

Mega

Instructions for Piston Closing Machine

Versions xxx to xxx

The device is designed to be used in a laboratory.
It is not equipped with any safety fittings and therefore should only be operated by personnel who have been especially assigned to use it.

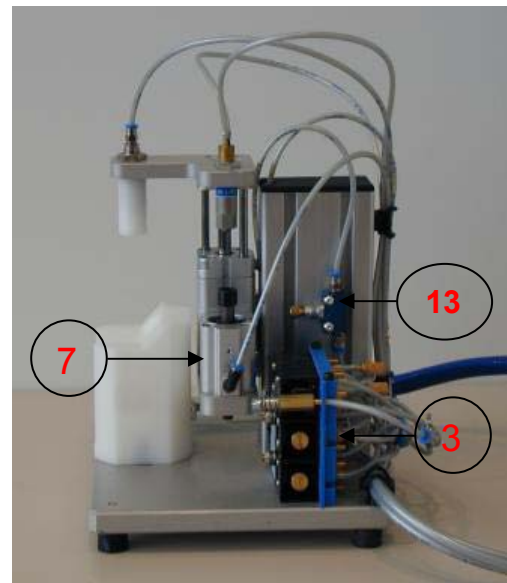
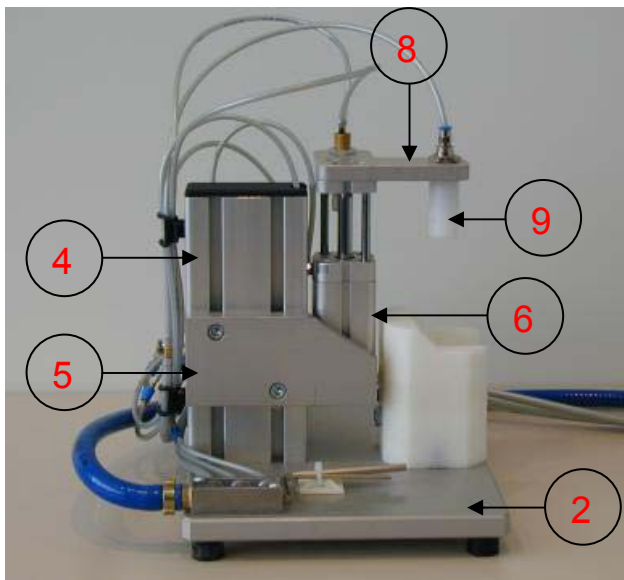
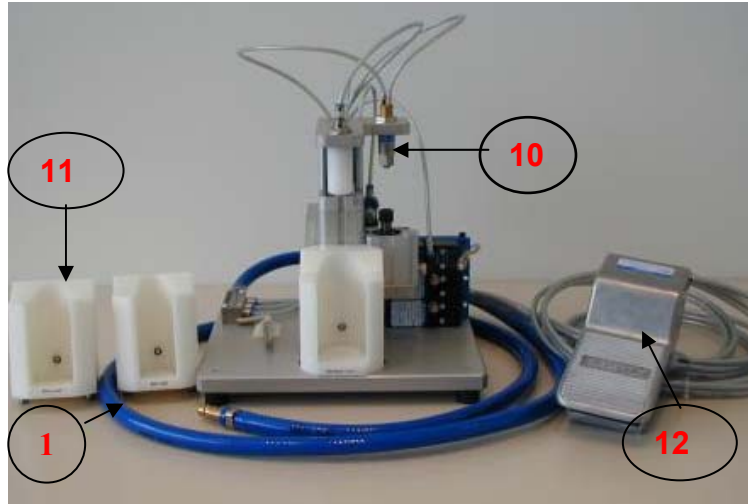


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1. Piston Closing Machine and accessories

1. Air Hose
2. Base plate
3. Controls
4. Vertical base
5. Support plate
6. Main closing cylinder
7. Plug closing cylinder
8. Base plate
9. Format part
10. Depth gauge
11. Format cup
12. Foot switch
13. Throttle valve



2. Connecting the machine

Connect blue air hose to compressed air supply.
 Set pressure at a minimum of 6 bar. (Ideally 6 – 8 bar).
 Only use filtered and oil free compressed air (filter to 5 microns).

3. Pneumatic control

Any alteration of the control valve will lead to a malfunction !

The end of the closing process is indicated by a red control light. (see fig. 3.1)

In the event of problems with the controls, our sales staff will be glad to help you.



fig. 3.1

4. The piston

Fig. 4.1 Cross section of piston

Fig. 4.2 Piston from above with open plug (condition on delivery)

Fig. 4.3 Piston with closed plug

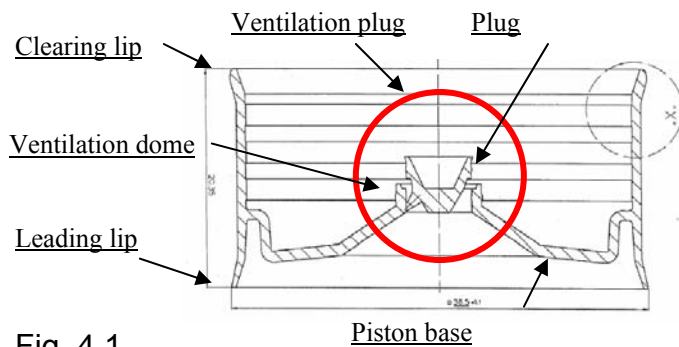


Fig. 4.1



fig. 4.2

The plug is closed correctly when it is level with the ventilation dome.



fig. 4.3

5. Inserting the piston

Insert the piston with the clearing lip pointing upwards and push down until it is level with the dispenser. While being pushed down air will escape through the open plug.



fig. 5.1

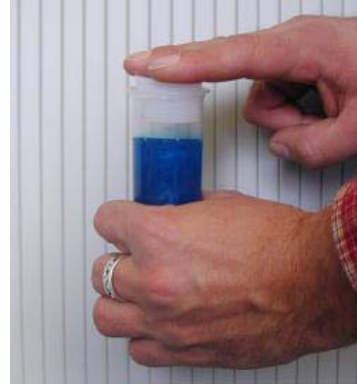


fig. 5.2

6. Changing the format cup

All Mega models can be used simply by changing the format cup or the format parts.

Format cups can be changed as shown in figures 6.1 – 6.3.



fig. 6.1



fig. 6.2

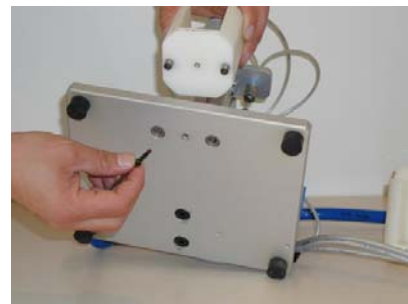


fig. 6.3

7. Setting the position of the piston

The level of the piston should be set at the middle of the support plate. fig. 7.2

Danger of injury: Always turn off the pressure before setting the piston level !

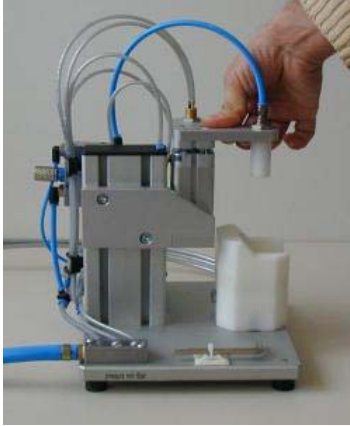


fig. 7.1

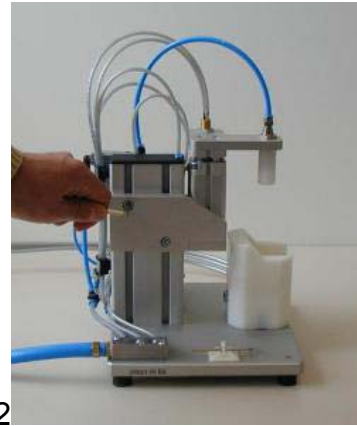


fig. 7.2

Setting the level of the piston:

Loosen screws (fig. 7.2).

Press support plate (fig. 7.3) with extended format part to the desired level (fig. 7.4) and tighten screws.

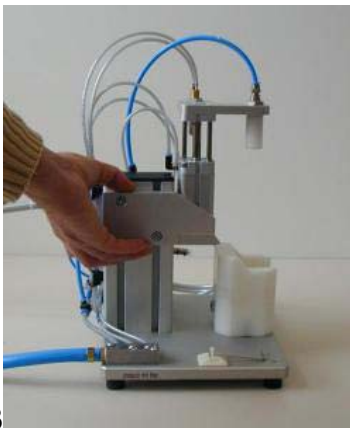


fig. 7.3

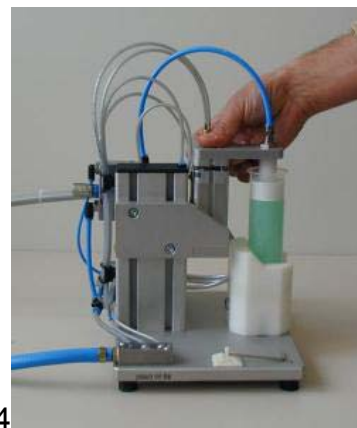


fig. 7.4

Re-adjust if necessary.

Maximum size of air pocket between piston and product to aim for is approx. 1 mm.

The larger the air pocket the more pump strokes needed to prime the dispenser !

8. Pre-filling the dispenser

Mega dispensers do not need to be pre-primed, they can also transport air. This option can be switched on when necessary (e.g. with higher levels of viscosity). Ask our sales staff.



fig. 8.1

9. Filling up Mega dispensers

1. Fill up with desired amount, aim for a smooth filling level.
2. Insert piston. Keep dwelling time on machine as short as possible.
3. Put dispenser in format cup and hold it in place from the front with your finger. Avoid standing dispenser in slanting position.
4. Activate closing process with foot pedal and keep it held down.
5. After red control lamp lights up, release foot pedal (see fig. pos. 3).
6. Check position of plug (e.g. visually, see fig. 4.3).
7. Insert optional bottom plate.

10. Replacement part list

POS	NO.	Part name	Measurements/Norm	Material	Supplier
1	1	Base plate	200x245x15	Alu eloxiert	MegaPlast
2	1	Vertical base	40x80x180 (0.0.026.34)	Alu eloxiert	ITEM
3	2	Centering screw	Z38 10x16		Hasco
4	-	Various cups	Ø80x95	Delrin	MegaPlast
5	1	Support plate	40x102x13	Alu eloxiert	MegaPlast
6	1	Side plate	60x125x15	Alu eloxiert	MegaPlast
7	1	Base plate	80x100x10	Alu eloxiert	MegaPlast
8	1	Format part	Ø20x40	Delrin	MegaPlast
9	1	Tappet	Ø8x15	1.4306	MegaPlast
10	4	Shock absorber	Typ D Ø20x13,5 M6		bwz
11	2	Centering bushing	DIN 172 A-8,1x12		Norelem
12	2	Cylinder screw	DIN 912 M3x20		
13	2	Cylinder screw	DIN 912 M4x20		
14	2	Cylinder screw	DIN 912 M4x25		
15	2	Cylinder screw	DIN 912 M4x90		
16	2	Cylinder screw	DIN 912 M5x12		
17	2	Cylinder screw	DIN 912 M5x16		
18	2	Cylinder screw	DIN 912 M5x20		
19	2	Cylinder screw	DIN 912 M5x50		
20	2	Cylinder screw	DIN 912 M6x16		
21	2	Parallel pin	DIN 6325 5m6x16		
22	2	Parallel pin	DIN 6325 5m6x20		
23	1	Time delay plug/valve	VZO-3-PK-3		Festo
24	1	Time delay plug/valve	VZ -3-PK-3		Festo
25	1	Pneumatic plug/valve	VL/O-3-PK-3x2		Festo
26	1	Optic display	OH-8		Festo
27	1	Throttle rebound valve/plug	GR-M5		Festo
28	1	Micro-tappet valve w. rocker lever	S-3-PK-3-B with AH-06-6		Festo
29	1	Cylinder	AV-25-5-A		Festo
30	1	Cylinder	ADVUL-25-40-PA		Festo
31	1	Depth gauge	SDK-3-PK3		Festo
32	1	Miniature cylinder	CJPB-10-10H6		Festo
33	1	Cap	0.0.026.02		ITEM
34	1	Distributor block / collector	FR-4-1/8-B		Festo
35	1	Parallel pin	DIN 6325 6m6x12		
36	1	Cylinder screw	DIN 912 M4x16		
37	1	Screw	Form A M8x30 (angepasst)		Gross
38	1	Hexagonal nut	DIN 439 M8		
39	-	-	-	-	-
40	1	Stroke limiter	Ø14x20,2	1.2210 brün.	MegaPlast
41	1	Thread insert	Trisert 136-M4		Koenig
42	2	Parallel pin	DIN 6325 8m6x30		
43	-	-	-	-	-
44	1	Screw	DIN 913 M8x30		MegaPlast
45	1	Nut	DIN 934 M8		
46	1	Washer	DIN 1258.4 M8		
47	1	Support plate pin	NLM 02010.041		Norelem
48	1	O-Ring	Ø6x1,5	72 NBR	Lager

