

Calibration

Needed - Scale and a bucket or two. Notepad and pen.

Bagger should be plugged in and have air supplied at 50PSI or so. The pressure regulator on the water inlet is set about 65 or 70psi. This should be adjusted to about 10 psi below your local line pressure in order to maintain consistency in water weight. Adjustments are made with a flat head screwdriver.

The Control Panel has three displays arranged upper left, mid way down and to the right, and centered at bottom. In the same order, they control the left hopper, right hopper, and water dispensing.

Each display looks like the one depicted at the right. The top numbers are the time that material will be dispensed, and this is the only setting that should be changed.

Naturally, the higher the number, the more material will be dispensed, but you're setting the length of time that material will be dispensed, not the target weight.

To change the time, hold the "Set" button until the "P0" starts flashing. Press "Set" again so that the numbers at the top are flashing. Now press the up and down arrows until you reach the desired time. Now hold "Set" again until the display stops flashing.

To test the weight, hold a bucket under the cone and press the Trigger button. The material will dispense into the bucket and you'll need to weigh it and repeat a few times to get an average. (If the pellets have been sitting for a while, then ignore the first reading) Adjust the time up or down until the average weight is correct.

Follow this for all three timers. Pro tip, tare a bag with the bucket when you're setting the water so that you can use it to keep the water from splashing out of the bucket.

Production

The foot switch triggers all three controllers simultaneously. If the pellets have been idle for a while, first dispense them one at a time and recycle the material, because the flow will be lower. After that, just put a bag under the cone and press the foot switch and all three materials will dispense at the same time. Once the material has dispensed, remove the bag and get another one and so forth.

It can be useful to keep a notebook or whiteboard with times that have been calibrated for different material or different sizes of bags so that you can switch between sizes without having to recalibrate each time.

