as shown in Figure 2-2. Connect the black wire (L-1) to the black wire, the white wire (L-2) to the white wire and the green wire (Ground) to green. Connect the Rejector wires (red and brown) to the corresponding wires in the conduit box.

ADR-50DX INSTALLATION WIRING

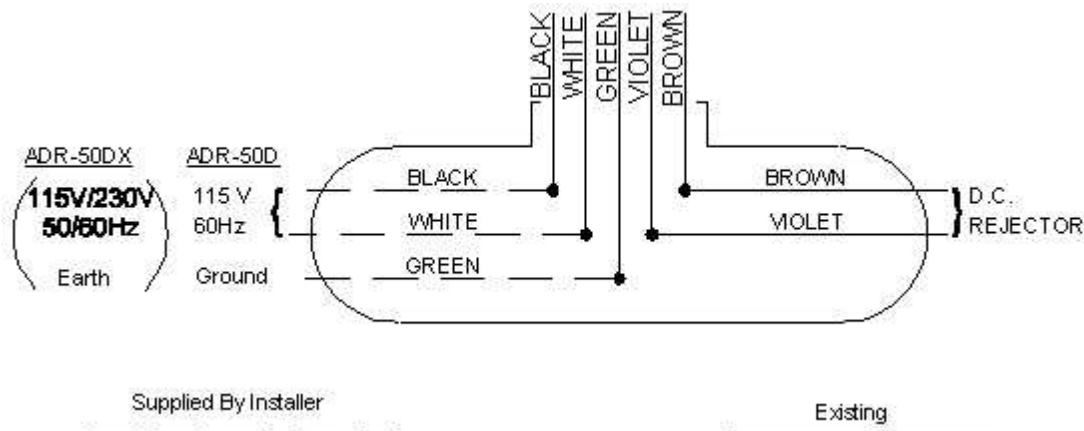


FIGURE 2.2

- 2.4.3. **REJECTOR INSTALLATION:** If your unit is supplied with the VRR-1 Variable Rate Reject Control, refer to that installation manual for reject installation instructions.

Mount the air cylinder rejector to the side of the conveyor at a convenient point one-half to ten container diameters downstream from the crossline under the Delrin reference strip. The rejector should be positioned vertically so that the rubber bumper is slightly below the center of the container to be rejected. Set the rejector so that the stroke is angled downstream about fifteen degrees, not perpendicular to container flow. If necessary, remove a section of guide rail to clear the rejector hammer. Then slide the rejector forward until the hammer just clears the container.

Remove the guide rail on the opposite side of the line for a sufficient distance to clear the containers being rejected. This is usually about one-half container diameter plus six inches downstream from the center and one-half diameter upstream. It may be necessary to increase this for higher line speeds. Attach a filtered air line to the rear of the rejector.

Attach a reject receiving tray or carry-off device for the rejected containers. This completes installation.

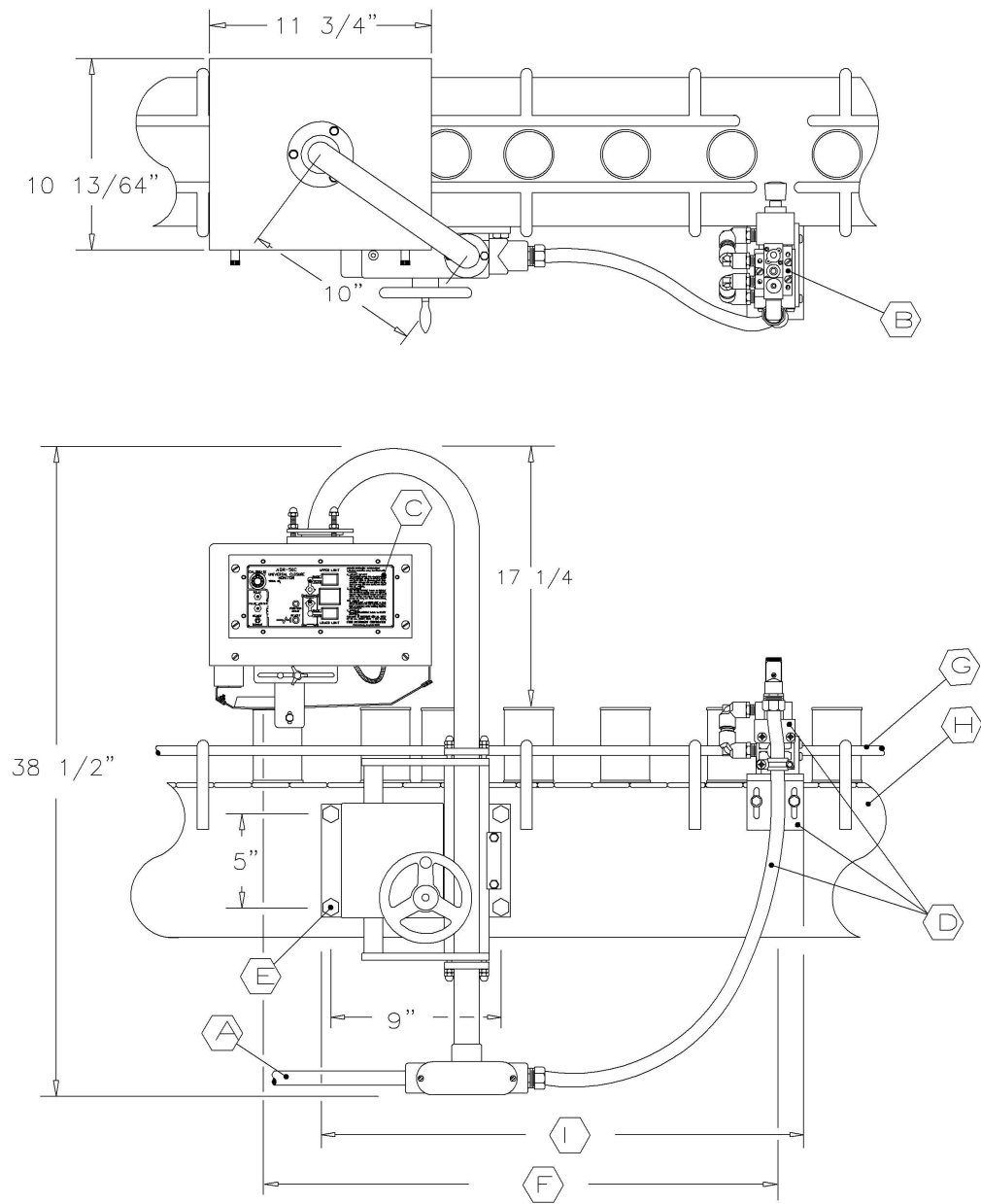


Figure 2.3

NOTES:

- A. POWER IN: 115 VOLTS, 50/60HZ.; 220V AVAILABLE ON SPECIAL ORDER. POWER SHOULD REMAIN ON CONTINUOUSLY.
- B. REJECTOR AIR INLET, 1/4" I.P.S. REQUIRES 60-150 P.S.I., 3 C.F.M. CONTINUOUS CYCLING. AIR MUST BE DRIED AND FILTERED. REFER TO DRAWING NUMBER A-102R149.
- C. CONTROL PANEL; MAY BE LOCATED ON EITHER SIDE OF LINE.
- D. AIR REJECTOR CYLINDER & MOUNTING BRACKET ASSEMBLY, SHIPPED ASSEMBLED & WIRED, AMY BE LOCATED ON EITHER SIDE OF LINE.
- E. MOUNTING BRACKET ASSEMBLY. 4 HOLES, 7/16" DIA. LOCATED AS SHOWN.
- F. DETERMINED AT INSTALLATION. (MUST NOT EXCEED MAX. DISTANCE OF REJECT DELAY ADJUSTMENT).
- G. GUIDE RAIL, NOT SUPPLIED.
- H. CONVEYOR, NOT SUPPLIED.
- I. MINIMUM LINE DISTANCE REQUIRED 16" (SEE NOTE F).

INTENTIONALLY
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3 OPERATION

3.0 MECHANICAL ADJUSTMENTS

The initial mechanical set-up of the ADR is the most critical part of the operation of the unit. Improper adjustments will cause apparent drift and instability, insensitivity, or complete failure. In a large percentage of apparent electronic troubles, the cause is really improper mechanical adjustment.

Because of the nature of the ADR-50D mount, there is some interaction between the various mechanical adjustments, so before starting the line, check carefully to see that all of the final mechanical settings are correct. (See pages 3-3 through 3-5.)

3.0.1 GUIDE RAILS: Before swinging the ADR-50D housing over the line, the guide rails must be set so that there is minimum clearance. Set the rails so there is no more than one-sixteenth inch (1.5mm) clearance between the container and guide rails. Do not set the rails tight against the container as there will be some variation in diameters.

3.0.2 CENTERING: Swing the unit over the line and lower until the low point of the Delrin reference strip just touches the top of the container. Lock the pipe support in this position.

Snug the ball joint so that it is fairly tight but it is still possible to move the housing on the ball.

Adjust the centerline adjust (crank at the lower center of the line housing face) to place the reference strip in the center of its travel. Align the centerline on the Delrin reference strip with the center of the container and rotate the line housing on the ball joint until the container center travels down the centerline. The unit must be centered when the container is under the cross lines of the reference strip.

3.0.3 CONTACT PRESSURE: Next, set the angle of approach so that there is a very slight incline of the reference strip as the can approaches the crossline on the Delrin reference strip (page 3-3).

The container should contact the reference strip at least one container diameter before the crossline is reached.

When the container is centered on the crossline, it should lift the reference strip between 1/16" (1.5mm) and 3/32" (2mm) (page 3-3). Less lift will result in bouncing on the container causing false readings and more lift will result in excess wear of the reference strip.

With the container under the crossline, the Delrin reference strip must rest on both container edges at the crossline. Now, check

for equal pressure at both points of contact. Lift the reference strip at each edge at the crossline. The pressure must be the same on each edge or uneven wear and erratic results will occur.

Lock the ball joint very tightly.

Have you done everything correctly? Check again for the following:

1. Container travels down the centerline.
2. Container contacts reference strip at least one can diameter before crossline.
3. Low point of Delrin reference strip (at crossline), resting on edges of container when centered.
4. Equal pressure on both edges of container at crossline.
5. Delrin reference strip lifts 1/16" (1.5mm) to 3/32" (2mm) with can at crossline.

3.0.4 **LIGHT & PHOTOCELL ADJUSTMENT:** For units equipped with the MAP-1190 Microadjustable Sensing System, set the Light Source/Photo Sensor pair position with the end crank. For units without, position manually as follows (page 3-6):

Center a container under the crossline. Loosen the light source and photocell bracket clamps and move them to a position where they are centered on the trailing edge of the container. Move the light source and/or photo cell brackets forward until the Position sense light goes out. (Light source and photocell must be aligned perpendicular to the line of travel of containers). Then slide back to the point here the Position Sense light comes on. Tighten the locking knobs.

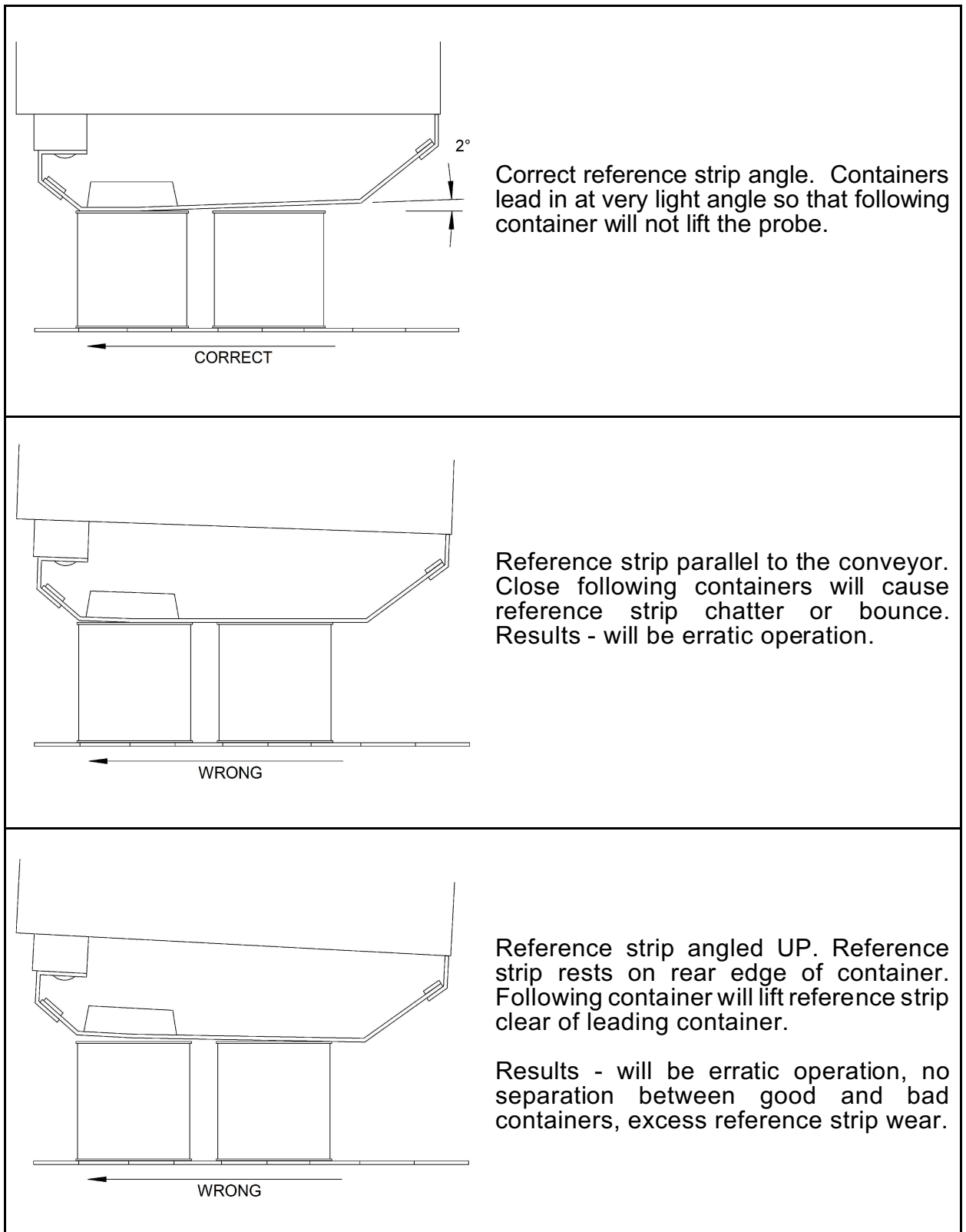
To check light and photocell positions, slide a container down the line in the direction of flow until the Position Sense light goes out. Continue down the line until the indicator light reappears. At this point, the container should be centered under the crossline on the delrin reference strip.

Repeat this procedure with two containers touching each other as they come down the line. The Position Sense light must appear as the point between the two containers passes between the light source and photocell.

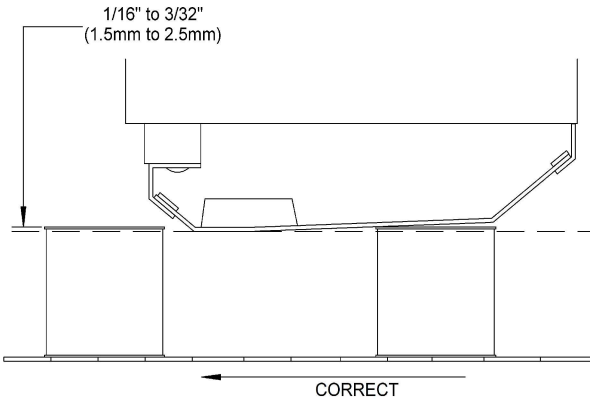
3.1 **CALIBRATION/OPERATION**

In the following procedures, you will be setting the equipment to match the condition of your containers on your line. You will make two adjustments - first, you will adjust the ADR-50D to the average deflection of normal or acceptable containers, and secondly, you will set the limits of the normal or acceptable variation in lid deflections. Any container whose lid deflection falls outside the pre-set limits will then be ejected from the line.

REFERENCE STRIP FORE/AFT TILT ADJUSTMENT

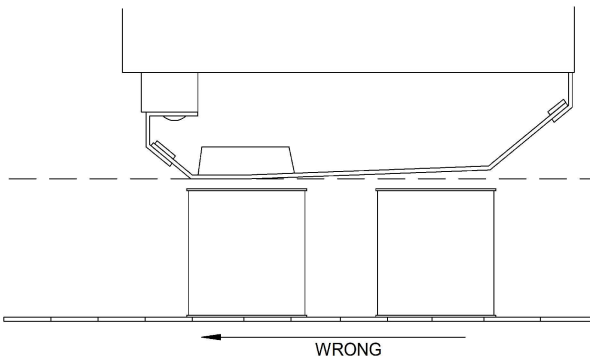


REFERENCE STRIP HEIGHT ADJUSTMENT



Each container raises reference strip 1/16" (1.5mm) to 3/32" (2.5mm) as it passes under probe. Container lid should touch strip about half way down along center line.

Results - no bounce or chatter, no excessive wear optimum measurement results.



Reference strip set too high. Does not make firm, positive contact with container top.

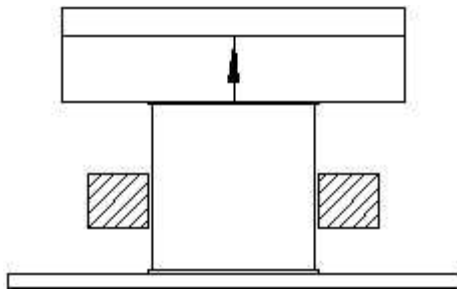
Results - no discrimination between good and bad containers, erratic results. Unit will probably appear inoperative. Will probably drive you nuts while trying to set up.



Reference strip set too low. Container raises reference strip more than 3/32" (2.5mm) as it passes under probe.

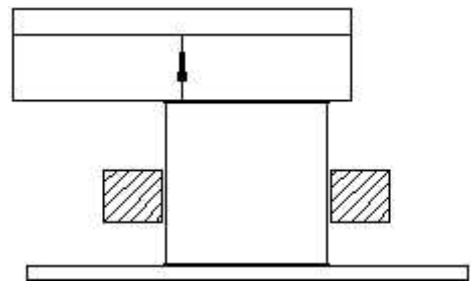
Results - if not too severe, unit will operate normally but reference strip will wear excessively. If severe, will cause container to stumble, may cause erratic results. Will cause reference strip to wear quickly.

REFERENCE STRIP/GUIDE RAIL LATERAL ADJUSTMENT



CORRECT

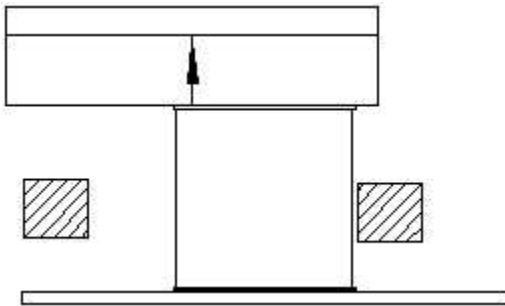
Container centered on centerline of reference strips, guide rails closed down to 1/16" (1.5mm) clearance from container body. Reference strip contacts both sides of container lid with equal pressure.



WRONG

Container off centerline of reference strip - probe not centered over center of lid.

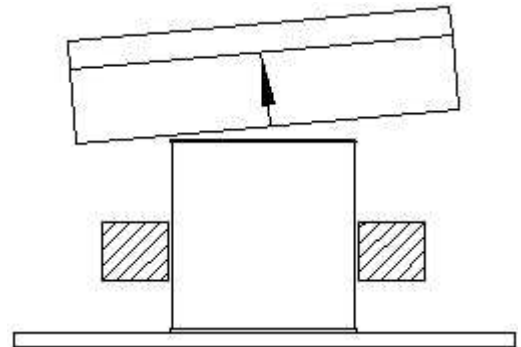
Results - poor or no discrimination between good and bad cans. May exhibit rotational error.



WRONG

Guide rails not stopped down on container.

Results - erratic operation, poor or no discrimination.

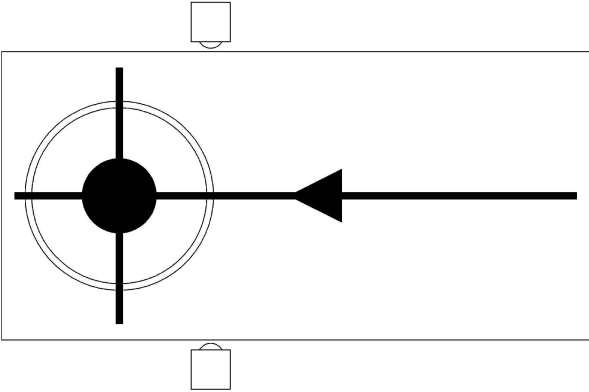
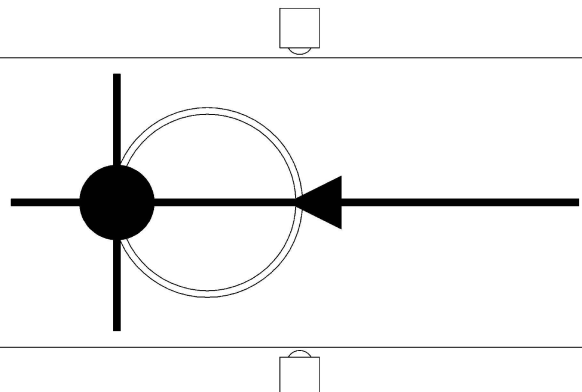
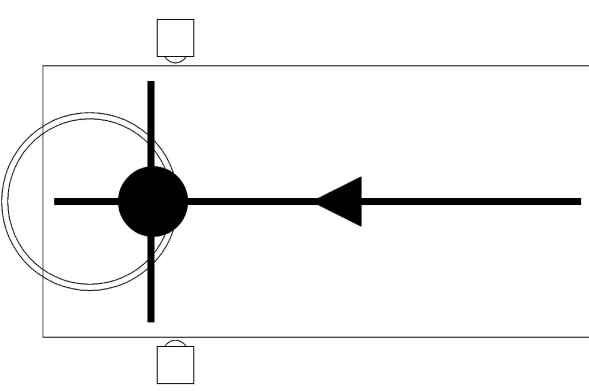
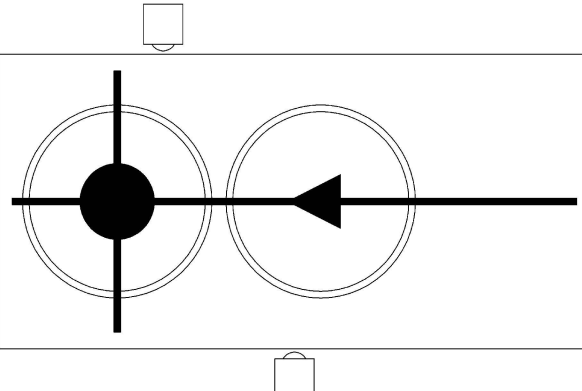


WRONG

Reference strip tilted, contacting on side of lid only.

Results - erratic operation, unreliable setting, excessive reference strip wear.

PHOTO ELECTRIC POSITION SENSE ADJUSTMENT

 <p style="text-align: center;">CORRECT</p> <p>Container centered under probe/cross lines when Position Sense Light comes on, Light Source and Photosensor properly aligned.</p>	 <p style="text-align: center;">WRONG</p> <p>Light Source and Photosensor positioned to far back, container not centered under probe when Position Sense Light comes on.</p> <p>Results - poor or no discrimination between good and bad containers.</p>
 <p style="text-align: center;">WRONG</p> <p>Light Source and Photosensor positioned too far forward, container not centered under probe when Position Sense Light comes on.</p> <p>Results - poor or no discrimination between good and bad containers.</p>	 <p style="text-align: center;">WRONG</p> <p>Light Source and Photosensor improperly aligned.</p> <p>Results - Setup and operation will appear normal with spaced containers, but will not check containers that are close to following containers.</p>

3.2 **OPERATING CONTROLS**

- 3.2.1 **CALIBRATE CONTROL:** The calibrate control is the 10 turn precision potentiometer on the front panel. The control adjusts the level of the signal which is received from the probe when a container lid is being sensed. When an average normal container is being sensed by the probe, the received signal level is adjusted so that NO reject signal is present.
- 3.2.2 **LIMIT SWITCHES:** The Upper and Lower Limit toggle switches set the limit displays. Their function is to establish the highest and lowest deflection for acceptable containers. Any container falling outside the limits set by the Limit Switches will be rejected. The Upper Limit switch controls the "Internal Pressure Too High" lid set point, and the Lower Limit switch controls the "Internal Pressure Too Low" set point. (Remember, lower pressure means higher vacuum.)
- 3.2.3 **REJECT DELAY CONTROL:** Controls the amount of delay after the decision to reject has been made. This permits installation of the rejector downstream from the point of testing so that the point of rejector impact can be adjusted electrically rather than mechanically.
- 3.2.4 **REJECT PULSE WIDTH:** Controls the amount of time power is applied to the rejector solenoid valve of the reject air cylinder. This is not critical at normal line speeds but should be increased for heavy containers and made as short as practical for high line speeds.
- 3.2.5 **REJECT/DISABLE SWITCH:** The Reject/Disable switch controls the reject signal to the D.C. Switch Module. In the Disable position, all other functions and displays are normal. The Reject/Disable switch is placed in the Disable position during set-up, and any time it is necessary to stop the rejecting of the ADR-50C without disturbing the set-up.

3.3 **DISPLAYS**

- 3.3.1 **LARGE L.E.D. TWO DIGIT DISPLAY:** Displays relative lid position of each container. For higher speed lines, the unit can be adjusted so that every second, third, etc. container lid position is displayed. When a reject occurs, that number is displayed and held for an extended period unless overridden by another reject.

- 3.3.2 **UPPER & LOWER LIMIT DISPLAYS:** The smaller two digit displays show the limits of lid excursion you have selected. When power is applied to the unit, the upper limit will be set on 75 and the lower limit on 25. You can then expand or contract the limits as necessary. If power is interrupted momentarily, the limits will return to 25 and 75 and must be reset.
- 3.3.3 **RED L.E.D. INDICATOR LIGHT DISPLAYS:** Red L.E.D.s associated with the Upper and Lower Limit Displays show that the most recent reject exceeded either the upper or lower limit. One or the other will light and will remain lighted until a reject of the other limit occurs.
- 3.3.4 **POSITION SENSE (GREEN) L.E.D. INDICATOR LIGHT:** This L.E.D. lights when the light from the I.R.L.E.D. light source is sensed by the photosensor. It is used to:
1. Verify operation of the light source and photosense circuits of ADR-50C.
 2. Make Position Sense adjustments in setting up for container diameter.
 3. Check operation and set-up while containers are being tested.
- 3.3.5 **REJECT (ORANGE) L.E.D. INDICATOR LIGHT:** Indicates that a reject has been sensed, even when the rejector is disabled.

3.4 **REJECT ADJUST**

NOTE: For units supplied with the VRR-1 Variable Rate Reject Control, the ADR reject system is not used. Disregard section 3.4.

IMPORTANT

Before attempting calibration of the ADR-50D, the mechanical set-up outlined in the previous section must be done correctly. Before proceeding, check to be sure that the mechanical set-up conforms to Pages 3-3 through 3-5.

After completion of the mechanical set-up (pages 3-1 through 3-6), set the ADR to assure reject containers. Set the Calibrate control to 0 (fully counterclockwise) and set the lower limit to 25. Set the Pulse Width and Reject Delay controls to mid-range. Set the Reject/Disable switch to Reject and apply air pressure to the rejector air cylinder.

With the conveyor running, pass a container through the ADR and observe the position of the container when the rejector ram extends. If the container has passed the rejector, reduce the delay setting; if it has not reached the rejector, increase the delay setting. Repeat the process until the container is rejected from the line with a consistent, positive motion.

Continue passing the reject container through the ADR and reduce the Pulse Width control setting until you notice a change in the trajectory of the container off of the line. Then increase the setting slightly.

Then pass two containers, tightly spaced, through the ADR. The unit should move both off of the line smartly. If not, increase the pulse width setting.

3.4.1 HIGH SPEED LINES

At line speeds in excess of 800 c.p.m., we recommend use of the HSR-2000 High Speed Rejector. This unit should be installed with a regulator, filter and oiler. Operating pressure should be set between 50 p.s.i. and 60 p.s.i.

3.4.2 LOW SPEED LINES

On low speed lines carrying large containers or glass, operation can be improved by putting a regulator on the air line and reducing air pressure. Air pressure should be set between 60 p.s.i. (minimum operating pressure) and 70 p.s.i. You can further slow operation of the SSR-1000 Air Rejector by installing the restrictor valve (provided with the cylinder) in the exhaust port (See figure 3.5).

EXHAUST RESTRICTOR VALVE INSTALLATION

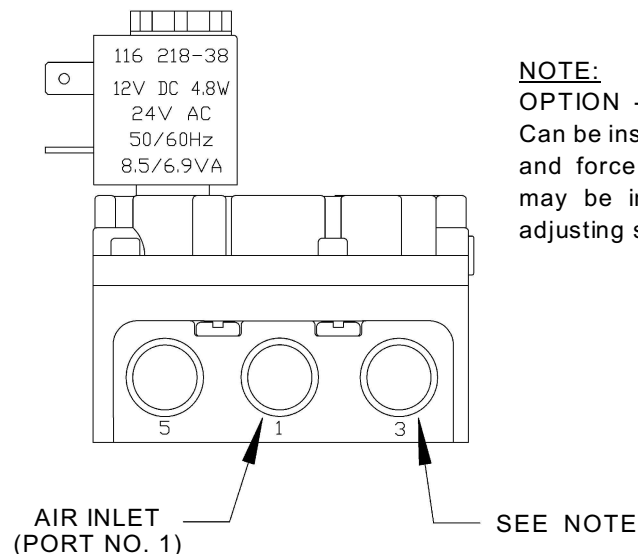


FIGURE 3.5

3.5 CALIBRATION

After adjustment of the reject system, place the Reject/Disable switch in the Disable (down) position. When production is underway and the line is running normally, proceed as follows:

- 3.5.1 Observe the "Position Sense" light. The light should blink with the passage of each container. (No minimum spacing is required between cans, but it may be necessary to space glass if the Position Sense light does not come on after each container.)
- 3.5.2 Set the Lower and Upper Limit displays to 25 and 75 respectively. Observe the Reject light for pulses, indicating a reject signal. Set the Calibrate control fully clockwise, and observe the Upper Limit Light. It should remain on. Reset the Calibrate control fully counterclockwise. The Upper Limit Light should extinguish and the Lower Limit Light should come on. This preliminary check indicates that the instrument is functioning properly.
- 3.5.3 Raise the Calibrate control setting until numbers begin to appear on the large L.E.D. Displays. On cans with deep countersink, it may require several turns of the control before numbers other than 00 appear. Until the numbers appearing exceed 25, you will get a number displayed for each container and the reject light will flash for each container.

When you raise the calibrate control so that the numbers exceed 25, there will be a delay of several seconds before the numbers begin to change. When a reject occurs, the displayed number for that reject is held, blanking the display for any acceptable container for several seconds. This held figure will be overridden by a subsequent reject during the holding period.

If the numbers are changing too rapidly to be recognized, the ADR-50C can be adjusted to display the relative lid position of every second, third, etc. up to every ninth container. This does not affect the operation of the unit. Every container is checked and compared to the upper and lower limit settings.

To make this change, remove the Front Panel assembly from the Waterproof enclosure. Remove the Sense (rear) circuit board from the panel assembly and place the board on a bench with the 15 pin receptacle facing you on the left end of the board. To the right of pins 6-8 of that connector, you will see a circular hole pattern numbered 1-9. There is a jumper connected between the center position and hole 1. Remove that jumper and reconnect to hole 2 and center to display every second container deflection, hole 3 and center to display every third container, etc.

Continue to raise the Calibrate Control until the relative lid position display is varying around 50.

3.5.4 Observe the range of numbers displayed and then set the Upper and Lower Limits to bracket the range of readings.

3.5.5 Throw the Reject/Disable Switch to the Reject position. Then start lowering the Upper Limit until a container is rejected. Raise the Upper Limit four or five points. Check the rejected container for proper vacuum or pressure. Use this as a guide to determine Upper Limit setting. Repeat this procedure to determine proper Lower Limit setting.

NOTE: To disable the Upper Limit function, set the Upper Limit to 99. To disable the Lower Limit function, set the Lower Limit to 00. Disabling either limit will not affect operation of the other limit.

This ADR-50C is now calibrated and ready for operation.

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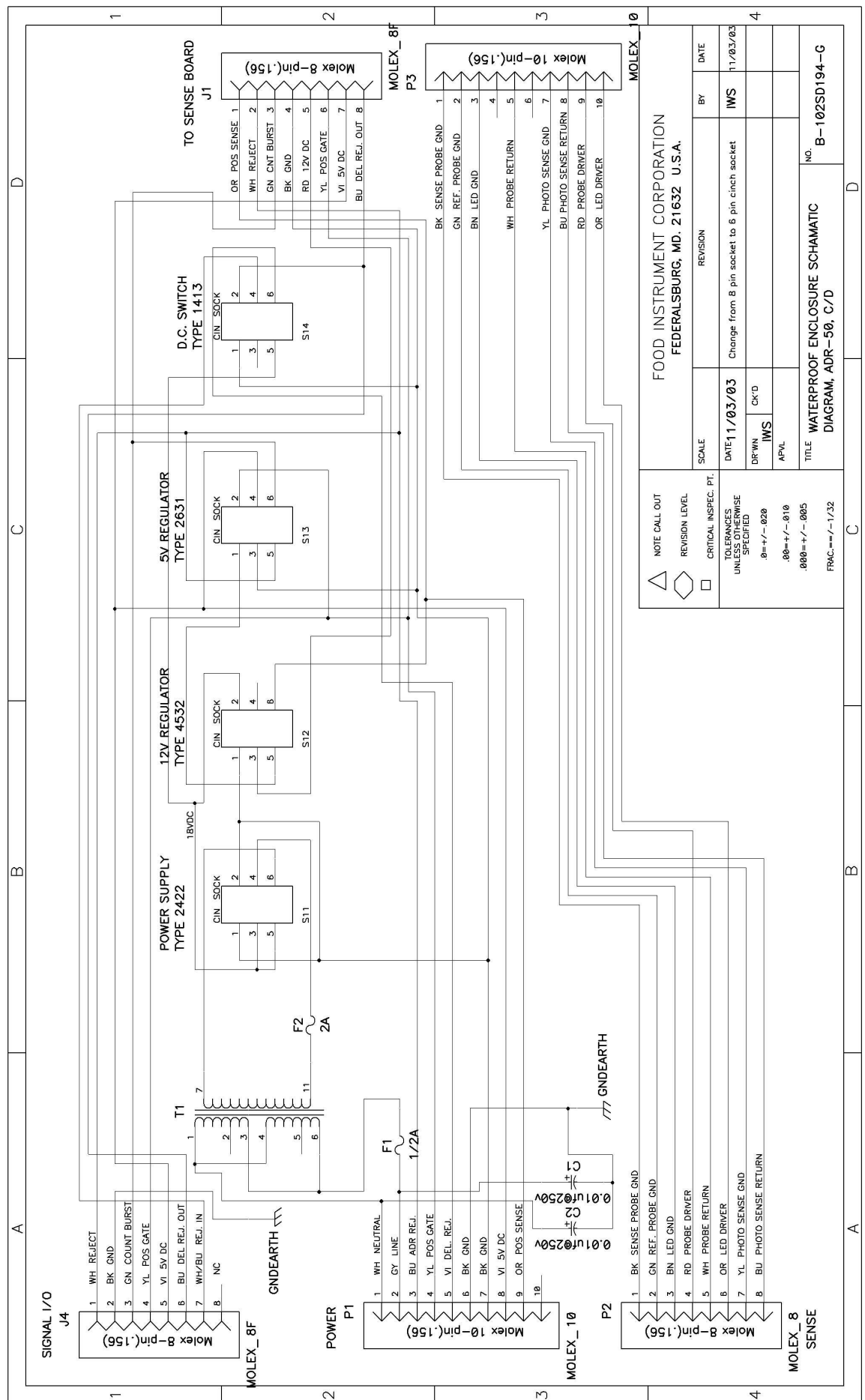
4 ADR-50C TROUBLESHOOTING GUIDE

4.0	<p style="text-align: center;">PRIMARY POWER TROUBLESHOOTING</p> <p>NOTE: Insure that a single ground wire goes back to the electrical panel.</p> <p>Insure that the ADR-50C <u>is not</u> connected to <u>any</u> motor supply voltages.</p> <p>Insure that the ADR-50C is connected directly to the AC power source through a panel breaker.</p> <p>4.0.1 Check for a tripped breaker or a bad fuse in breaker panel.</p> <p>4.0.2 Check AC power input for water in connectors, frayed wires, or broken wires.</p>
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4.1	<p style="text-align: center;">AC POWER SUPPLY TROUBLESHOOTING (Fuses blow when AC Power is applied)</p> <p><u>CAUTION:</u> DO NOT APPLY AC POWER AT THIS TIME.</p> <p>4.1.1 Remove 10 front panel screws using 7/64" Allen Wrench in spare parts kit.</p> <p>4.1.2 Separate amplifier assembly (front panel and attached circuit boards) from waterproof enclosure.</p> <p>4.1.3 Unplug two cable connections on back of circuit board and set amplifier assembly aside.</p> <p>4.1.4 Remove Power Supply Module, DC Switch Module, and 12V Regulator Module.</p> <p>4.1.5 Ground common lead of VOM meter to waterproof enclosure and set VOM to measure 200 K OHMS.</p> <p>4.1.6 Measure Pin 3 of the Power Supply socket. If infinite resistance is not measured, remove 6 sub-chassis screws, and inspect for broken or frayed wires and repair as needed.</p> <p>Reinstall sub-chassis and 6 screws, DO NOT ALLOW ANY WIRE TO BE PINCHED DURING INSTALLATION.</p> <p>4.1.7 Measure Pin 5 of 12 V Regulator socket.</p> <p>If meter measures 0 OHMS, replace 5 V Regulator Module with a good 5 V Regulator from Spare Parts Kit.</p> <p>4.1.8 Reinstall 12 V Regulator Module.</p> <p>4.1.9 Measure Pin 3 of Power Supply socket</p> <p>If meter measures 0 OHMS, replace 12 V Regulator Module with a good 12 V Regulator from Spare Parts Kit.</p>
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ADR-50C TROUBLESHOOTING GUIDE

	<p>4.1.10 Reinstall DC Switch Module.</p> <p>4.1.11 Measure Pin 3 of Power Supply socket.</p> <p>If meter measures 0 OHMS, replace DC Switch Module with a good DC Switch from Spare Parts Kit.</p> <p>4.1.12 Measure pin 5, J-1 of sub-chassis cable.</p> <p>4.1.13 If meter measure 0 OHMS, replace 12 V Regulator.</p> <p>4.1.14 Measure pin 7, J-1 of sub-chassis cable.</p> <p>4.1.15 If meter measure 0 OHMS, replace 5 V Regulator.</p> <p>4.1.16 Install fuses in waterproof enclosure as required.</p> <p><u>WARNING:</u> Caution should be used when power is applied.</p> <p>4.1.17 Apply AC power, watch for smoke or sparks, smell enclosure for burning wire insulation.</p> <p>4.1.18 DISCONNECT POWER, check to see if fuses are blown.</p> <p>4.1.19 If fuses did not blow, replace Power Supply module with a good Power Supply from Spare Parts Kit.</p> <p>4.1.20 If fuse(s) did blow, remove fuses, check pin 1 of P1 to pin 6 of P1 for a short. Also check pin 2 of P1 and pin 6 of P1 for a short.</p> <p>4.1.21 If there is a short, return waterproof enclosure to Food Instrument Corporation.</p> <p>4.1.22 If there are no shorts, replace transformer.</p>
4.2	<p style="text-align: center;">DC POWER SUPPLY TROUBLESHOOTING (<u>No</u> L.E.D.s or digits on front panel light, fuses are good.)</p> <p><u>DO NOT</u> APPLY AC POWER AT THIS TIME.</p> <p>4.2.1 Remove 10 front panel screws using 7/64" Allen wrench in Spare Parts Kit.</p> <p>4.2.2 Separate amplifier assembly (front panel and attached circuit boards) from waterproof enclosure.</p> <p>4.2.3 Unplug two cable connections from back of circuit board and set amplifier assembly aside.</p>



ADR-50C TROUBLESHOOTING GUIDE

NOTE:	Make all measurements (Steps 4.2.4-4.2.11) and tabulate results. Then compare to conditions in Table 4-A.
<u>WARNING:</u>	Caution should be used when power is applied due to shock hazard.
<u>NOTE:</u>	(-) Negative meter lead should be grounded to Waterproof Enclosure.
4.2.4	Apply power and measure violet wire of sub-chassis cable for a (+) positive 5 VDC supply.
4.2.5	Measure the red wire of sub-chassis cable for a (+) positive 12 VDC supply.
4.2.6	Disconnect AC power.
4.2.7	Remove the 12 V regulator module.
<u>WARNING:</u>	Caution should be used when power is applied due to shock hazard.
<u>NOTE:</u>	(-) Negative Meter Lead should be grounded to Waterproof Enclosure.
4.2.8	Reconnect AC power and measure pin 2 of the 12 V Reg. module socket for (+) positive 18 VDC.
WARNING:	Caution should be used when measuring AC voltages due to shock hazard.
<u>NOTE:</u>	Change meter to measure <u>AC</u> voltage.
4.2.9	Put meter leads on terminal 7 (purple wire), and terminal 11 (brown wire) of the transformer. Measure for 16 <u>VAC</u> .
4.2.10	DISCONNECT AC power from the white connector of AC power cable.
<u>NOTE:</u>	Change meter to measure resistance.
4.2.11	Using VOM, measure black and white wires of AC power cable for approximately 60 OHMS.
4.2.12	Check Table 4-A.

ADR-50C TROUBLESHOOTING GUIDE

TABLE 4-A

MEASUREMENTS TAKEN	TABULATED RESULTS AND CONDITIONS FOUND					
5 VDC	0	0	0	0	0	5 VDC
12 VDC	0	0	0	0	12 VDC	12 VDC
18 VDC	0	0	0	18 VDC	18 VDC	18 VDC
16 VAC	0	0	16 VAC	16 VAC	16 VAC	16 VAC
60 OHM	infinite	60 OHM	60 OHM	60 OHM	60 OHM	60 OHM
Replace or Check	Trans- former and/or Input to Trans- former	Trans- former and/or Wiring to P.S.	P.S. Module	12 V Reg.	5 V Reg.	Amplifier Assembly

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4.3	AMPLIFIER ASSEMBLY TROUBLESHOOTING	
	<u>TROUBLE</u>	<u>POSSIBLE SOLUTIONS</u>
	4.3.1 Green Position Sense L.E.D. Does not light.	<u>Recheck</u> - Section 4.4, Pan Assembly Repair. <u>Inspect and Repair</u> - Broken or frayed wires and connections to sense board. <u>Replace (In Order)</u> - Sense Board. - Delay Board. <u>Check and/or Replace</u> - Section 4.4, Pan Assembly repair.
	4.3.2 Upper Limit or Lower Limit will not adjust Correctly.	<u>Check and/or Replace</u> - Solder connection on switches. <u>Replace</u> - Display Board.
	4.3.3 Center digits read "00" <u>with</u> a can correctly positioned under ADR <u>and</u> calibration control full clockwise after position sense has been blocked then unblocked (green L. E. D. Light on front panel goes out then comes on).	<u>Recheck</u> - Section 4.4, Pan Assembly. - Repair Sense Cable, #C-1A. <u>Inspect and Repair as Needed</u> - Amplifier Assembly Wire Harness for broken or frayed wires. - Waterproof Enclosure to Sense Board Cable.
	4.3.4 Center digits do not read "00" <u>with no</u> container under ADR <u>and</u> position sense triggered.	<u>Replace (In Order)</u> - Sense Board. - Calibration Control Pot. - Display Board. <u>Recheck</u> - Section 4.4, Pan Assembly Repair.

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		<u>TROUBLE</u>	<u>POSSIBLE SOLUTIONS</u>
	4.3.5	Reject (Yellow) L.E.D. Does not light for a reject.	<u>Replace (In Order)</u> <ul style="list-style-type: none"> - Sense Board. - Delay Board. - Pan Assembly Wire - Harness Connections.
	4.3.6	Reject L.E.D. (Yellow light) stays lit.	<u>Check</u> <ul style="list-style-type: none"> - Section 3, Operation, Light & Photocell Adjustment. - Vertical Misalignment of Light & Photocell. - Insert Holders. <u>Inspect for Broken or Frayed Wires</u> <ul style="list-style-type: none"> - Pan Cable, #C-1A. - Amplifier Assembly Wire Harness. - Waterproof Enclosure to Sense Board Cable. - Connections between Sense & Display Board. <u>Replace (In Order)</u> <ul style="list-style-type: none"> - Sense Board. - Delay Board. - Display Board.
	4.3.7	Reject Cylinder does not operate.	<u>Check</u> <ul style="list-style-type: none"> - Air Supply. - Reject/Disable Switch to Reject. - Pulse Width Adjustment too Low. <u>Inspect and Repair</u> <ul style="list-style-type: none"> - Power Cable from Sub-chassis to Sense Board. - Amplifier Assembly Wire Harness and Connectors for broken or frayed wires. <u>Replace</u> <ol style="list-style-type: none"> 1. D.C. Switch. 2. Sense Board. 3. Delay Board. 4. Display Board. 5. Reject Switch. 6. Pulse Width Pot. 7. Delay Pot. 8. Air Cylinder Coil 9. Air Cylinder

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		<u>TROUBLE</u>	<u>POSSIBLE SOLUTIONS</u>
	4.3.8	<p>Lower Limit (Red L.E.D.) Reject light does not light.</p> <p>- OR -</p> <p>Upper Limit (Red L.E.D.) reject light does not light.</p>	<p><u>Check</u></p> <ul style="list-style-type: none"> - That a Lower or Upper Limit has passed. <p><u>Inspect</u></p> <ul style="list-style-type: none"> - Connections between Sense and Display Board. - Connections between Sense and Delay Board. <p><u>Replace</u></p> <ul style="list-style-type: none"> - Sense Board. - Delay Board. - Display Board.

4.4	PAN ASSEMBLY TROUBLESHOOTING		
		<u>TROUBLE</u>	<u>POSSIBLE SOLUTION</u>
	4.4.1	<p>ADR <u>does not</u> read "00" when no can is present under probe.</p>	<p><u>Replace</u></p> <ul style="list-style-type: none"> - Sense and Reference Probe. <p><u>NOTE:</u> Probes must be changed as matched pairs.</p>
	4.4.2	<p>ADR reads "00" with can positioned under sense probe and calibration turned full clockwise.</p>	<p><u>Check</u></p> <ul style="list-style-type: none"> - Pin Terminals for loose or poor connections in Pan Assembly Connector. <p><u>Check and/or Replace</u></p> <ul style="list-style-type: none"> - Pan Cable, #C-1A. <p><u>Replace</u></p> <ul style="list-style-type: none"> - Sense and Reference Probe Pairs. <p><u>NOTE:</u> Probes must be changed as matched pairs.</p>

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		<u>TROUBLE</u>	<u>POSSIBLE SOLUTIONS</u>
	4.4.3	No Green Position Sense Light on Front Panel.	
	4.4.3.1		<p><u>Clean Position Sens Insert Lenses with Dry Cloth</u></p> <p><u>Check Red Light Source Insert</u></p> <p>2.1 Set OHM meter to Diode test.</p> <p>2.2 Place meter leads on 3 violet and Pin 4 Black of pan connector, and record resistance reading.</p> <p>2.3 Reverse connections and record resistance reading.</p> <p>2.4 Remove one lead and connect to Pan Assembly, and record reading.</p> <p>2.5 Compare results with Table 4-B.</p> <p><u>Check Yellow Photosensor In-</u> <u>sert</u></p> <p>3.1 Set OHM meter to Diode test.</p> <p>3.2 Place meter leads on Pin 2 Blue wire, and Pin 1 Yellow wire of Pan Connector.</p> <p>3.3 Using sunlight, flashlight or low wattage incandescent bulb shine lighted directly on yellow insert lens and record resistance reading.</p> <p>3.4 Reverse connections and repeat Step 3.3.</p> <p>3.5 Remove one meter lead and connect to Pan Assembly, and repeat Step 3.3.</p> <p>3.6 Compare results with Table 4-B, (Pg. 4-10).</p> <p>3.7 Check Pin Terminals for loose wire in Pan Assembly.</p> <p>3.8 Check and/or replace Pan Cable, #C-1A.</p>

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TABLE 4-B

INSERT TESTED	METER LEAD CONNECTIONS			
	LEAD TO PAN	FORWARD RESISTANCE		REVERSE RESISTANCE
RED LIGHT SOURCE INSERT	INFINITE	<3K OHMS		>20K OHMS
YELLOW PHOTO-SENSOR INSERT	INFINITE	LIGHT	DARK	LIGHT OR DARK
		<3K OHMS	>5K OHMS	>20K OHMS

If measurements are different than above table, replace inserts as required.

ADR-50C UNIVERSAL CLOSURE MONITOR APPLICATION NOTES

ADR OPERATION ON EZO (PULL TAB) CANS SPECIAL SET-UP PROCEDURE

The ADR will work on the pull-tab end of EZO cans just as well as on the opposite end, and in some cases, where the opposite end is rigid, will only work on the pull-tab end.

The top of a non-EZO can is generally symmetrical about its center. If a number of cans are passed through the ADR with various rotations about the center point of the lid, there is essentially no difference in how the lid appears to the ADR. If the mechanical set-up of the ADR is such that the can is not precisely centered under the probe, there will not be a significant difference in ADR readings regardless of rotational orientation of the lid.

This is not true of the pull-tab or foil-tab can end. If the can end is not precisely centered under the probe, then a different reading will be displayed depending upon the orientation of the pull tab as the can passes under the ADR. In extreme cases, this variation can be as much as fifty or sixty on the ADR display. Even a set-up that would be perfectly acceptable on a non-EZO can may yield a fifteen or twenty point variation on an EZO container end.

The following instructions will achieve the set-up of the ADR which will assure perfectly satisfactory operation on the EZO can.

Step 1: Go through the mechanical set-up procedure (Pages 3-1 through 3-6, ADR-50C Instruction Manual) and be absolutely certain that the set-up procedure has been followed accurately.

Step 2: Turn on the conveyor. The conveyor must be running at operating speed for the rest of this procedure. ADR readings on EZO cans are speed sensitive and any variation in speed will necessitate repeating this entire procedure. Do not pass cans under the ADR by hand since that will not duplicate the operating speed of the system.

Step 3: Place an EZO can on the conveyor so that it passes under the ADR with the pull tab pointed forward in the direction of can flow. Repeat this procedure and adjust the Calibrate control until the ADR displays a reading of fifty.

Place the same can on the conveyor so that it passes under the ADR with the pull tab pointing back. Note the difference in ADR readings. (If the ADR reads fifty with the tab pointing forward and thirty-seven with the tab pointing back, the difference is thirteen (13)).

Step 4: Move the light source and photosensor forward (in the direction of can flow) 1/16 inch. Repeat the procedure of passing the can under the ADR with tab pointing forward and with tab pointing back. The readings will have changed from those noted in Step 3. If the difference in ADR readings in Step 4 has increased over that noted in Step 3, move the light source and photosensor back 1/8 inch. If the difference has decreased, move the light source and photosensor forward 1/16 inch. Again, pass the can under the ADR with the tab pointing forward and with the tab pointing back and note the difference. Repeat this procedure of moving the light source and photosensor in very small increments and testing for diminishing differences in ADR readings until a difference of no more than plus or minus one is achieved.

Step 5: Pass the can under the ADR repeatedly with the pull tab pointing forward and readjust the Calibrate control to give an ADR reading of fifty.

Step 6: Place the can on the conveyor with the pull tab pointing at your belt buckle as it passes under the ADR. Note the ADR reading. Pass the can under the ADR with the pull tab pointing away from your belt buckle. Note the ADR reading and calculate the difference. Loosen the cane lifter swivel clamps so that you can swing the ADR across the line and move the unit 1/16 inch toward you. Note the difference in ADR readings when the can is passed under the ADR with the tab pointing toward you and when the can is passed under the ADR with the tab pointing away from you. If the difference decreased after moving the ADR toward you, continue moving the unit toward you. If the difference increased, move the ADR away from you 1/8 inch. Continue moving the ADR in the direction that diminishes the difference between ADR readings when the can is passed under the ADR with the pull tab pointed toward you and with the pull tab pointed away from you. Repeat this procedure until the difference between ADR readings has been reduced to plus or minus one division.

Step 7: Repeat Steps 3 and 4 if necessary. Lock down the clamps holding the light source and photosensor and lock the swivel clamps.

Step 8: Pass the can through the ADR without regard to pull-tab orientation. The ADR reading should hold within plus or minus two divisions of the mid-range reading. If not, repeat Steps 3 through 6 until you get it. Don't accept anything worse than plus or minus two divisions.

NOTE: If your unit is equipped with the MAP-1190 Microadjustable Sensing System, turn appropriate crank to move sensors in Steps 4 and 6.