

INSTRUCTION BOOKLET FOR

“PALLET DECOILER”

**MODEL: 1200, 3500, 5000, 6000, 7500, 8500,
10M, 12M, W-1000, W-2000,
W-3500 & W-5000**



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ATTENTION: PLANT MANAGER

Thank you for purchasing Durant equipment. Enclosed are very important safety instructions, operating instructions, and setup procedures.

Read all these materials completely and carefully. Please distribute copies to your SAFETY MANAGER, PRODUCTION MANAGER, and MACHINE OPERATORS.

If there is any help required in setup or operation, we will be readily available for your assistance.

Thank you again and we look forward to developing and maintaining a fine relationship with your company.

Sincerely,

DURANT TOOL COMPANY

SAFETY INSTRUCTIONS FOR ALL DURANT EQUIPMENT

The enclosed information and instructions must be forwarded and distributed to the Plant Safety Director, Plant Manager, Production Manager, and all Operators of Durant equipment.

Operators of Durant equipment must have a minimum of (3) three years operating experience with similar Durant press room equipment or a minimum of (3) three years experience with identical equipment manufactured by other press room equipment manufacturers.

WARNING

Never operate, install, or maintain this machine without understanding the complete and safe operation thereof.

It is the employer's responsibility to provide proper safety devices and equipment to safeguard the operator from harm and to safeguard this machine at all times to meet all current government safety codes and standards.

CAUTION

All Durant equipment must be securely fastened to the floor. This will prevent the machine from tipping. Failure to follow the above instructions could cause harm to the operator or machine.

ATTENTION

If any danger points are observed:

1. Immediately stop machine.
2. Do not run machine until danger point is eliminated.
3. Report danger point in writing to your employer.
4. Keep a copy of your report for your records.
5. Do not run machine again until danger point has been corrected.
6. It is your employer's responsibility to safeguard this machine to meet all government safety codes and standards.
7. There are U.S. companies that specifically specialize in safe guarding machines to plant requirements and government codes. The safe guarding companies are located throughout the United States, Canada, and foreign countries. Representatives will visit your site to advise and recommend safe guarding procedures for your company.

IMPORTANT

Before the first use and monthly thereafter, all nuts, screws, and bolts should be checked for tightness. Gears, sprockets, chains, and belts should also be checked for tightness.

Grease and oil fittings and reducers monthly.

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PALLET DECOILER**

THEORY OF OPERATION:

THE ELECTRONIC CONTROL PACKAGE MODEL # MCD-1030 CONSISTS OF 3 MAIN CONTROL ITEMS. THEY ARE AS FOLLOWS:

1. MATERIAL ROLLER CONTROL ASSEMBLY.
2. D.C. AMPLIFIER WITH DANCER/ SPEED POTENTIOMETER AND E-STOP CIRCUIT.
3. STAND.

WITH THE ROLLER BACK TO ITS ZERO POSITION THERE IS NO ROTATION OF THE TURNTABLE. AS THE DANCER / ROLLER ASSEMBLY IS PULLED FORWARD THE TURNTABLE WILL INCREASE SPEED FROM ZERO TO FULL SPEED IN PROPORTION TO THE DANCER / ROLLER ASSEMBLY POSITION.

OPERATOR CONTROLS: (LOCATED ON COVER)

1. POWER ON/OFF TOGGLE SWITCH: THIS SWITCH IS USED TO TURN THE MAIN POWER EITHER ON OR OFF TO THE PALLET DECOILER.
2. PILOT LIGHT: LIGHT WILL BE ON WHEN MAIN POWER IS ON AND RESET BUTTON IS ON. (SEE E-STOP CIRCUIT).
3. FORWARD / OFF/ REVERSE TOGGLE SWITCH: THIS TOGGLE SWITCH SETS THE DIRECTION OF ROTATION OF THE TURNTABLE. IN THE MIDDLE POSITION THE DRIVE IS DISABLED. NOTE: NEVER SWITCH FROM FORWARD TO REVERSE OR VICE-VERSA WHILE MACHINE IS IN MOTION!
4. 0-100% SPEED POTENTIOMETER: THIS SETS THE RATIO OR GAIN OF THE OUTPUT SPEED. EXAMPLE, IF POT IS SET AT 100% MACHINE WILL OPERATE AT 0-FULL SPEED. IF POT IS SET AT 50%, MACHINE WILL OPERATE AT 0-HALF SPEED. IF SET AT 0% MACHINE WILL NOT OPERATE AT ALL.
5. OVERTRAVEL SWITCH: IN THE EVENT THE DANCER/ ROLLER MOVES TO THE END OF ITS TRAVEL IT WILL ACTIVATE AN E-STOP SWITCH AND WILL SHUT THE MAIN POWER OFF. TO RESET YOU FIRST MUST BRING THE DANCER / ROLLER ASSEMBLY BACK TO ZERO POSITION AND THEN PRESS THE WHITE RESET BUTTON LOCATED ON THE BOTTOM OF THE ELECTRONIC CONTROL BOX.

E-STOP OUTPUT: THERE IS A HUBBLE STYLE PLUG LOCATED ON THE BOTTOM OF THE CONTROL BOX. THIS IS TO BE USED AS AN OVERTRAVEL FAULT FOR EXTERNAL CUSTOMER USE. THERE ARE TWO TERMINALS ON THE MALE PLUG. WHEN THE MACHINE IS IN ITS NORMAL RUNNING MODE THE SWITCH CONTACT SUPPLIED TO THIS PLUG IS N/C OR NORMALLY CLOSED. WHEN THE DANCER / ROLLER ASSEMBLY GOES TO ITS OVERTRAVEL POSITION THE E-STOP SWITCH WILL OPEN INDICATING A FAULT. NOTE: THIS IS A DRY CONTACT RATED AT 15AMPS @ 115VAC.

WARNING!!!

**EMERGENCY OVERTRAVEL CONTACTS MUST BE CONNECTED TO
PRESS E-STOP CIRCUITS!**

**IN THE EVENT THE PALLET DECOILER CONTROL ROLLER REACHES AN
OVERTRAVEL STATE, THE PALLET DECOILER WILL STOP.**

**THE OUTPUT N/C CONTACTS MUST BE CONNECTED TO CUSTOMERS
MACHINERY TO SHUT DOWN ALL ASSOCIATED EQUIPMENT OR CONTROL
MECHANISM WILL BE DAMAGED.**

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DECOILER MECHANICAL SETUP INSTRUCTIONS**

1. Be sure that correct power voltage is connected to the machine. It will be labeled on the machine. Voltage must be constant. A voltage drop will cause failure to the machine and eventual damage.
2. Mount control assembly on machine pole. See diagram A for best position of post and position of control arm in relation to the press or machine which you are feeding coil into.
3. Adjust position of material roller. Roller should be slightly higher than level of the top coil of material.
4. Your DECOILER is delivered with preset maximum, minimum, speed, acceleration and deceleration levels. You may find that it is necessary to adjust these control. They are located in the main control box on the post. Please refer to the control adjustment page attached. Adjust these control levels to match your line requirements.
5. Emergency Stop Attachment. There is (1) Method to activate the emergency stop feature on all models.

Method #1: Is described in the electrical set up procedures enclosed.

Input Power - input power must be 115 VAC / 1 Ph / 50-60 Hz. or 230 VAC / 1 / 50-60 Hz. - which will be indicated in the control box unless other voltage is requested.

If you required further assistance call 1-800-338-7268.

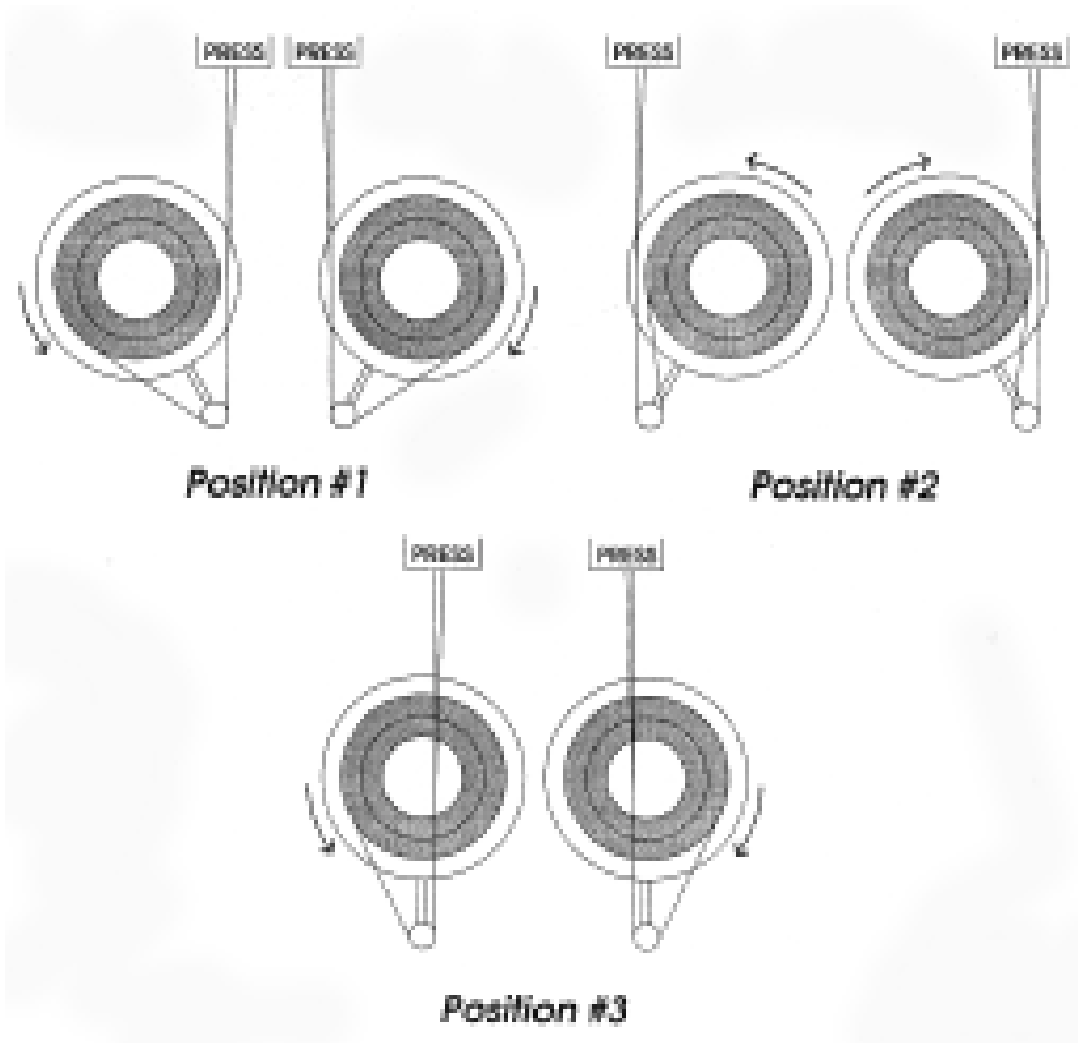
POSITIONING

CONTROL HEAD POSITION

The Control Head should always be aligned with the production equipment feed entry so that the strip loop will follow a straight run from the Decoiler Guide Drum directly to the forming equipment entry. This alignment can be done by visual line of sight from Control Head to feed entry.

TURNTABLE POSITION

The turntable position may be placed in one of three ways depending on space available and direction of coil unwinding. The following diagrams demonstrate the various positions available.



**PALLET DECOILER
DIAGRAM "A"**

