



Production
engineering



TURNING STATION ASF 15

HOWTO - SETUP FOR ADDITIONAL BOTTLE HEIGHTS

This document explains how to adjust the turning station ASF15 to further bottle heights without existing positioning holes

Normally, the ASF15 turning station is equipped with predefined positions for each bottle height. However, if the height of the bottle packs is not known at delivery, the ASF15 must be adjusted manually. To do this, please follow the following steps.

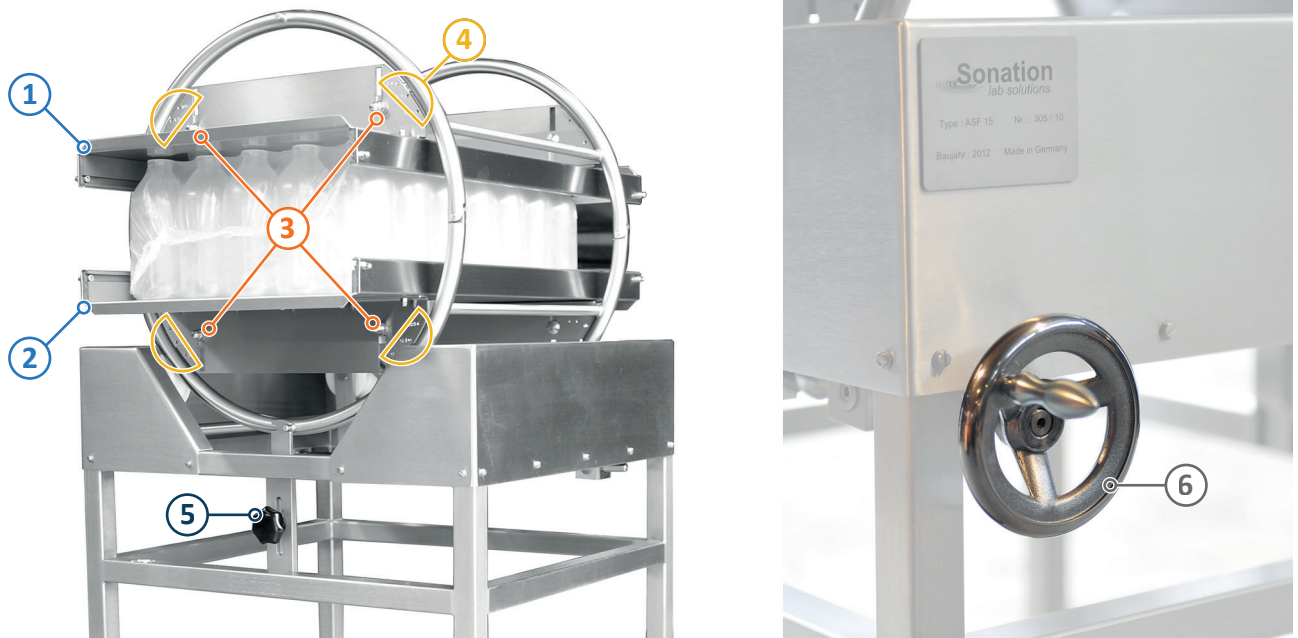
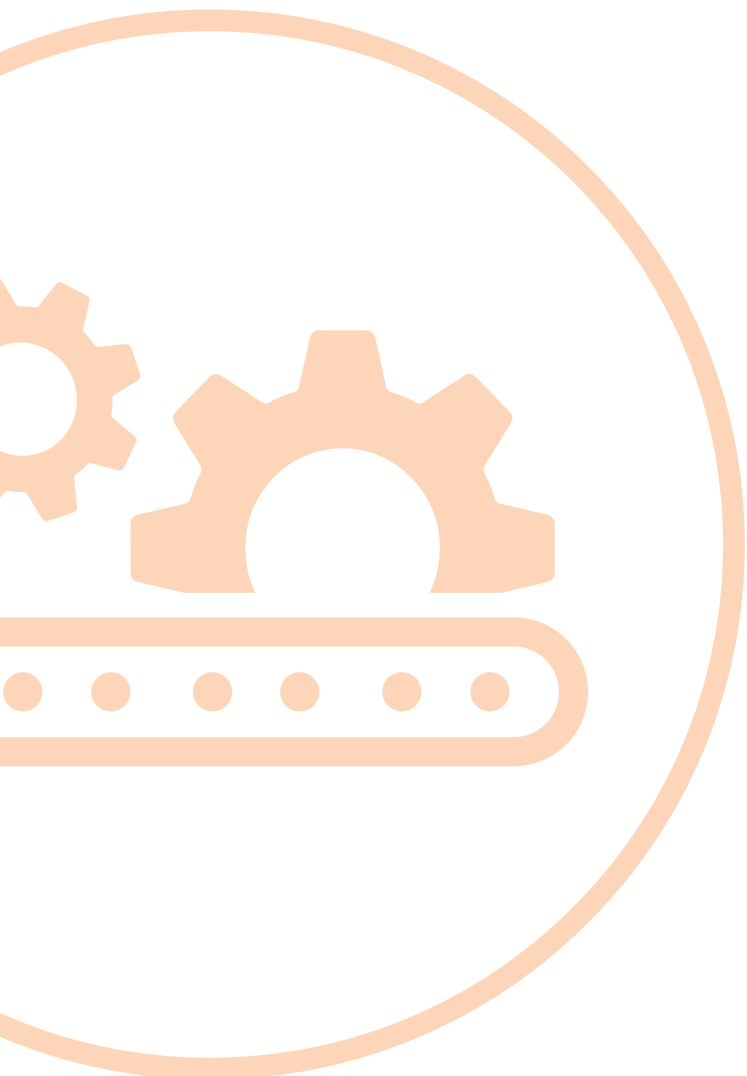


Fig. 1: Turning station ASF15 (base and rotor)

- | | | | |
|--|------------------|---------------------------|--|
| ① Bottle plate 1 | ② Bottle plate 2 | ③ Locking Screws | |
| ④ Pegging holes for predefined heights | ⑤ Star knob | ⑥ Height adjustment wheel | |

- Place the ASF15 near the table or the production line the bottles shall be shifted to for further handling.
- If not already done, adjust the ASF15 to the smallest predefined bottle height. Even on models without any given bottle height there is at least one predefined reference position. To do so, loose the screws that hold the plates in position (3) and move the plates into position that the locking bolts can be put into the predrilled holes (4).
- Release the stopper mechanism by loosening the star knob (5).
- Turn the handle (6) to lower the rotor to the lowest possible position.
- Close the stopper mechanism by fastening the star knob (5).
- The lower plate (2) should now have the same height as your production line. If not so, adjust the height of the base by screwing the caster wheels in or out. Use a water level to ensure that the turning station stands horizontally in both directions.
- Now turn the adjustment wheel (6) to move the rotor up by half of the difference between the height that is adjusted at the moment and the height of the bottles you want to use. For example if the actual height is 50mm and you want to adjust the unpacker to 120mm bottles, move the rotor up by $(120 - 50) / 2 = 35\text{mm}$. Please ensure that the stopper mechanism is loosened during this step.
- Release the screws (3) of the lower plate (2) and adjust it to the height of your production line. Use a water level to ensure that it is horizontally mounted. Fix this position by tightening the screws.
- Turn the rotor by 180° and repeat the last step with the other plate.

The unpacker is now set-up for this bottle height. To fix this position, additional holes can be drilled like the ones already present (see (4) in figure 1).



SONATION GMBH
ALTE SCHULSTRASSE 39
DE-88400 BIBERACH

TEL.: +49 (0) 7351 80093-0
E-MAIL: MAIL@SONATION.COM
WWW.SONATION.COM