

## ADJUSTMENT OF LOAD CONTROL

**IMPORTANT** Before adjusting the load control, the loading gate. and servo unit must be properly adjusted.

There are match marks on the load control to aid in adjustment

With the servo connection rod disconnected from the servo lever, proceed as follows:

1. Turn adjusting screw S2 counter-clockwise until stop pin on servo lever does not touch the cam.
2. Rotate the cam lever to #5. on the index.
3. Reconnect the servo connection rod to the servo lever rod and pull the servo lever forward to FULLY EXTEND the cylinder
4. Check the setting. With the cylinder fully extended, use a straight edge and check that the match mark on the servo lever is lined up with the match mark on the cover. (B) If the match marks do not line up, readjust the link end.

**IMPORTANT** The cylinder must be FULLY EXTENDED before adjusting the link end.

After the above adjustments have been completed and with the rod connected to the loading control, proceed as follows:

1. Rotate the cam lever to the "1" position on the index. (The "1" match mark should line up with the match mark (A) on the cover.)
2. Energize gate solenoid valve to open the gate. (Hold LOAD button and push JOG button).
3. With the gate open, turn screw S2 clockwise until the gate is open 2 inches.

**NOTE:** If gate opening is more than 2 inches and cannot be adjusted to less, it will be necessary to shorten the stop pin by 1/8" or more.

The limit switch trip arm must be adjusted so that it depresses the limit switch plunger and the switch makes contact when the servo lever is on the "1" position of the index. With the cover removed proceed as follows:

**NOTE:** With the gate closed the limit switch trip arm must have. approximately 1/32" free travel.

1. Rotate the cam lever to the "0" position.
  2. Energize the gate solenoid valve to open the gate.
- NOTE: The gate will NOT open the full 2 inches set by screw S2.
3. Push the servo lever handle to the rear and close the gate. Release the handle and the gate should reopen.
  4. Advance the cam lever towards the "1" position in small increments repeating Step 3 each time. When the cam lever is on position "1" and the servo lever handle is pushed to close the gate, the gate should remain closed when the servo lever handle is released.
  5. If the gate remains closed before reaching the "1" position, the limit switch is being tripped too soon. If the gate will not remain closed at the "1" position, the limit switch has not been tripped. The limit switch trip arm can be adjusted by slightly bending it or by filing metal off the sloping face to change the clearance between it and the cam as necessary.

**CAUTION:** Bending should be done very carefully as normally only a slight change is necessary.

