

# AutoStream - Model P1

---

## Manual



---

**Thiele**  
Technologies  
A Barry-Wehmler Company

***Streamfeeder***  
®

Part Number: 00900492

**© 2009 Thiele Technologies, Inc. - Streamfeeder. All rights reserved.**

No part of this publication may be reproduced, photocopied, stored on a retrieval system, or transmitted without the express written consent of Thiele Technologies, Inc. - Streamfeeder.

Thiele Technologies, Inc. - Streamfeeder  
103 Osborne Road  
Minneapolis, MN 55432-3120 USA

TEL: 763.502.0000  
FAX: 763.502.0100  
E-MAIL: [service@streamfeeder.com](mailto:service@streamfeeder.com)  
WEB: [www.streamfeeder.com](http://www.streamfeeder.com)

Printed in the USA.

# CONTENTS

---

**Before You Begin..... ii**

**Specifications ..... v**

**Section 1: About the Machine ..... 1**

**Section 2: Operation..... 3**

**Section 3: Mechanical Components ..... 5**

**Section 4: Electrical Diagrams ..... 25**

# BEFORE YOU BEGIN

---

## Message Conventions



DANGER signifies an action or specific equipment area that can result in serious injury or death if proper precautions are not taken.



WARNING signifies an action or specific equipment area that can result in personal injury if proper precautions are not taken.



CAUTION signifies an action or specific equipment area that can result in equipment damage if proper precautions are not taken.



ELECTRICAL DANGER signifies an action or specific equipment area that can result in personal injury or death from an electrical hazard if proper precautions are not taken.



TIP signifies information that is provided to help minimize problems in the installation or operation of the equipment.



NOTE provides useful additional information that the installer or operator should be aware of to perform a certain task.



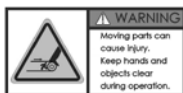
IMPORTANT alerts the installer or operator to actions that can potentially lead to problems or equipment damage if instructions are not followed properly.

## Warning Label Descriptions

WARNING LABELS affixed to this product signify an action or specific equipment area that can result in serious injury or death if proper precautions are not taken.



Hazardous voltage. Contact will cause electric shock or burn. Turn off and lock out power before servicing.



Moving parts can crush and cut. Keep guards in place. Lock out power before servicing.

# SAFETY

---

Make sure you thoroughly read this section to become familiar with all the safety issues relating to the safe operation of this product.

*Please read all of the warnings that follow to avoid possible injury.* Although Streamfeeder has made every effort to incorporate safety features in the design of this equipment, there are residual risks that an installer or operator should be aware of to prevent personal injury.

*Please read all of the cautions that follow to prevent damage to this product.* This product is built with the highest quality materials. However, damage can occur if the system is not operated and cared for within design guidelines as recommended by Streamfeeder.

---

## Danger



To insure proper machine operation make sure that all the safety devices are installed properly and functioning. Do not attempt to defeat a safety interlock or safety feature.

**Equipment interior contains incoming 115VAC electrical power. Bodily contact with these high voltages can cause electrocution, which can result in serious injury or death.**

---

## Electrical Noise

Electromagnetic interference (EMI) and radio frequency interference (RFI), also known as electrical noise, do not usually cause problems. If intense enough, however, it can cause problems for other electrical equipment.

# SPECIFICATIONS

---

**Maximum Product Size:** ..... 12 x 12 in (304 x 304 mm)

**Minimum Product Size:** ..... 3.625 x 5 in (92 x 127 mm)

**Min./Max. Product Thickness:** ..... .003-.75 in (.076 x 19 mm)

**Conveyor Belt Speed:** ..... Variable up to 300 ipm (7620 mmpm)

**Electrical Requirements:** ..... 115vac, 60Hz, 3A

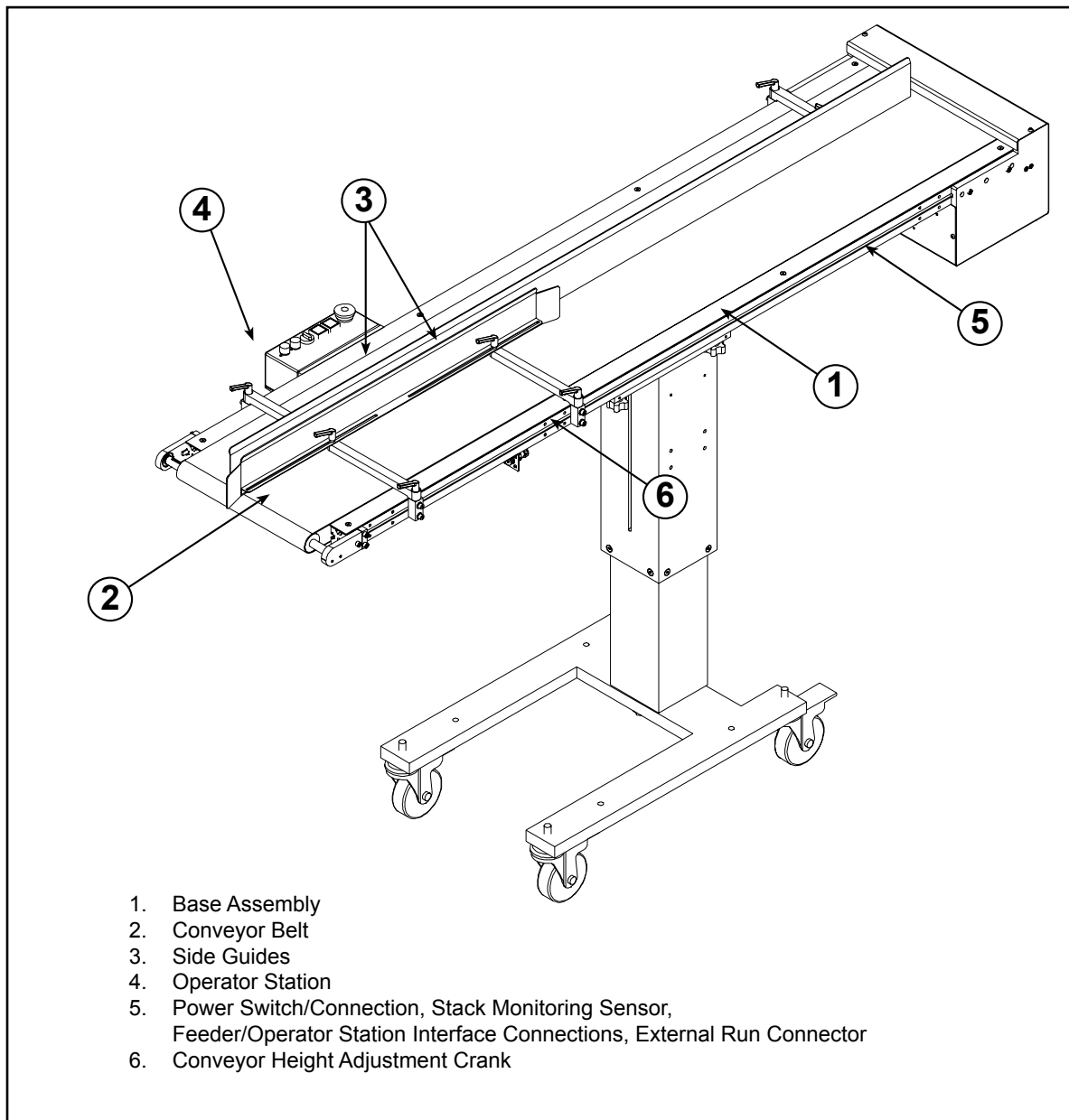
**Table Height (adjustable range):** ..... 45-58 in (1143-1473 mm)

# 1 About the Machine

---

The AutoStream Model P1 is designed for reliability, flexibility, and ease of use. All parts required for setup, loading, feeding, sensing and easy operator control is combined into one compact unit. Review the main assemblies to become familiar with names and locations of feeder parts and adjustments. This will help to prepare you for initial setup.

## Main Assemblies

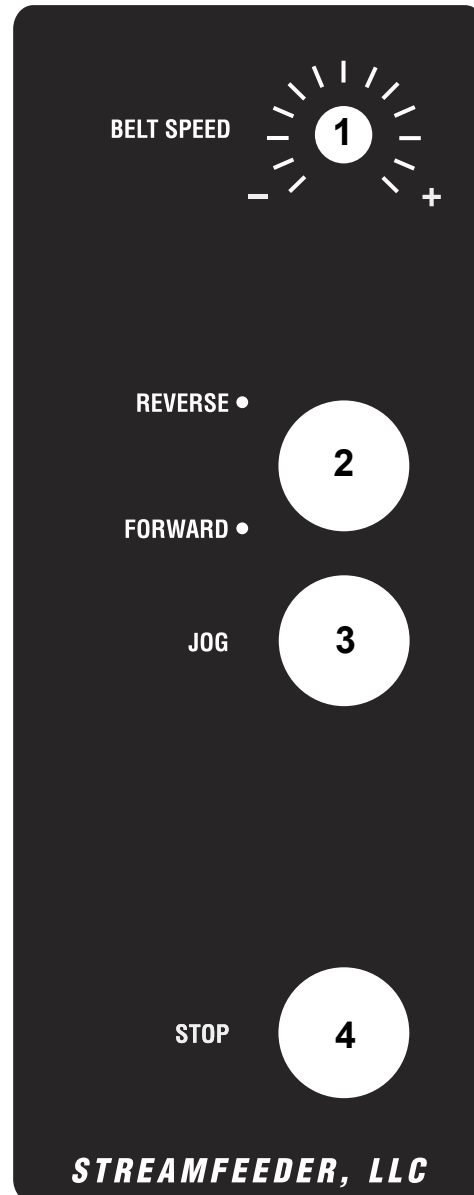




# Operator Station

## Operator Station

1. Belt Speed Control Knob: Turn clockwise to increase speed, counterclockwise to decrease speed.
2. Forward/Reverse Selector Switch: Selects conveyor direction.
3. Jog: Jogs the conveyor.
4. Stop Button: Stops all motors.



## 2 Operation

---

### Overview

#### IMPORTANT

##### CONDITION OF INSTALLMENT:

*Warning decals must be visible to machine operator.*

Preparing for operation is based on the material you are going to run. The following are basic guidelines. Additional adjustments will be necessary in order to properly feed product. After all the adjustments have been made, be sure to test run to verify the settings.

### STEP 1: Connecting Power



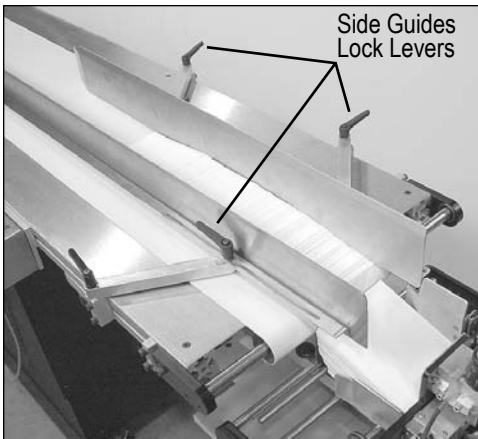
The AutoStream must only be connected to a 110-120VAC source, and the power entry module must be set for 115V.

1. Before powering on, make sure the 115V tag is showing through the window in the power entry module. If the 220V tag is showing, the module must be opened and the switch block must be removed, turned 180 degrees and re-inserted so the 115V tag shows through the window when the receptacle is closed.
2. The AutoStream is protected by two 5A/250V fuses. These fuses are located inside the power entry module. To replace/inspect the line fuses, open the module and remove the switch block. In each side of the switch block is a 5A/250V fuse. If the fuse has blown, it will normally show discoloration. Replace the blown fuse with a new fuse of the same type and rating. Re-insert the switch block, making sure the 115V tag shows through the window when the module is closed.
3. Make sure the power switch is set to the OFF position.
4. Connect the power cord to the AC socket in the power entry module. Connect the other end of the power cord to an earth grounded 110-120VAC outlet.

### STEP 2: Height Adjustment

The discharge of the conveyor must be set slightly higher than the component it is feeding. Loosen the lock lever, then turn the height adjustment crank to set the height.

## STEP 3: Conveyor Set Up



### Procedure

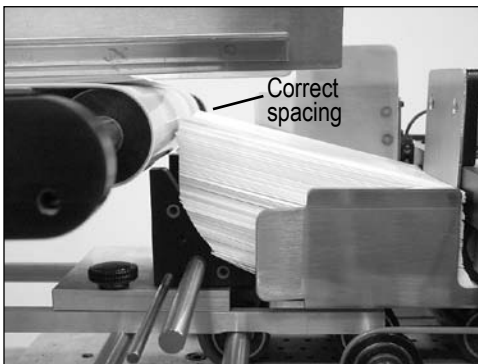
The conveyor side guides are adjustable to accommodate the varying sizes of products. To adjust, loosen the levers and slide the side guides open to allow for wider material or closed to allow for narrower material.

Place shingled product between the guides. Press the conveyor jog button to advance product toward the feeder.

Place product into the hopper of the feeder below the level of the feeder side guides.

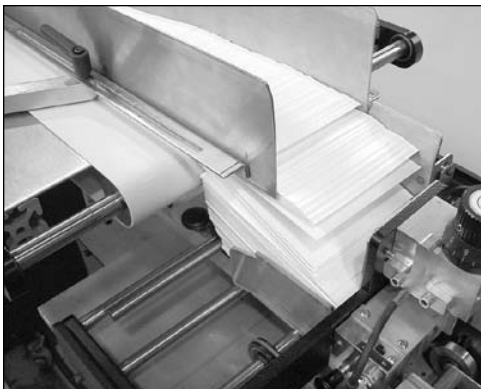


*The conveyor belt will continue to advance even if the speed control is turned all the way down. To stop all motors, press the STOP button.*



The discharge of the conveyor must be set above the feeder to allow product to fall into the hopper. Release the docking plate by loosening the lock knobs and lever. Then turn the conveyor height adjustment crank to set the height of the conveyor.

The front edge of the conveyor belt must be set approximately 1/16 in (depending upon product type) from the product in the feeder hopper. This keeps product that rests above the feeder back wedge from slipping back towards the conveyor. With the docking lock lever tightened, loosen the 2 conveyor base adjust lock knobs to move the conveyor base forward or backward.

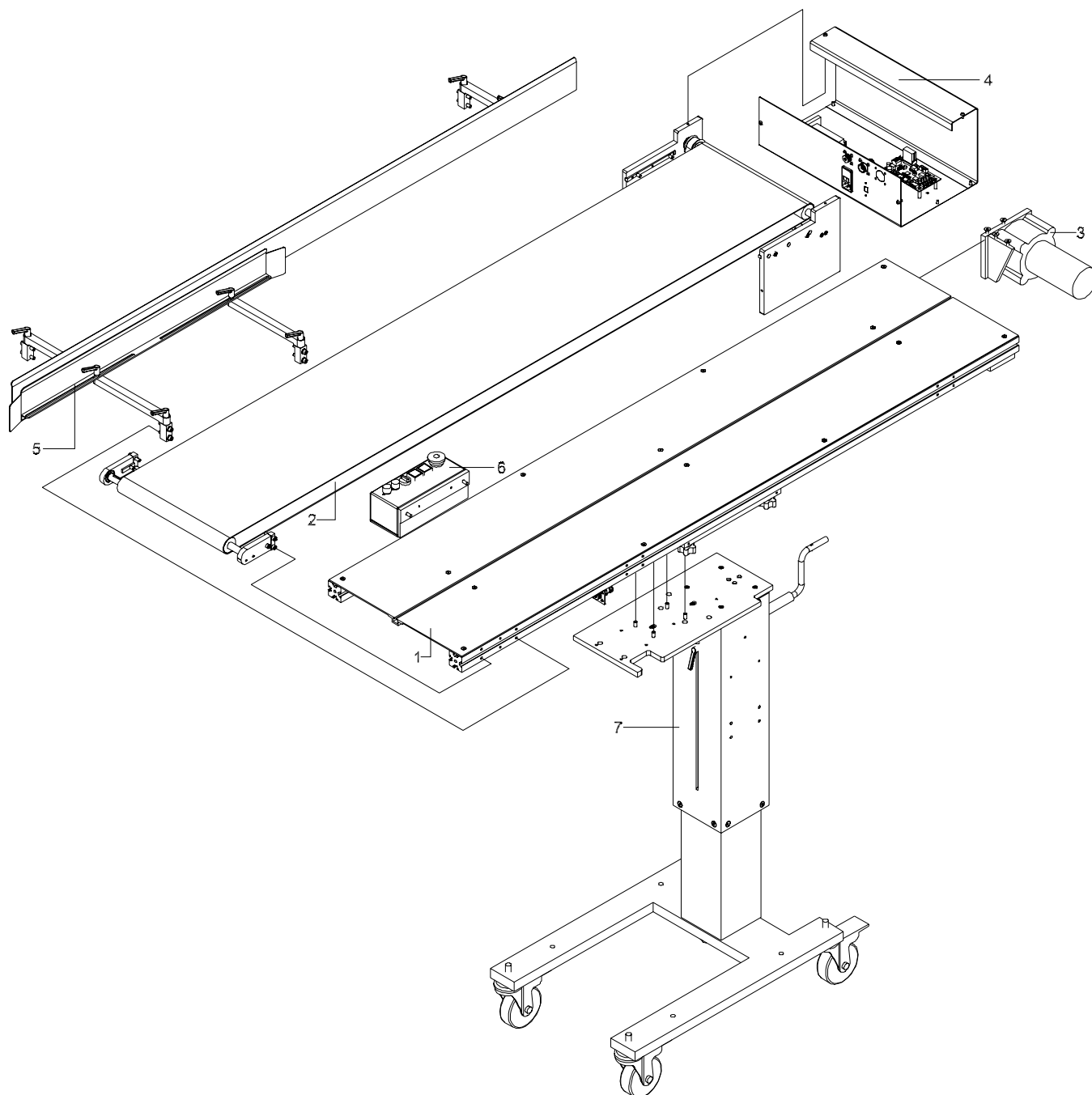


**Product evenly dropping into hopper**

Start the feeder and conveyor at slow speed to test. Product discharged from the conveyor must be set at a speed sufficient to strike the feeder's gate plate and fall evenly into the hopper. Adjust the speed controls until the conveyor drops a constant, even level of product into the feeder hopper.

# 3 Mechanical Components

## AUTOSTREAM P1

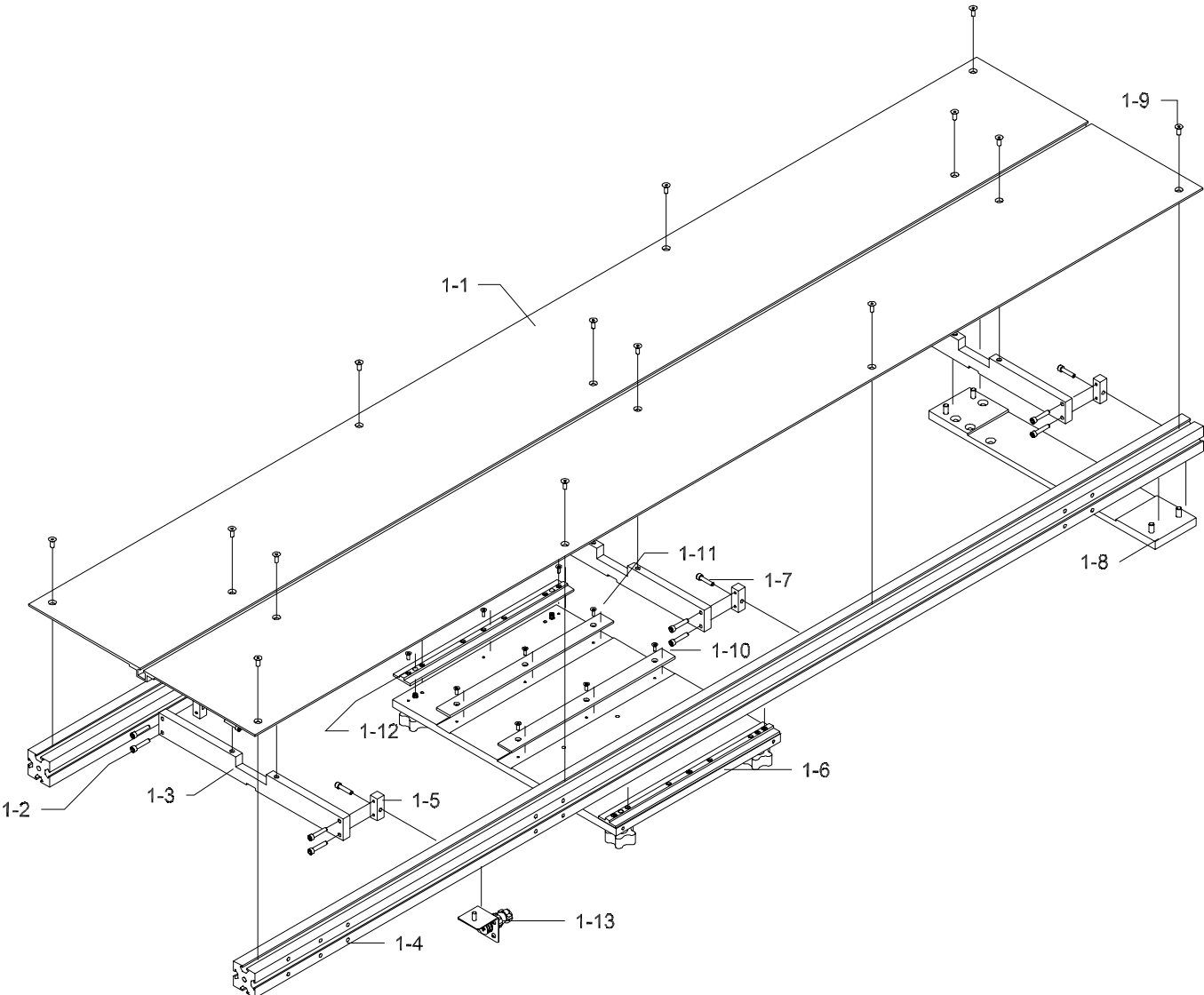


## **AUTOSTREAM P1**

<b>Diagram Number</b>	<b>Description</b>	<b>Part Number</b>
<b>1</b>	P1 BASE ASSEMBLY	14971112
<b>2</b>	BELT ASSEMBLY	14971102
<b>3</b>	MOTOR ASSEMBLY	14971103
<b>4</b>	MOTOR ENCLOSURE ASSEMBLY	14971124
<b>5</b>	SIDE GUIDE ASSEMBLY	14971104
<b>6</b>	REMOTE BOX ASSEMBLY	14971132
<b>7</b>	STAND ASSEMBLY	51021034
<b>NS</b>	OPTIONAL DOCKING STATION STANDARD ASSEMBLY	14971113
<b>NS</b>	OPTIONAL DOCKING STATION HEAVY ASSEMBLY	14971114

NS = NOT SHOWN

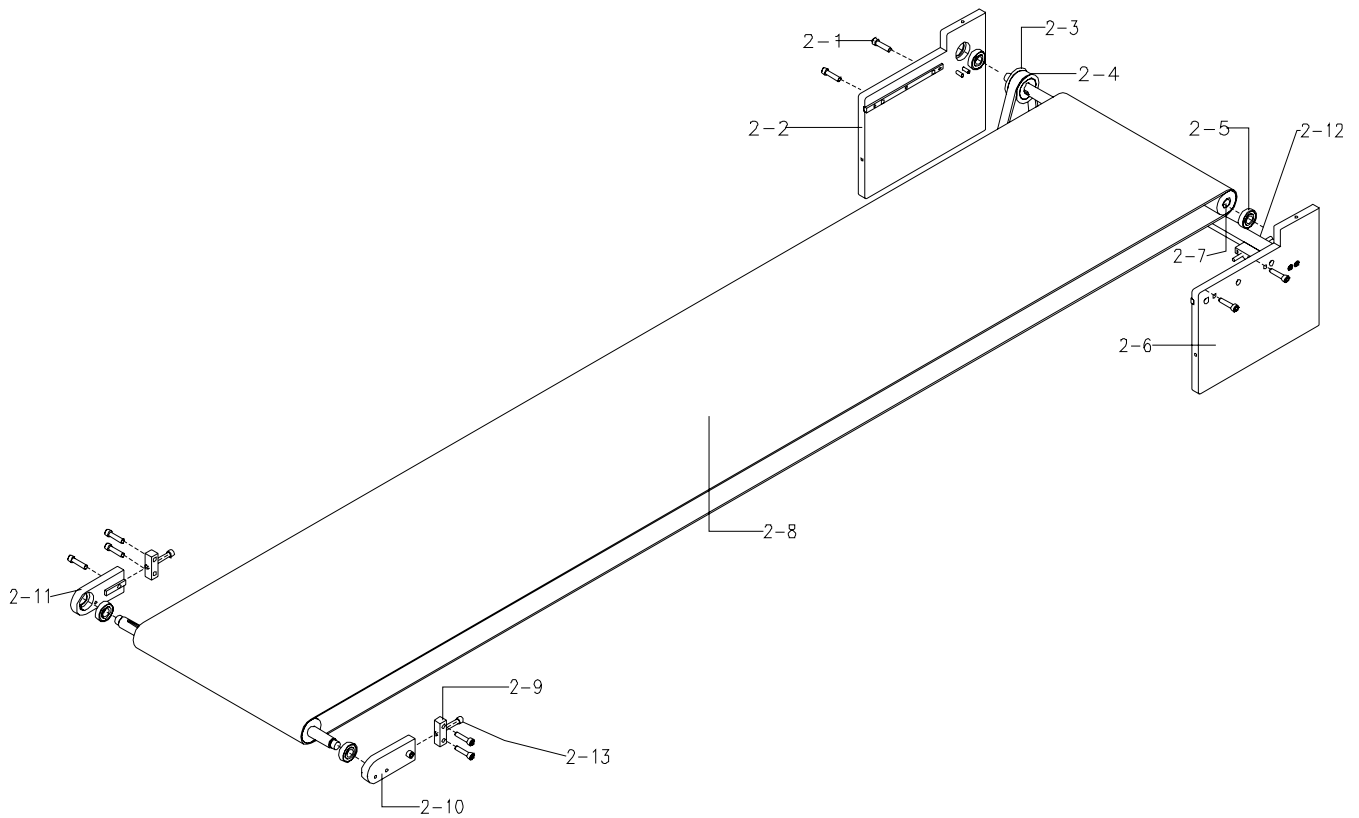
**P1 BASE ASSEMBLY**  
**Assembly # : 14971112**



**P1 BASE ASSEMBLY**  
**Assembly # : 14971112**

<b>Diagram Number</b>	<b>Qty</b>	<b>Description</b>	<b>Part Number</b>
1-1	1	Panel Top	51497015
1-2	12	SHCS 10-32 X 1	00002335
1-3	3	Support Deck	51497024
1-4	2	Rail	51497011
1-5	6	Mount Deck Support	51497025
1-6	1	Support Stand	51497009
	4	5 Lobe Knob	44947121
	4	Set Screw 1/4-20 X 1-1/2	00003399
1-7	6	SHCS 10-32 X 7/8	00003302
1-8	1	Bracket Motor Mount	51497027
	4	SHCS 1/4-20 X 1	00002390
1-9	14	FHSHCS 10-32 X 1/2"	00002830
1-10	3	Block Belt Support	51497060
1-11	9	FHSHCS 6-32 X 3/8	00002235
1-12	2	Slide Rail Mount	51497066
	6	BHSHCS 6-32 X 3/8	00003314
1-13	1	Bracket Harness Extension	51497070
	1	BHCS 10-32 X 1/2	00002334
	1	Harness Sensor Extension	14971121
	4	BHCS 6-32 X 1/4	00003305
NS	16	Nut T Slide 1/4-20	51208214
NS	15	Nut T Slide 10-32	51390108
NS	1	Photo Sensor Mount	51497051
NS	1	Sensor Assembly	63011038
NS	4	Washer Flat #10	00002605
NS	1	Graphic Set	51497067
NS	4	Set Screw 1/4-20 X 1"	00002390

**BELT ASSEMBLY**  
**Assembly # : 14971102**

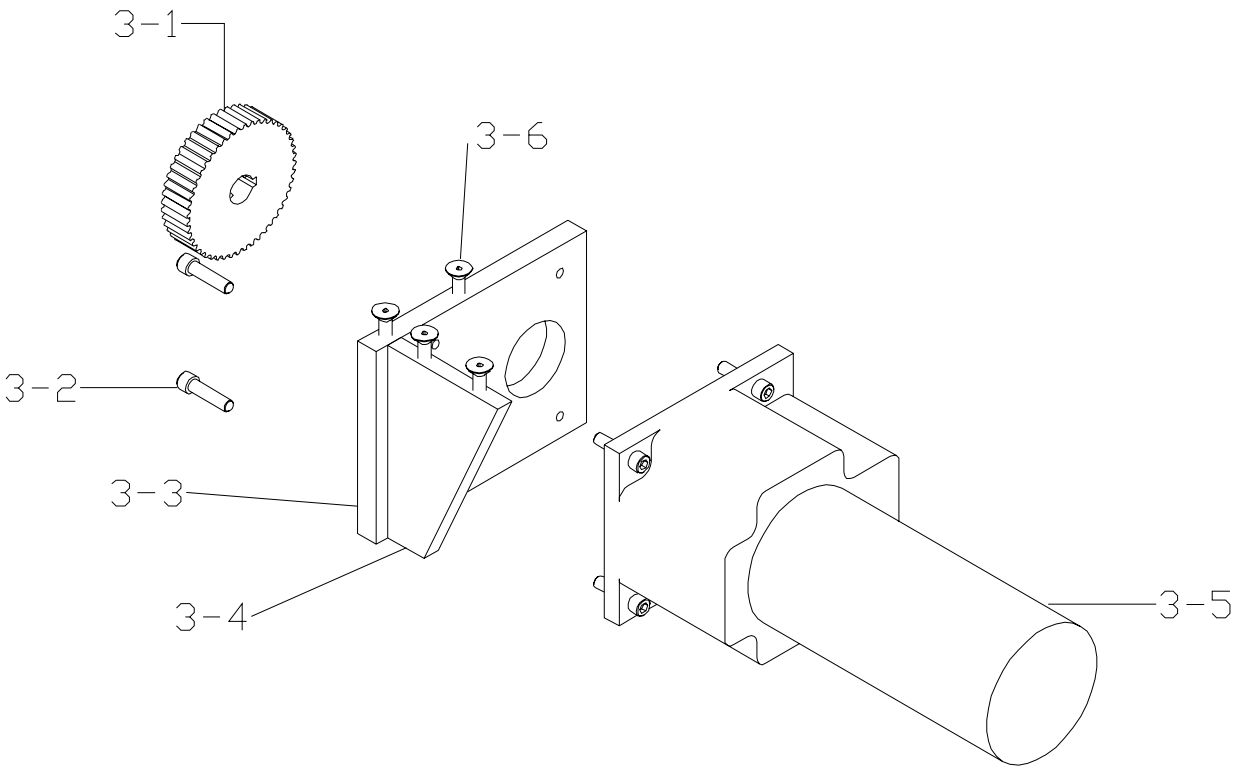




**BELT ASSEMBLY**  
**Assembly # : 14971102**

<b>Diagram Number</b>	<b>Qty</b>	<b>Description</b>	<b>Part Number</b>
2-1	10	SHCS 1/4-20 X 1	00002390
2-2	1	Shaft Mount Rear Right	51497062
	2	SHCS, 10-32 x 3/4	00002825
2-3	1	Timing Belt, 5MR375-15	51497144
2-4	1	Pulley Timing 24 Tooth	51497141
2-5	4	Bearing Ball R8	23500094
2-6	1	Shaft Mount Rear Left	51497063
	2	SHCS, 10-32 x 3/4	00002825
2-7	2	Shaft Drive	51497007
	2	Roller Drive	51497014
2-8	1	Belt Transport	51497016
2-9	2	Mount Side	51497012
2-10	1	Mount Driven Roller Right	51497017
2-11	1	Mount Driven Roller Left	51497018
2-12	1	Tensioner Bar	51497140
	2	Tensioner Spacer	51497143
	4	SHCS, 8-32 x 1	00002303
	2	SSSCPPT, 10-32 x 1/8	00003352
	2	Set Screw, 10-32 X 3	00003379
2-13	2	SHCS 1/4-20 X 1 3/4	00002329
NS	4	Set Screw 10-32 X 1/4"	00002205
NS	1	Key Stock 3/16	44852081

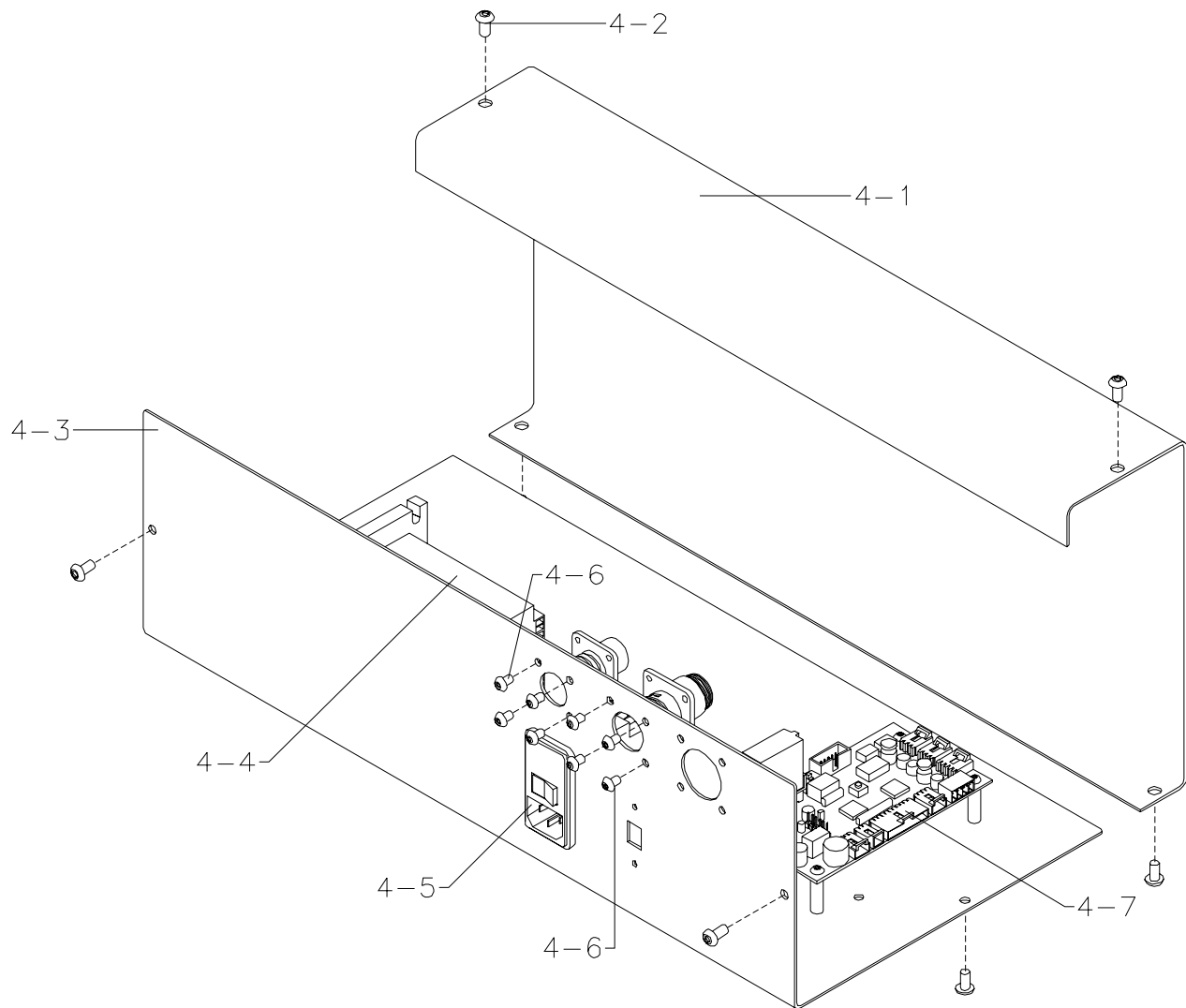
**MOTOR ASSEMBLY**  
**Assembly # : 14971103**



**MOTOR ASSEMBLY**  
**Assembly # : 14971103**

<b>Diagram Number</b>	<b>Qty</b>	<b>Description</b>	<b>Part Number</b>
3-1	1	Pulley Timing 48 Tooth	51497142
3-2	10	SHCS 1/4-20 X 1	00002390
3-3	1	Mount Motor	51497028
3-4	1	Gusset	51497031
3-5	1	Motor	51497026
3-6	4	FHSHCS 1/4-20 X 3/4	00003395
NS	1	Plug 3 Pin	53500385
NS	3	Male Pin	53500386
NS	10"	Varflex	44649085

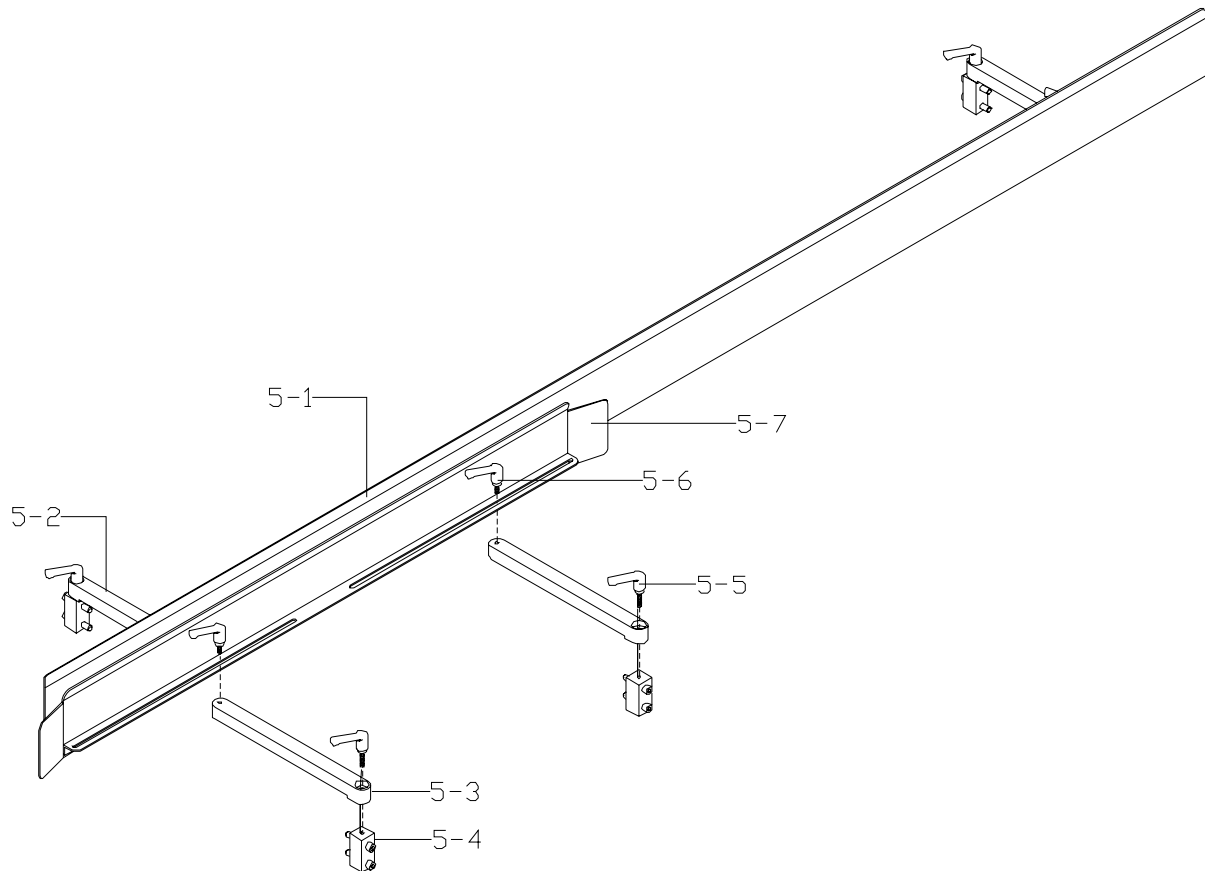
**MOTOR ENCLOSURE ASSEMBLY**  
**Assembly # : 14971124**



**MOTOR ENCLOSURE ASSEMBLY**  
**Assembly # : 14971124**

<b>Diagram Number</b>	<b>Qty</b>	<b>Description</b>	<b>Part Number</b>
4-1	1	Cover Top	51497064
4-2	8	BHCS 10-32 X 3/8	00002805
4-3	1	Cover Back	51497061
4-4	1	DC Drive	51050252
4-5	1	Module Power AC	44649034
4-6	8	BHCS 6-32 X 1/4	00003305
4-7	4	BHCS 6-32 X 1/4	00003305
	4	Stand-Off	53500511
	1	PCB	44841015
	4	PHMSPH 6-32 X 3/8" W/Washer	00002450
NS	2	Fuse, 5.0A 250V Slo-Blo 5x20mm	53500558
NS	1	Cord Power 115VAC IEC 3-Prong	53500002
NS	1	Harness Inhibit	14971120
NS	1	Harness Power	14971118
NS	1	Harness Motor	14971116
NS	1	Harness Main	14971115
NS	2	Terminals	53500254
NS	4	Keps Nut	00002121
NS	1	Graphic Set	51497067

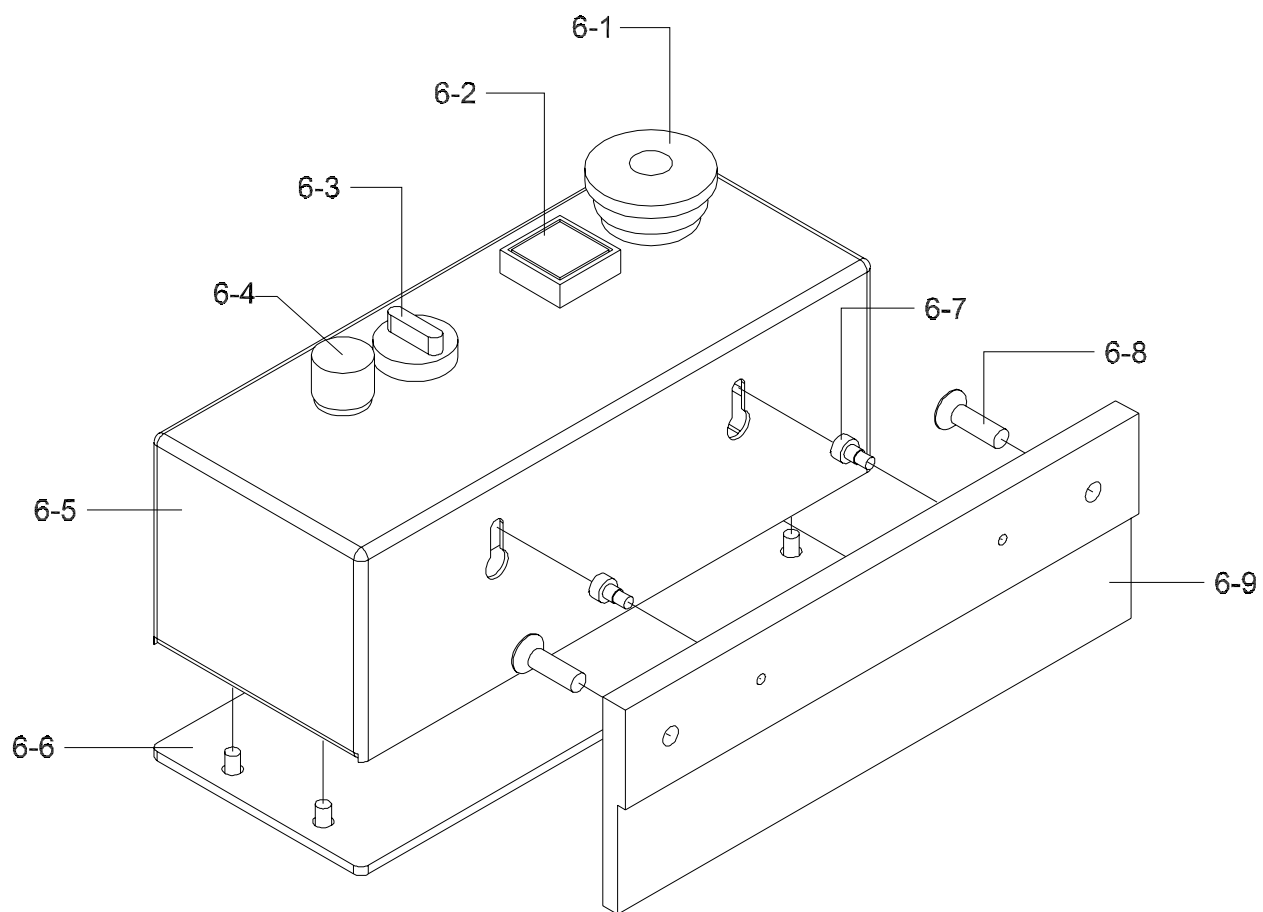
**SIDE GUIDE ASSEMBLY**  
**Assembly # : 14971104**



**SIDE GUIDE ASSEMBLY**  
**Assembly # : 14971104**

<b>Diagram Number</b>	<b>Qty</b>	<b>Description</b>	<b>Part Number</b>
5-1	1	Side Guide	51497019
5-2	2	Block Side Guide Adjust	51497022
5-3	2	Block Side Guide Adjust	51497128
5-4	4	Block Side Guide Mounting	51497023
	8	SHCS 1/4-20 X 1-1/4	00003372
5-5	4	Lever Adjustable Ratchet 10-32 X 3/4	43555098
5-6	4	Lever Adjustable Ratchet 10-32 X 1/2	43555097
5-7	1	Side Guide Front	51497020

**REMOTE BOX ASSEMBLY**  
**Assembly # : 14971132**

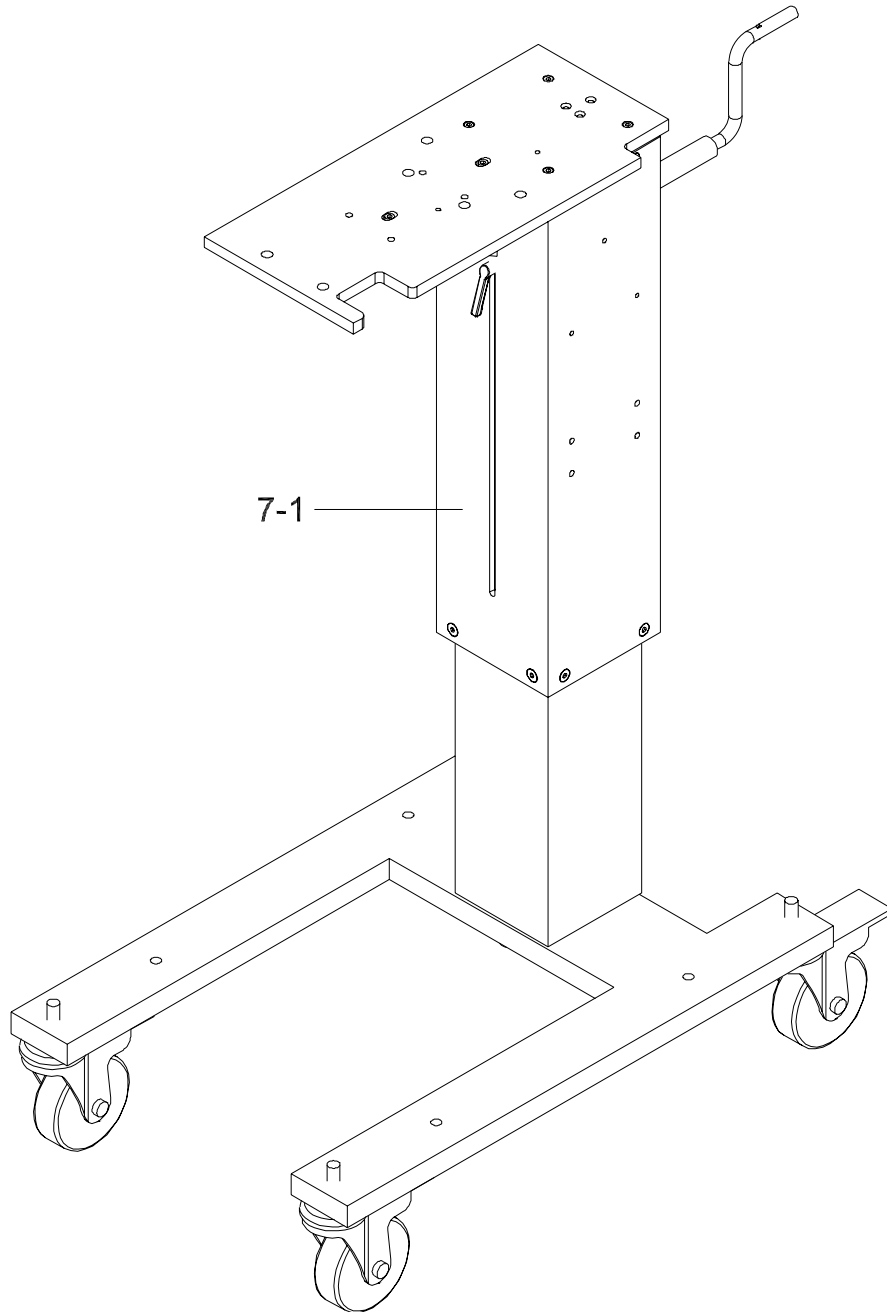




**REMOTE BOX ASSEMBLY**  
**Assembly # : 14971132**

<b>Diagram Number</b>	<b>Qty</b>	<b>Description</b>	<b>Part Number</b>
6-1	1	E-Stop 22mm	53500552
	1	Contact Block NC	51327025
6-2	1	Blue Button	51379088
6-3	1	Selector 3 Position	51379085
6-4	1	Knob	44675030
6-5	1	Remote Operator Station Enclosure	51460097
6-6	1	Plate Base Operator Station	51460099
6-7	2	Shoulder Bolt	00003321
6-8	2	FHSHCS 1/4-20 X 3/4	00003395
6-9	1	Remote Box Mount	51497068
NS	1	Harness Potentiometer	14971117
NS	1	Harness Operator Switch	14971119
NS	4	BHCS/SS 10-32 X 3/8	00002805
NS	2	Cable Tie Mount	00003402
NS	2	Cable Tie Black	435SO263

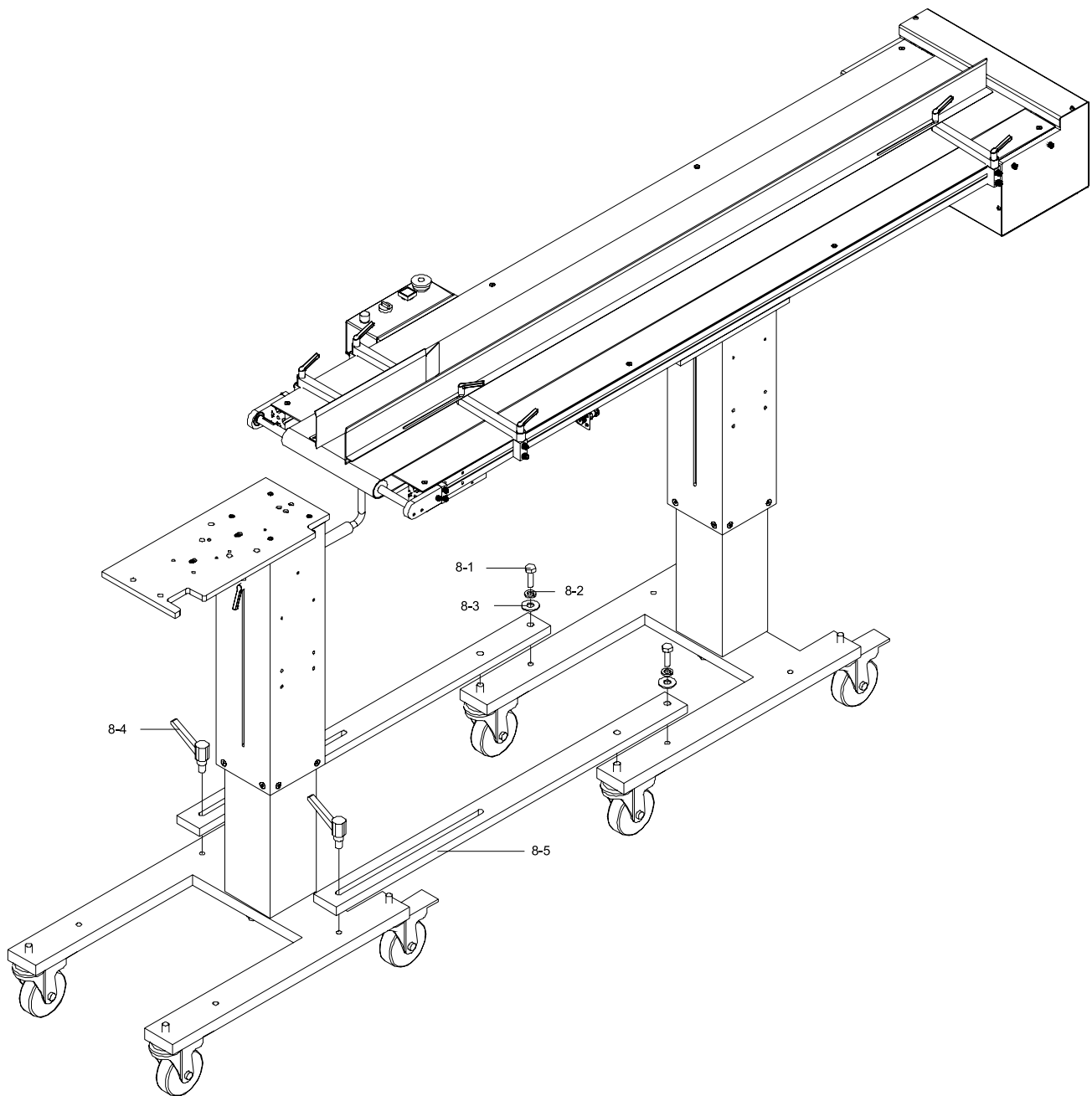
**STAND ASSEMBLY**  
**Assembly # : 51021034**



**STAND ASSEMBLY**  
**Assembly # : 51021034**

<b>Diagram Number</b>	<b>Qty</b>	<b>Description</b>	<b>Part Number</b>
7-1	1	Heavy Duty Stand 39" (Standard)	51021034
	1	Heavy Duty Stand 29" (Optional)	51021001

**OPTIONAL DOCKING STATION HEAVY DUTY ASSEMBLY**  
**Assembly # : 14971114**

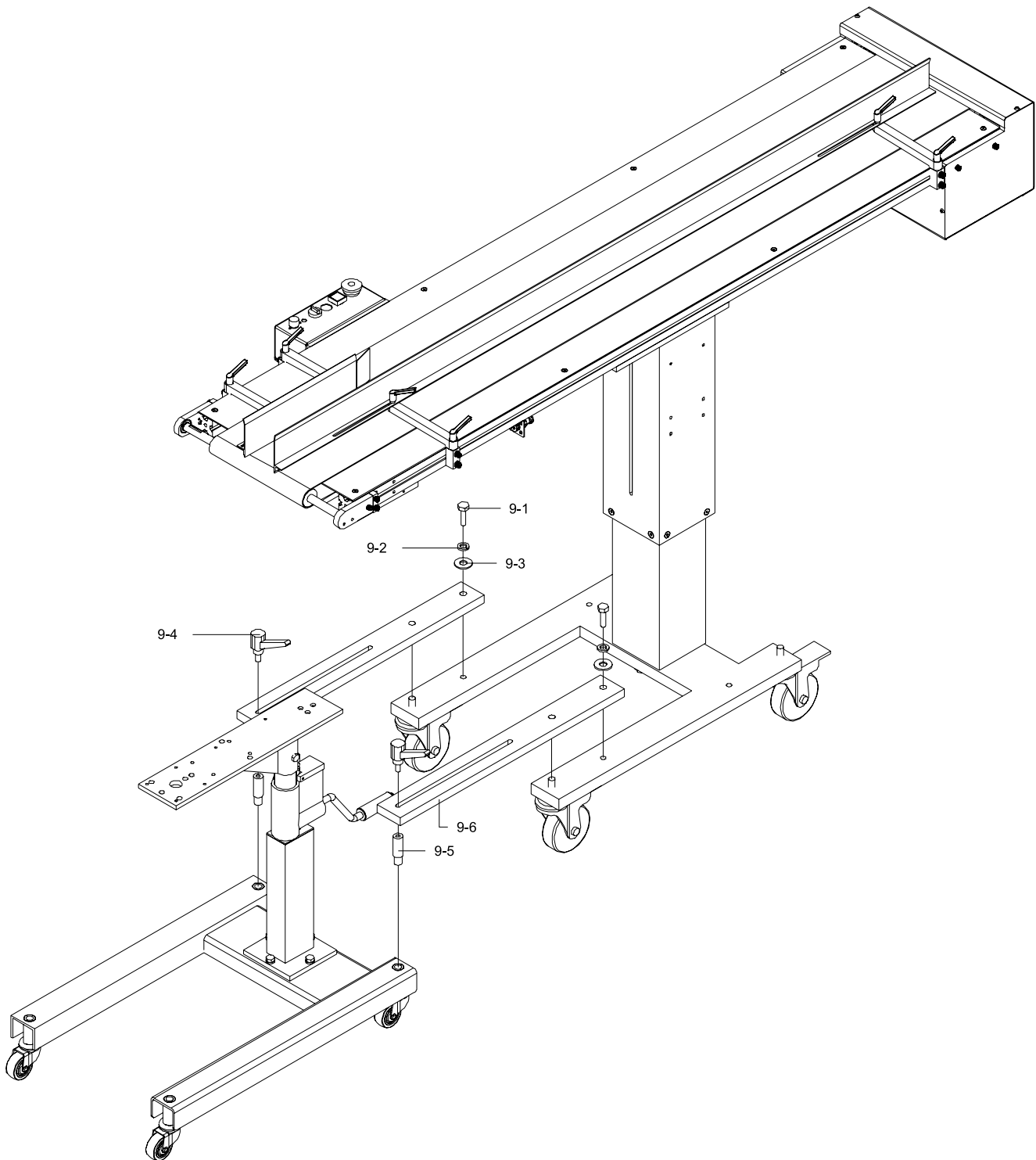


## **OPTIONAL DOCKING STATION HEAVY DUTY ASSEMBLY**

**Assembly # : 14971114**

<b>Diagram Number</b>	<b>Qty</b>	<b>Description</b>	<b>Part Number</b>
8-1	2	Hex Head Bolt 1/2-13 X 1-1/2	00003461
8-2	2	Lock Washer 1/2	00003462
8-3	2	Washer 1/2	00003483
8-4	2	Ratchet Handle	51497073
8-5	2	Support Bar	51497072

**OPTIONAL DOCKING STATION STANDARD ASSEMBLY**  
**Assembly # : 14971113**



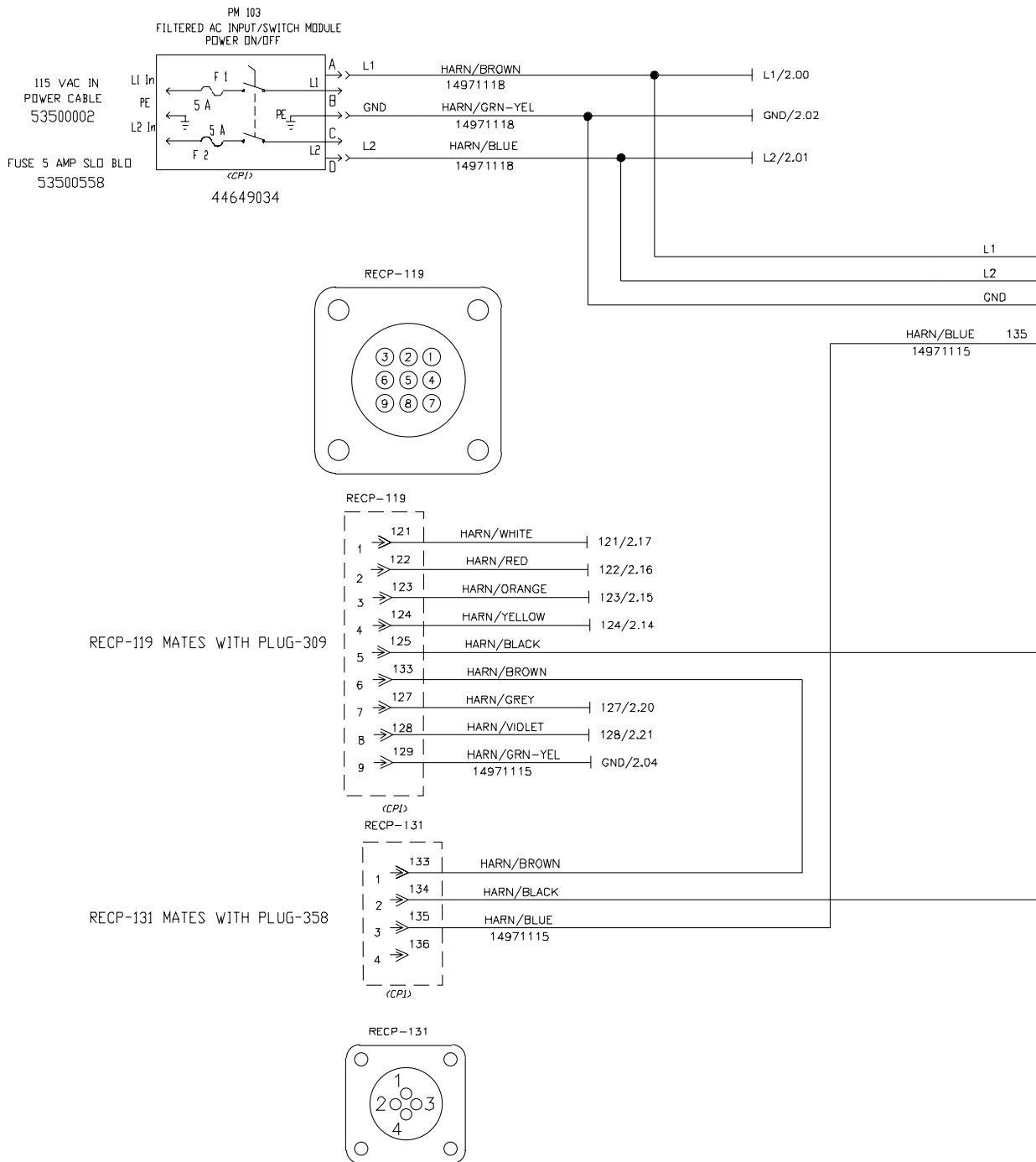
## **OPTIONAL DOCKING STATION STANDARD ASSEMBLY**

**Assembly # : 14971113**

<b>Diagram Number</b>	<b>Qty</b>	<b>Description</b>	<b>Part Number</b>
9-1	2	Hex Head Bolt 1/2-13 X 1-1/2	00003461
9-2	2	Lock Washer 1/2	00003462
9-3	2	Washer 1/2	00003483
9-4	2	Ratchet Handle	44775507
9-5	2	Docking Standoff	51497071
9-6	2	Support Bar	51497069

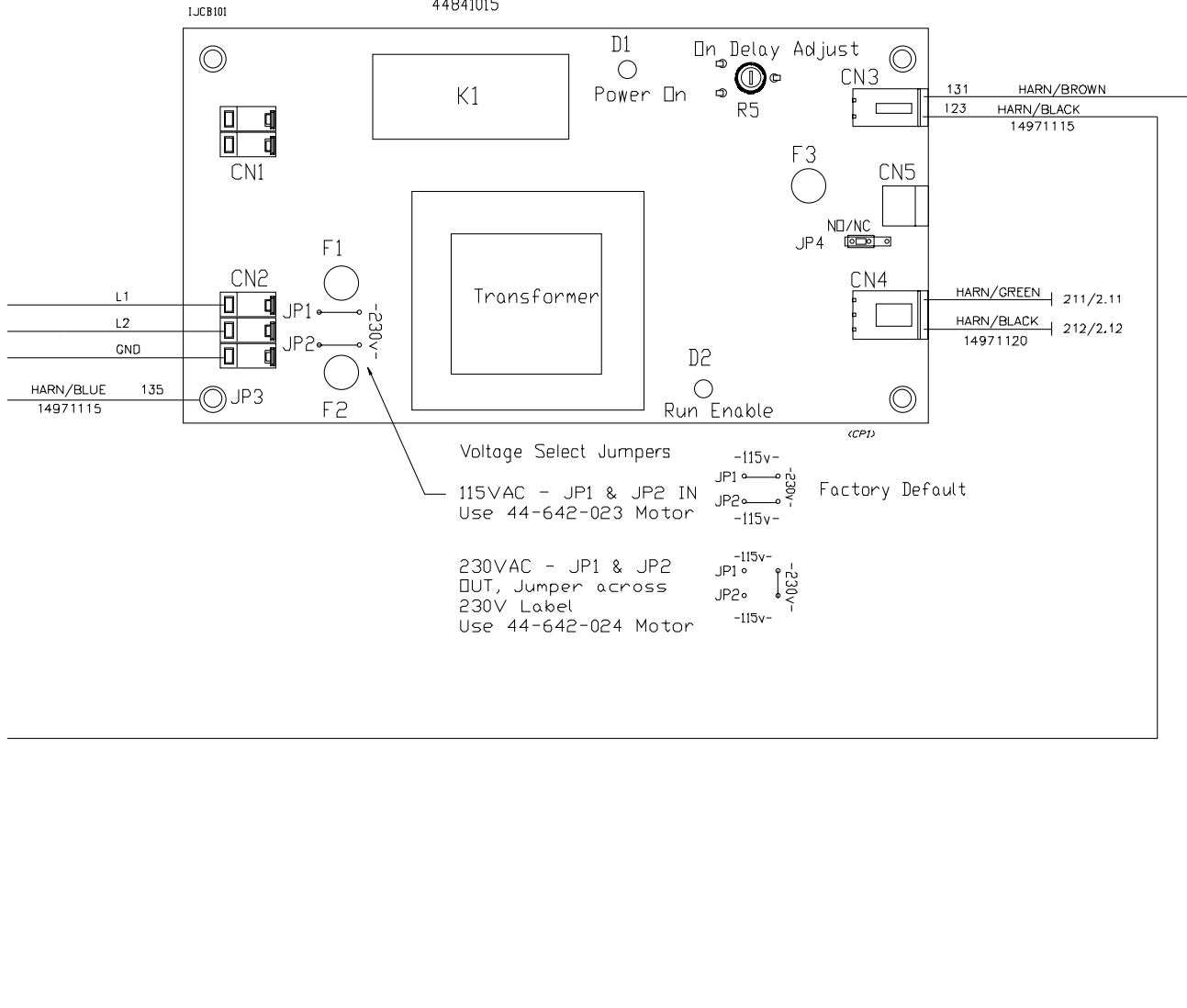
# 4 Electrical Schematics

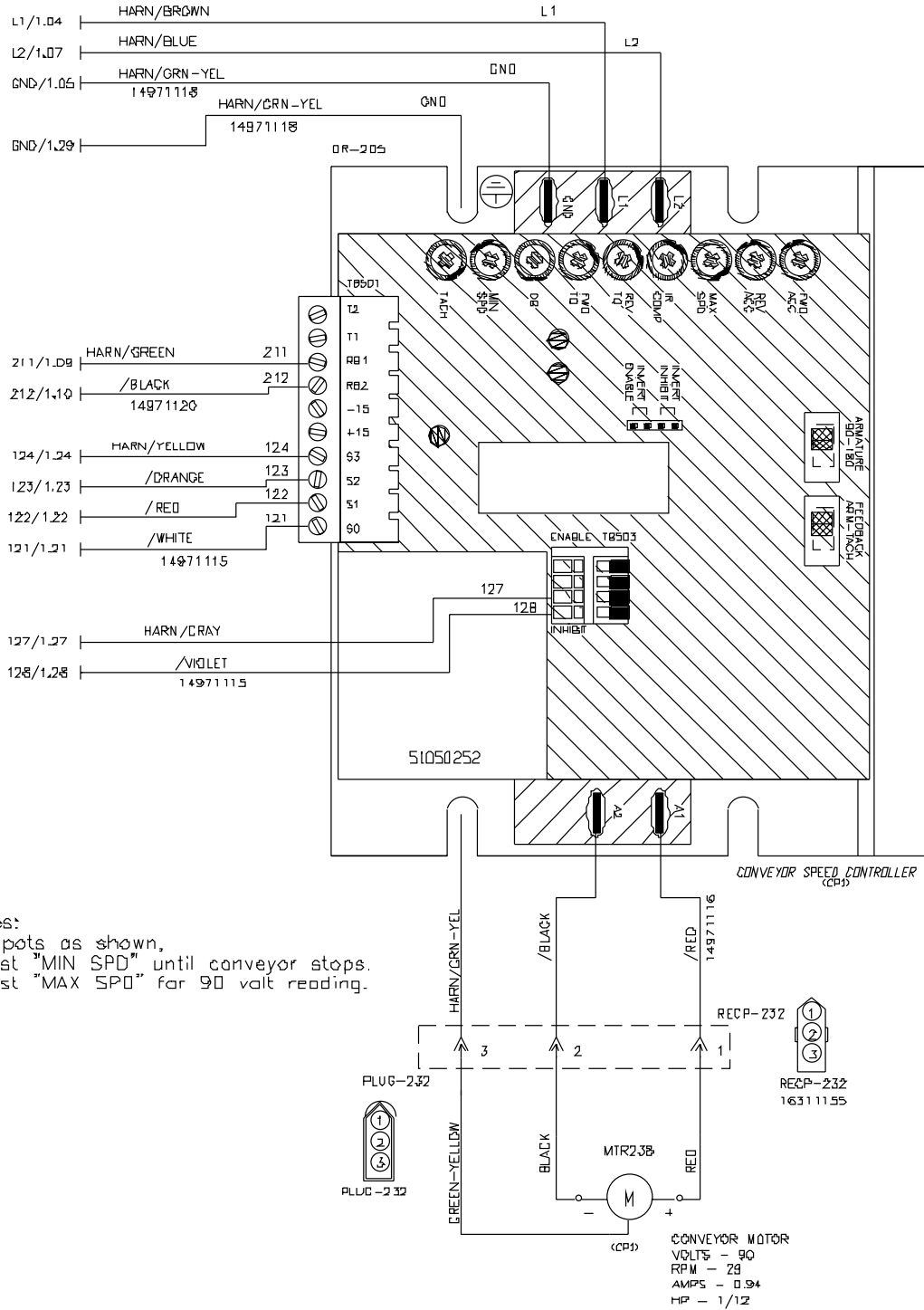
100  
101  
102  
103  
104  
105  
106  
107  
108  
109  
110  
111  
112  
113  
114  
115  
116  
117  
118  
119  
120  
121  
122  
123  
124  
125  
126  
127  
128  
129  
130  
131  
132  
133  
134  
135  
136  
137  
138  
139  
140  
141  
142  
143  
144  
145

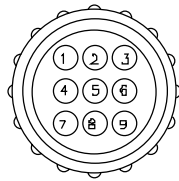




Board, V710 IJ Control  
44841015



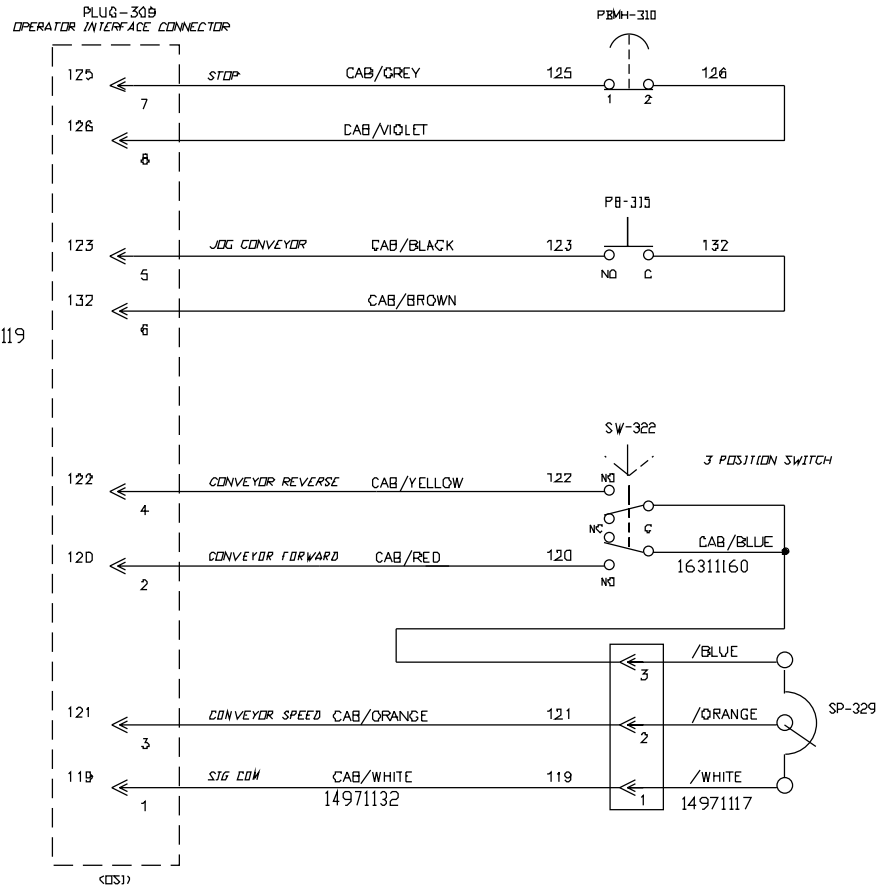




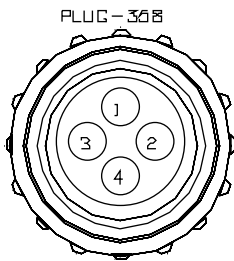
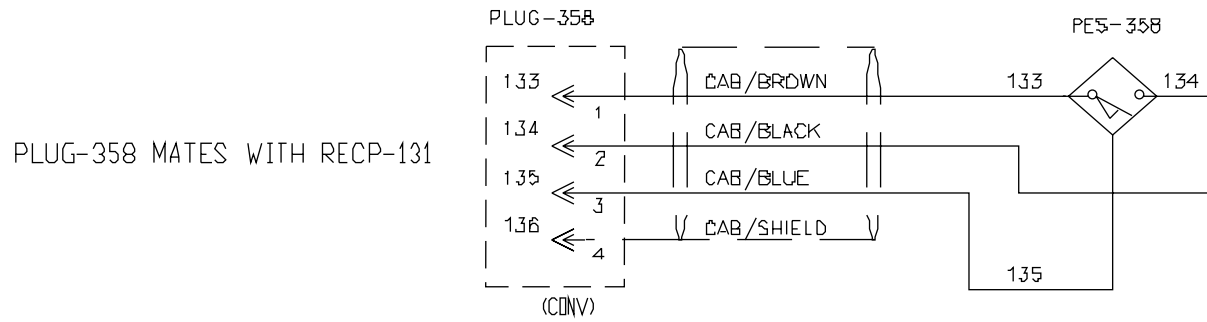
PLUG-309  
14971132

PLUG-309 MATES WITH RECP-119

## Remote Operator Station



# PHOTO EYE SENSOR







103 Osborne Road • Minneapolis, MN 55432-3131 USA  
TEL: 763.502.0000 • FAX: 763.502.0100  
E-MAIL: [service@streamfeeder.com](mailto:service@streamfeeder.com)  
WEB: [www.streamfeeder.com](http://www.streamfeeder.com)

