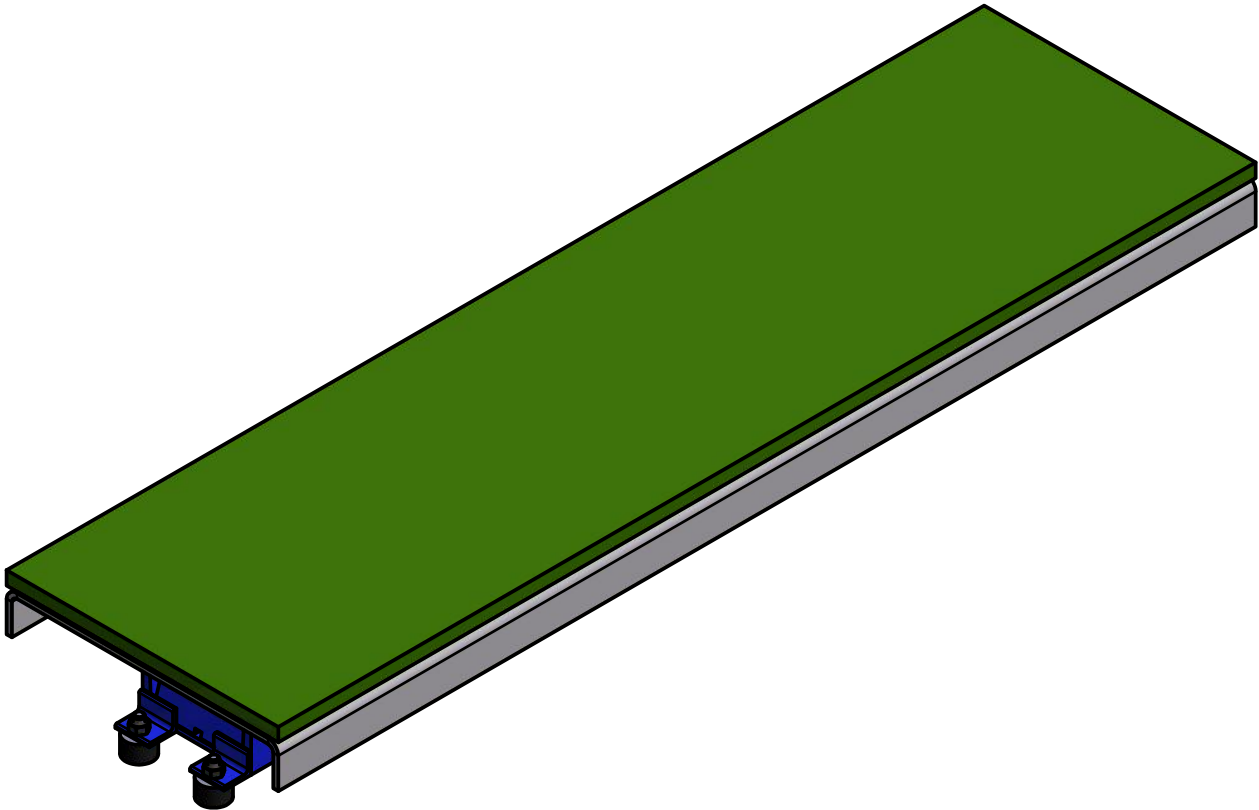


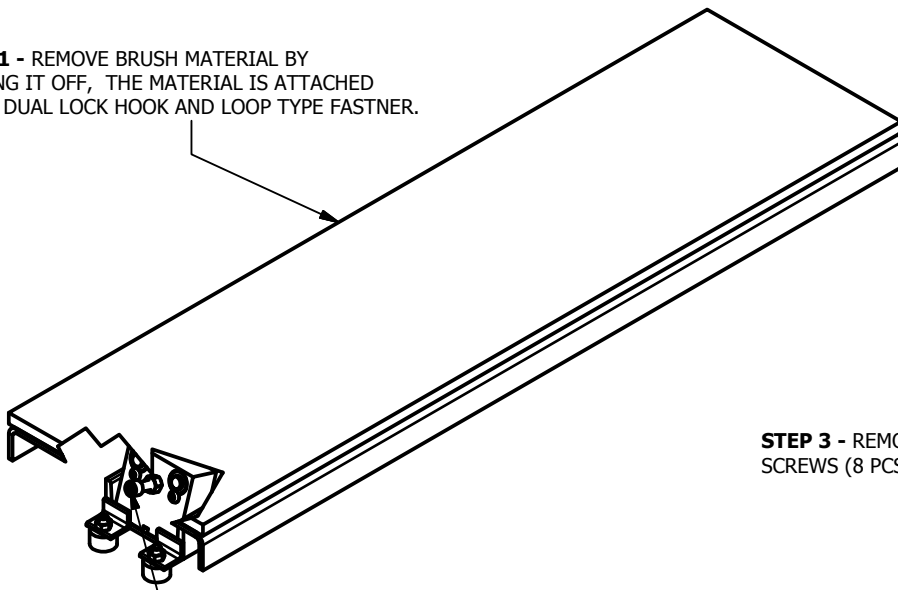
# RoboShop Inc.

## MAINTENANCE MANUAL FOR A STANDARD VIBRATORY FEEDER

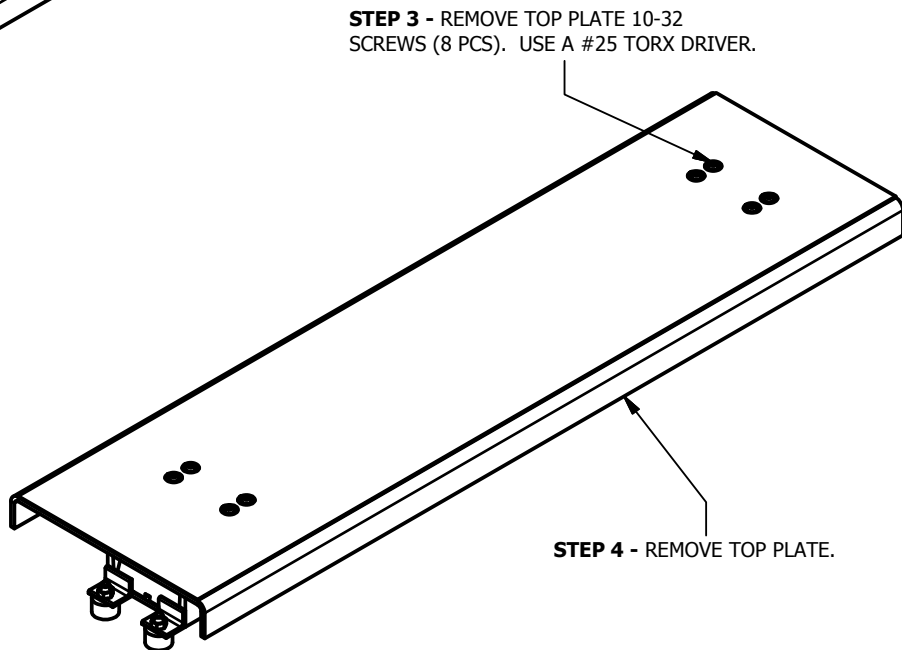


# DISASSEMBLY INSTRUCTIONS

**STEP 1** - REMOVE BRUSH MATERIAL BY PEELING IT OFF, THE MATERIAL IS ATTACHED BY 3M DUAL LOCK HOOK AND LOOP TYPE FASTNER.



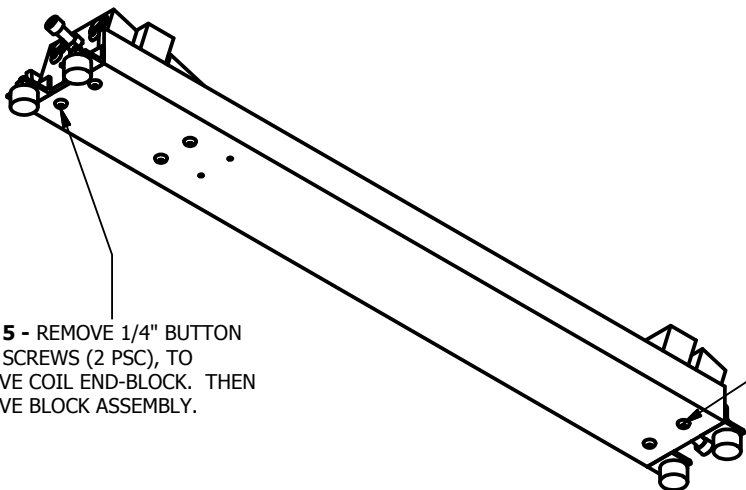
**STEP 2** - LOOSEN LOCK NUT, THEN LOOSEN 3/8 CAP-SCREW SO THERE IS NO PRESSURE ON INTERNAL SPRING - BOLT WILL MOVE FREELY WITH FINGERS. REPEAT ON OTHER END.



**STEP 3** - REMOVE TOP PLATE 10-32 SCREWS (8 PCS). USE A #25 TORX DRIVER.

**STEP 4** - REMOVE TOP PLATE.

**STEP 5** - REMOVE 1/4" BUTTON HEAD SCREWS (2 PSC), TO REMOVE COIL END-BLOCK. THEN REMOVE BLOCK ASSEMBLY.



**STEP 6** - REMOVE 1/4" BUTTON HEAD SCREWS (2 PSC), TO REMOVE SPRING END-BLOCK. THEN REMOVE BLOCK ASSEMBLY.

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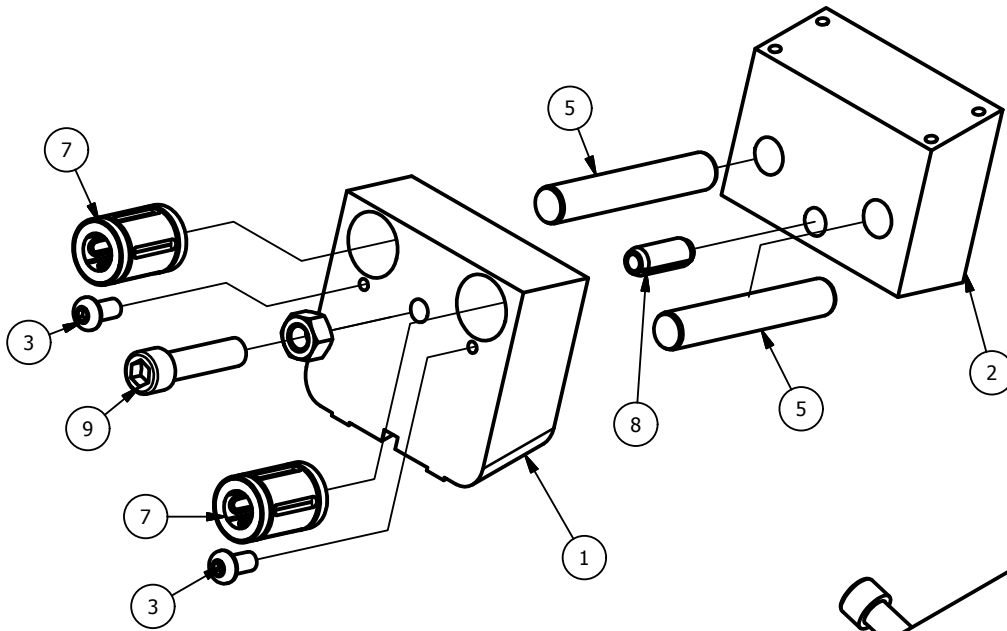
**ROBOSHOP INC.**  
VIBRATORY MOTION SYSTEMS

STANDARD VIBRATORY FEEDER  
MAINTENANCE MANUAL

# STANDARD COIL BLOCK ASSEMBLY

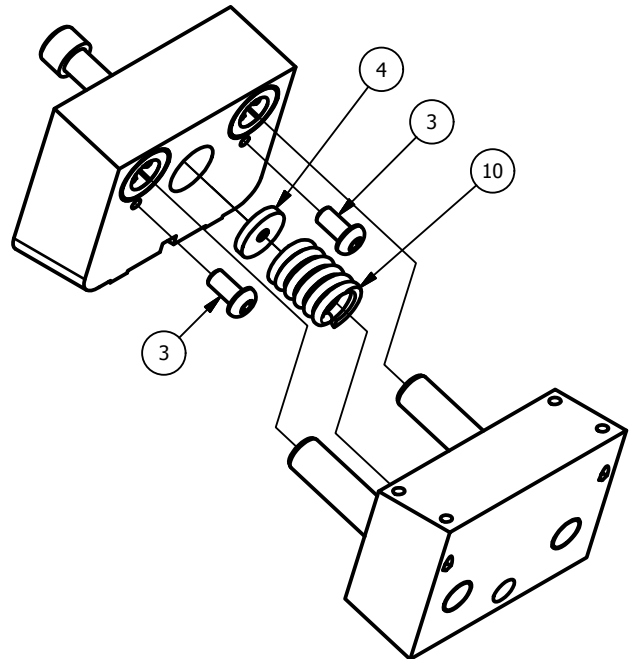
## PARTS LIST

ITEM	QTY	DESCRIPTION	PART NUMBER
1	1	ANGLED END BLOCK - COIL - STANDARD	RoboShop-P-009
2	1	ANGLED PULL BLOCK - STANDARD	RoboShop-P-007
3	4	Button Head Cap Screw	10-32 x 1/2"
4	1	Gibraltar - Countersunk Washers	3/16 x 3/4 x 1/8
5	2	Hardened Ground Dowel Pin	1/2 x 3"
6	1	Hex Nut	3/8 - 16 UNC
7	2	Linear Bearing	1/2 ID x 7/78 OD x 1 1/4"
8	1	Roll Pin	3/8 x 1"
9	1	Socket Head Cap Screw	3/8 - 16 UNC x 1 1/2"
10	1	Raymond Spring	106-404 - Die Spring



### NOTES:

- 1 - REMOVE PULL BLOCK ASSEMBLY (ITEMS: 2, 5 & 8) FROM MAIN ASSEMBLY.
  2. REMOVE SPRING (ITEM 10) AND THEN INSPECT FOR CRACKS. REPLACE IF WORN OR CRACKED.
  3. REMOVE WASHER (ITEM 4), TAKE NOTE OF ORIENTATION.
  4. REMOVE TWO (2) SCREWS (ITEM 3) FROM MAIN ASSEMBLY, FROM ONE SIDE ONLY.
  5. SLIDE OUT BEARING (ITEM 7), CHECK FOR WEAR AND EXCESS PLAY. REPLACE IF WORN.
  6. INSPECT SLIDER PINS (ITEM 5) FOR WEAR. IF OUT OF TOLLERANCE, PRESS OUT AND REPLACE WITH NEW PINS.
  7. REINSTALL BEARING (ITEM 7) AND THEN SCREWS (ITEM 3).
  8. REINSTALL WASHER (ITEM 4) AND SPRING (ITEM 10), LUBRICATE WITH GENERAL PURPOSE, HEAVY-DUTY GREASE
  9. REINSTALL PULL BLOCK ASSEMBLY (ITEMS: 2, 5 & 8) TO MAIN ASSEMBLY. LUBRICATE PINS WITH GENERAL PURPOSE, HEAVY-DUTY GREASE BEFORE ASSEMBLING. PULL BLOCK ASSEMBLY SHOULD FREELY MOVE IN MAIN ASSEMBLY.
- TIP: USE A LARGE RUBBER BAND OR ZIP-TYE TO HOLD THE TWO ASSEMBLIES TOGETHER UNTIL THE TOP PLATE HAS BEEN SECURED.



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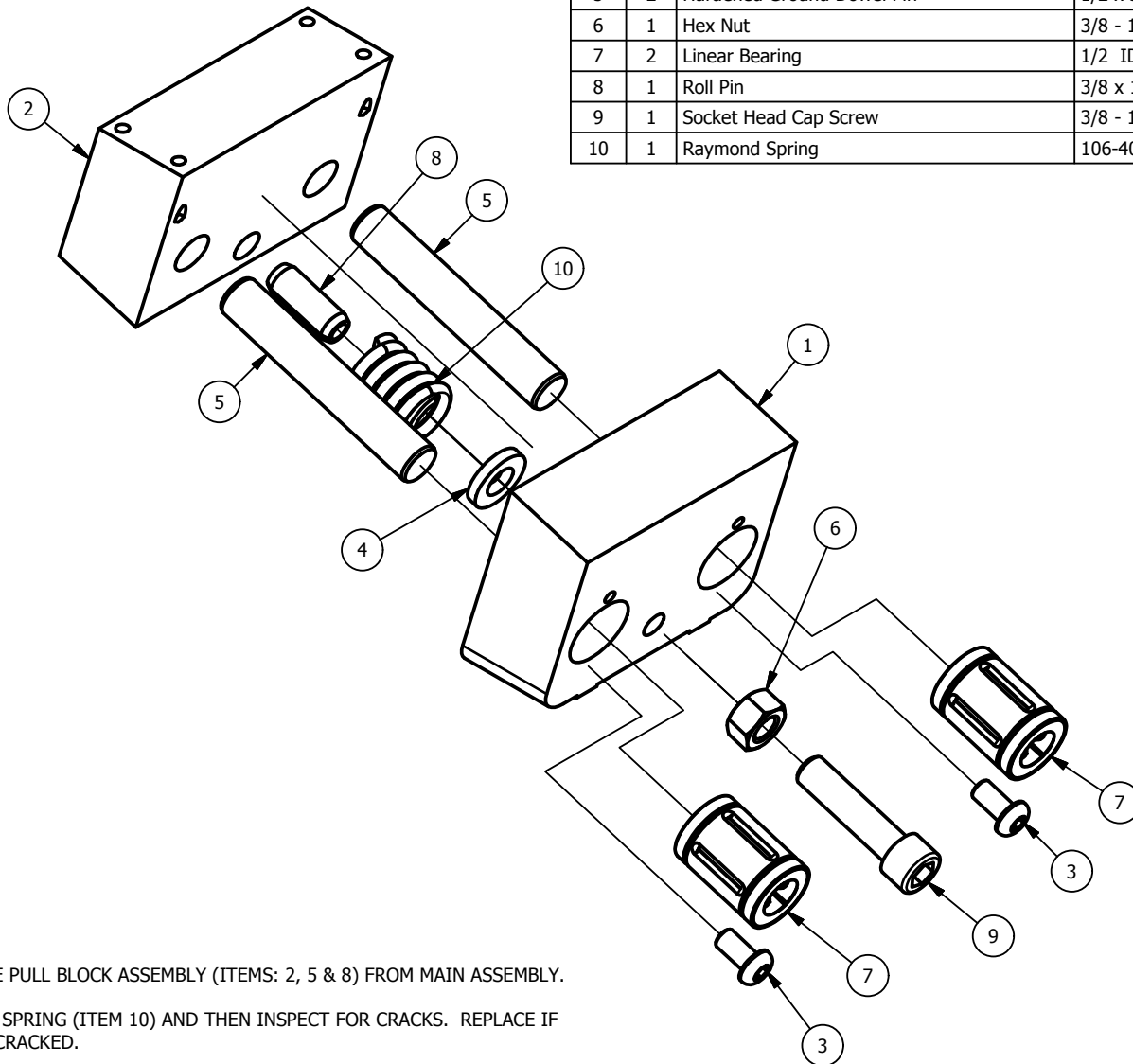
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VIBRATORY MOTION SYSTEMS

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MAINTENANCE MANUAL

# STANDARD SPRING BLOCK ASSEMBLY

## PARTS LIST

ITEM	QTY	DESCRIPTION	PART NUMBER
1	1	ANGLED END BLOCK - SPRING - STANDARD	RoboShop-P-008
2	1	ANGLED PULL BLOCK - STANDARD	RoboShop-P-007
3	4	Button Head Cap Screw	10-32 x 1/2"
4	1	Gibraltar - Countersunk Washers	3/16 x 3/4 x 1/8
5	2	Hardened Ground Dowel Pin	1/2 x 3"
6	1	Hex Nut	3/8 - 16 UNC
7	2	Linear Bearing	1/2 ID x 7/78 OD x 1 1/4"
8	1	Roll Pin	3/8 x 1"
9	1	Socket Head Cap Screw	3/8 - 16 UNC x 1 1/2"
10	1	Raymond Spring	106-404 - Die Spring



### NOTES:

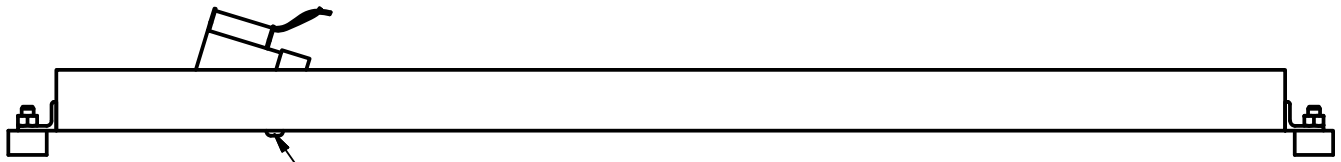
- 1 - REMOVE PULL BLOCK ASSEMBLY (ITEMS: 2, 5 & 8) FROM MAIN ASSEMBLY.
  2. REMOVE SPRING (ITEM 10) AND THEN INSPECT FOR CRACKS. REPLACE IF WORN OR CRACKED.
  3. REMOVE WASHER (ITEM 4), TAKE NOTE OF ORIENTATION.
  4. REMOVE TWO (2) SCREWS (ITEM 3) FROM MAIN ASSEMBLY, FROM ONE SIDE ONLY.
  5. SLIDE OUT BEARING (ITEM 7), CHECK FOR WEAR AND EXCESS PLAY. REPLACE IF WORN.
  6. INSPECT SLIDER PINS (ITEM 5) FOR WEAR. IF OUT OF TOLLERANCE, PRESS OUT AND REPLACE WITH NEW PINS.
  7. REINSTALL BEARING (ITEM 7) AND THEN SCREWS (ITEM 3).
  8. REINSTALL WASHER (ITEM 4) AND SPRING (ITEM 10), LUBRICATE WITH GENERAL PURPOSE, HEAVY-DUTY GREASE
  9. REINSTALL PULL BLOCK ASSEMBLY (ITEMS: 2, 5 & 8) TO MAIN ASSEMBLY. LUBRICATE PINS WITH GENERAL PURPOSE, HEAVY-DUTY GREASE BEFORE ASSEMBLING. PULL BLOCK ASSEMBLY SHOULD FREELY MOVE IN MAIN ASSEMBLY.
- TIP: USE A LARGE RUBBER BAND OR ZIP-TYE TO HOLD THE TWO ASSEMBLIES TOGETHER UNTIL THE TOP PLATE HAS BEEN SECURED.

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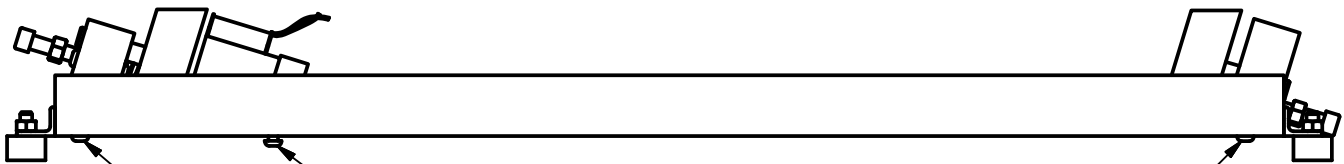
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VIBRATORY MOTION SYSTEMS

STANDARD VIBRATORY FEEDER  
MAINTENANCE MANUAL

# ASSEMBLY AND TUNING INSTRUCTIONS



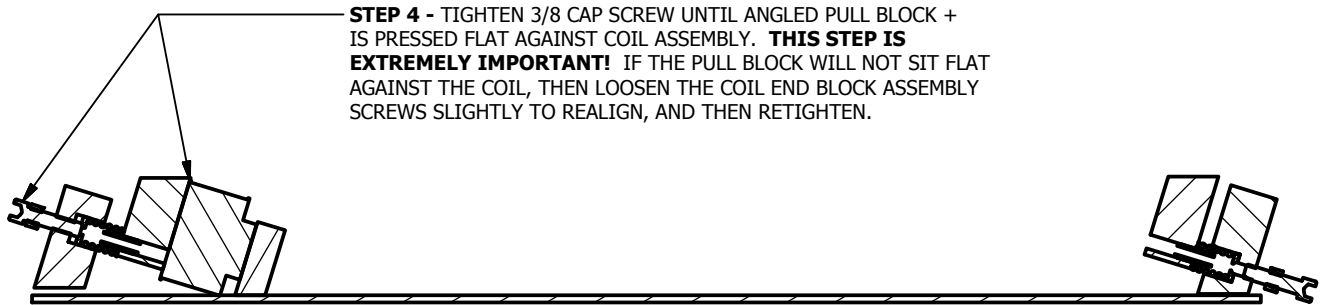
**STEP 1** - LOOSEN SCREWS TO COIL ASSEMBLY SO ASSEMBLY CAN MOVE, BUT IS NOT REMOVED. IF COIL ASSEMBLY IS BURNED OUT OR SHORTED. ORDER REPLACEMENT FROM ROBOSHOP INC. COIL ASSEMBLY PART NUMBER IS: RS-1306.



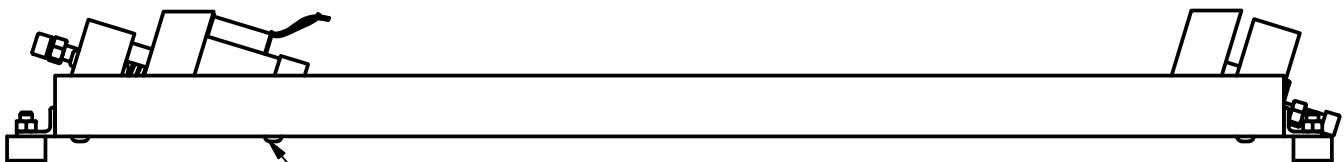
**STEP 2** - INSTALL COIL BLOCK ASSEMBLY AND TIGHTEN BOTH BOTTOM SCREW. THE 3/8" CAP SCREW SHOULD BE LOOSE RIGHT NOW.

**NOTE:** SCREW POSITION HAS BEEN EXAGGERATED, THEY SHOULD ONLY BE 1/4 TURN LOOSE

**STEP 3** - INSTALL SPRING BLOCK ASSEMBLY AND TIGHTEN BOTH BOTTOM SCREW. THE 3/8" CAP SCREW SHOULD BE LOOSE RIGHT NOW.



**STEP 4** - TIGHTEN 3/8 CAP SCREW UNTIL ANGLED PULL BLOCK + IS PRESSED FLAT AGAINST COIL ASSEMBLY. **THIS STEP IS EXTREMELY IMPORTANT!** IF THE PULL BLOCK WILL NOT SIT FLAT AGAINST THE COIL, THEN LOOSEN THE COIL END BLOCK ASSEMBLY SCREWS SLIGHTLY TO REALIGN, AND THEN RETIGHTEN.



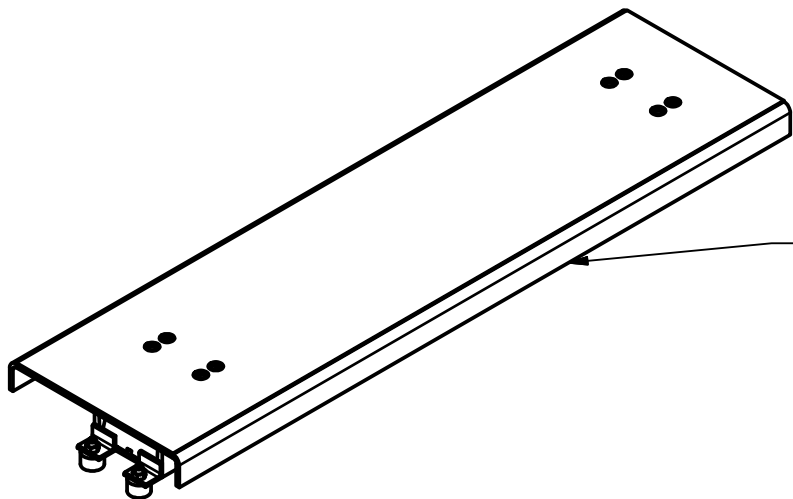
**STEP 5** - WITH PULL BLOCK STILL PRESSED FLAT AGAINST THE COIL ASSEMBLY, TIGHTEN THE COIL ASSEMBLY SCREWS. AFTERWARD, BACK THE 3/8 CAP SCREW OFF SO THAT BOTH PULL BLOCKS (COIL AND SPRING SIDE) CAN MOVE FREELY AGAIN.

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VIBRATORY MOTION SYSTEMS

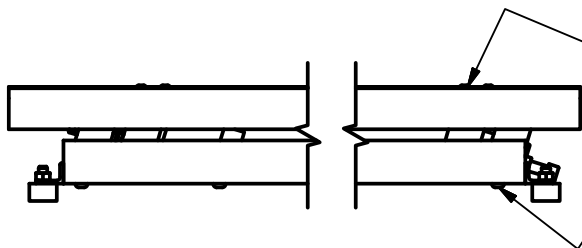
STANDARD VIBRATORY FEEDER  
MAINTENANCE MANUAL

# ASSEMBLY AND TUNING INSTRUCTIONS



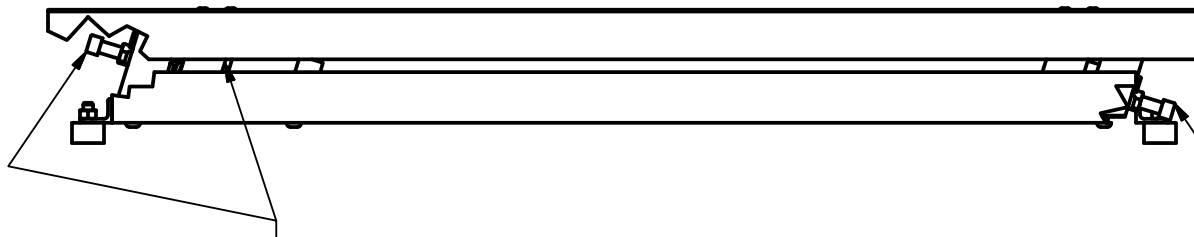
**STEP 6** - WITH BOTH 3/8 CAP SCREWS STILL LOOSE, INSTALL THE TOP PLATE USING 10-32 BUTTON HEAD SCREWS. ONCE THE TOP PLATE HAS BEEN INSTALLED IT SHOULD FREELY MOVE BACK AND FORTH 1/8".

IF THE TOP PLATE BINDS AND WILL NOT MOVE FREELY, GO TO STEP 6B. OTHERWISE, CONTINUE WITH STEP 7.



**STEP 6B** - IF THE TOP WILL NOT MOVE FREELY OR DOES NOT LINE UP WITH THE HOLES:

LOOSEN THE 10-32 BUTTON HEAD SCREW, ALSO LOOSEN THE 1/4-20 BUTTON HEAD SCRWs HOLDING THE SPRING BLOCK ASSEMBLY. REALIGN ALL, AND THEN RETIGHTEN ALL. CHECK AGAIN TO SEE IF TOP PLATE WILL MOVE FREELY.



**STEP 7** - ONCE TOP CAN FREELY MOVE. TIGHEN COIL SIDE COMPRESSION SCREW IN BY HAND UNTIL PULL BLOCK TOUCHES COIL FACE. THEN TURN ADDITIONAL 1/2 TURN WITH WRENCH. TIGHTEN LOCK NUT.

**STEP 8** - TIGHEN SPRING SIDE COMPRESSION SCREW IN BY HAND UNTIL PULL BLOCK TOUCHES COIL FACE. THEN TURN ADDITIONAL 2 1/2 TO 3 FULL TURN WITH WRENCH. THIS WILL SET THE COIL GAP AT .080" TO .100" ~ INITIAL MECHANICAL TUNING. TIGHTEN LOCK NUT WHEN UNIT IS TUNED.

NOTE: FINE TUNING MAY BE REQUIRED AFTER TESTING UNDER POWER. FINE TUNING SHOULD BE DONE WITH THE SPRING SIDE COMPRESSION SCREW.

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