

INSTRUCTIONS FOR PNEUMATIC BOX TILTER FLOOR LEVEL LOADING - 2000 LBS. CAPACITY



MODEL NO.
BT1600
SERIAL NO.

PPE Box Tilters are manufactured and sold direct by Plastic Process Equipment, Inc. We are not associated with any other manufacturer except Budget Molder's Supply, Inc. Always specify genuine PPE or Budget Machinery! Do not accept substitutes.

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PLASTIC PROCESS EQUIPMENT, INC.

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**PPE
WEST**

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**PPE
SOUTH**

11218 Challenger Avenue, Odessa, Florida 33556
727-834-8888 • 800-282-6783 • Fax: 727-834-8873

8303 CORPORATE PARK DRIVE, MACEDONIA (Cleveland), OHIO 44056, USA

216-367-7000 • Toll Free: 800-321-0562 • Fax: 216-367-7022 • Order Fax: 800-223-8305

Toll Free: USA, Canada & Mexico
800-362-0706

Thank you for purchasing a Pneumatic Box Tilter from Plastic Process Equipment, Inc. These instructions are intended as a guide for your new product. If you have any additional questions, contact PPE at 800-321-0562.

RECEIVING

Upon receiving, inspect for damage and report any damage to the motor freight carrier before uncrating for setup. They are responsible for any damage incurred during transit.

SETUP

Your PPE Pneumatic Box Tilter must be securely fastened to the floor before operation. We recommend using 1/2" anchor bolts. Make sure the entry to the unit is not restricted. **WARNING Do Not inflate this unit unless fully secured to the floor.** Once the unit is secured to the floor check the hand control valve to make sure it is pushed down. Pull the regulator knob up and turn counterclockwise until it stops and lock it back down. Connect the air hose.

LUBRICATOR

(Lubricator is only available on units with vibrator option) All Lubricators are filled with SAE10 oil prior to shipping. Check lubricator to make sure no leakage has occurred during shipment. Always make sure lubricator has oil in it to prevent premature failure of the vibrator units.

To initially set your lubricator, use a mirror at the air outlet of the vibrator unit and adjust the drip rate of the lubricator so that it is set just below the setting needed generate an oil film on the mirror. Full instructions for the oiler are included elsewhere in the instruction package.

OPERATION

Once your PPE Tilter is fastened to the floor and connected to an air supply it is ready to use. Locate the regulator, the adjustment knob pulls up to adjust and locks down once you have set the pressure. With the tilter empty, set the regulator at 0 psi, and pull the hand control valve up. When the valve is pulled up the exhaust port is closed and air flows to the regulator. The regulator adjusts the amount of lift pressure that flows to the air bag, the greater the pressure the higher the unit will tilt. **WARNING Never Exceed 40 psi of pressure.** To adjust the pressure pull the regulator knob up and turn to the desired lift pressure, then lock in place by pushing down. Next to the regulator is a flow control valve, this valve adjusts the speed at which the platform rises. To set the flow control valve push the hand control valve down so the unit lowers, then turn the flow control valve clockwise until it stops and pull the hand control valve back up. The unit will not raise until you open the flow control valve, you can now set it at the desired lift speed. When you have set the lift speed, turn the regulator to 0 and push the hand control valve down.

You are now ready to load the unit. If your material box is full, tilting it could cause it to spill, we recommend you wait until it is about 1/2 empty before continuing. If you are using the floor level tilter make sure the gaylord hook is installed prior to operation, this will keep the box secure.

WARNING Never adjust the regulator beyond 40 psi. With the material box half empty turn the regulator knob until the box just begins to lift. Lock the regulator in this position. As the material is drawn out, the box will become lighter and the tilter will automatically lift it higher the lighter it gets.

WARRANTY

All PPE machinery is warranted to be free of defective material and workmanship for a minimum period of 1 year from date of invoice. Some machinery components may carry a longer warranty per our suppliers policies which are passed on to our customers.

VIBRATOR OPTION INSTALLATION INSTRUCTIONS

Floor Level Unit Only

The optional vibrator assembly has been preassembled for easy field installation.

- 1) Disconnect the air supply at the quick coupler (**see Figure 1**). **NOTE: MAKE SURE THE UNIT IS IN THE DOWN POSITION BEFORE DOING THIS!!**

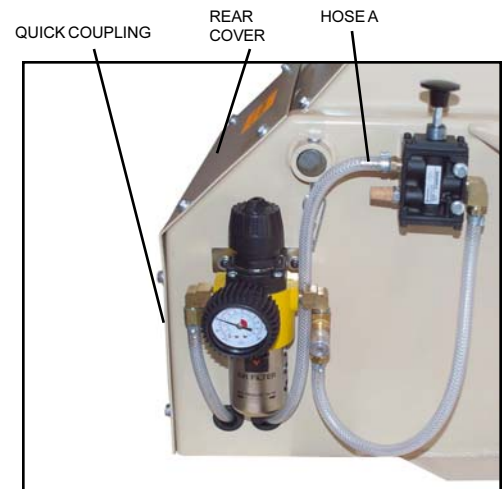


Figure 1

- 2) Remove the quick coupler and set aside, you will need to reuse this coupler later.
- 3) Remove the rear cover of the tilter.
- 4) Fasten the anchor coupling to the back cover and screw the quick coupler into the outside port.
 1. Screw the T fitting into the inside port.
- 5) On the opposite side of the base from the regulator, bolt the Oiler/Regulator assembly (**see Figure 2**).
- 6) Pass hose A and hose B thru the holes in the base and connect them to the T fitting.

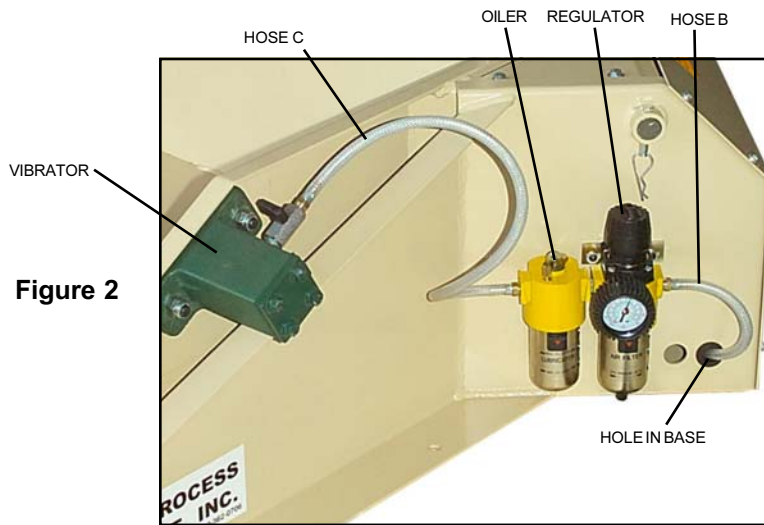


Figure 2

- 7) Connect Hose C to the vibrator ball valve.
- 8) Bolt the vibrator to the pad on the platform (*see Figure 3*), making sure the button head end of the bolts face inward towards the center of the platform.



Figure 3

- 9) At this point you can reconnect the air supply hose.

VIBRATOR OPTION OPERATING INSTRUCTIONS

The vibrator package includes a vibrator, a shut off valve and a pressure regulator/oiler. The vibrator is turned on and off by the shut off valve and the vibration intensity is controlled by the regulator. Pull the regulator knob up and turn it to the desired pressure for the level of vibration you need and lock in place by pressing down.



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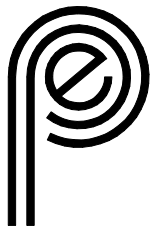
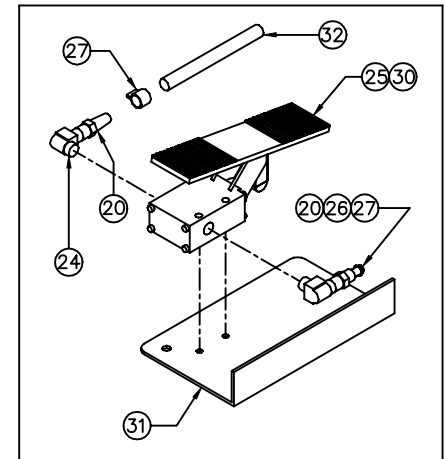
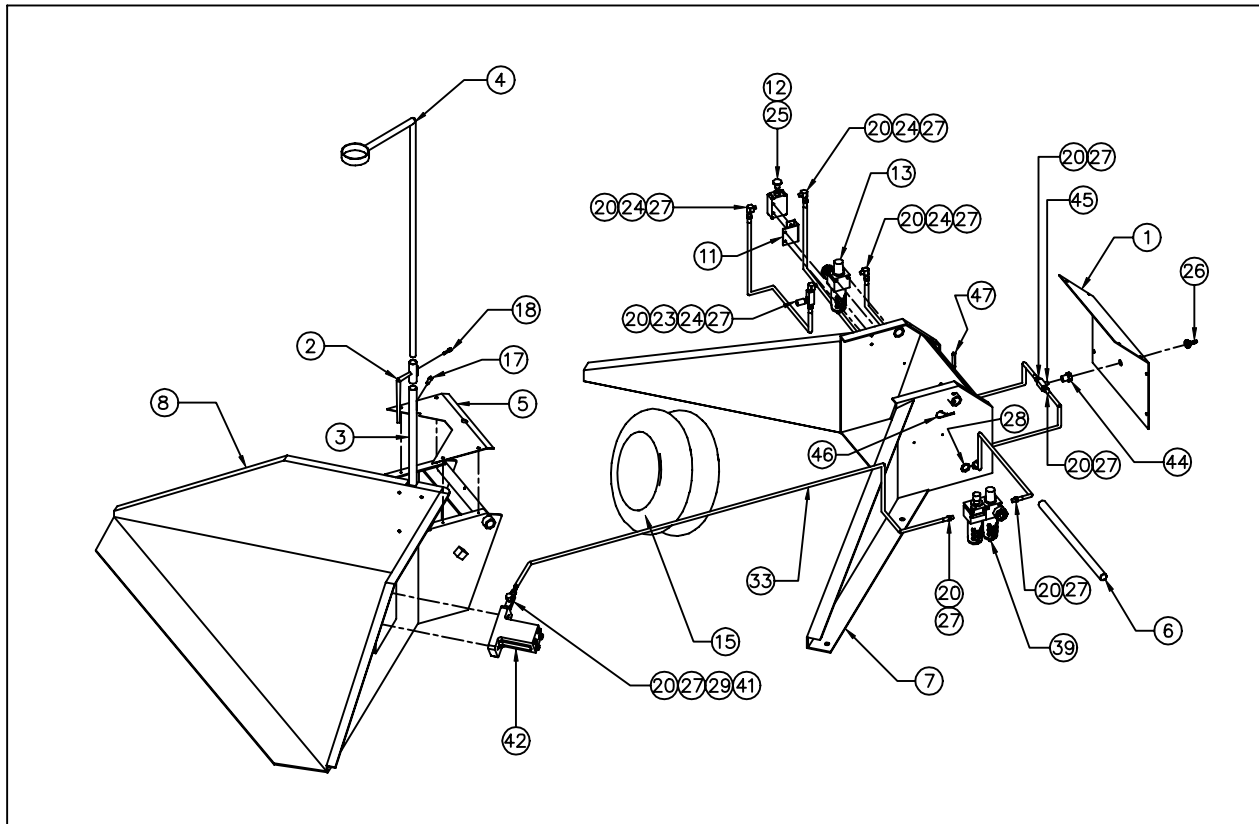
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GROUND ENTRY PALLET TILTER PARTS



PLASTIC PROCESS EQUIPMENT, INC.

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BT1600 TILTER PARTS

ID NUMBER	PART NUMBER	DESCRIPTION	02/13/19	UOM
1	A-4637	AIR SPRING COVER FOR BT1600		EA
2	A-4638	GAYLORD SUPPORT BRACKET		EA
3	A-4639	PICK-UP TUBE HOLDER SUPPORT BACKET		EA
4	A-4640	PICK-UP TUBE HOLDER		EA
5	A-4641	TOP COVER FOR BT1600		EA
6	A-4642	SHAFT FOR BT1600		EA
7	A-11337	UPPER FRAME - TILTER		EA
8	A-11332	LOWER FRAME		EA
9	A-4669	"GREASE DAILY" STICKER		EA
10	A-4669A	"IMPORTANT" STICKER		EA
12	K41DA00-KC0-KB0	HAND VALVE		EA
13	AMC403D	AIR REGULATOR		EA
15	2B12-311	AIR BAG		EA
16	1293K11	ZIRK FITTING (ZIEGLER #AUV15420)		EA
17	3/8-16X1	3/8-16X1 BUTTON HEAD BOLTS		EA
18	37C75MT	ZINC PLATED THUMB SCREW		EA
19	2214P-4-4	1/4 X 1/4 45deg ELBOW ON AIR BAG		EA
20	125HBL-4-4	1/4 X 1/4 MALE BARBED INSERT		EA
21	102-04	1/4 HOSE PER INCH		22"
22	102-04	1/4 HOSE PER INCH		18"
23	JF2	FLOW CONTROL VALVE		EA
24	2202P-4-4	1/4 X 1/4 90deg STREET ELBOW MxF		EA
25	4450K2	MUFFLER FILTER 4450K2		EA
26	H2C	HOSE NIPPLE		EA
27	EC1315	HOSE CLAMPS		EA
28	Z2168	RUBBER GROMMET		EA
29	215PN-4	1/4" CLOSE NIPPLE		EA
	BTW100	BOX TILTER WARNING SIGN		EA
46	90149A032	HAIR PIN		EA
47	98306A278	LEG CLEVIS PIN 3/8 dia		EA

OPTIONAL FOOT VALVE PACKAGE

20	125HBL-4-4	1/4 X 1/4 MALE BARBED INSERT		EA
24	2202P-4-4	1/4 X 1/4 90deg STREET ELBOW MxF		EA
25	4450K2	MUFFLER FILTER 4450K2		EA
26	H2C	HOSE NIPPLE		EA
27	EC1315	HOSE CLAMPS		EA
30	K41DA00-KC0-KT0	FOOT VALVE (OPTIONAL)		EA
31	A-4643	FOOT VALVE MOUNTING PLATE (OPTIONAL)		EA
32	102-04	1/4 HOSE PER INCH		72"

OPTIONAL VIBRATOR PACKAGE

20	125HBL-4-4	1/4 X 1/4 MALE BARBED INSERT		EA
27	EC1315	HOSE CLAMPS		EA
29	215PN-4	1/4" CLOSE NIPPLE		EA
32	102-04	1/4 HOSE PER INCH		72"
33	102-04	1/4 HOSE PER INCH		36"
39	AMC420D	AIR REGULATOR/LUBRICATOR		EA
41	FMV-0014	1/4" BALL VALVE		EA
42	125	VIBRATOR (QUIET TYPE)		EA
43	4450K2	MUFFLER FILTER 4450K2		EA
44	207ACBH-4	ANCHOR COUPLING		EA
45	2224P-4	1/4 X 1/4 X 1/4 TEE		EA