



Model CS1 Cotton Inserter



Operation Manual

Dear Customer,

Thank you for purchasing a Pharmafill Model CS1 Cotton Inserter. We at Deitz Company hope you will find that the Model CS1 meets or exceeds your expectations and requirements for an affordable, reliable and innovative addition to your packaging operation.

Pharmafill products are designed and manufactured by Deitz Company Inc., in Wall, NJ, USA. We have manufactured machinery for the bottle filling industry since 1966 and began directly marketing our Pharmafill line in 1993. We are a small (but growing) family-owned business that emphasizes quality, innovation and superior customer service.

If you have any questions or comments, please contact us by phone or visit our website. Chances are someone whose last name is Deitz will handle you inquiry personally.

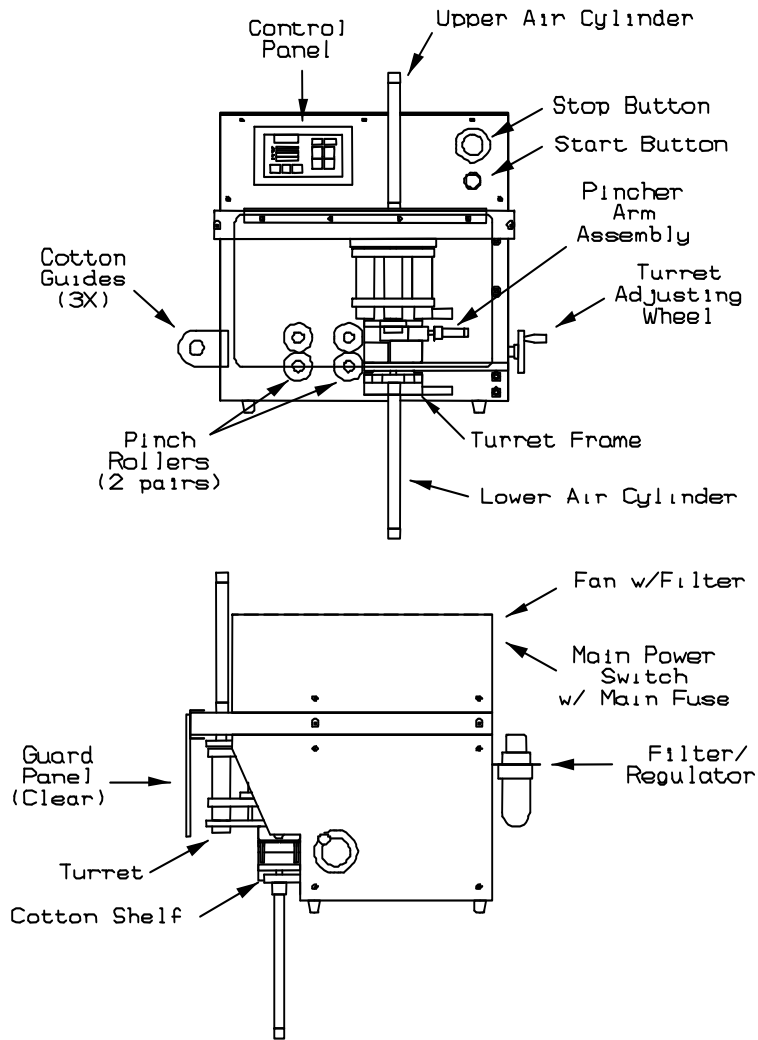
Deitz Company Inc.
PO Box 1108
1750 Route 34
Wall, NJ, USA 07719

Tel 732-681-0200
Fax 732-681-8468
E-mail support@deitzco.com or
support@pharmafill.com

Yours truly,

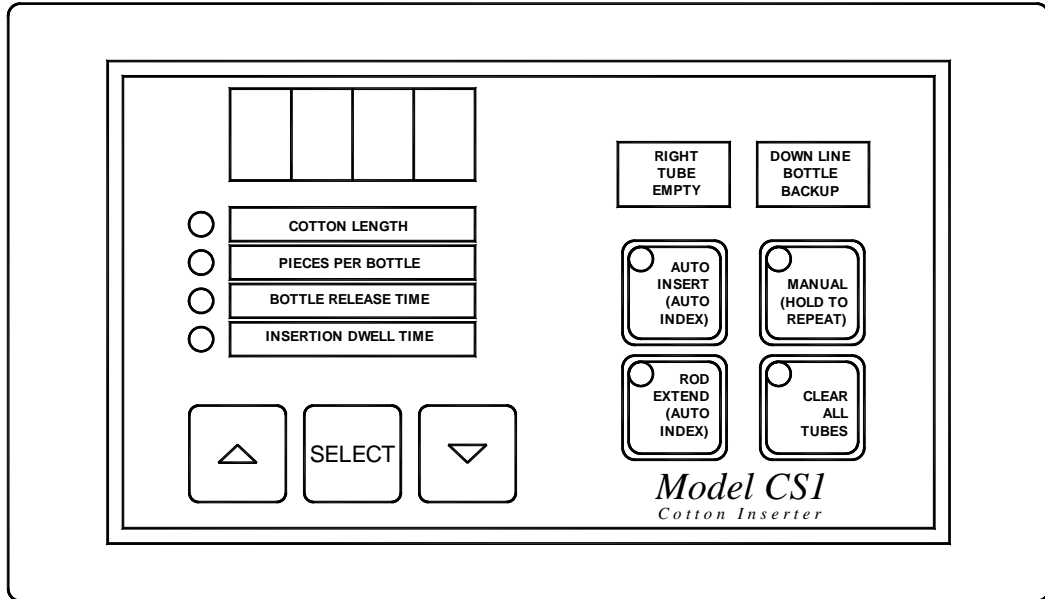
The Deitz Company

Model CS1 Cotton Inserter Features and Components



Pharmafill Model CS1 Cotton Inserter
Operating Instructions

SECTION I: OPERATOR PANEL



DISPLAY

The left side of the Operator Panel consists of a 4-digit display, a list of four values which may be displayed and buttons to select and set these values:

Value	Description	Range of Values
Cotton Length	Straight length of cotton piece	2 to 9 inches
Pieces Per Bottle	Number of pieces of cotton per bottle	1 to 10 pieces
Bottle Release Time	Time to let filled bottle move away	0.1 to 5.0 sec
Insertion Dwell Time	Time plunger remains in bottle	0.0 to 5.0 sec

To set or view the display values:

1. Press **SELECT** until the red light turns on next to the value you wish to view or set. The value will be displayed.
2. Increase the value by pushing the up arrow. Decrease the value by pushing the down arrow. The new value will be displayed.

PUSHBUTTONS

The right side of the Operator Panel contains four pushbutton and two warning indicator lights. Each push button has a small light which turns on while the button is active. There is also an audible "beep" when a button is pressed.

The four buttons on the lower right side of the Operator Panel work as follows:

Label	Type	Function
Auto Insert	On/Off	Will automatically fills start filling cycle when bottle is detected by the Bottle Sensor. Disables Manual Cycle and Clear All Tubes . Automatic operation will stop if Tube Empty lights (see below).
Rod Extend	On/Off	Press to extend and hold the insertion rods. Press again to release. Used for set-up and troubleshooting.
(Auto Index)	On/Off	Pressing both the Auto Insert and Extend Rod buttons will activate the Auto Index function. The will automatically index bottles without inserting cotton . Used when cotton is not required but uniform bottle spacing is needed for the next process such as automatic capping and banding. The Bottle Release Time setting works just as with Auto Insert.
Manual (Hold To Repeat)	On while pushed	Starts one fill cycle with or without cotton or bottle. Hold down for continuous cycling.
Clear All Tubes	On while pushed	Empties cotton from all tubes by running four consecutive fill cycles without feeding cotton. Remove bottle from filling station before using this function

INDICATOR LIGHTS

The lighted indicators on the upper right side of the Operator Panel work as follows:

Label	Cause	Reaction	Solution
Right Tube Empty	Cotton not present in right-hand tube	Stops automatic operation	Turn Auto Cycle off & find cause. Then press Manual Cycle to fill tube. Press Auto Cycle to resume automatic operation. Catch unfilled bottle & recycle.
Downline Bottle Backup	Bottles backed- up downline	Stops automatic operation	Operation resumes automatically when downline backup clears. Prevents jams when next process downline is stopped.

SECTION II: INSTALLATION AND SET-UP

INSTALLATION

1. Connect electric (110 VAC 7A) and compressed air line. Adjust air pressure to **80 PSI**.

SET-UP

(See drawing no. TN 0056)

1. Switch on **Main Power** (in back). Cooling fan will start running. Small **indicator light** on front panel will light.
2. Set **Cotton Stop** fully to right end of Cotton Shelf.
3. Place clear **Guard Panel** in lowered position.
4. Press **Start** button. **Operator Panel** will light up. **Turret** finds home position.
5. Press **Clear All Tubes** pushbutton. All four tubes will be cycled to remove any stray cotton pieces.
6. Using the **Operator Panel** (see section I), set values for:
 - a. **Cotton Length** in inches
 - b. **Pieces Per Bottle**
 - c. **Bottle Release Time** in seconds
 - c. **Insertion Dwell Time** in seconds
7. Load cotton:
 - a. Raise **Guard Panel** .
 - b. Use one, two or three **Cotton Guide** loops as needed.
 - c. Raise upper roller of left set of **Pinch Rollers** by lifting end of roller by hand.
 - d. Place cotton so end is between upper and lower roller to trap cotton.
 - e. Lower **Guard Panel**.
8. Press **Manual** pushbutton once. The cotton will feed through the right set of rollers and a piece of random length will be produced.
9. Raise the **Guard Panel** and remove the first piece of cotton. Lower the **Guard Panel**.
10. Press **Manual** pushbutton again. The second piece produced is the exact length that will be repeated each time.

11. Raise the guard and adjust the **Cotton Stop** from right to left to just barely touch end of cotton piece.

12. Adjust the **Turret** left or right to center on the length of the cotton piece by turning the **Turret Adjusting Wheel** on the right side of machine (turn clockwise to move turret to right). Numbers on scale on front of **Cotton Shelf** show correct turret position relative to **Cotton Length** setting.

13. Press **Manual** pushbutton twice. This will result in cotton loading into the front tube and the right-hand tube.

14. Start conveyor. Set conveyor speed. Place bottles on conveyor.

15. Adjust height of machine using handle on front of **Lift Platform**.

16. Press **Rod Extend** pushbutton and adjust the position of **Bottle Stop 1** (filling station). Press **Rod Extend** pushbutton again to release. Adjust **Bottle Stop 2** (release distance) to a position one bottle width downstream for Stop 1.

17. Adjust **Bottle Sensor** (starts fill action) to detect the bottle at **Stop 1 or any bottle to the left or upstream**. Adjust **Backup Sensor** (stops action) to detect bottles backing up from the right or downstream direction (already filled with cotton).

18. Press **Auto Insert** pushbutton to begin automatic operation.

SECTION III: SPECIFICATIONS

Product size range

Continuous coil, cotton or synthetic 6 to 20 gram, low density.

Max. Continuous Speed
(Revised 3/99)

Length Setting

Rate per min.

2	88
3	84
4	80
5	76
6	72
7	68
8	64
9	60

Electrical

Voltage

115 VAC 60 Hz

Current

7A (inrush)
5A (continuous)

Fuses

Main

7A SloBlo (313)

24 VDC Power supply

5A SloBlo (313)

5 VDC

1A (312)

Size (without Lift Platform)

Inches: 26.5 W x 23 D x 24.5 H

Centimeters: 68 W x 59 D x 63 H

Weight (without Lift Platform)

150 lb.

68 Kg

SECTION IV: OPTIONS AND MAINTENANCE ITEMS (prices as of 11/02)

Options

AD1029	CS1 Secondary Tamper Assembly
AD1035	Cotton Box Cover Assembly (center draw, no breaks)

Maintenance Items

(also see Preventative Maintenance document in Section 10 Technical Documents)

Insertion Air Cylinder life expectancy varies widely with each installation, usually due to air supply quality (oil, water). Insertion Air Cylinders may be returned to the factory to be rebuilt, at no charge other than shipping costs for the 2-year warranty period (from date of machine purchase) and for a small charge of \$25 thereafter. Swapping out a complete assembly will take 10 minutes each. Swapping out the cylinder only and wiper will take up to 30 minutes each (requires complete disassembly). You may also purchase the seal kit to do-it-yourself, but we are not responsible for the quality of your work.

Assemblies

AD1034-1F	CS1 Upper Air Cylinder Assembly
AD1034-2F	CS1 Lower Air Cylinder Assembly
AD1071	CS1 Rebuild Parts Kit (1) FM3283F, (2) P0156, (1) P0157

Parts Only

P0158	CS1 Upper Air Cylinder ONLY (Also purchase one P0157)
FMA3044-1	CS1 Lower Air Cylinder ONLY (Also purchase one P0157)
FM3283F	Cylinder Internal Seal Set
P0157	Air Cylinder Rod Wiper (1 per cylinder ass'y)
P0156	Brass Air Fitting 10-32 to 1/4" Tube

SECTION V: TECHNICAL NOTES/DRAWINGS

(documents follow after last page)

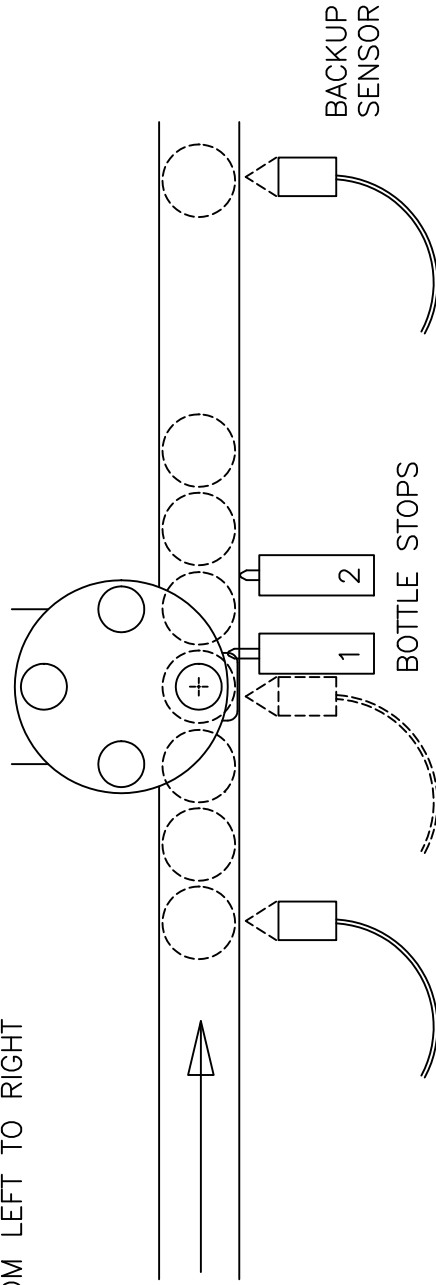
1. **TN0056 pg 1 of 2** **Downstream gating set-up, conveyor moving L to R (normal), PLC v 4.0 and up.**
2. **TN 0056 pg 2 of 2** **Downstream gating set-up, conveyor moving R to L (unusual), PLC v 4.0 and up.**
3. **TN 0053 pg 1 of 2** **Downstream gating set-up, with optional tamper unit installed, conveyor moving L to R (normal), PLC v 4.0 and up.**
4. **TN 0053 pg 2 of 2** **Downstream gating set-up, with optional tamper unit installed, conveyor moving R to L (unusual), PLC v 4.0 and up.**
5. **SC 1003 (7 pgs)** **Electrical schematic (wiring diagram)**
6. **SC 1013 (4 pgs)** **Pneumatic schematic (air line diagram)**
7. **AD1086-PARTS** **Parts List: Wear, Spare and Service Parts**
8. **AD0994_CCD** **Contact Compliance Document**
9. **AD0994_PM** **Preventative Maintenance Document**

NOTE	REV	DESCRIPTION	DATE
-	-	-	-

REVISION
A

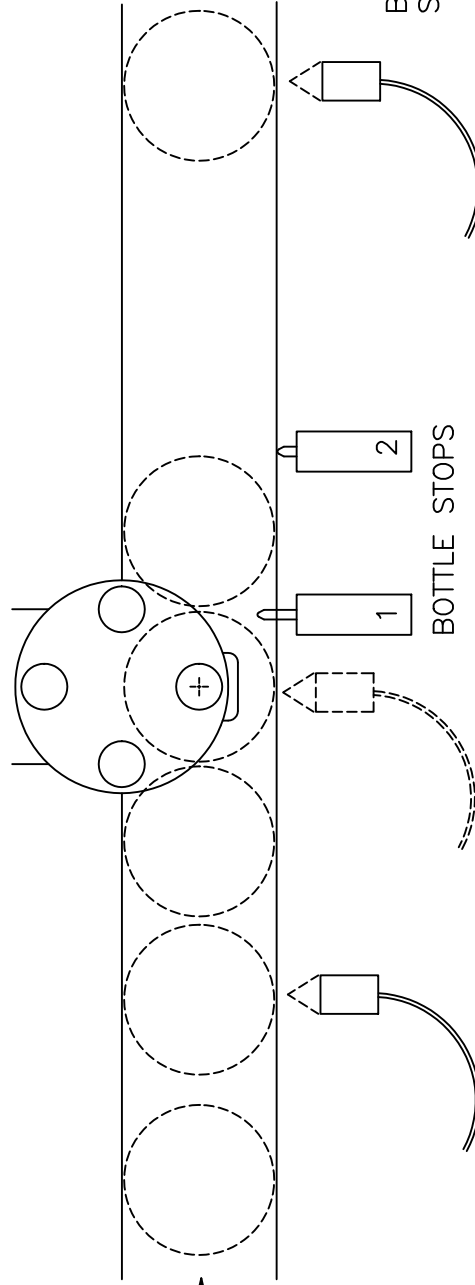
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CONVEYOR MOVING FROM LEFT TO RIGHT



SMALL BOTTLES

BOTTLE SENSOR HERE... ... OR HERE*



LARGE BOTTLES

BOTTLE SENSOR HERE... ... OR HERE*

*BOTTLE SENSOR MAY BE FOCUSED ON BOTTLE BEING FILLED OR ANY BOTTLE UPSTREAM OF THAT ONE (MUST BE CENTERED).

FOR ALL BOTTLES SIZES, THE DISTANCE BETWEEN EACH BOTTLE STOP IS ALWAYS EQUAL TO ONE BOTTLE WIDTH.

PRODUCT	CS1 WITHOUT TAMPER OPTION	BY	SJD2	DATE:	11/11/02
TITLE	HOW TO SET-UP BOTTLE STOPS AND BOTTLE & BACKUP SENSORS	SHEET	1	OF	2
TECHNICAL DRAWING -- PRODUCT INFO		NUMBER	TN 0056	REVISION	A

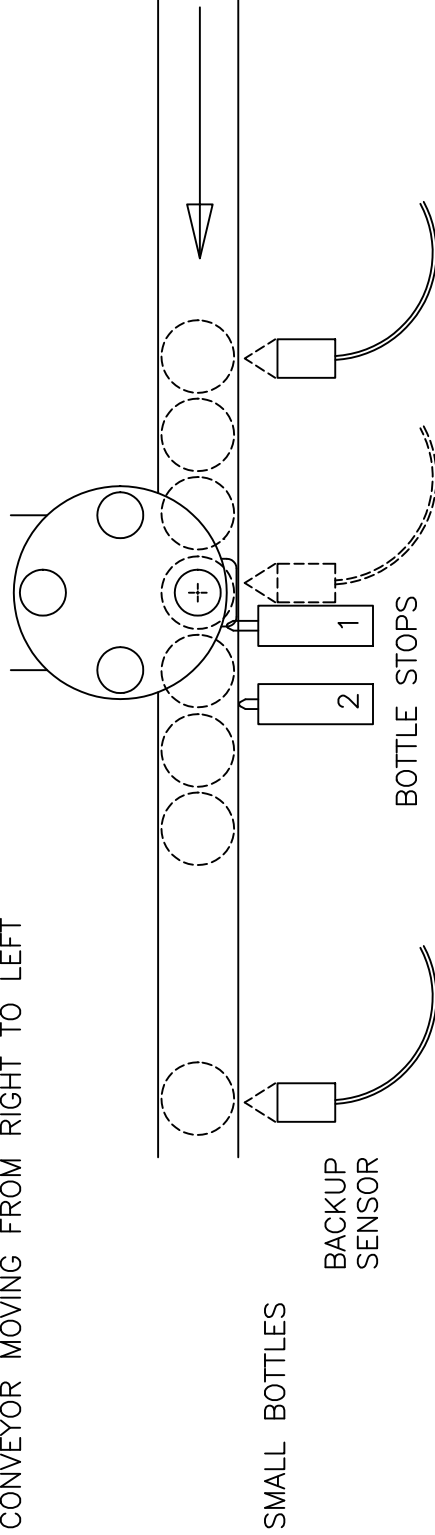
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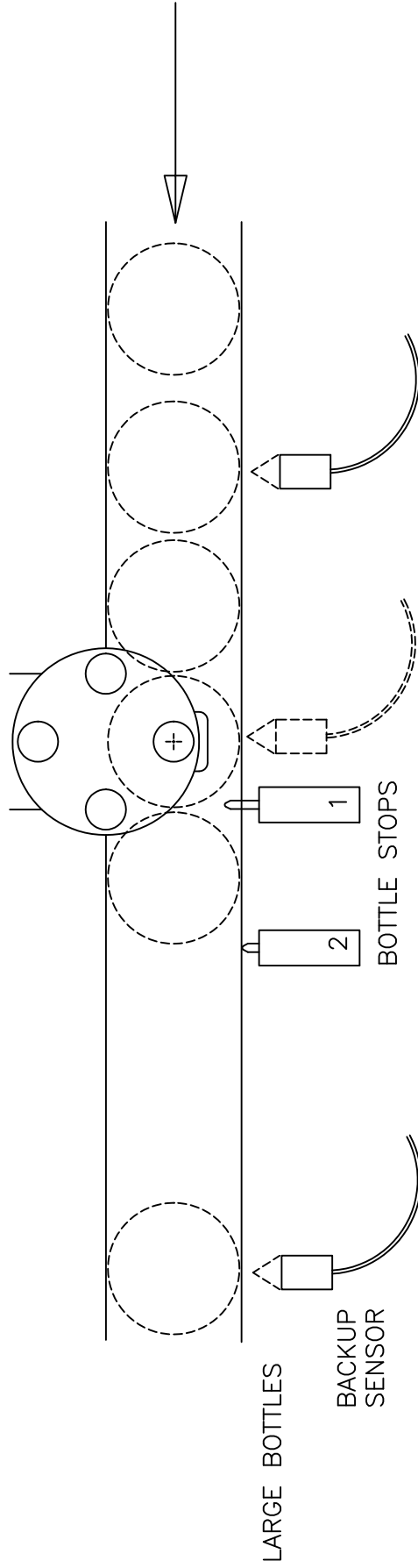
NOTE	REV	DESCRIPTION	DATE
-	-	-	-
REVISION			A

NUMBER: TN 0056

CONVEYOR MOVING FROM RIGHT TO LEFT



BOTTLE SENSOR HERE... ... OR HERE*



BOTTLE SENSOR HERE... ... OR HERE*

FOR ALL BOTTLE SIZES, THE DISTANCE BETWEEN EACH BOTTLE STOP IS ALWAYS EQUAL TO ONE BOTTLE WIDTH.

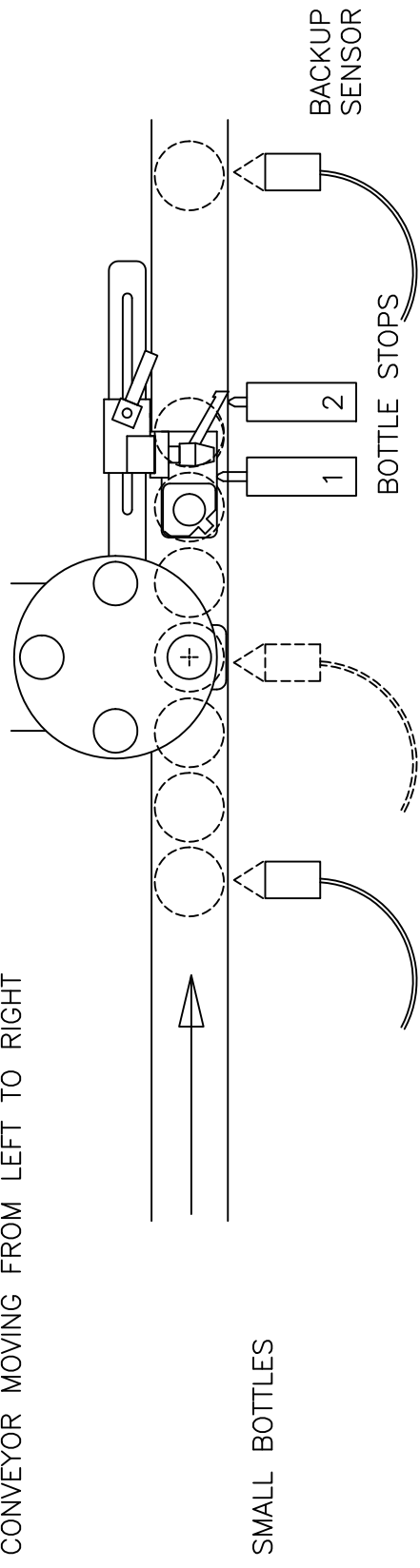
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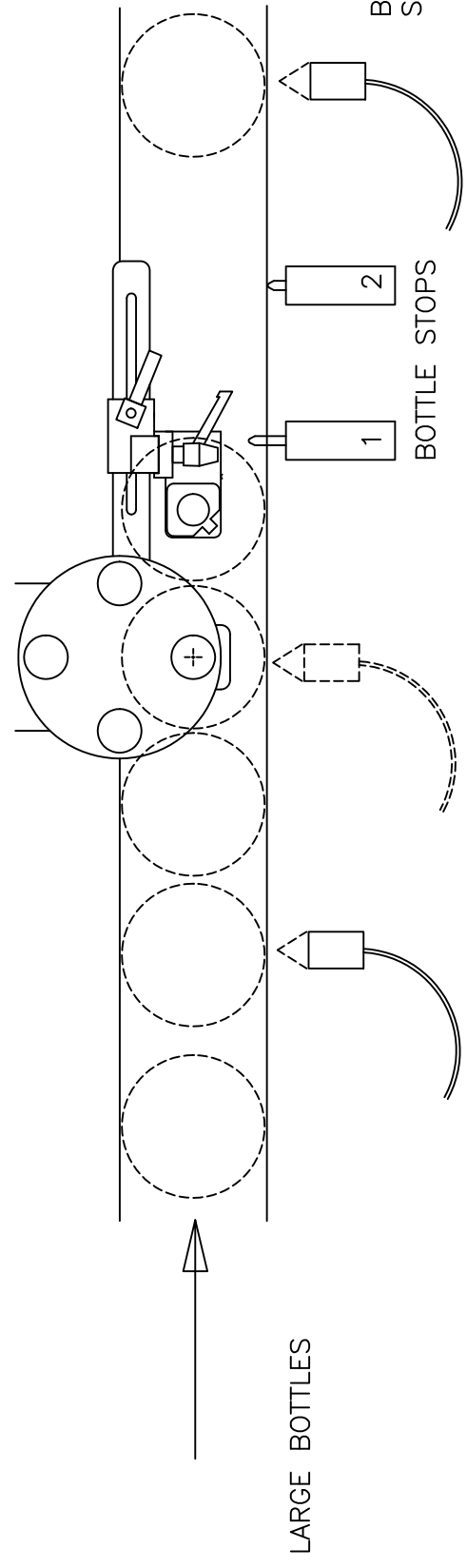
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TECHNICAL DRAWING -- PRODUCT INFO			NUMBER	TN 0056	REVISION
					A

CONVEYOR MOVING FROM LEFT TO RIGHT



BOTTLE SENSOR HERE... ... OR HERE*



BOTTLE SENSOR HERE... ... OR HERE*

*BOTTLE SENSOR MAY BE FOCUSED ON BOTTLE BEING FILLED OR ANY BOTTLE UPSTREAM OF THAT ONE (MUST BE CENTERED).

FOR ALL BOTTLES SIZES, THE DISTANCE BETWEEN EACH BOTTLE STOP IS ALWAYS EQUAL TO ONE BOTTLE WIDTH.

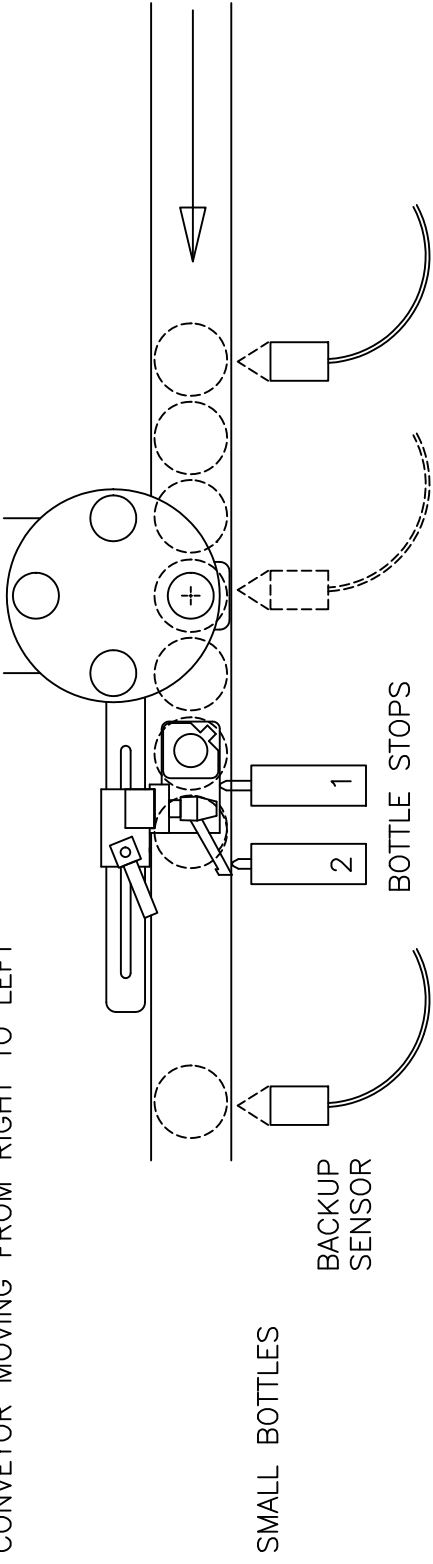
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	<p>TITLE HOW TO SET-UP BOTTLE STOPS AND BOTTLE & BACKUP SENSORS</p>	<p>SHEET 1 OF 2</p>	<p>NUMBER TN 0053</p>

NOTE	REV	DESCRIPTION	DATE
-	A	REDUCED FROM FOUR TO TWO BOTTLE STOPS	10/19/01
-	B	ADDED RIGHT-TO-LEFT VERSION	11/11/02

NUMBER: TN 0053

REVISION B

CONVEYOR MOVING FROM RIGHT TO LEFT

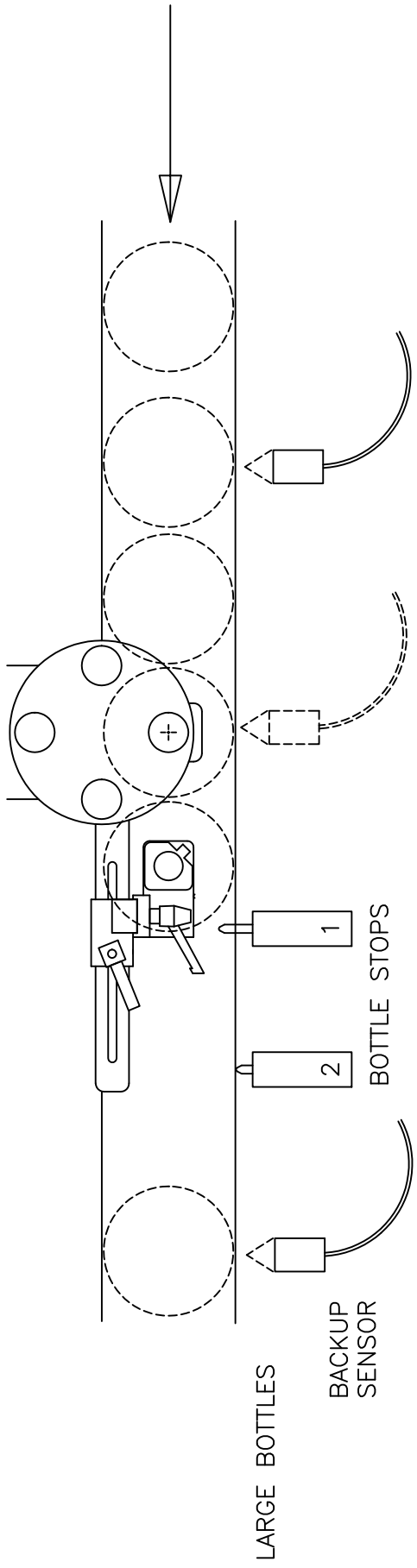


SMALL BOTTLES

BACKUP SENSOR

BOTTLE STOPS

BOTTLE SENSOR HERE... ... OR HERE*



LARGE BOTTLES

BACKUP SENSOR

BOTTLE STOPS

BOTTLE SENSOR HERE... ... OR HERE*

FOR ALL BOTTLES SIZES, THE DISTANCE BETWEEN EACH BOTTLE STOP IS ALWAYS EQUAL TO ONE BOTTLE WIDTH.

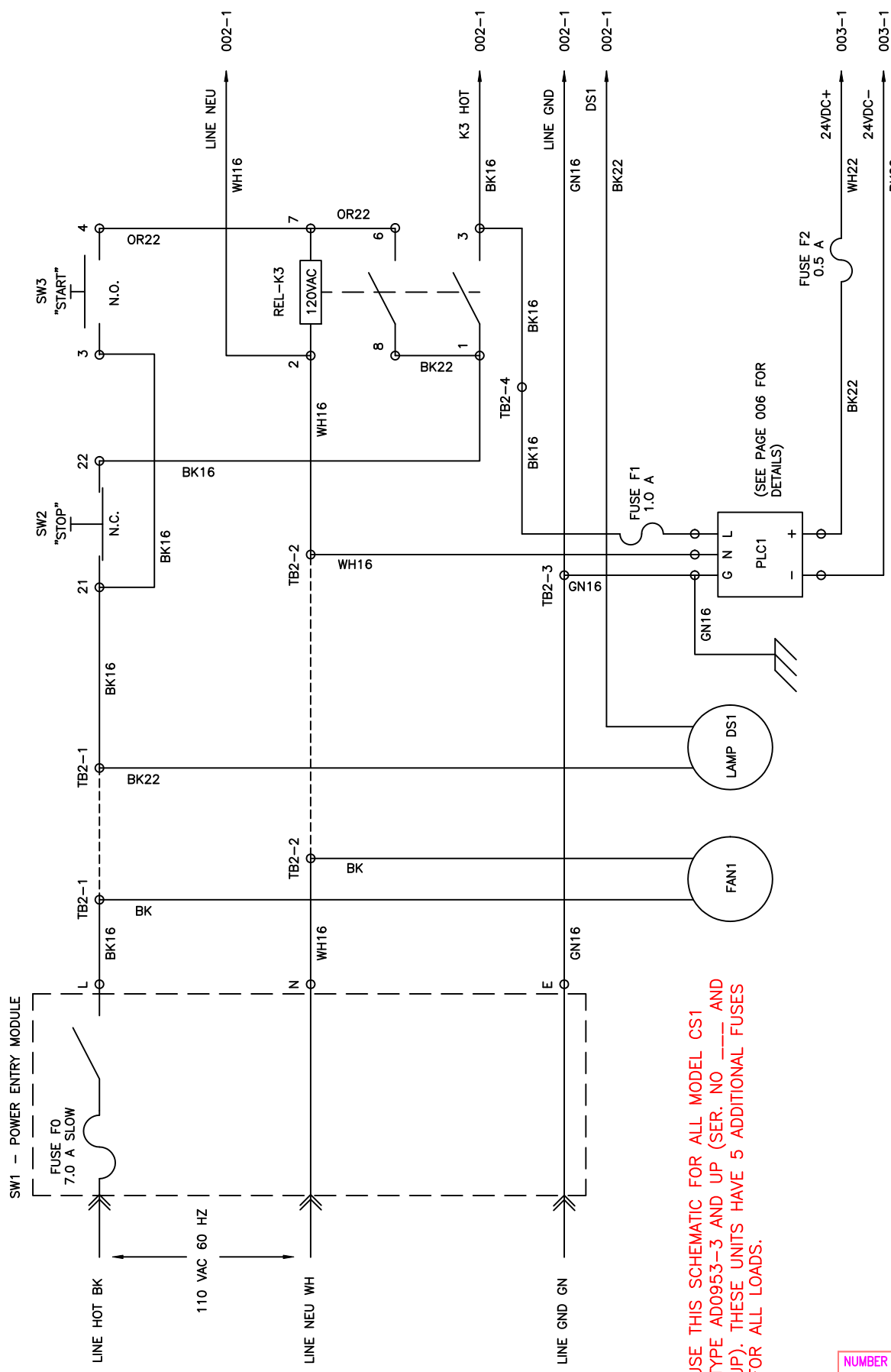
*BOTTLE SENSOR MAY BE FOCUSED ON BOTTLE BEING FILLED OR ANY BOTTLE UPSTREAM OF THAT ONE (MUST BE CENTERED).

NUMBER: TN 0053

REVISION B

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			NUMBER	TN 0053	REVISION	B

1	2	3	4	5	6	7	8	9	0		
				<p><u>PG</u> <u>CONTENTS</u></p> <p>0. NOTES AND REVISIONS</p> <p>1. MAIN POWER</p> <p>2. TURRET MOTOR</p> <p>3. BRAKE/CLUTCH, ROLLER MOTOR</p> <p>4. INTERFACE, INPUTS</p> <p>5. VALVE OUTPUTS</p> <p>6. PLC DETAILS</p> <p>7. TURRET DRIVE DETAILS</p>			<p><u>SYMBOL</u> <u>KEY</u></p> <p>+24VDC → 004-1 → PAGE REFERENCE</p> <p>----- → JUMPED TERMINALS</p> <p>==== → INTERFACE CABLE</p> <p>⋈ → MULTI-PIN CONNECTOR (MOLDED)</p> <p>⋈ → MULTI-PIN CONNECTOR (SOLDERED)</p>				
				<p>DEITZ COMPANY, INC. ROUTE 34, WALL, N.J. TECHNICAL DRAWING - PRODUCT INFO</p>			<p>SECTION NOTES AND REVISIONS</p> <p>TITLE CS1 COTTONER SCHEMATIC</p> <p>SER. NO. 252 AND UP</p>			<p>BY: SJD2 DATE: 12/02/02</p> <p>SHEET 000 OF 007</p> <p>NUMBER SC1003 REVISION B</p>	
				<p>FUSE "FO" WAS "F1", ADDED FUSES F1-F5 ADDED PAGE 0 (THIS PAGE) 2008-08-08</p>			<p>ADDED GENERAL INFO PAGE CORRECTED PG. 7 PLC-Y0 & -COM 12/31/02</p>				
				<p>NOTE DESCRIPTION DATE</p>							
<p>NUMBER PAGE</p> <p>SC1003 000</p>											



USE THIS SCHEMATIC FOR ALL MODEL CS1 TYPE AD0953-3 AND UP (SER. NO ---- AND UP). THESE UNITS HAVE 5 ADDITIONAL FUSES FOR ALL LOADS.

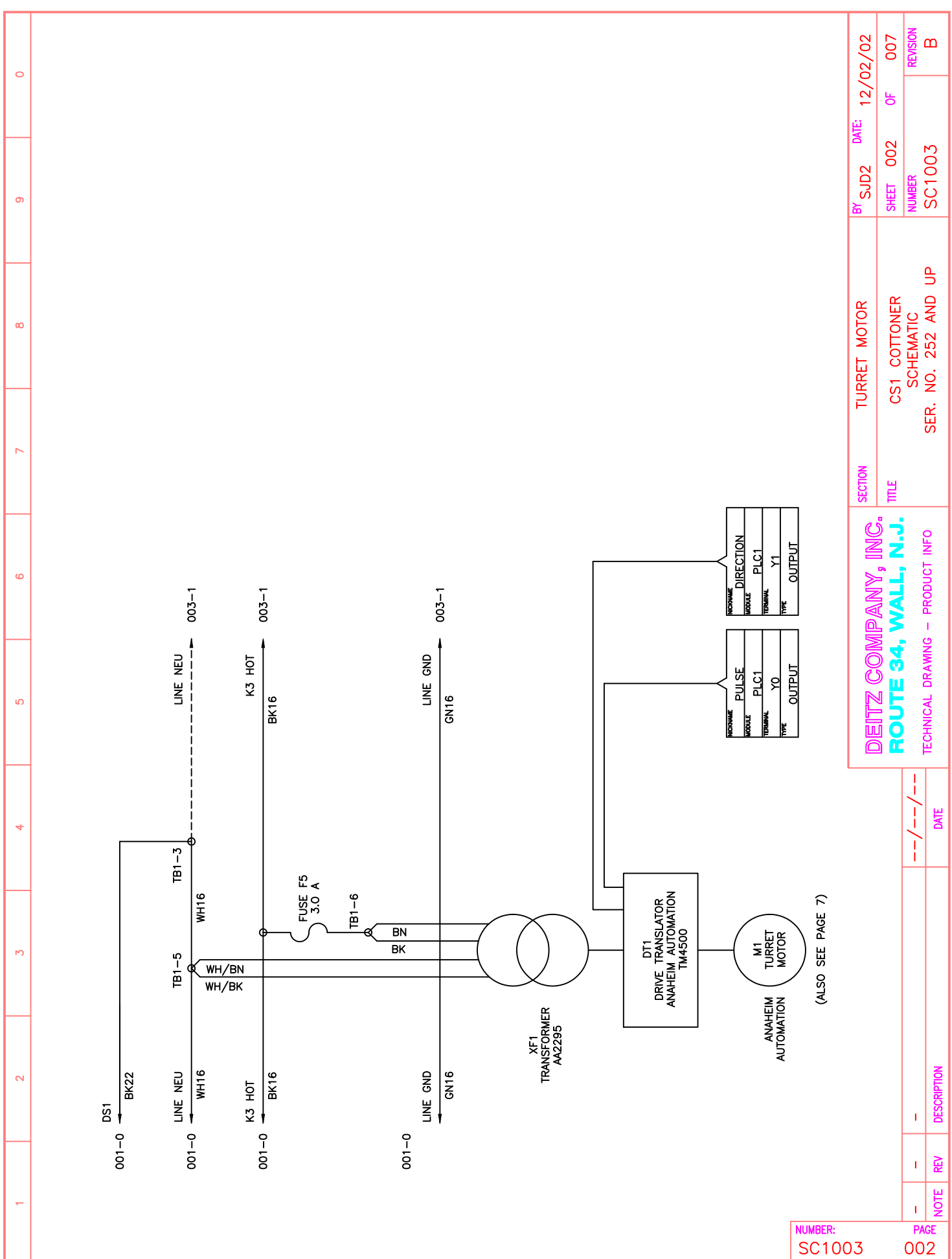
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DEITZ COMPANY, INC.
ROUTE 34, WALL, N.J.
 TECHNICAL DRAWING - PRODUCT INFO

SECTION: MAIN POWER
 TITLE: CS1 COTTONER SCHEMATIC
 SER. NO. 252 AND UP

BY: SJD2 DATE: 12/02/02
 SHEET 001 OF 007
 NUMBER SC1003 REVISION B

NOTE	REV	DESCRIPTION	DATE
-	-	-	---/---/---



NUMBER: SC1003 PAGE 002

BY SJD2 DATE: 12/02/02

SECTION TURRET MOTOR

TITLE CS1 COTTONER SCHEMATIC

SHEET 002 OF 007

NUMBER SC1003

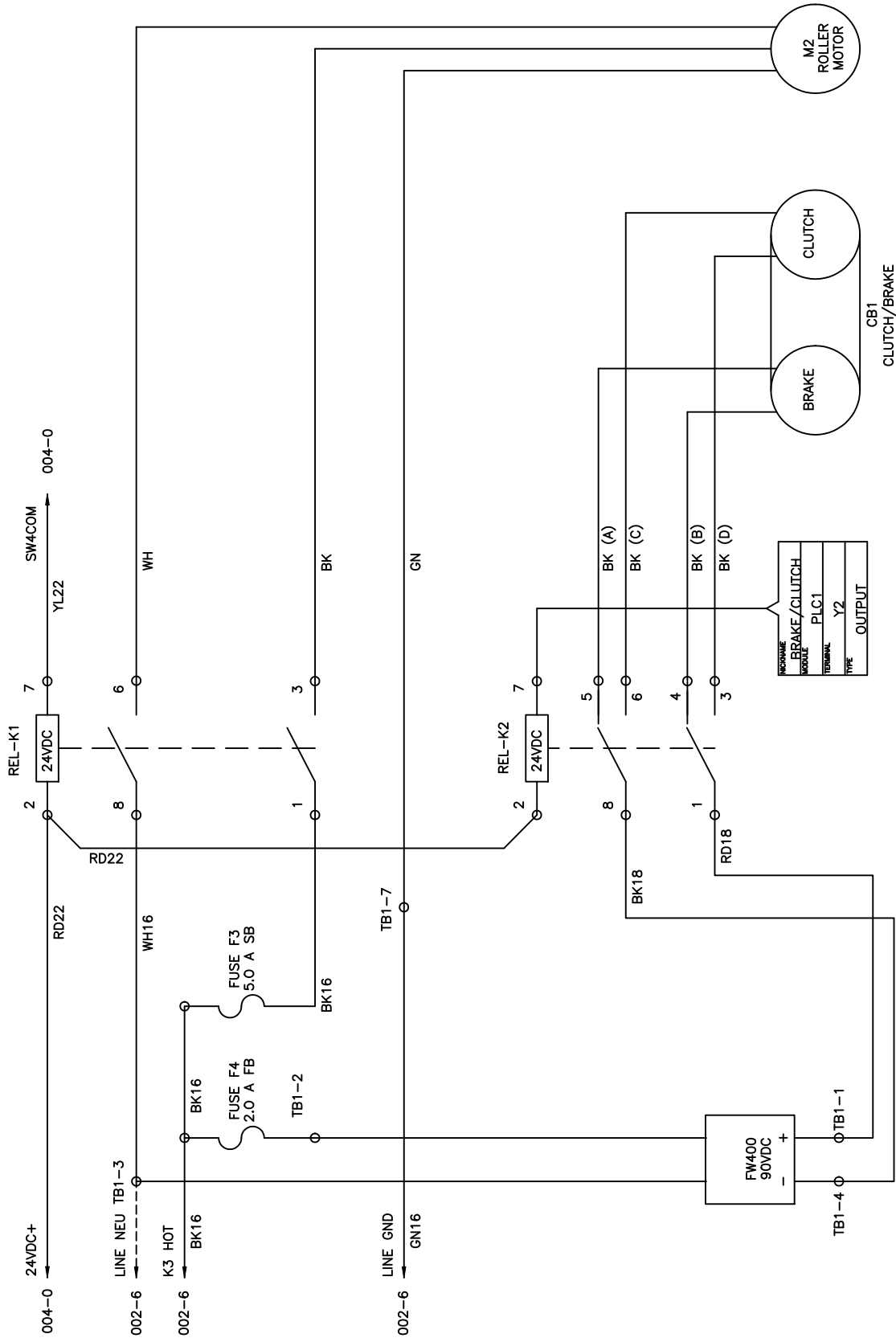
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SER. NO. 252 AND UP

DEITZ COMPANY, INC.
ROUTE 34, WALL, N.J.

TECHNICAL DRAWING - PRODUCT INFO

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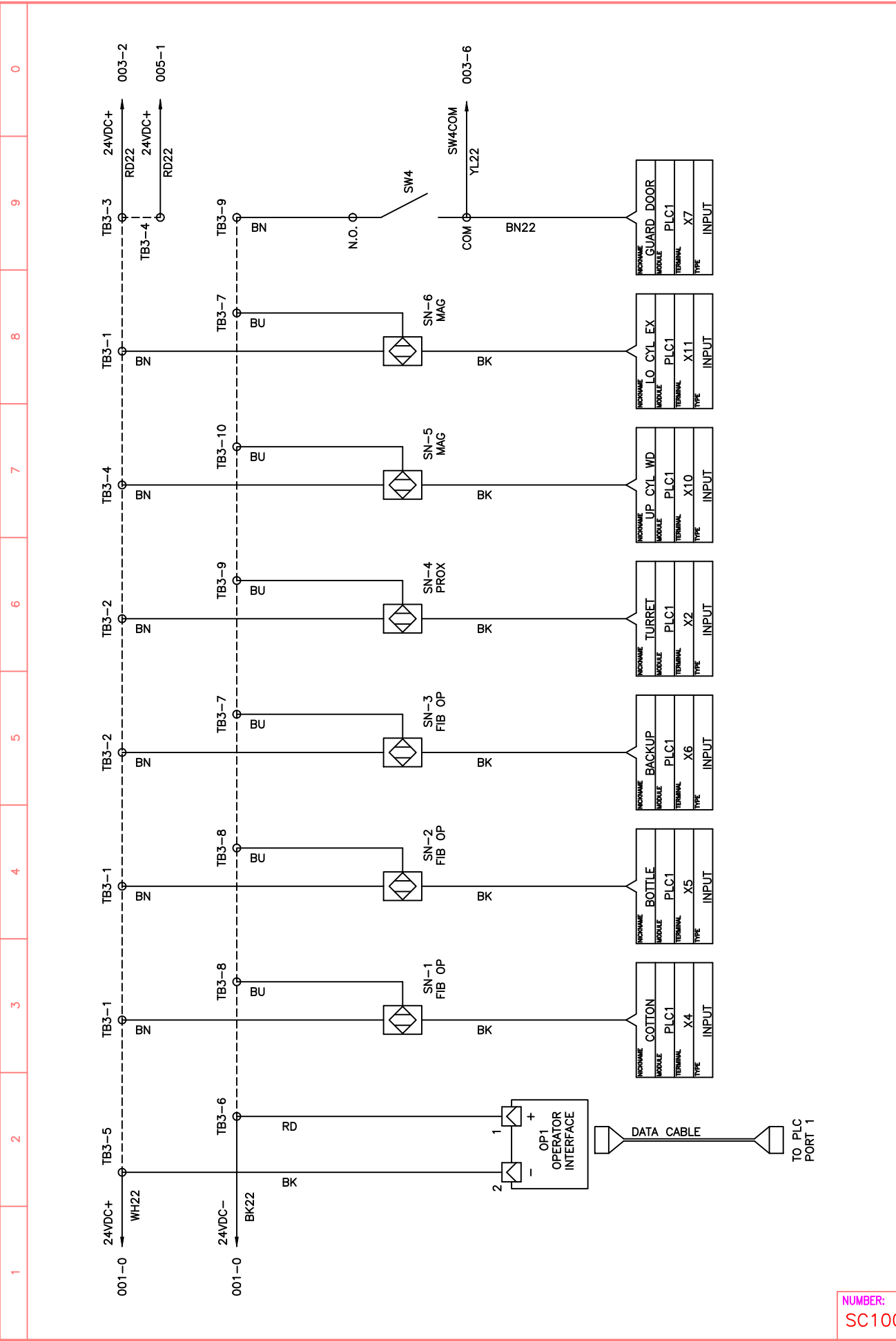


SECTION
BRAKE/CLUTCH, ROLLER MOTOR

TITLE
**CS1 COTTONER
 SCHEMATIC**

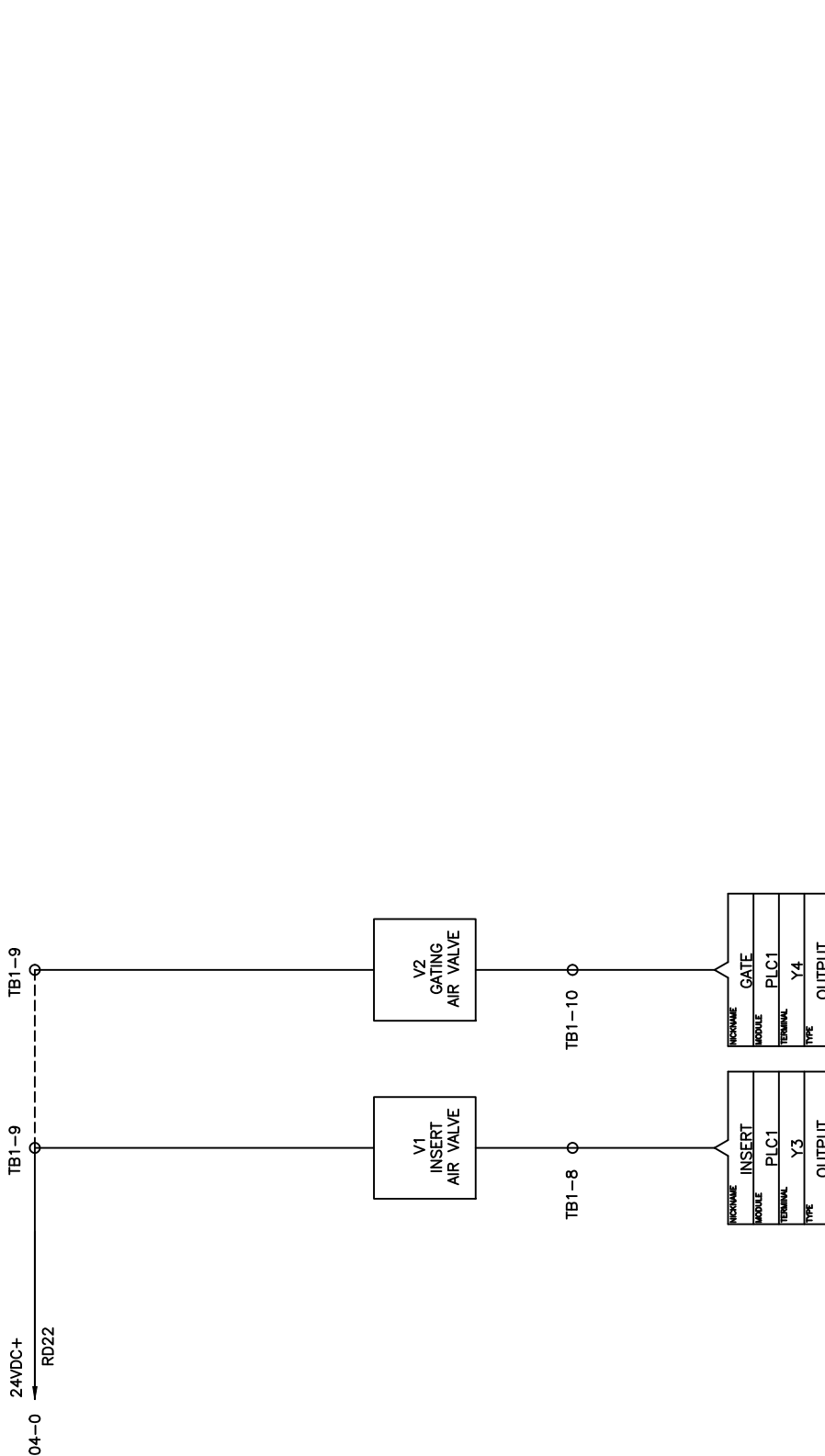
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**DEITZ COMPANY, INC.
 ROUTE 34, WALL, N.J.**

NOTE	REV	DESCRIPTION	DATE
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DEITZ COMPANY, INC.	<p>ROUTE 34, WALL, N.J.</p> <p>SER. NO. 252 AND UP</p>								
NOTE	REV	DESCRIPTION	DATE						

<p>NUMBER: SC1003 PAGE: 004</p>									



NUMBER: SC1003 PAGE 005

NOTE	REV	DESCRIPTION	DATE
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DEITZ COMPANY, INC.
ROUTE 34, WALL, N.J.
 TECHNICAL DRAWING - PRODUCT INFO

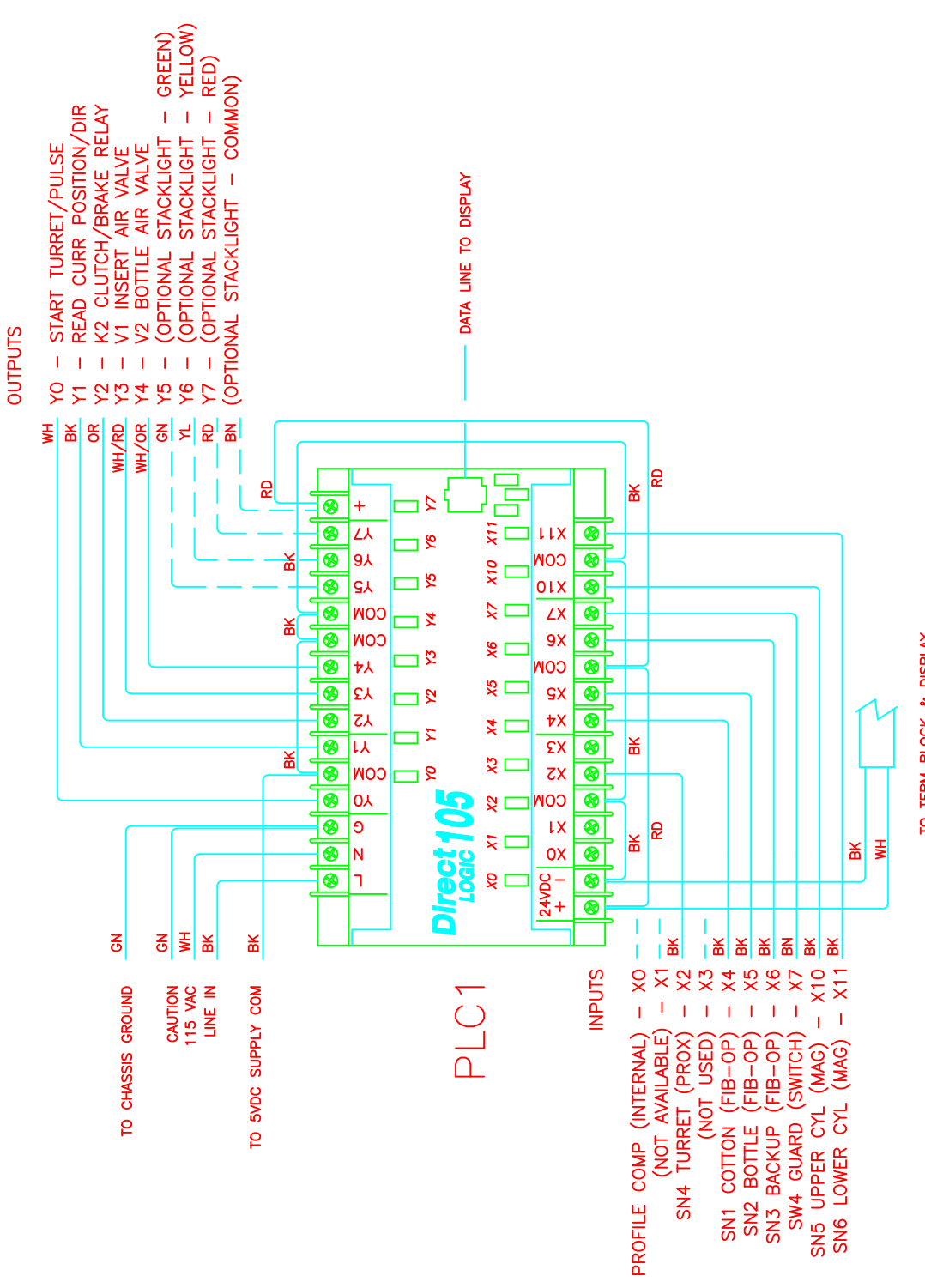
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BY: SJD2 DATE: 12/02/02

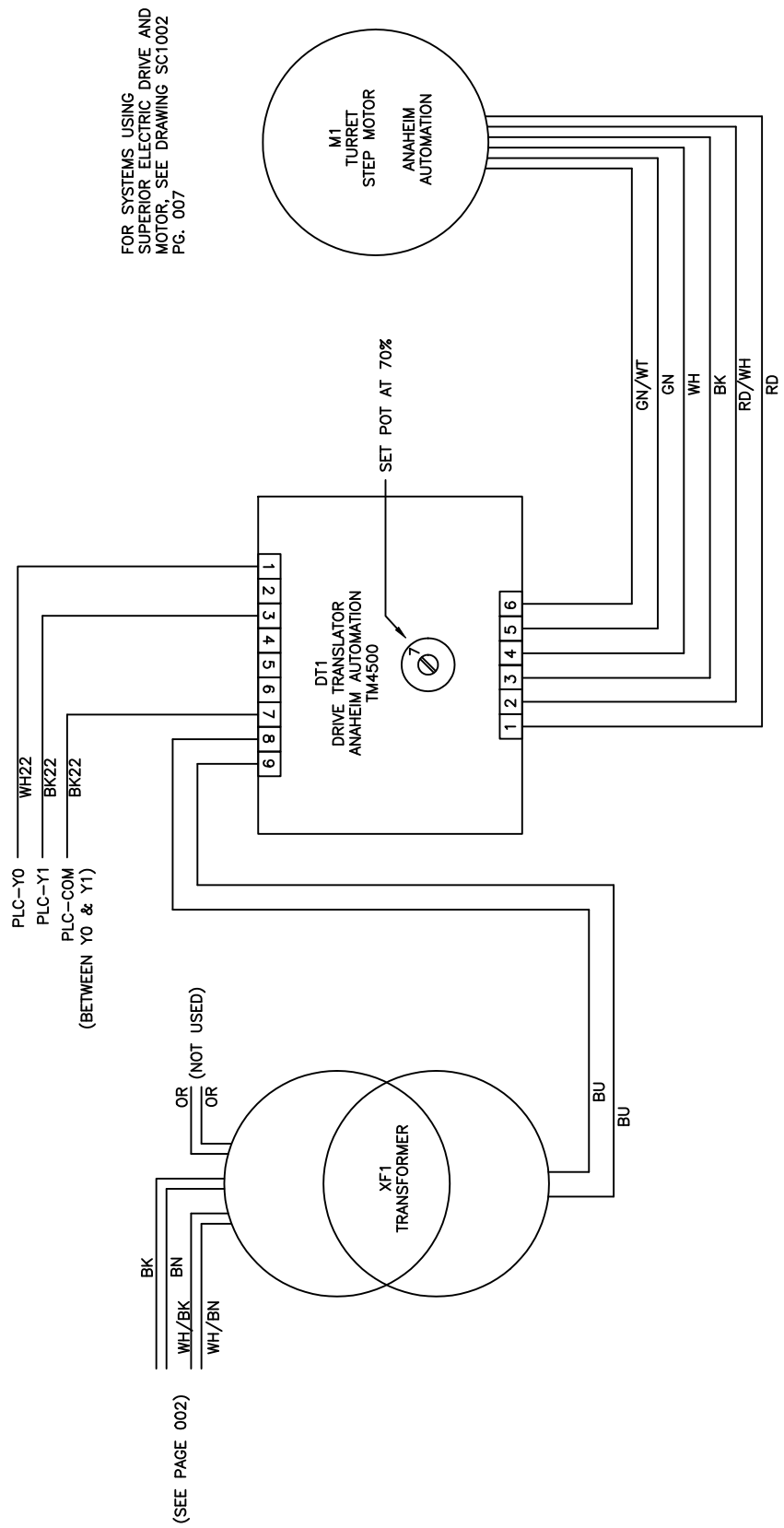
SHEET 005 OF 007

NUMBER SC1003 REVISION B



ALSO SEE PAGE 005

BY SJD2		DATE: 2005-02-17
SHEET 006		OF 007
NUMBER SC1003		REVISION B
SECTION	PLC DETAILS	
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SER. NO. 252 AND UP		
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NOTE	REV	DESCRIPTION
		DATE
NUMBER: SC1003		PAGE 006



NUMBER: SC1003
PAGE: 007

BY SJD2		DATE: 12/02/02	
SECTION: TURRET DRIVE DETAILS		SHEET 007 OF 007	
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SER. NO. 252 AND UP		REVISION: B	

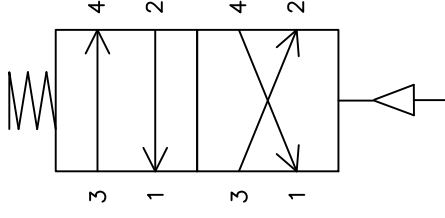
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ROUTE 34, WALL, N.J.		DATE: ---/---/---	
NOTE	REV	DESCRIPTION	
-	-	-	

CONTENTS

- 1. NOTES AND REVISIONS
- 2. INLET/CONTROL VALVES
- 3. AIR CYLS: INSERT/PINCH/TAMP
- 4. AIR CYLS: GATING

NOTES

TYPICAL AIR VALVE
4 PORT/2 POSITION
24 VDC



DEITZ COMPANY, INC.
ROUTE 34, WALL, N.J.

TECHNICAL DRAWING - PRODUCT INFO

SECTION

TITLE

NOTE AND REVISIONS

MODEL CS1 COTTONER
AIR LINE SCHEMATIC
FROM SERIAL NO. 001

BY SJD2

DATE: 5-23-03

SHEET

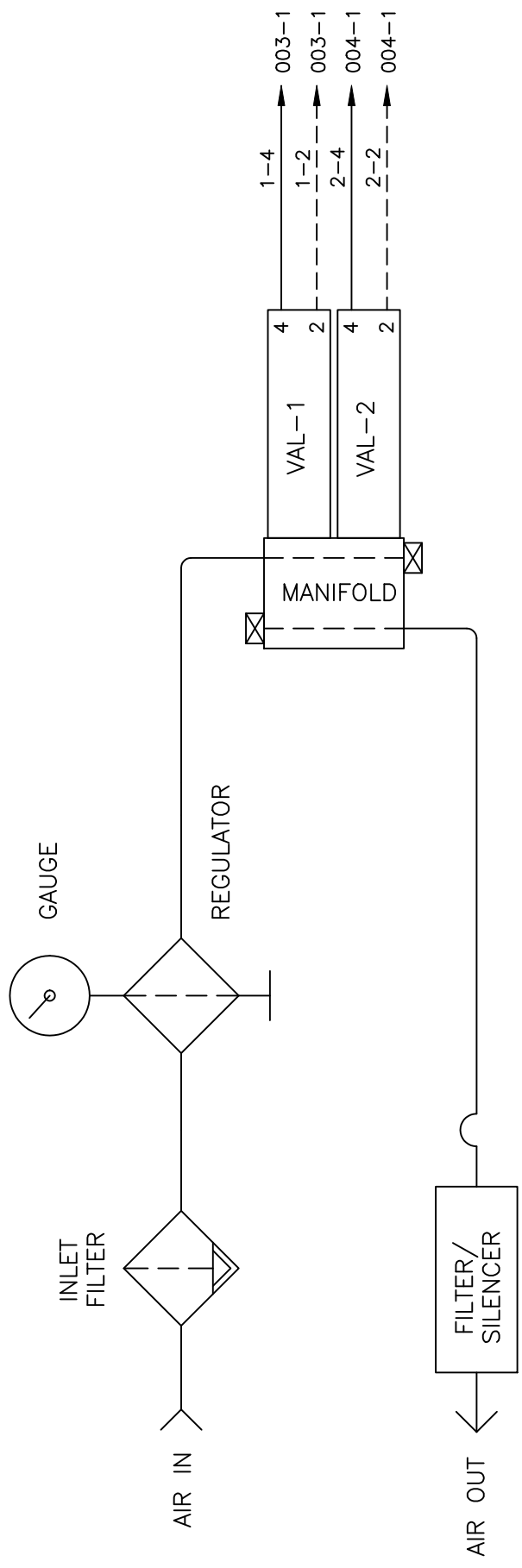
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NUMBER

SC1013

REVISION

-



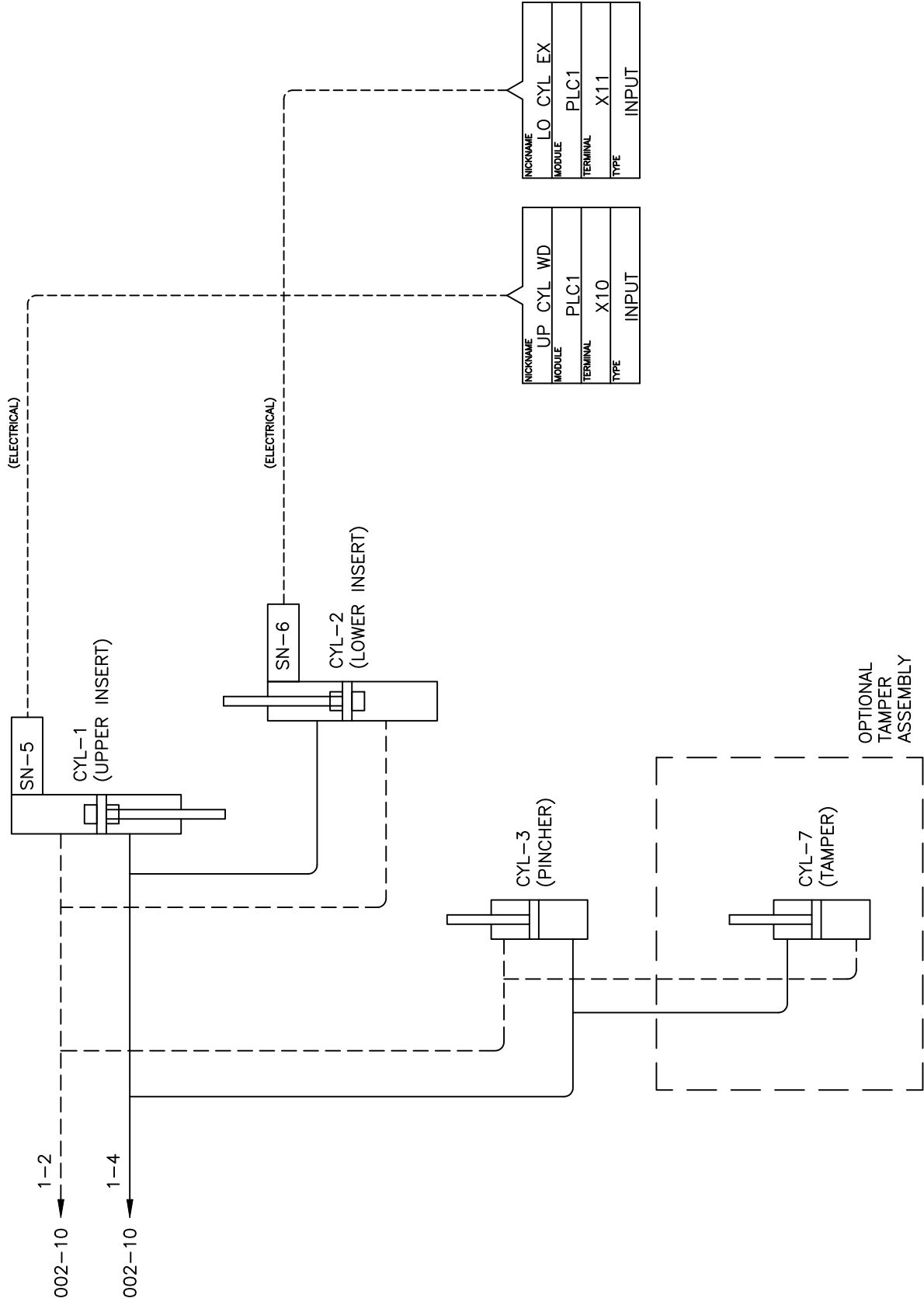
DEITZ COMPANY, INC.
ROUTE 34, WALL, N.J.

TECHNICAL DRAWING - PRODUCT INFO

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 INLET/CONTROL VALVES
 MODEL CS1 COTTONER
 AIR LINE SCHEMATIC
 FROM SERIAL NO. 001

BY SJD2 DATE: 5-23-03
 SHEET 002 OF 004
 NUMBER SC1013 REVISION -

NOTE	REV	DESCRIPTION	DATE
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002-10 1-2

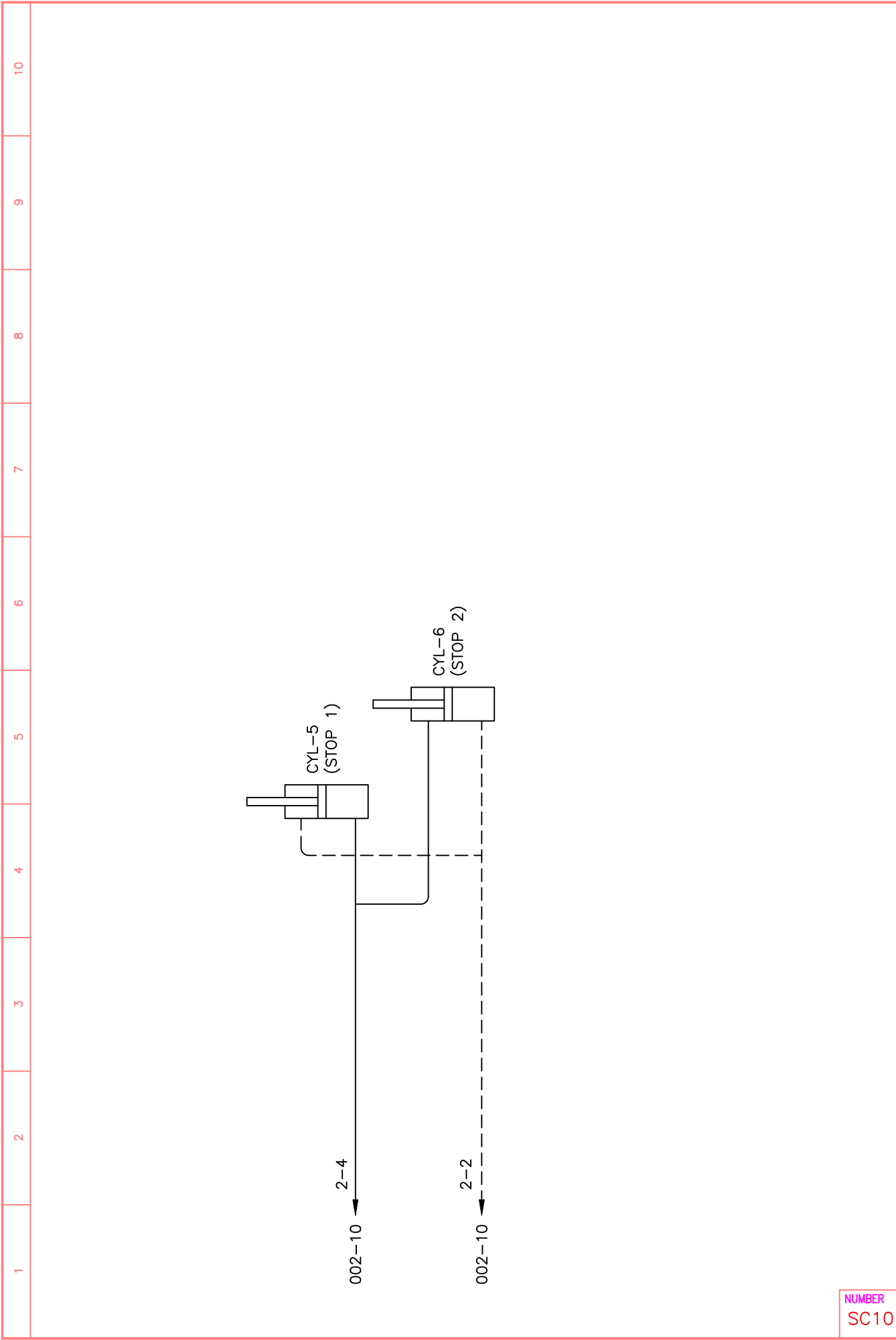
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DEITZ COMPANY, INC.
ROUTE 34, WALL, N.J.
 TECHNICAL DRAWING - PRODUCT INFO

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 TITLE MODEL CS1 COTTONER
 AIR LINE SCHEMATIC
 FROM SERIAL NO. 001

BY SJD2 DATE: 5-23-03
 SHEET 003 OF 004
 NUMBER SC1013 REVISION -

NOTE	REV	DESCRIPTION	DATE
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NUMBER
SC1013

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NOTE	REV	DESCRIPTION
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DATE

DEITZ COMPANY, INC.
ROUTE 34, WALL, N.J.

TECHNICAL DRAWING - PRODUCT INFO

SECTION TITLE
AIR CYLS: GATING/ROLLERS
MODEL CS1 COTTONER
AIR LINE SCHEMATIC
FROM SERIAL NO. 001

BY SJD2
DATE: 5-23-03
SHEET NUMBER
004 OF 004
SC1013
REVISION
-

Deitz Company Inc. - Price List**Effective Date: October 6, 2008**

<u>Part Number</u>	<u>Description Line 1</u>	<u>Price</u>
<u>AD1086-1 CS1 Wear Parts Kit</u>		
AD1071	CS1 Air Cyl Rebuild Parts Kit	\$40.00
AD1085-1	CS1 Spare Fuse Kit	\$8.00
FM3049-2	CS1/2/10 Air Filter Element	\$7.00
FMA3044-1	CS1 Lower Air Cyl Mod	\$220.00
P0158-7	Air Cyl CS1/CS2 7" Stroke	\$100.00
P5816	Relay, DPST 24VDC	\$23.00
Total price for this group (above):		\$398.00

AD1086-2 CS1 Critical Spare Parts Kit

AD0991	CS1 Operator Display Unit	\$399.00
FA1014-1	CS1 Pincher Arm Assy LH Inner	\$47.00
FA1014-2	CS1 Pincher Arm Assy RH Outer	\$47.00
FM2978-1	CS1 Cylinder End (Upper)	\$14.00
FM3015-1	CS1,2, &10 Pincher Slide Blk	\$26.00
FM3264F	Air Cylinder Mod's, 1" Stroke	\$89.00
P0141	Air Cyl 1/2 Stroke REVERSE ACT	\$52.00
P0142	AIR VALVE 4 WAY 24VDC 1/4 TUB	\$108.00
P0160	Air Cyl Auto-Sw, w/Led	\$117.00
P0414	Belt, Gear 90XL037(URETHANE)	\$8.00
P1807	Controls PLC CPU 105 Series	\$399.00
P1810	Controls Interconnect Cable	\$33.00
P1822-1	Control Driver	\$279.00
P2736	Flatwasher NYLATRON .262ID X	\$3.00
P5018	Sensor Fib-Op Amplifier	\$176.00
P5814	Relay, DPST 110 VAC	\$23.00
P6501	FULL WAVE RECTIFIER FW400	\$6.00
P6981	Sensor - Proximity Switch PNP	\$184.00
Total price for this group (above):		\$2,010.00

<u>Part Number</u>	<u>Description Line 1</u>	<u>Price</u>
<u>CS2 Service Parts</u>		
FM2987	CS1 Clear Polycarbonate Front	\$79.00
FM3004-2	Stepper Motor Mod's, 2 Stack	\$478.00
FM3283F	CS1 Cylinder Internal Seals	\$14.00
P0109	Air filter/regulator	\$112.00
P0110	Air Filter Bracket & Nut	\$8.00
P0156	BRASS AIR FITTING 10-32 to 1/4	\$8.00
P0157	Air Cylinder Rod Wiper, 5/16	\$14.00
P0308	Bearing, Oilite .50x.62x.50	\$10.00
P1190	Clutch/Brake	\$790.00
P1339	Connector Power Entry Module	\$26.00
P1714	CS1 Vinyl Dust Cover	\$67.00
P1822-3	Transformer - 100 Watt	\$120.00
P2916	Magnetic Latch	\$8.00
P2917	Door Strike, Polished Chrome	\$5.00
P4413	Motor PS Gearhead AC 120 RPM	\$499.00
P6709	Spring Extension .38x1.50L 12.	\$9.00
P6924	Switch PB Blk 22 mm	\$14.00
P6928	Switch Micro Pin Plunger	\$8.00
P6929-1	PB Emer Stop Actuator, Red	\$33.00
P6929-3	PB Emer Sw Contact Block	\$12.00
Total price for this group (above):		\$2,314.00



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PRODUCT COMPLIANCE DATA
Model CS1 Cotton Inserter Type AD0994

FOOD COMPLIANCE STATEMENTS
MATERIALS IN DIRECT CONTACT WITH PRODUCT

Deitz Company Inc hereby certifies that the list below contains all the parts of the above-cited machine that come in direct contact with the product, and that those parts are manufactured using raw materials and surface treatments which conform to the requirements of such parts as established by the Food and Drug Administration of the United States. Certificates of compliance for raw materials and treatments are maintained according to our internal Quality Control System.

CONTACT PARTS, MATERIALS AND TREATMENTS

PART NUMBER	DESCRIPTION	MATERIAL	CERTIFICATION
FM2979	Cotton Guide Loops	Acetal	FDA 21 CFR 177.2480
FM2952	Rollers	INOX AISI 304	ASTM Standard
FM3033	Cotton Shelf Guides	INOX AISI 304	ASTM Standard
FM3014	Pincher Arms	INOX AISI 304	ASTM Standard
FM2973	Cotton Shelf	INOX AISI 304	ASTM Standard
FM3034	Stop Plate	INOX AISI 304	ASTM Standard
FM2978	Insert Cylinder Rod Tip	INOX AISI 303	ASTM Standard
FM2961	Tube Extension	Acetal	FDA 21 CFR 177.2480
FM2951	Turret Tube	Polycarbonate	FDA 21 CFR 177.15803
FM2978	Upper Cylinder Rod Top	Acetal	FDA 21 CFR 177.2480

Legal disclaimer: Deitz Company believes the above information to be truthful, based on information provided to us from our suppliers. However, Deitz Company cannot guarantee the accuracy of the reporting, testing or procedures of our suppliers and assumes no liability or obligation as to the same. Deitz Company also assumes no liability as to the suitability of the above materials to the application for which the customer intends to use the machine. It is the customer's responsibility to assure that the above materials meet the customer's requirements.

This document is submitted only in English language.



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Monthly

1. Pincher Assembly
 - a. Inspect condition of pincher arms, looking for cracks in the bend area. Replace both arms if any cracks are found.
 - b. Check up-and-down free play of pincher arm at pivot screw. If excessive, tighten pivot screws, in small increments and re-inspect. Some free play is necessary for arms to move freely.
 - c. Check open-close free play. If excessive, replace slide block.
 - d. Check that space between pincher arms when closed = ½ inch. Adjust by turning threaded air cylinder rod into or out of slide block.
 - e. Check that locknut on air cylinder rod is tight against slide block
2. Turret Assembly
 - a. By hand, move turret assembly back and forth. Look for freeplay at turret pulley and motor pulley. Tighten as necessary.
 - b. Inspect condition of belt. Replace if necessary.
 - c. Inspect condition of turret tubes for cracking. Replace if necessary.
3. Rollers
 - a. Inspect surfaces for scratched or gouges. Replace if necessary.
4. Guard Door
 - a. Inspect condition of magnetic catches. Replace if necessary.
 - b. Inspect condition and function of safety switch. Replace if necessary.
 - c. Inspect condition of clear panel. Replace if necessary.
5. Miscellaneous
 - a. Clean or replace cooling fan air filter.
 - b. Check all external hardware for tightness.
 - c. Check condition of all external electrical and fiber optic cables for wear or damage. Replace if necessary.

Annually

1. Roller Drive Unit (internal)
 - a. Remove covers and inspect drive unit. Clean internal spaces prior to inspection.
 - b. Inspect condition of belts and chains. Replace if necessary.
 - c. Inspect condition of bearings and shafts in roller pivot block. Replace if necessary.
 - d. Inspect condition of linkage on roller pressure air cylinder. Replace if necessary.
2. Carriage Drive Unit (internal)
 - a. Inspect condition of turret horizontal drive screw. Clean and lubricate screw with a small amount of lithium grease.
 - b. Inspect condition of hand wheel and handle. It should turn easily and turret should move side to side smoothly.