

World Class Manufacturing + Cutting Edge Technology

Agility Flexible Powered Conveyor Operator Manual







Standard AFLEX Conveyor

AFLEX Conveyor with End Loading Module (ELM)

Contacts

CASI (Cornerstone Automation Systems, LLC)

(972) 346-2242 (800) 401-0304

For Standard Technical Support, call: M-F 8:00am – 5:00pm CDT

Or, fill out an Online Technical Support Form and a Customer Service Representative will contact you.

CASI website

www.casiusa.com

Cornerstone Automation Systems, LLC 10601 Clarence Dr. Suite 100 Frisco, TX 75033-3808

The contents of this document may not, neither wholly nor in part, be reproduced or translated into another language or transmitted in any form or by any means, without the prior written consent of CASI (Cornerstone Automation Systems, LLC).

As we are constantly striving to improve our products, we reserve the right to make changes and updates to our product documentation.



World Class Manufacturing + Cutting Edge Technology

© Copyright 2020 All Rights Reserved.

Table of Contents

1	SAFE	ΞΤΥ	4
	1.1	GENERAL SAFETY	4
	1.2	SAFETY PRECAUTIONS AND WARNINGS	5
2	Еме	RGENCY STOP (E-STOP) SYSTEM	5
	2.1	EMERGENCY STOP RESET PROCEDURE	6
	2.2	E-STOP System Check Procedure	6
	2.3	RESTART ROUTINE AFTER AN E-STOP	6
	2.4	SHUTTING DOWN THE AFLEX CONVEYOR	6
3	STAI	NDARD PRODUCT SPECIFICATIONS	7
4	Αρρ	LICATION GUIDELINES	9
5	MEC	CHANICAL OPERATION	9
6	PREV	VENTIVE MAINTENANCE	.16
	6.1	CLEANING	16
	6.2	GENERAL MECHANICAL PREVENTIVE MAINTENANCE	16
	6.3	GENERAL ELECTRICAL PREVENTIVE MAINTENANCE	17
	6.4	GENERAL CONVEYOR PREVENTIVE MAINTENANCE	18
7	TRO	UBLESHOOTING GUIDE	.19
	7.1	DISCLAIMER	19
	7.2	GENERAL TROUBLESHOOTING	20
	7.3	CONVEYORS TROUBLESHOOTING	21
8	WAI	RRANTY	.22

List of Tables

TABLE 1 – SAFETY PRECAUTIONS, WARNINGS AND SAFETY LABELS	5
Table 2 - General AFLEX Cleaning Schedule	16
Table 3 – General Mechanical Preventive Maintenance Schedule	16
Table 4 – General Electrical Preventive Maintenance Schedule	17
Table 5 – General Conveyors Preventive Maintenance Schedule	18
TABLE 6 – GENERAL TROUBLESHOOTING	20
Table 7 – General Conveyor Troubleshooting	21

 \mathbf{N}

List of Figures

FIGURE 1: EMERGENCY STOP (E-STOP) BUTTON	6
FIGURE 2: HALO SCANNER CONNECTED TO TEE SORTER	
FIGURE 3: FAST SOLIDVIEW SOFTWARE ICON ON HALO SCANNER	
FIGURE 4: SOLIDVIEW STARTUP SCREEN	11
FIGURE 5: MOVE AFLEX CONVEYOR IN LINE WITH HALO SCANNER	11
FIGURE 6: ELECTRICAL AND MECHANICAL CONNECTIONS	12
FIGURE 7: AFLEX CONVEYOR STARTUP	12
FIGURE 8: INTRODUCTION OF 2ND AFLEX CONVEYOR BETWEEN HALO AND AFLEX WITH ELM CONVEYOR	13
FIGURE 9: CONNECTION BETWEEN AFLEX CONVEYORS	14
FIGURE 10: COMPLETE AFLEX CONVEYOR SYSTEM CONNECTED TO HALO SCANNER	15

1 Safety

For safe operation of the CASI (Cornerstone Automation, LLC) AFLEX conveyor, read and understand the entirety of this CASI AFLEX Operator Manual prior to operating the conveyor system.

Should the end-user (or one its designees) operate this conveyor in a manner for which it is not designed or change the conveyor system rate, process, physical dimensions/layout from original factory settings, such configuration could possibly lead to decreased reliability or possible injury, and may void factory warranty.

1.1 GENERAL SAFETY

- Do not leave the CASI AFLEX conveyor running unmonitored.
- Personnel operating the conveyor must be properly trained in its use, including the proper sequence of starting and stopping the conveyor and the correct loading and unloading methods.
- Use the handles on each side of the conveyor, at both ends, to move, expand and compact the AFLEX conveyor. While doing so, keep hands clear of the frame's sidebars to avoid pinch point injury.
- Keep hands, long hair, loose clothing and jewelry away from moving conveyor parts and rollers.
- Do not exceed recommended maximum conveyor load capacity.
- Before starting the conveyor, be sure no unwanted boxes, or other items are on the conveyor rollers.
- Do not operate the conveyor with damaged or broken parts.
- All operation and basic preventive maintenance should be performed by trained and competent individuals.
- To avoid risk of electric shock, do not operate the conveyor with a cover of an electrical box removed. Do not operate conveyor in a rainy and/or leaking environment.
- Only qualified and trained technicians and maintenance personnel should perform service and/or repair work on the conveyor.



1.2 SAFETY PRECAUTIONS AND WARNINGS

Table 1 – Safety Precautions, Warnings and Safety Labels



2 Emergency Stop (E-Stop) System

The **Emergency Stop (E-Stop) System** uses **Emergency Stop (E-Stop) Buttons** to activate the safety circuit. Pushing an E-Stop button causes conveyor components, including drive roller pully assemblies, drive cards, and photoelectric sensors (photoeyes) to halt.

When an emergency stop (E-Stop) button is pressed, all power is removed from the conveyor operational components, however, the light stays on. This is accomplished by de-energizing the safety relay. The safety relay in turn opens its contacts. The opening of these contacts removes power from the electrical boxes.

A **Designated Person** should check the emergency stop (E-Stop) buttons for proper operation, physical damage, button looseness, and excessive environmental contamination. This should take place on a periodic schedule determined by the user, based on the severity of the operating environment and the frequency of switch actuations. Adjust, repair, or replace components as needed. If inspection reveals contamination on the switch, thoroughly clean the switch and eliminate the cause of the contamination. Replace the switch and/or appropriate components when any parts or assemblies are damaged, broken, deformed, or badly worn; or if the electrical/mechanical specifications (for the environment and operating conditions) have been exceeded. **Always test the control system for proper functioning** under machine control conditions after performing maintenance, replacing the emergency stop device, or replacing any component of the device.

CASI recommends the end user conduct a risk assessment and risk reduction analysis (see ISO 12100 or ANSI B11.0) to determine the appropriate frequency for E-Stop system checks. In lieu of the assessment and analysis, test each component before start of each production day. Refer to the E-Stop System Check Procedure for the process to check the E-Stop system.



Figure 1: Emergency Stop (E-Stop) Button

2.1 EMERGENCY STOP RESET PROCEDURE

For immediate conveyor shut down, push a red E-Stop button to completely turn off the conveyor. **This function should only be used in an actual emergency or when adding additional AFLEX conveyors to the system.** After resolving the issue that triggered the necessity of the E-Stop or completing the addition of an AFLEX conveyor to the system, follow these steps for mechanical operation to resume.:

- 1. Turn the **E-Stop** button clockwise (the direction of arrow on the button if present) to release the E-stop.
- 2. Press the green **Start** button on the electrical control panel box.

2.2 E-STOP SYSTEM CHECK PROCEDURE

Follow these steps to check the Emergency Stop (E-Stop) system:

- 1. Press an E-Stop button.
- 2. Verify that **all** mechanical functionality stops on the conveyor.
- 3. Reset the E-Stop by turning the red mushroom pushbutton clockwise.
- 4. Press the green **Start** button on the electrical control box.

2.3 RESTART ROUTINE AFTER AN E-STOP

- 1. Resolve the issue that triggered the necessity of the E-Stop.
- 2. Reset the E-Stop device that was triggered.
- 3. Press the green **Start** button on the electrical control box.

2.4 SHUTTING DOWN THE AFLEX CONVEYOR

- 1. Press the conveyor's red **STOP** button on the conveyor electrical control box to stop the conveyor (only one red E-Stop button on the AFLEX needs to be pressed).
- 2. Power down (turn *OFF*) all associated equipment and/or turn *OFF* disconnects according to current plant procedures and practices.

3 Standard Product Specifications

Conveyor Lengths [First to last roller center distance]:

	<u>Compressed</u>	<u>Expanded</u>
With ELM zone	172.5″	317.5″
Without ELM zone	116"	235.5″
	Between Frame 1.5" Rollers	<u>Between Frame 1.9" Rollers</u>
Conveyor Bed width	29.25"	29.25″
Product height	36" (from ground)	36" (from ground)
Load capacity Per Linear Foot	100 lbs.	100 lbs.
Roller spacing	1.5″ ≤ 4″	3" (fixed)
Roller:	1.5%	4.0"
Diameter	1.5 16 Course	1.9 16 Gauge
Bearings	Precision	Precision
Speed	0-120 FPM	0-120 FPM
Maximum Transfer Rate	30 Boxes per minute	30 Boxes per minute
Product:		
Minimum box size	6" X 6"	6" X 6"
Maximum box size	24" X 48"	24" X 48"
Cartons to have flat rigid bottoms with		
weight evenly distributed within carton		
Caster:	0"	o."
Material	o Zinc plated body, rubber tread	o Zinc plated body rubber tread
Material	polvolefin wheel core	polvolefin wheel core
Swivel lock	Available	Available
Motion lock	Available	Available
O-rings:		
Diameter	.1875″	.1875″

Lozier + CASI Walmart AFLEX Operator Manual for FAST Systems - Rev A

Material

Polyurethane

Special Features

Constant tension O-rings

Gapping capability (creates gaps between transported product)

Auto configure IP address (allows mixed configuration of multiple sections of AFLEX together) On-board telemetry capability (motor temperature, motor faults, photo eye blocked) Automatic sleep function

Two speed product gap reduction (Used mainly at the beginning of the loading process to utilize downstream space on the AFLEX and allow the loader room to quickly load more items)

Electrical Specifica	<u>ition</u>
Voltage	120 VAC
Maximum	
Current	9.87 Amps
Rating	UL 508A
Connectors	
Infeed end	Phoenix Female
Outfeed end	Phoenix Male
Pue	
Dus	20 Amp AC
Data	≥0 Amp AC
Safety	Category 1
<u>Environmental Spe</u>	<u>ecifications</u>
Temperature	0° C to 40° C
Humidity	10% to 90% RH non-condensing
Rating	IP54
	Protected against dust and ingress
	Protected against water splashed for 5 minutes
Noise Levels	
Rating at convey	or bed (approx.) 70 dB
Rating at convey	or bed (approx.) 60 dB

4 Application Guidelines

The CASI AFLEX is a patented intelligent flexible conveyor, with unique kinematics and built-in features that make this the gold standard for flexible conveyors. This conveyor is ideal for use and storage in areas where space is at a premium. The fully stretched length is twice the length of the fully compressed conveyor. The flexibility in length allows this conveyor to be deployed in applications where the distance between product loading and unloading point is not constant. The AFLEX conveyor also has the ability to curve around tight corners with an approximate turning radius of 30". The AFLEX conveyor is capable of conveying boxes varying in sizes, from 6" X 6" up to 24" X 48" with a load carrying capacity of 100 lbs/linear foot. The conveyor has the capability to achieve Zero Pressure Accumulation (ZPA) due to the built-in logic. Also due to the ethernet enabled inter-conveyor communication, the conveyors can auto address their IP addresses which allows the operator with flexibility to connect the conveyors in a random order. The conveyors are provided with latches that are capable of compensating for unevenness in the supporting floor. This ensures a smooth product transfer going from one conveyor section to the other. The AFLEX conveyors are best suited for applications in the warehousing industry in areas such as shipping, receiving and product sorting. However, the versatility of the AFLEX conveyor makes it ideal for applications in any industry where space is at a premium and a smooth and fast product transfer from one area to another is desired.

5 Mechanical Operation

Before attempting to operate the AFLEX conveyor, the operator must familiarize himself/herself with other equipment that constitutes the FAST system (Halo scanner and Tee sorter modules), in order to ensure safe and efficient operation of the system.

Step 1: Before attempting to connect the AFLEX conveyor to the FAST system, the Halo scanner and the Tee sorters must be connected mechanically and electrically as shown in Figure 2. The yellow light at the infeed end of the Halo flashes, as shown in **Figure 2**.

Step 2: Once connected, double click the SolidView software application icon on the touch screen all-inone computer mounted on the side of the Halo scanner, as shown in **Figure 3**.

Step 3: Once the account login credentials have been entered, the startup screen displays, as shown in **Figure 4**.





		waimart 215	i dot Oyo	tom (Jourers		LAIL
			System running				
gout Operations Reset Event	.og Layout Configuration	Lanes RouteConfigura	tion Reports System Lo	ogs Admin Rp_Dist	Install	_	
		Step	1			v242	
Chosen trailer:	103899	Outs qty:		Missing or incomp	olete trailer?		
File date:. Please try a new fi	le.			Enter below and cl	lick Get Trailer		
Click the trailer to use							
					Get Trailer		
			L				
					Use FTP for trailer		
					TV ON/OFF		
				_			
					Move Count Screen		
					Use test trailer		

Figure 4: SolidView Startup Screen

Step 4: Click the '**Start**' button on startup screen of SolidView. The Halo scanner sounds a voice message stating '*System Scanning*'. Wait for this step to complete – normally the Halo voice message will state '*Scan Complete*'. The light on the infeed end of the Halo scanner flashes yellow. Next, the Halo scanner sounds a voice message stating '*System Reconfiguring*'. Wait for this step to complete. The light on the infeed end of Halo scanner flashes yellow. Once reconfiguration is complete, the Halo scanner sounds a voice message stating '*Reconfiguration complete*'. The system will sound a voice message of '*System Ready*'. This entire configuration process can take 1-2 minutes depending on how many sortation modules are connected.

Step 5: Wheel the AFLEX with ELM conveyor into position in-line with the Halo scanner as seen in **Figure 5**.



Figure 5: Move AFLEX Conveyor in Line with Halo Scanner

Step 6: Make mechanical and electrical connection at AFLEX conveyor and Halo scanner junction, as shown in **Figure 6**.

- > Use latch to connect AFLEX conveyor to Halo scanner.
- Plug in the AFLEX conveyor pigtail with Phoenix Male connector to the Phoenix Female connector on the Halo scanner.





The system voice will announce 'Scanning System'; 'Scan Complete'; 'Reconfiguring System'; repeat 'Reconfiguring System' several times, then 'Reconfiguring Complete' and finally 'System Ready'.

The flashing green light turns to solid green. Ensure the E-Stop buttons on the AFLEX conveyor have been reset. Wait 8-190 seconds then press the green '**Start**' button located at the upstream end of the AFLEX conveyor as shown in **Figure 7**. Initially all the zones of the AFLEX conveyor will run for a few seconds. Then, only the ELM zone on the AFLEX with ELM conveyor continues to run while the other zones stop running. This indicates that the AFLEX conveyor is ready for operation.

Step 7: Pull the AFLEX conveyor into position such that the ELM section is closest to the operator that is loading product on to the conveyor. Lock the ELM zone in place by engaging the locks on the casters. Load boxes with barcode labels facing up (facing the ceiling) or in whichever direction the barcode scanner is located. If required, pull the AFLEX conveyor into position by grabbing the green handles on the side of

the conveyor. Do not grab rollers or scissor pieces to move the conveyor into position. When conveyor has been stretched to its maximum length, but boxes are still more than an arm's length away, then add another AFLEX conveyor by following **Steps 8 and 9**, below.

Step 8: Press the E-Stop button on the ELM zone of the AFLEX with ELM conveyor. Disconnect the AFLEX conveyor and Halo scanner, both electrically and mechanically. Move the AFLEX with ELM conveyor out of the way. Connect a 2nd AFLEX conveyor (with no ELM) to the Halo scanner, both electrically and mechanically by following the process as explained in **Steps 5 and 6** above.



Figure 8: Introduction of 2nd AFLEX Conveyor Between Halo and AFLEX with ELM Conveyor



Figure 9: Connection Between AFLEX Conveyors

Step 9: Connect AFLEX with ELM conveyor to the 2nd AFLEX conveyor (which is now connected to the Halo) **Figure 9**. Reset the E-Stop button on the AFLEX with ELM conveyor. Wait for flashing yellow light on Halo to turn solid green. The system voice will announce '*Scanning System*'; '*Scan Complete*'; '*Reconfiguring System*'; repeat '*Reconfiguring System*' several times, then '*Reconfiguring Complete*' and finally '*System Ready*'.

Note: If the configuration process fails, press any AFLEX E-Stop button and release/reset it. This will trigger the steps announced by the system voice - '*Scanning System*'; '*Scan Complete*'; '*Reconfiguring System*' repeat '*Reconfiguring System*' several times, then '*Reconfiguring Complete*' and finally '*System Ready*'.

Press the green '**Start**' button on the AFLEX with ELM conveyor. Do NOT press Start before the '*System Ready*' message is announced.

Step 10: Pull the AFLEX with ELM conveyor into position such that the ELM section is closest to the operator that is loading product onto the conveyor. Lock the ELM zone in place by engaging the locks on the casters. Load boxes with barcode labels facing up (facing the ceiling). When both conveyors have been stretched to their maximum length, but boxes are still more than an arm's length away, then add the 3rd AFLEX conveyor by following the process as explained in **Steps 11 and 12** below.

Step 11: Move the AFLEX with ELM conveyor and 2nd AFLEX conveyor out of the way. Connect a 3rd AFLEX conveyor (with no ELM) to the Halo scanner, both electrically and mechanically by following the process as explained in **Step 6** above. Connect the 2nd AFLEX conveyor to the 3rd AFLEX (which is now connected to the Halo). Release E-Stop on the AFLEX with ELM conveyor. Wait for flashing yellow light on the Halo scanner to turn solid green. The system voice will announce '*Scanning System*'; '*Scan Complete*';

'Reconfiguring System'; repeat *'Reconfiguring System'* several times, then *'Reconfiguring Complete'* and finally *'System Ready'*.

Note: If the configuration process fails, press any AFLEX E-Stop button and release/reset it. This will trigger the steps announced by the system voice - '*Scanning System*'; '*Scan Complete*'; '*Reconfiguring System*'; repeat '*Reconfiguring System*' several times, then '*Reconfiguring Complete*' and finally '*System Ready*'.

Press green '**Start**' button on the AFLEX with ELM conveyor. Do NOT press Start before the '**System Ready**' message is announced.



Figure 10: Complete AFLEX Conveyor System Connected to Halo Scanner

Step 12: Pull the AFLEX into position such that the ELM section is closest to the operator that is loading product on to the conveyor. Lock the ELM zone in place by engaging the locks on the casters. Load boxes with barcode labels facing up (facing the ceiling) or whichever direction the barcode scanner is located.

If any **E-Stop** button is pressed for any reason, after it is cleared or released, wait about 5-6 seconds to press any green **Start** button on the AFLEX to start them back up.

6 Preventive Maintenance

The following tables describe the suggested preventive maintenance for the CASI AFLEX conveyor, on a Daily, Weekly, Monthly, and Quarterly basis.

6.1 CLEANING

		Frequency			
Description	D	w	N	q	
Wipe down conveyor rollers and photoeye bars with alcohol wipes.	х				
Wipe photoeyes with a dry cloth. If there is build up on them, use an alcohol wipe.	x				
Vacuum debris off conveyor and conveyor parts to ensure conveyor is free of dust and debris which could interfere with normal operation.		x			
Complete wipe down of entire conveyor, including frame.			х		

Table 2 - General AFLEX Cleaning Schedule

6.2 GENERAL MECHANICAL PREVENTIVE MAINTENANCE

Table 3 – General Mechanical Preventive Maintenance Schedule

		Frequency			y
ltem	Description	D	¥	equency W M C X .	Q
Roller Motors	Ensure the Motor Roller fasteners are tight.		X		
Conveyor Visual Inspection	Perform visual inspection for broken or damaged components.	Х			
Hardware Checks	 Ensure all nuts and bolts are tight. Ensure belts are snug and do not slip. Ensure Idler rollers are free spinning. Check Roller motors for visible damage. 			x	

6.3 GENERAL ELECTRICAL PREVENTIVE MAINTENANCE

		F	req	cy 🛛	
ltem	Description	D	w	М	Q
Emergency Stop Circuit	Check the functionality of all Emergency Stop (E-Stop) buttons.	X			
Photoeyes	 Verify photoeyes are functioning with these steps: Hold your hand over one photoeye. Section of conveyor should start to run. Remove hand. Section of conveyor will stop. Repeat Steps 1 and 2 for all other photoeyes on that bar. If one photoeye fails, that photoeye bar fails and conveyor section will fail to run. 	x			
	Clean photoeye lenses and reflectors with a dry cloth to remove dust or an alcohol wipe if needed for any build up.		x		
Electrical Ensure all electrical connections are in place and fully connected.					
Flex Conduit	Ensure any/all flex conduit is free of nicks, cuts, or abrasions.		x		

Table 4 – General Electrical Preventive Maintenance Schedule



6.4 GENERAL CONVEYOR PREVENTIVE MAINTENANCE

Item	Description				ÿ	
nem	Description	D	w	Μ	Q	
	Tighten any loose Pulse Geared Drive fasteners that are found.	x	x			
	Check Pulse Geared Drive for visible damage.			x		
Pulse Geared Drive	Ensure roller shaft is secured properly.	Α	nnı	nually		
	Dust and dirt in combination with humidity may bridge the electric circuit. Regularly blow off dust and dirt by using low compressed air.	As	ne	ede	d	
	Check looseness or backlash of bolts/screws. Tighten them, if necessary.	x				
	Check the drive card leads for visible damage.			x		
Motor Drive Cards	Ensure the screws of the drive cards are still tight and that the cables are still laid properly and connected to the terminals.	A	nnı	ually	/	
	Dust and dirt in combination with humidity may bridge the electric circuit. Regularly blow off dust and dirt by using low compressed air.	As needed				
Roller O-rings	Inspect for wear, replace as necessary.			x		
Entire Conveyor	Conduct daily and weekly walkthroughs of the conveyor. Look for any abnormal action of conveyor, unusual noises, etc. Repair before use.	x	x			

Table 5 – General Conveyors Preventive Maintenance Schedule

7 Troubleshooting Guide

7.1 DISCLAIMER

- Risk of electric shock, pinch point injury, among other injuries, could occur if the conveyor is operated or maintenance work is performed in an unsafe manner. Care should be taken at all times when working with moving, rotating, and electrically energized machinery.
- All operation and maintenance should be performed by trained and competent individuals.
- Personnel operating the conveyor must be properly trained in its use, including the proper sequence of starting and stopping the conveyor and the correct loading and unloading methods.
- Use the handles on each side of the conveyor, at both ends, to move, expand and compact the AFLEX conveyor. While doing so, keep hands clear of the frame's sidebars to avoid pinch point injury.
- Keep hands, long hair, loose clothing and jewelry away from moving conveyor parts and rollers.
- Do not exceed recommended maximum conveyor load capacity.
- Before starting the conveyor, be sure no unwanted boxes, or other items are on the conveyor rollers.
- Do not operate the conveyor with damaged or broken parts.
- All operation and basic preventive maintenance should be performed by trained and competent individuals.
- To avoid risk of electric shock, do not operate the conveyor with a cover of an electrical box removed.
- Only qualified and trained technicians and maintenance personnel should perform service and/or repair work on the conveyor.
- If this first level troubleshooting does not return the conveyor to operation, CASI technical support is available.

CASI Technical Support 800-930-3788

7.2 GENERAL TROUBLESHOOTING

The Troubleshooting Guide is intended to assist operators in resolving issues while operating the CASI AFLEX conveyor. Written in an "if-then" style, each problem identified during the installation and start-up of the conveyor is included.

The following tables serve as reference for common issues. For issues not listed, call CASI Technical Support.

Problem	Correction
Clearing a jammed product	 Ensure equipment is stopped (wait at least 5 seconds to make sure the equipment does not auto start). Assess the situation to best determine the cause of product jam. Clear jammed materials. Check for damage or loose pieces of product that might later free up and block or re-jam components. Boxes without rigid flat bottoms may not convey.

Table 6 – General Troubleshooting

7.3 CONVEYORS TROUBLESHOOTING

Issue	Check	Correction
No Zones on the conveyor will run	 No power to the Power Supply unit No lights on Power Supply 	 Ensure conveyor power is <i>ON</i> Ensure power supply is properly connected. Check for loose connections and repair or replace any loose or damaged power supplies. Check output power of the power supply.
Individual zone will not run	 Drive Card problem Bad cable connection to Drive Card Roller Motor defective 	 Check all drive cards in affected conveyor section. Replace any defective drive cards as necessary. Check all connections on the drive card for any loose or disconnected wires. Repair or replace any wire or connectors, as necessary. Check all roller motors in affected conveyor section. Replace any defective roller motors, as necessary. Ensure photoeye cable is fully connected to drive card. Inspect cable for cuts or abrasions. Repair or replace as necessary. Ensure photoeye is seated into circuit board. Ensure there is no debris or foreign object interfering with the operation of each
	Test Photoeyes	 photoeye. Hold your hand over one photoeye. Section of conveyor should start to run. Remove hand. Section of conveyor will stop. Repeat Steps 1 and 2 for all other photoeyes on that bar. If one photoeye fails, that photoeye bar fails and conveyor section will fail to run.
A zone will not start after accumulation	Check O-rings	 Ensure O-rings are not stretched, worn or cut. Replace any and all defective belts. Ensure O-rings are not binding on the pulleys. Ensure the pulleys are not binding.

8 Warranty

CASI's solutions come with a 1-year warranty from date of installation, provided installation occurs within three months of the ship date. This includes all parts and labor as well as unlimited email, web-based, and on-site support (with the exception of travel expenses) during normal business hours. On-site support is provided as needed, or when online or remote support cannot resolve the issue. After one year from installation, unless the support agreement is renewed, CASI standard hourly support rates apply. CASI standard support guarantees a four-hour response time by phone within the hours of 7 AM to 6 PM US central standard time Monday through Friday.

[This Page Intentionally Left Blank]



World Class Manufacturing + Cutting Edge Technology

© Copyright 2020 All Rights Reserved.