

# PREROLLER INFORMATION

# PREROLLER 1 V3 MODIFICATION AND UPGRADES

All stations have been modified by the manufacturer to fit a 120mm glass tip cones.

Station 4 has a quick release on the dosing funnel.

Station 6 has tool less grippers.

Station 7 has tool less grippers. And a Vacuum upgrade.

Station 8 not used.

Station 9 has a new scale less than 6 months old.

Station 10 has a longer ejection bar for 120mm cones.



# Data from data plates, advanced options screens, and production history

## Preroller 1

Model- Preroll-ER V3

Manufacturing date- 2022

Serial Number- 2020-1006

Cycles- 3,119,303

## Machine configuration:

\*Carousel Drive: Omron

\*Safety Controller: V0 Safety PLC

\*S2- cone loader /cone separation type: v1 shelf & grippers

\*S2- pick & place/ cone detection type: v1 laser

\*S3- cone opener type: v1 pusher

\*S4- dosing station height adjustment: v0 manual

\*S4- shaker drive type: festo v18

\*S5- compactor drive type: v2 servo motor (stroke limit 110mm)

\*S6 Twist Version: v0 stepper

\*S8- options: not used

\*S9- transfer type: version 1

\*S10- paper remove version: v1 air jet

## Options:

\*S12- the tube dispenser: no

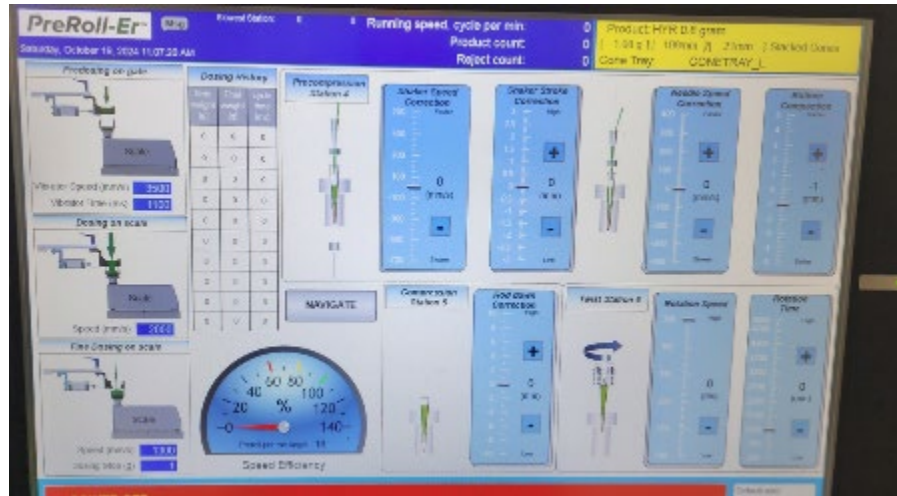
\*S4- needle cleaning: no

\*S5- rod cleaning: no

\*S9- Monoblock Connection: no

\*S9- vision: no

# PREROLLER 1 images

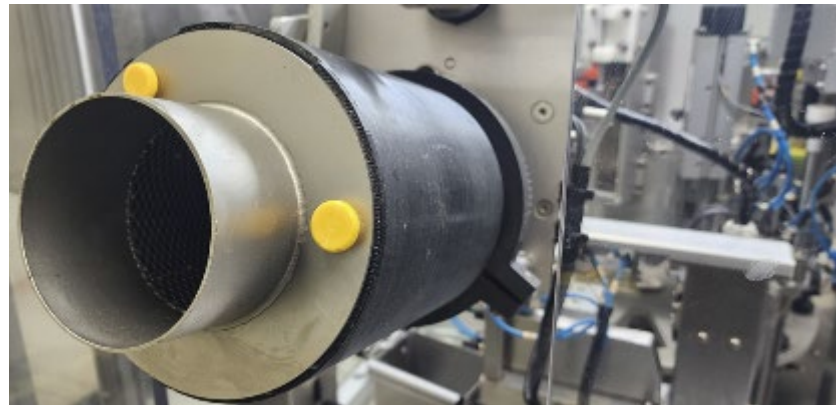


Serial Number	Date / Time
3090972	10/16/2024 3:01:05 PM
3090971	10/16/2024 3:01:02 PM
3090970	10/16/2024 3:01:00 PM
3090969	10/16/2024 3:00:56 PM
3090968	10/16/2024 3:00:53 PM
3090967	10/16/2024 3:00:49 PM
3090966	10/16/2024 2:50:59 PM
3090965	10/16/2024 2:50:55 PM
3090964	10/16/2024 2:50:51 PM
3090963	10/16/2024 2:50:47 PM
3090962	10/16/2024 2:50:43 PM
3090961	10/16/2024 2:50:39 PM
3090960	10/16/2024 2:50:35 PM
3090959	10/16/2024 2:50:31 PM
3090958	10/16/2024 2:50:27 PM
3090957	10/16/2024 2:50:23 PM
3090956	10/16/2024 2:50:19 PM
3090955	10/16/2024 2:50:15 PM
3090954	10/16/2024 2:50:10 PM
3090953	10/16/2024 2:50:06 PM
3090952	10/16/2024 2:50:02 PM
3090951	10/16/2024 2:49:58 PM
3090950	10/16/2024 2:49:54 PM
3090949	10/16/2024 2:49:28 PM
3090948	10/16/2024 2:49:24 PM
3090947	10/16/2024 2:49:20 PM
3090946	10/16/2024 2:49:16 PM
3090945	10/16/2024 2:49:12 PM
3090944	10/16/2024 2:49:08 PM





## PREROLLER 1 images



## PREROLLER 2 V5 MODIFICATION AND UPGRADES



All stations have been modified by the manufacturer to fit a 120mm glass tip cones.  
Station 4 has a dosing ramp upgrade to help even out product dose while running.  
And a quick release on the dosing funnel.  
Station 5 has been upgraded for 120mm cones.  
Station 8 has the injection unit.

# **Data from data plates, advanced options screens, and production history**

## **Preroller 2**

Model- Preroll-ER 200 V5

Manufacturing Date- 2022

Serial Number- 2022-2043

Cycles- 1,364,161

## **Machine configuration:**

\*Carousel Drive: Festo V18

\*Safety Controller: V1 Safety relay

\*S2- cone loader /cone separation type: v1 shelf & grippers

\*S2- pick & place/ cone detection type: v1 laser

\*S3- cone opener type: v1 pusher

\*S4- dosing station height adjustment: v2 tumbler mounted on table

\*S4- shaker drive type: festo v31

\*S5- compactor drive type: v2 servo motor (stroke limit 110mm)

\*S6 Twist Version: v2 stepper/home sensor/ encoder

\*S8- options: v2 oil injector

\*S9- transfer type: version 1

\*S10- paper remove version: v1 air jet

\*S11- air supply valve: valve v1

## **Options:**

\*S12- the tube dispenser: no

\*S4- needle cleaning: no

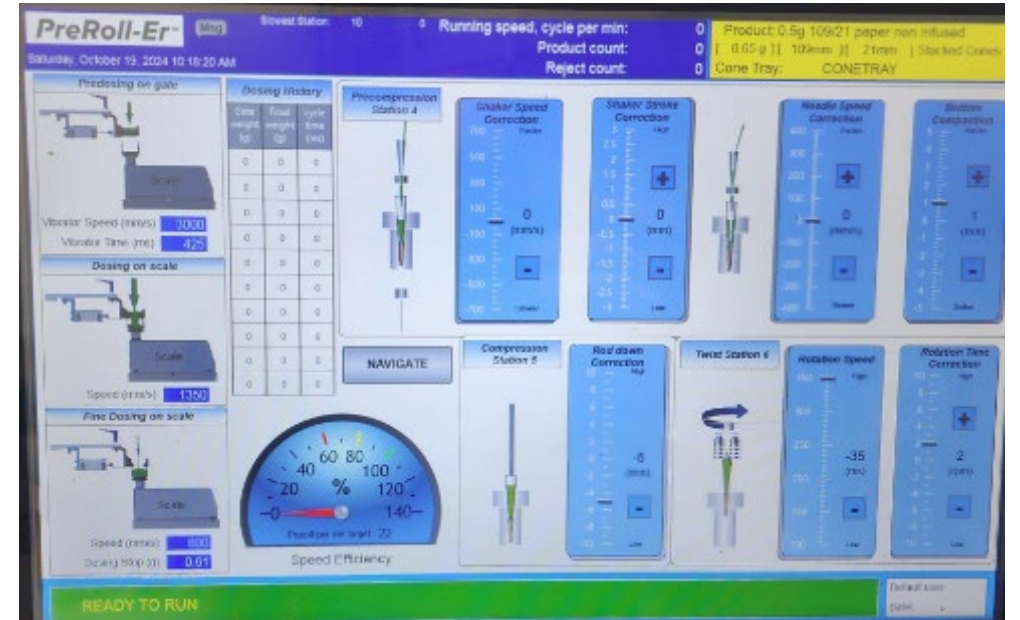
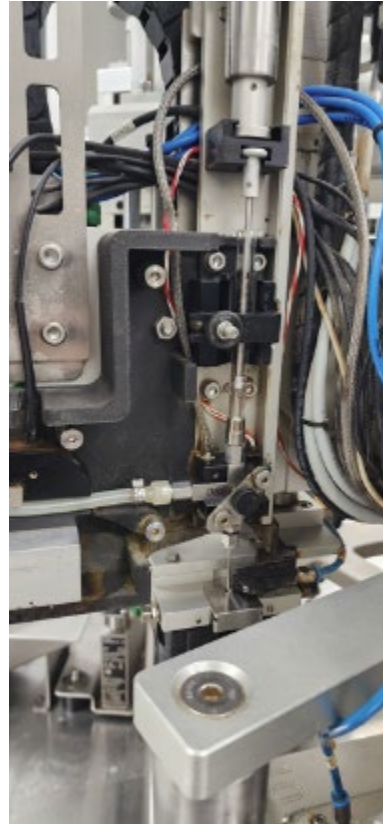
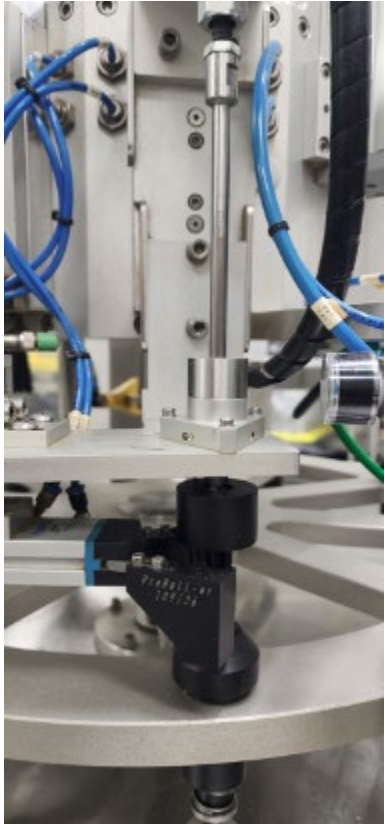
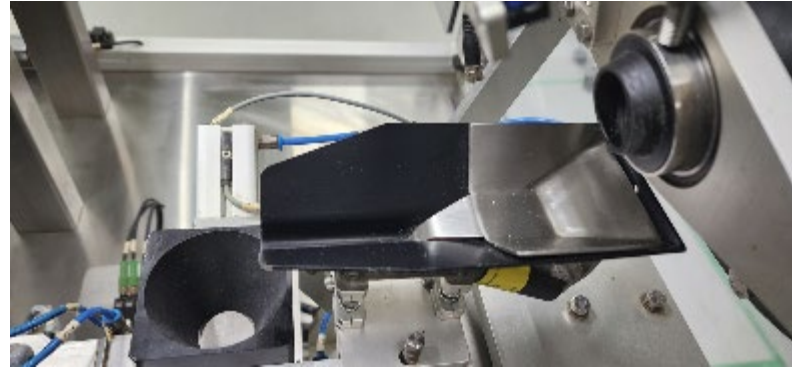
\*S5- rod cleaning: no

\*S9- Monoblock Connection: no

\*S9- vision: no



## PREROLLER 2 images

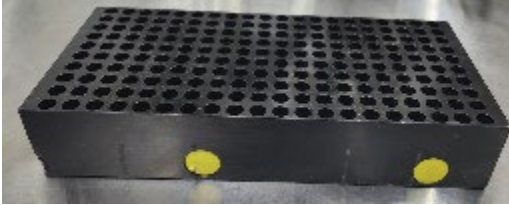




## PREROLLER 2 images



## PREROLLER 2 images



Records	Shifts	Alarms
Serial Number		Date / Time
1364161	9/25/2024 9:06:30 AM	
1364160	9/25/2024 9:06:27 AM	
1364159	9/25/2024 9:06:24 AM	
1364158	9/25/2024 9:06:21 AM	
1364157	9/25/2024 9:06:18 AM	
1364156	9/25/2024 9:06:14 AM	
1364155	9/25/2024 9:06:10 AM	
1364154	9/25/2024 9:06:06 AM	
1364153	9/25/2024 9:06:02 AM	
1364152	9/25/2024 9:05:54 AM	
1364151	9/25/2024 9:05:50 AM	
1364150	9/25/2024 9:05:46 AM	
1364149	9/25/2024 9:05:42 AM	
1364148	9/25/2024 9:05:38 AM	
1364147	9/25/2024 9:05:34 AM	
1364146	9/25/2024 9:05:30 AM	
1364145	9/25/2024 9:05:21 AM	
1364144	9/25/2024 9:05:17 AM	
1364143	9/25/2024 9:05:13 AM	
1364142	9/25/2024 9:05:09 AM	
1364141	9/25/2024 9:05:01 AM	
1364140	9/25/2024 9:04:57 AM	
1364139	9/25/2024 9:04:45 AM	
1364138	9/25/2024 9:04:41 AM	
1364137	9/25/2024 9:04:37 AM	
1364136	9/25/2024 9:04:33 AM	
1364135	9/25/2024 9:04:30 AM	
1364134	9/25/2024 9:04:22 AM	
1364133	9/25/2024 9:04:18 AM	
1364132	9/25/2024 9:04:14 AM	

# Parts inventory

Row	Bin	On Hand	Part Number	Station	Description
1	1	7	FHSC M3X10	TABLE	FLAT HEAD SCREW
1	2	1	CAELE 98	TABLE	CABLE
1	3	2	CAELE 53	TABLE	ETHERNET CABLE
1	4	3	CANPE 16	TABLE	CYLINDER
1	5	4	CANPE 16	TABLE	CYLINDER
1	6	5	CAPRT 311	TABLE	PUSH ROD
1	7	6	CAMEC 380	TABLE	DUST PREVENTOR FOR STATION TOWERS
1	8	9	camec 445	TABLE	WASHER AND CLIPS FOR PODS
1	9	11	CAMEC 444	TABLE	SPRINGS FOR PODS
1	10	4	CAMEC 1148	TABLE	BRASS SPACER
1	11	2	CAPNE 13	TABLE	ONE WAY FLOW CONTROL VALVE
1	12	12	SHCS M6X20	TABLE	SOCKET HEAD SCREW
1	13	2	SHCS M3X12	TABLE	FLAT HEAD SCREW
2	1	100	SHCS M4-70X35	6	SOCKET HEAD SCREW
2	2	1	CAMEC 177	TABLE	COUPLER
2	3	3	CAMEC 687	TABLE	BRASS SPACER
2	4	2	CAMEC 200	TABLE	SCREWS FOR SHAKER UNDER THE TABLE
2	5	1	CAPNE 104	TABLE	
2	6	6	CAPNE 13	TABLE	ONE WAY FLOW CONTROL VALVE
2	7	1	ACCUATOR	2	ACCUATOR (NO PART NUMBER)
2	8	3	CAPRT 2572	2	CONE DROP TUBE 84/24
2	9	1	CASSY 626	2	TRAP DOOR (1 EXTRA BROKEN DOOR FOR PARTS)
2	10	2	CAMEC 366	2	SPRINGS
2	11	3	CAPNE 68	2	AIR FLOW VALVE
2	12	2	CAPRT 2768	2	HOLDING PIN (PART IS NOT NEEDED, GOT UPGRADED)
2	13	2	CAMEC 197		
3	1	2	SHCS M6-1X25		SOCKET HEAD SCREW
3	2	1	CAPNE 29	4	COMPACT CYLINDER
3	3	4	CAMEC00003	4	MOUNTING SCREWS FOR DOSING RAMP
3	4	2	CAPNE 141	4	AIR FLOW VALVE
3	5	1	CAELE 137	4	PROXIMITY SENSOR
3	6	20	CAMEC 609	4	RUBBER WASHER
3	7	1	CAMEC 604	4	HAIRPIN COTTER PIN
3	8	3	CAELE 108	4	FIBER OPTIC AMPLIFIER
3	9	1	CAMEC 503	4	REDUCTOR
3	10	2	CAPNE 78	4	PROXIMITY SENSOR

PR2:

1. 7 extra syringes
2. 8 extra needles
3. 1 station 8 set for 109mm cones
4. 1 station 8 set for 84mm straight tubes
5. Extra oil reservoir tank
6. Full set of 109x26 or 109x21mm cones.
7. Full set of 84x26mm straight tubes



# Parts inventory

Row	Bin	On Hand	Part Number	Station	Description
3	11	2	CAPNE 72	4	SENSOR
3	12	1	CAELE 139	4	SENSOR
3	13	37	CAMEC 454	6	O RING
4	1	2	SHCS M6-1X30		SOCKET HEAD SCREW
4	2	5	CAMEC000233	4	AIR VIBRATORS
4	3	2	CAPNE 196	4	ELBOW FITTING
4	4	6	CAMEC 51	4	CONE FORMER BLANK SCREWS(PART NO LONGER NEEDED, HAS BEEN UPGRADED)
4	5	1	CAMEC 585	4	BLUE HANDLE
4	6	2	FHCS M3X10	5	SOCKET HEAD CAP SCREW
4	7	1	CASSY 714	4	UPGRADED FUNNEL
4	8	4	CAPRT 370	4	DOSING CUPS
4	9	1	CAELE 121	4	PROXIMITY SENSOR
4	10	1	CAPRT 1836	4	SPUR GEAR
4	11	2	CAMEC 452	4	SPACER
4	12	4	CAPNE 105	4	PUSH IN L FITTING
4	13	1	CAMEC 643		RUBBER WASHER
5	1	7	CAMEC 465	5	O RING
5	2	0		4	PR2 DOSING CUPS AND HARDWARE
5	3	2	CAPNE 141	4	AIR FLOW VALVE
5	4	1	CAPRT 1858	4	BASE GATE DOSING
5	5	5	CAPNE 77	4	PUSH IN L FITTING
5	6	1	CAPRT 233	5	109/21 COMPACTING PIN
5	7	2	CAPRT 718	5	COMPACTING ROD 6MM ST-5 84MM
5	8	1	CAPNE 68	5	ONE WAY FLOW CONTROL VALVE
5	9	2	FHCS M3X16	5	HEX SOCKET FLAT HEAD SCREW CAP
5	10	4	BHCS M6X16	5	BUTTON HEAD CAP SCREW
5	11	4	FHCS M4X16	5	HEX SOCKET FLAT HEAD SCREW CAP
5	12	2	SHCS M4X8	5	SOCKET HEAD CAP SCREW
5	13	4	FHCS M5X12		FLAT HEAD CAP SCREW
6	1	1	BHCS M5X10		BUTTON HEAD CAP SCREW
6	2				EMPTY
6	3	12	CAMEC 907	5	O RING
6	4	125	CAMEC 196	4	LARGE O RING
6	5	1	CAELE 32	6	PROXIMITY SENSOR
6	6	4	CAMEC 908	6	O RING
6	7	16	CAMEC 88	6	O RING



# Parts inventory

Row	Bin	On Hand	Part Number	Station	Description
6	8	1	CAPRT 1279	6	POST FOR CUTTER
6	9	6	CAPRT 3527	6	CONE OPENER ON COMPACTION STATION
6	10	2	CAPNE 77	6	PUSH IN FITTING
6	11	3	CAME 695	6	DOWEL PIN
6	12	2	CAMEC 140	6	PUSH IN L FITTING
6	13	2	SHCS M4X10		SOCKET HEAD CAP SCREW
7	1	3	SHCS M6-12		SOCKET HEAD CAP SCREW
7	2	1	CAMEC 214	6	CLAMPIN PRECISION FLEXIBLE SHAFT COUPLING
7	3	1	CAPNE 227	6	PUSH IN L FITTING
7	4	3	CAPNE 105	6	PUSH IN L FITTING
7	5	4	CAPRT 2493	6	GLASS TIP FOAM GRIPPERS
7	6	14	CAPRT 1973	6	1 GRAM FOAM GRIPPERS
7	7	2	CAPRT 1974	6	STRAIGHT TUBE FOAM GRIPPERS
7	8	1	CAPNE 55	6	DGST MINI SLIDE
7	9	1	CAMEC 452	4	SPACER
7	10	5	CAMEC 908	6	O RING
7	11	1	CAPRT 1676	6	TWIST STATION
7	12	1	CAPNE 22	6	TWIST STATION SLIDE
7	13	2	SHCS M4X10		SOCKET HEAD CAP SCREW
8	1	1	SHCS M6-1X40		SOCKET HEAD CAP SCREW
8	2	1	CAELE 69	6	STEPPER MOTOR
8	3	1	CAELE 59	6	STEPPER MOTOR
8	4	1	CAELE 118	6	STEPPER MOTOR
8	5	1	CAELE 137	6	PROXIMITY SENSOR
8	6	3	CAMEC 454	6	O RING
8	7	31	CAMEC 448	7	RAZOR BLADES
8	8	2	CAPNE 65	7	SENSOR
8	9	1	CAPRT 1708	4	SPUR GEAR
8	10	1	CAMEC 698	7	BRASS SAE WASHER 7/16"
8	11	1	MULTI PACK		O RING MULTIPACK
8	12	4	CAMEC 449	7	LOW PROFILE SHOULDER SCREW
8	13	4			BLUE SCOURING PADS (OPEN PACK)
9	1	1	SHCS M6-1X55		SOCKET HEAD CAP SCREW
9	2	1	CAPRT 1278	7	CUTTING BLADE
9	3	1	CAPRT 1748	7	BLADE HOLDER
9	4	4	NYLON LOCK NUT	7	M10

# Parts inventory

Row	Bin	On Hand	Part Number	Station	Description
9	5	1	CAPRT 3574	7	FOR UPGRADED STATION
9	6	1	CAPNE000146	7	COMPACTION CYLINDER
9	7				EMPTY
9	8	1	CAPNE 77	7	PUSH IN FITTING
9	9	4	CAMEC 198	7	BRASS SPACER
9	10	1	LOCK NUT M8	7	M8 LOCK NUT
9	11	3	CAELE 346	8	SENSOR CABLE
9	12				EMPTY
9	13	1	SHCS M6-1X16		SOCKET HEAD CAP SCREW
10	1	92	FHCS 10-32X5/8		FOR EACH STATION - MOUNTS
10	2	1	CAPNE 16	9	CYLINDER
10	3	6	CAPRT 352	9	BLACK FOAM HOSE
10	4	1	CAPNE 86	9	CYLINDER
10	5	1	CAPNE 87	9	ROD EYE
10	6	3	CAPNE 66	7	PUSH IN FITTING
10	7	4	CAMEC 184	9	LINER FLANGED BUSHING
10	8	6	CAPRT 2301	9	BLUE AIR LINE
10	9	4	CAPRT 342	9	2 FOR 84/24 - 2 FOR 84/26
10	10	5	CAPNE 105	9	PUSH IN L FITTING
10	11	18	CAMEC 39	9	SNAP RINGS
10	12	4	CAMEC 969	9	METAL O RING
B	1	1	SPR 109X26		SPR 109X26 TOOLING (PR1)
B	2	1	FUTUROLA 109X26		FUTUROLA 109X26 (PR1)
B	3	1	FUTUROLA 84X26		FUTUROLA 84X26 (PR1)
C	1	1	BLUNT		BLUNT NEEDLE
C	1	2	CASSY000497		109 NEEDLE
C	1	4	CASSY000496		84 NEEDLE
C	5	1			BIN OF UPGRADED PARTS
D	1	1			TUMBLER