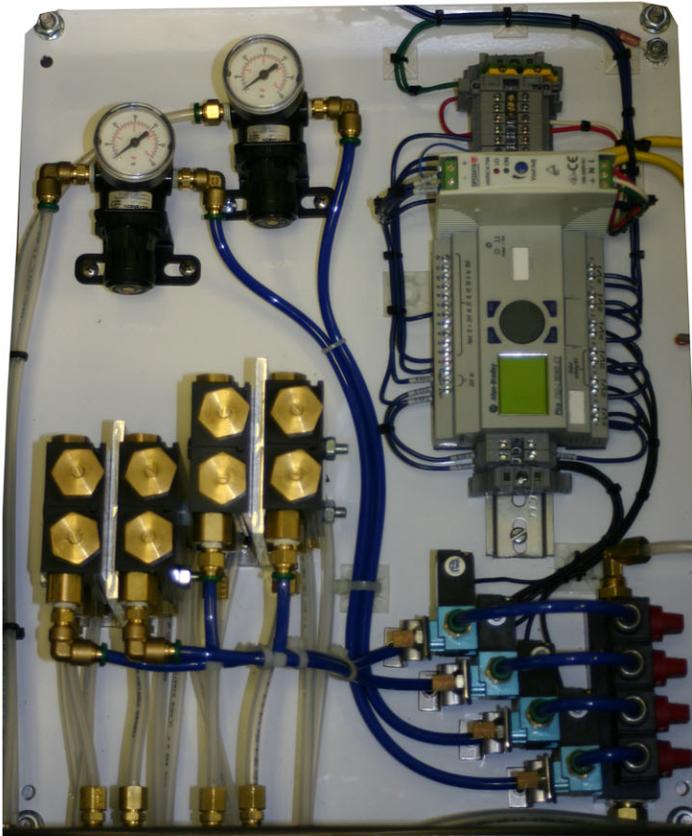


# J-Con Automatic Chain Lubrication System

## SETUP INSTRUCTIONS



### Application

Accurate chain lubrication is crucial for extended life of stainless steel chain specifically on the J-Con System. Follow the Setup Instructions to properly establish lube volumes for the Xact J-Con Lube System.

### Setup:

- Establish Power, Air, and Liquid connections.
- Establish Laser Eye and Nozzle Bracket locations.
- Power system and allow unit to prime output lines.
- Once primed, reduce pump volume output. Turn each pump adjustment 6 clockwise turns or until secure. Turn each adjustment stem 2 full turns counterclockwise.
- The control is set to dispense every 10 links. To adjust frequency, Hold controller pad LEFT for several seconds. You may then adjust frequency UP or Down as desired.
- Air regulation is for control of nozzle spray.

### Performance Benefits:

- Quick connect solenoid for ease of PM.
- Control automatically compensates for line speed.
- System is mechanically adjustable for volume and electronically adjustable for frequency of lubrication.
- Light indication of low-lube level (RED).

Light faults are backed by digital display on control. In the event of a light fault, consult enclosure control for further information as to fault specifics. RED will indicate low-lube or system malfunction. Flashing green indicates single line errors. Green illuminated is standard.

### Technical Data:

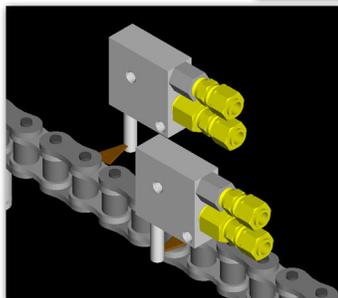
Part No.	XEAMOLS08N4XOM
Availability	Four Weeks
Typical Install Time	6 Hours w/ 3 Persons
Number of Lube Points	8 Oil Spray Points
Lubrication Intervals	Continuously Variable w/ chain speed
Recommended Lubes	JAX Proofer Chain Oil
Power Requirements	100 - 240VAC / 50/60 Hz
Air Requirements	40 psi @ 1 CFM
Recommended Maintenance	Annual PM inclusive of pump seal replacement

### ADJUSTMENT INSTRUCTIONS



Smoke Upper Far Side Adjustment Stem  
Smoke Upper Near

Smoke Lower Far Side  
Smoke Lower Near



With an increase in lubrication there needs to be an increase in regulated air. Initial settings were 1 1/2 turns out on each pump and 35 psi on each regulator.



### SYSTEM LAYOUT

There are two distinct chain lines for the J-Con system (upper and lower), two distinct logic circuits in the lubrication system, and two locations of lubrication. Post wash lubrication (up and to the Right) and Smoke Zone lubrication. There are brackets with two nozzles over each chain in a total of four locations. Each nozzle is represented by an independent pump inside the enclosure.

Smoke zone lower is the first of four lube locations. The two-pump manifold on the Left represents lube pumps for the smoke zone lower bracket. The upper pump, pump 1, is lubricating the furthest nozzle and the lower pump is lubricating the closer nozzle.

Smoke zone upper is the second of four lube locations. The next two-pump manifold controls lube to these nozzles. As before, the upper pump controls the furthest nozzle while the lower pump controls the closer nozzle.

Wash zone lines are at the same vertical height and the line closest to the cabinet is referred to as "lower". The wash zone lower is controlled by the third two-pump manifold with upper pump again controlling the furthest nozzle. The "upper" or further post wash line is lubricated by the final pump manifold. Again, the upper pump controls the further nozzle.

**NOTE:** The nozzles are internal mix nozzles and although the pumps will cycle and deliver a single drop, the nozzle output will be a continuous spray into the chain pins.

### PUMP ADJUSTMENT

Each pump is capable of delivering .012 cu. in. of fluid per cycle (1/2 teaspoon). To achieve full volume, turn each pump counterclockwise until the adjustment stem is all the way out (about 6 turns). To turn a pump output off, turn the adjustment stem clockwise 6 full turns, moving the adjustment stem in all the way. The established setting after priming was 1 1/2 turns out from off (.003 cu. in.).

### CYCLE ADJUSTMENT

The two distinct logic circuits are controlled by separate laser eyes mounted near the post wash area. You will note the lights on each laser correspond to the counting of the chain rollers. Each circuit is set to dispense lubricant to the prospective nozzles every 10 rollers (2 seconds). This method will automatically adjust for variations in line speed and provide accurate lubrication.

## J-Con Autolube System Controlled Frequency Adjustment

### Application

Adjustment of the amount of lubricant dispensed is controlled in numerous ways. Previously we depicted how the mechanical volume of each pump may be altered to either increase or decrease lubricant volume.

We will now instruct as to how to control the frequency of the lubrication cycle. This is done via the keypad on the front of the controller. The numbers to which you will modify represent the number of pins counted on each chain prior to firing of the solenoids controlling the lubrication pumps.

### Making Adjustments:

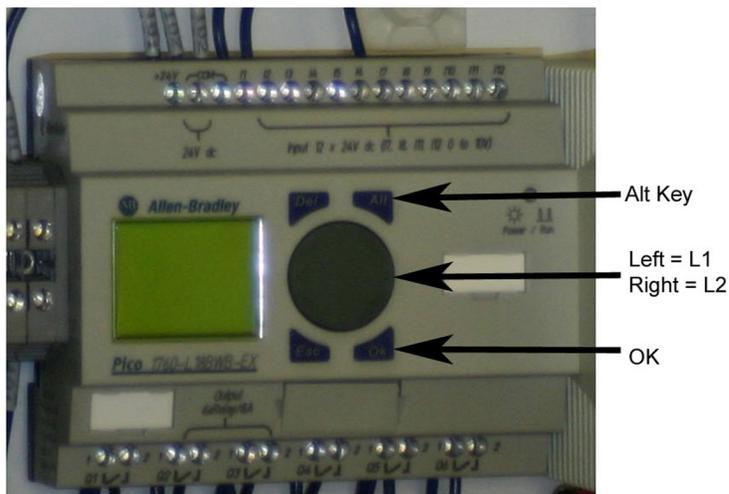
Note: You will have a total of 9 seconds to accomplish key-strokes. This is to avoid accidental changes.

- 1.) To access Line 1 frequency depress the LEFT key pad.
- 2.) To begin modification depress the ALT key. A cursor will appear to inform you of a potential change.
- 3.) When the cursor is flashing at the line you wish to modify, press OK.
- 4.) Using the RIGHT pad, move the cursor to the digit you wish to modify.
- 5.) To modify, depress the UP and DOWN pad accordingly.
- 6.) Once you have made your changes, press OK to save.

This process is repeatable and do not get frustrated if the first attempt is failed. Remember, you have a small window and no room for error.

This process is repeated with Step 1.) depressing the RIGHT key pad to modify timing on Line 2.

With pumps set to 1 1/2 turns out (.002 cu. in. specified standard) a pin count of approximately 10 will give a cycle of the lubricator every 2 seconds. This 3 second cycle equates to approximately 3 gallons of fluid per 24 hour period. At this rate a new drum will be required every two weeks.



## J-Con Autolube System Spare Parts List

### Application

In the event of a component failure, please refer to the following list of components prior to contact Xact with your request for parts.

Parent Assembly:	XEAMOLS08N4XOM
Component Description	Part No
Concept Style NEMA enclosure	X201684XOCLSR
Back Plate	X20166BPOCLSR
Ground Screw	XH10-32GGS
1/4-20X3/4 Hex Bolt	XH250-20-750HB
Aluminum Angle Bracket	XHB3503-1X00005
Xact pump	XCGASDS01X00005
1/4-20X3.5 Hex Bolt	XH250-20-3.5HB
1/4-20X6.5 Hex Bolt	XH250-20-6.5HB
1/4-20X1/4 Hex Nut	XH250-20-250HN
1/8NPTX1/4OD Elbow Fitting	XH125-27X250ODE
1/8NPTX1/4OD Straight Fitting	XH125-27X250ODS
1/4X1/4OD Bulkhead Fittings - Stainless	XH250ODX250ODBH
1/8NPTx1/8 ID Barb	XH125-27X125IDE
1/4OD 8x1/8 ID Poly Tube	XT250ODX125IDPB
Regulator Gauge Sub Assy	XPCRGSA
Allen-Bradley PICO	X1760L18BWBEX
24VDC 60W Power Supply	XCPWRSPLY60W
DIN Mount Power Distribution Block	XCPWRDISTBLK
16 AMP Disconnect Switch	XCPWRFSEBLK
Light Stack	XCREDGRNLT24V
Laser Cable (Std Length)	XLSRCBL6M
Laser Cable (30' Long)	XLSRCBL10M
Banner Lasor Diffuse 24VDC	XQS30LDQ
Water tight Cable Connection	XHWTCCLD
Mac Three-way Solenoid Valve	XPVH3WAYMOD4
Pneumatic Ball Vales	XHLEGBALLVLV
Four Port Manifold	XAL4PORT
16AWG Green	XWIREGREEN
16AWG Black	XWIREBLACK
16AWG Red	XWIRERED
16AWG Blue	XWIREBLUE
Stainless Steel Tubing	XT250ODX032WSS
Internal Mix Nozzle	XEHUBERORN
Nozzle Check Valve	XHOKDLC-10-BR
1/8NPTX1/4OD Straight Fitting	XH125-27X250ODS
Liquid Level Sensor	XCA138156SW

The failure mode of the entire system is designed around 300 million cycles. This equates to roughly 10 years of service. Ideally, nothing will need to be touched, yet the environment to which the system operates is not ideal. The solenoid valves are likely to be the weak link at this point. They are of course an inexpensive and easily stocked component and the system was designed with ease of change for this item in mind. A spare power supply and a spare controller may be a good backup plan as well.

Please contact customer service with any questions or concerns: Phone 262-781-6500