

DUAL BELTED SPIN TRIMMER SETUP

Step One: Conveyor Setup

- Adjust conveyor guide rails to allow 12.5mm of clearance on each side of the bottle for the full length of the spin off trimmer.

For a container with a centered neck the distance between the guide rails should be:

- Round Container Diameter + 25mm
- Square or Rect. Container Cross Corner Dim + 25mm
- Oval Container Width + 25mm

For an offset neck container, the distance between the rails should be:

- $2 \times ((\text{Width of the bottle}/2) + \text{Neck offset}) + 25\text{mm}$



Step Two: Belt to Dome Setup

- Carefully remove blade (if installed) with cut resistant gloves.
- Raise platen assembly to accommodate bottle height, matching the belt profile to the belt groove in the dome.
- Adjust belt tension against the bottle dome so the belt just touches the minor diameter of the dome. It should be difficult to slide the bottle side to side between the belts.



Step Three: Blade Placement

- Carefully insert the blade with sharpened bevel facing up and impact point of blade (45 degree angle) set to 10mm from the end of the blade holder.
- Tighten the blade holder, making sure the blade is pushed back into the knife set.



Step Four: Blade to Dome Setup

- Insert a bottle with a dome between the belts on the in-feed end of the trimmer to set the blade height.
 - Notice there are a number of adjustment screws with 3 main lock down bolts along the main blade assembly. This will allow you to pitch the blade in all four directions.
 - There are two adjustable brackets in the rear of the assembly which are attached to gray L brackets. This adjustment plunges the blade in and out. See picture below left.
- Adjust the point of the blade to the center of the knife groove, keeping the front to back pitch as level as possible. Remove the bottle and do the same setup on the exit end. See picture below right
- Carefully tighten the adjustment screws and lock down the bolts evenly so the blade does not move up or down during the tightening process.
- During setup, leave the adjusting screws in the middle of the blade assembly loose until the in-feed and exit ends are locked down, and then bring the screws in until they touch and snug/lock down.



Step Five: Belt/Blade/Platen Assembly Setup

- On the in-feed end of the, set the trimmer height from the table top conveyor to the knife equal to:
Overall height of a trimmed bottle + 2mm
- At the exit end of the trimmer set the blade height to:
Overall height of a trimmed bottle + 5mm
 - Use the adjustment rod and nut on top of the spin trimmer to raise and lower the entire platen/knife assembly.
 - Use the trimmers leveling feet to achieve the 3mm height difference from in-feed to exit.



- The desired result for the bottle entering the in-feed is for the belt groove in the bottle dome to be level with the belt. This will allow a smooth transition when the bottle enters the pickup point of belts.

Step Six: Knife Plunge Depth

- Using the two adjustment bolts in the back of the knife assembly, set the plunge depth of the knife 6 mm deep into the knife slot under the bottle dome. This cut depth should be the same on the in-feed and exit end of the trimmer.
- Note: you may have to plunge 2 or 3 mm deeper into the knife groove on the exit end, but start with an equal plunge depth parallel with the belts and make fine adjustments as required after startup.



Step Seven: Stabilization of Bottle

- Add two plastic ties (thin 20 to 30 cm) to mid-section of conveyor so they are placed at the final rotation and during dome/bottle separation. This will keep bottles from turning too far due to centrifugal force. With proper setup, the bottle will rotate 360 degrees after the knife has plunged into the knife slot using 75 to 85% of the knife length to make the full rotation. The plastic ties should be positioned so they have a very slight touch on the surface of the bottle. Anchor stabilizer ties with a vertical bracket mounted to the horizontal front rail system.



Step Eight: Dome Guide

- Adjust dome guide to assure proper release away from the top of the bottle.
 - Air assist, will help in high speed applications.



- New Trimmer has bracket system that will need to be welded.

Step Nine: Belt Speed Adjustments

- Set the belt speed on the blade side, to slightly faster than the conveyor speed.
- Set the belt speed on non-blade side, to faster than the blade side belt.
- Upon startup, dial in the speed of the non-blade side belt, so that the bottle completes one revolution using 75 to 85% of the blade length.



Sales and Service

For more information on this topic, please contact your local Uniloy Parts Sales Representative. Trained Uniloy Service Representatives are available to assist in the installation of these packages at your facility.