



CJWINTER

A Brinkman International Group, Inc. Company

Engineering Bulletin: How to Keep Attachments Running Efficiently

Protecting your assembly from moisture and debris is critical to avoid leaks and contamination.

There are a number of ways to keep thread rolling attachments running efficiently. Let's look at an airline assembly as an example:

1. Maintain proper air pressure and volume.

To run an airline assembly at its highest performance, air must be maintained at a proper pressure and volume to operate the attachment. This includes:

- A minimum of ½ inch inside diameter through the control valve connection fitting in order to provide ample air volume.
- Pneumatic attachments will work with air pressure 80-120 psi. We recommend running at 100 psi.

2. Use a T-Connection adjacent to control valve mounting.

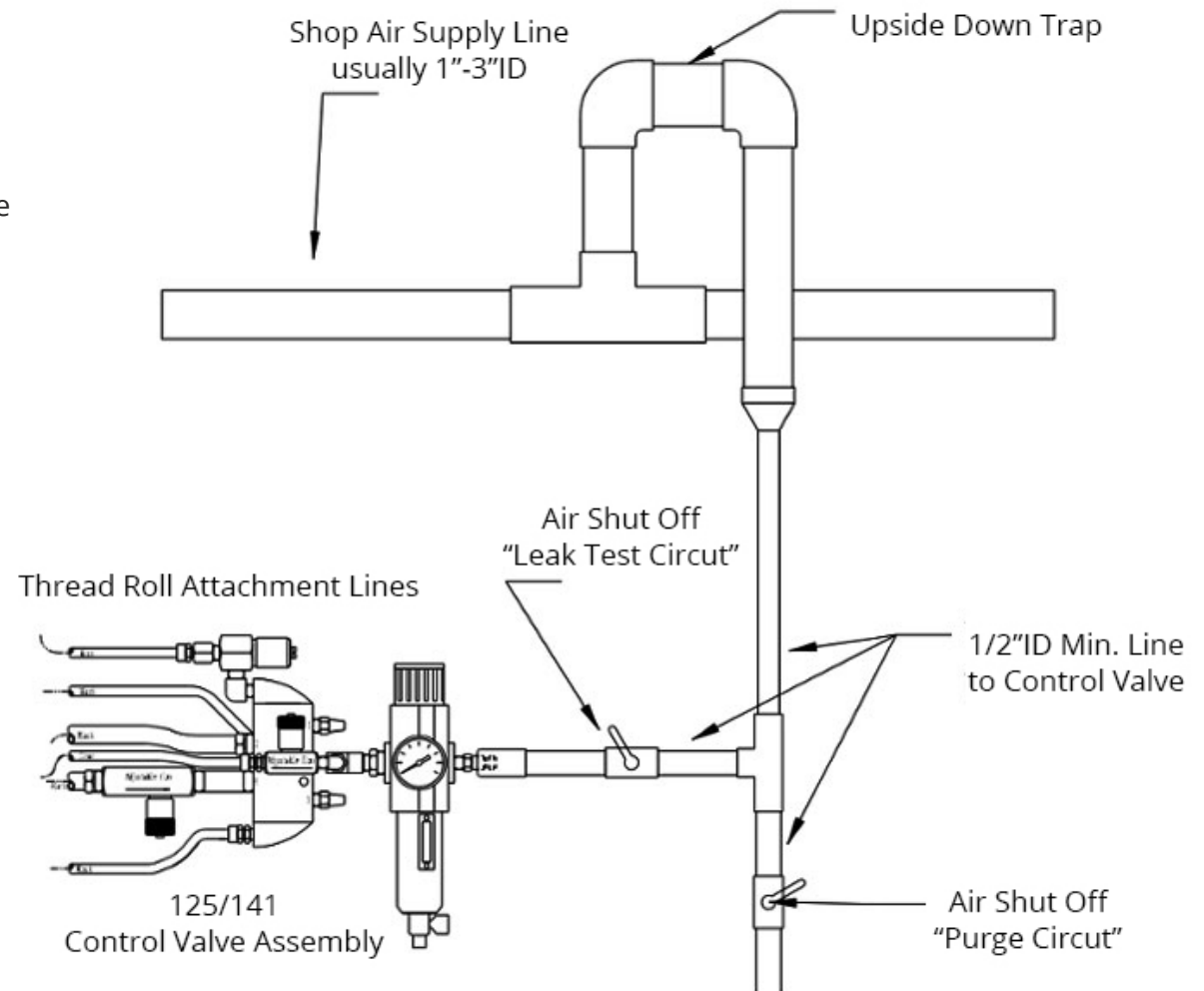
The connection acts as an additional measure to keep most of the moisture and debris from moving down the line into the control valve assembly.

3. Check for leaks.

To check for leaks on cylinder, please contact factory for instructions.

4. Use an "Upside-Down Trap"

As the diagram shows, an upside-down trap taps into the airline from the main supply line. When connections are made at the bottom of the line, moisture and debris can drain into the airline and end up contaminating the control valve and attachment. Using an upside-down trap keeps most of this moisture and debris from moving down the line.



Attachment Air Consumption at 90 PSI in SCFM

					(STANDARD CUBIC FEET / MIN)		
					161100	160911	163910
					(SINGLE POWER PACK)	(DOUBLE POWER PACK)	(TRIPLE POWER PACK)
MACHINE CYCLE TIME (SEC)	ALL: 125 'S	ALL: 126 'S 134 'S	ALL: 141 'S 151 'S	ALL: 142 'S 152 'S	ALL: 161 'S	ALL: 160 'S 162 'S 165 'S 170 'S 172 'S	ALL: 163 'S 173 'S 175 'S 177 'S 178 'S
1	4.11	6.32	9.21	N/A	12.55	N/A	N/A
1.5	2.74	4.21	6.14	10.31	8.36	N/A	N/A
2	2.05	3.16	4.60	7.73	6.27	9.72	N/A
2.5	1.64	2.53	3.68	6.18	5.02	7.77	10.43
3	1.37	2.11	3.07	5.15	4.18	6.48	8.70
3.5	1.17	1.80	2.63	4.42	3.58	5.55	7.45
4	1.03	1.58	2.30	3.86	3.14	4.86	6.52
5	0.82	1.26	1.84	3.09	2.51	3.89	5.22
6	0.68	1.05	1.53	2.58	2.09	3.24	4.35
7	0.59	0.90	1.32	2.21	1.79	2.78	3.73
8	0.51	0.79	1.15	1.93	1.57	2.43	3.26
9	0.46	0.70	1.02	1.72	1.39	2.16	2.90
10	0.41	0.63	0.92	1.55	1.25	1.94	2.61

5. Make sure you have enough air volume available for your pneumatic attachments.

Verify your system can provide adequate volume of air to attachment. See chart for more details. SCFM requirements for each of the attachment models as a function of machine cycle time. If you do not have adequate air volume - we recommend using a purge tank set up - please contact factory for instructions.