

# GAMMA 311

# AIRFEED SETUP

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**To process a split cycle airfeed application, the following steps need to be performed:**

- 1) Remove the second cam notch located on the top rear of the K300 press. This notch is located 180 degrees from the notch already removed.
- 2) Select closed barrel mode under the teach menu.
- 3) Lower press slide to capture, and hold terminal. **\*\*NOTE:** the cam may have to be repositioned in order to have the press stop at the correct place after firing.
- 4) Adjust the switches located on the main panel to activate split cycle/airfeed.

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## Proper split cycle/Airfeed operation:

The press slide should be down, holding the terminal in position. After the swing arm inserts into the terminal, the press will fire once, coming down, terminating the wire. The slide will then rise, stop in the top position, an air blast will fire, advancing the terminal, then the slide will return to its down position, capturing the next terminal.

## G311 AIRFEED ADJUSTMENTS:

T1: Wait time until actuation of airfeed.

T2: Pulse time of airfeed blast.

T3: Wait time before the actuation of the 2nd half of the split cycle.

T4: Press signal **\*\*\*SET AT FACTORY – DO NOT TOUCH\*\*\***

T5: Fixed pulse time for the firing of the press. **CANNOT BE CHANGED**

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### DEFAULT SETTINGS:

T1=.1 T2=.4 T3=.5 T4=.2

