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# Pearl Mini Client Assembly Guide

## Preparing for Pearl Mini Commissioning & Training

*Prepared by Nicholas Flatoff*

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## Remove the Pearl from the Crate

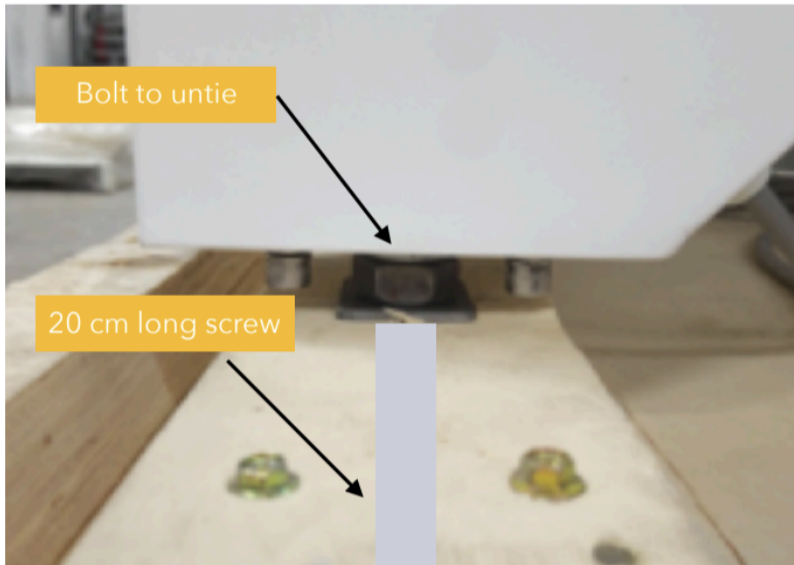


1. Once you remove the crate walls, you will see the following items:
  - a. Pearl Mini Hopper
  - b. Base
  - c. Pearl Mini Body
  - d. Accessories box
2. Please remove all items besides the Pearl body and organize them out of the way.

**Note:**The Pearl Mini body weighs 462kg/1019 pounds.

3. The Pearl Mini is equipped with lift points bolted to the top of the machine. Attach slings to the lift points of the Pearl Mini to lift it up. This requires a forklift. You then need to create enough space around the bolt so you can untie it. To do so, lift it up for about 5cm.

4. Then loosen the bolt, which will allow you to gradually release the Pearl Mini from the screw (pic) connecting it to the pallet.



5. If hex head machine screws are inserted in the feet of the body, remove those and put them in a convenient location you can access later.

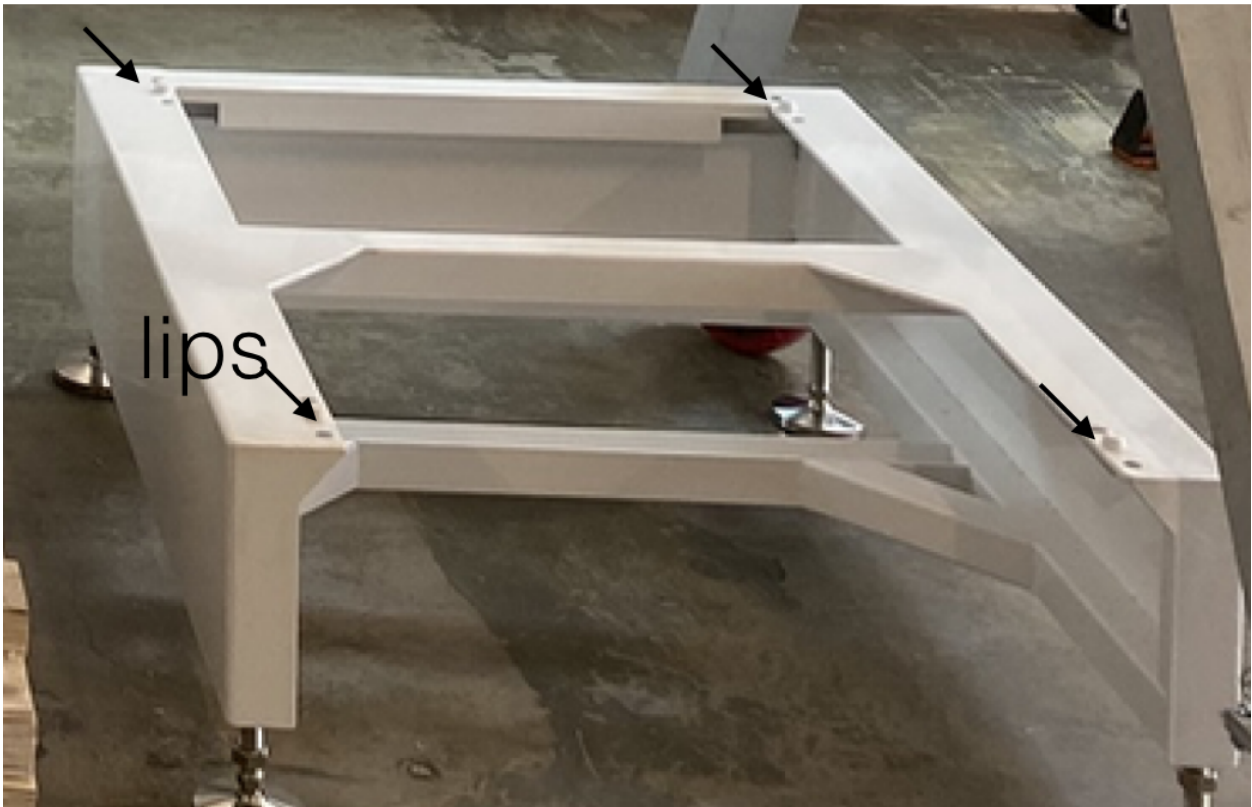
**ALTERNATIVES** If you don't have a forklift high enough to lift it up, you can lift it up with a jack stand and insert pallet jack forks below the Pearl.

## Assemble the Pearl Mini Body

1. Attach the feet (found in the Accessories Box) to the four corners of the base.
  - a. Make sure the bolts penetrate 1in/2.5cm into the base at a minimum
  - b. Make sure the base is relatively level
  - c. Snug the jam nuts on the feet against the base
2. Position the base in an area that's as close to the final location as possible but also provides room to maneuver the Pearl body from the crate to the base.
3. Lift the Pearl Mini body and maneuver it over the base.
  - a. Two commonly used options include a forklift or a winch/hoist:



4. Carefully lower the body onto the base, ensuring the lips on the base slot into the holes on the body.

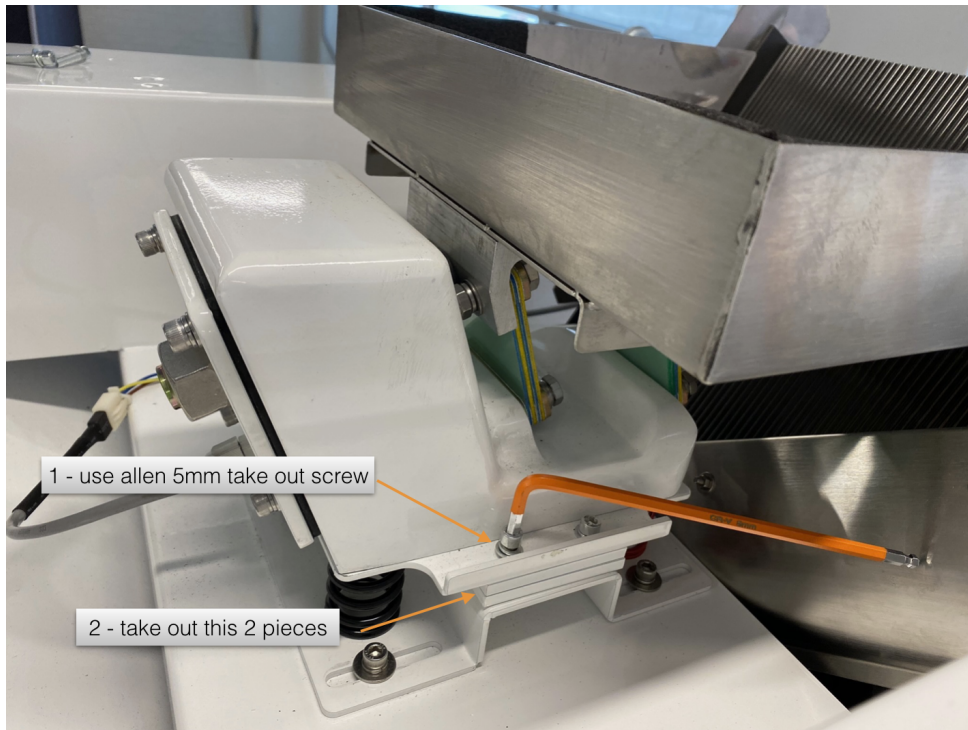


5. Install the appropriately sized hex head fasteners through the bolt points on the base and tighten them into the body to secure the body to the base.
6. Remove the central support bar using a 6mm allen key. Screw them back once the central bar is taken out.

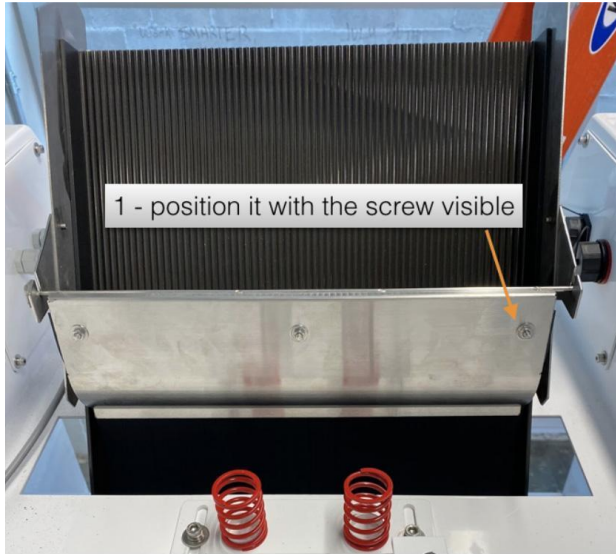


## Assemble the Feeder Mechanism

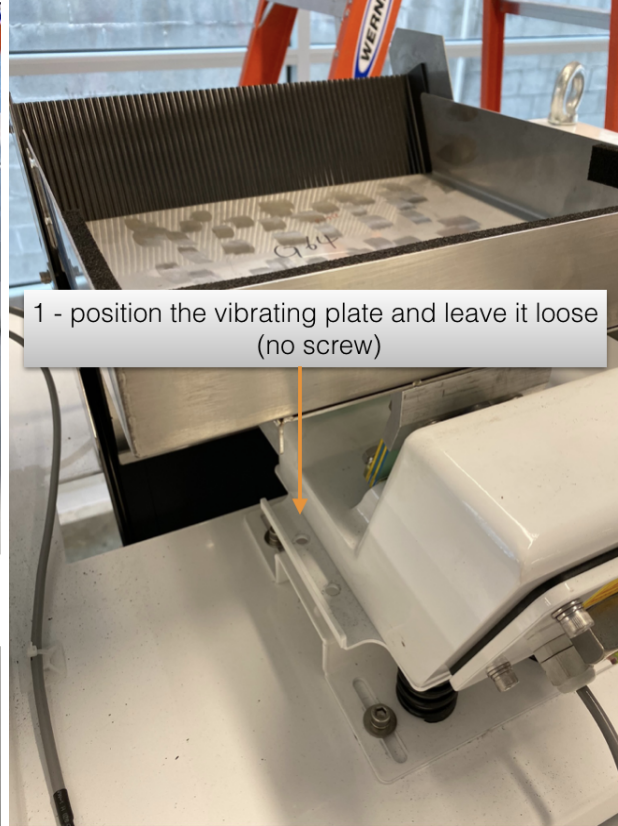
1. On the top of the machine, remove the shipping support brackets from the vibrator:



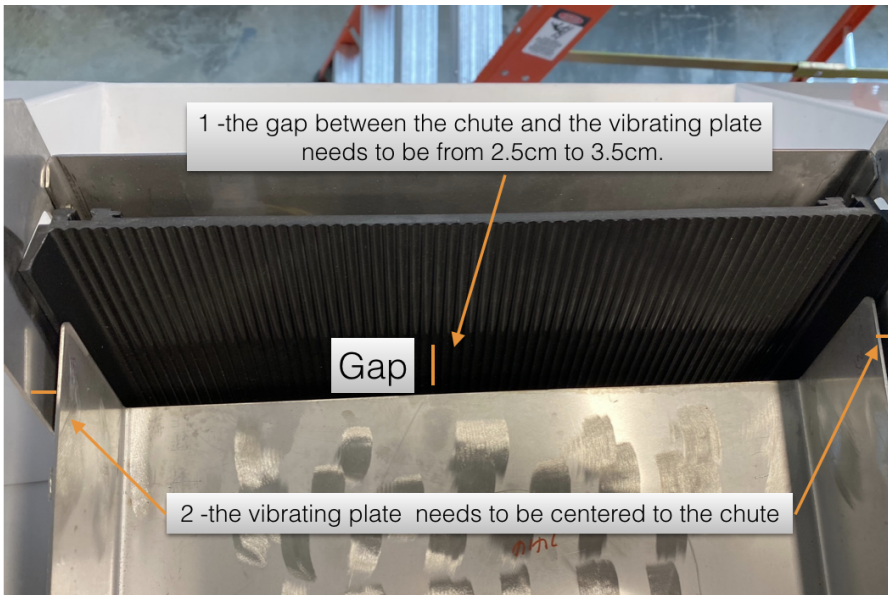
2. Insert the black teflon feeder fins (flat-packed in cardboard) so they curve towards the black chute:



2 - Red Springs towards the rear, while facing the Black Springs towards the front of the Pearl



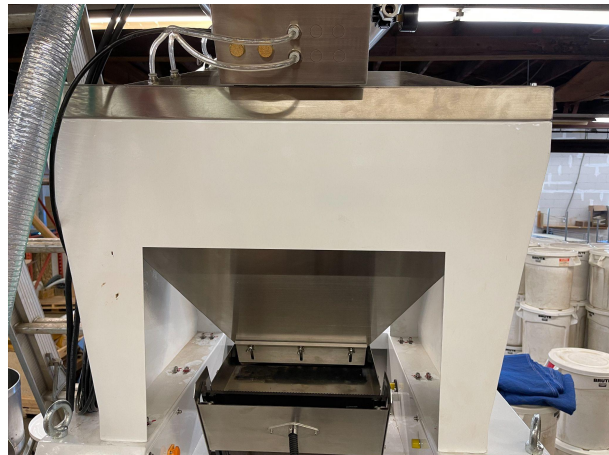
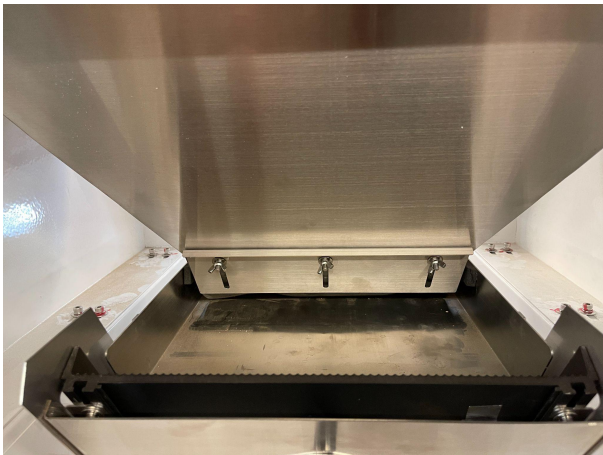
3. Verify the vibrating plate is well positioned as in the picture:



- a. If you don't have 2.5cm to 3.5cm you will need to loosen the 4 screws at the base of the vibrator plate so the vibrator can be adjusted. **Do not fully remove the screws, or the bolt plate they attach to will drop into the machine.** Simply loosening them slightly will be sufficient.

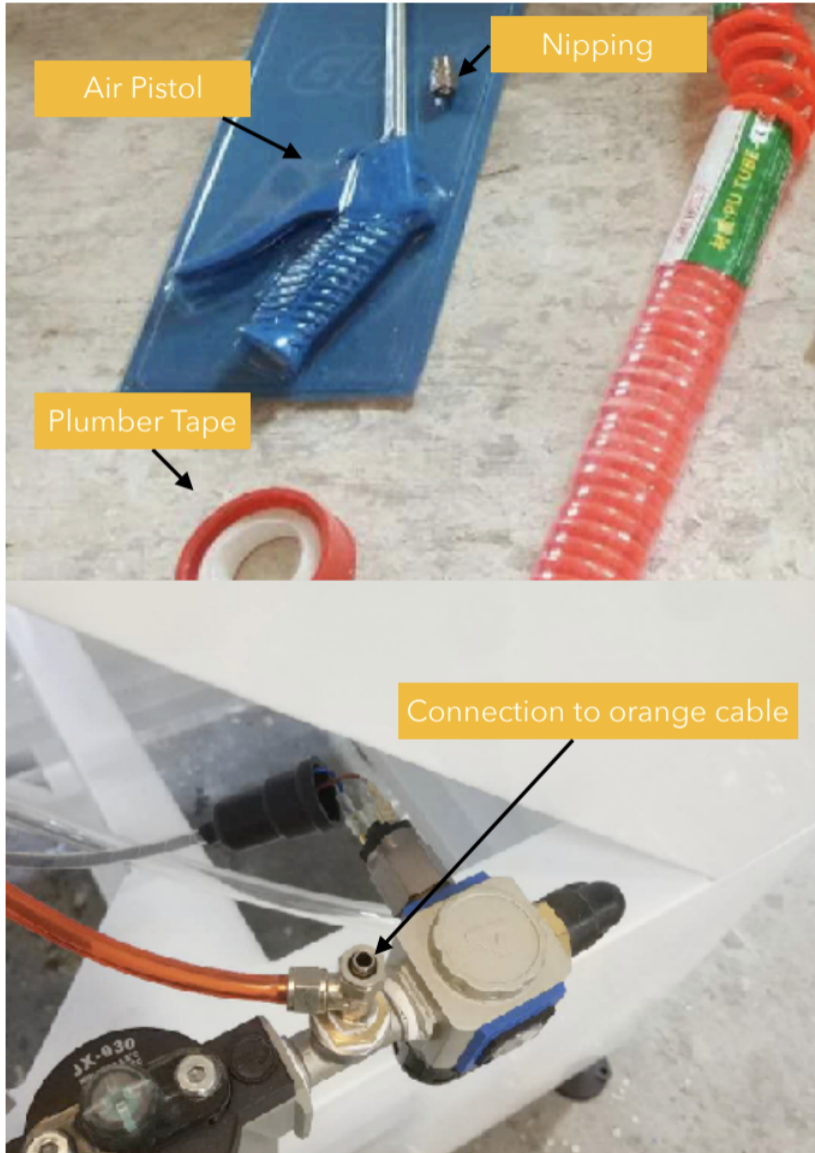
## Attaching the Hopper

1. Before lifting the hopper, note that the hopper has a Front and a Back. The Back of the hopper is equipped with an adjustable feed plate attached with 3 wingnuts.
  - a. If there is a rubber material between the feed plate and the hopper, remove the feed plate, discard the rubber, and re-attach the feed plate.
2. Lift the hopper to the top of the Pearl and slide it into position.
  - a. The feed plate and 3 wingnuts should be pointed towards the back of the machine
  - b. The bolt holes in the body of the Pearl should be visible through the hopper's bolt mounting slots
  - c. There should be 5-10mm clearance between the vibrator and the hopper outlet on the left, right and front of the machine.
3. Using hand tools, carefully secure the hopper to the base of the Pearl Mini using provided machine screws from the Accessories box.
  - a. Power tools will cause galling and consequent breakage of the machine screws.
4. The below photos are taken from the back of the machine, showing proper orientation. A change order and additional charges may be assessed during commissioning if the hopper needs to be re-oriented.





## Assemble the Air Gun



1. Remove the pipe nut from the nipping and slide it onto the orange airline with the threads facing the close end of the airline.
2. Force the nipping into the orange airline and tighten the pipe nut onto the nipping
3. Make 3 loops around the nipping using the provided plumber tape.
4. Torque the nipping into the bottom of the air pistol
5. On the Pearl Mini, remove the pipe nut from the nipping and slide it onto the opposite end of the orange airline with the threads facing the close end of the airline.
6. Force the airline onto the Pearl Mini nipping and torque the pipe nut onto it.

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## Level The Machine

1. Loosen the jam nuts on all feet.  
**Warning:** Do not over-extend the feet. Leveling by dropping the high side rather than increasing the low side will avoid this. If the threads on the foot disengage from the threads in the machine, the machine can fall over.
2. Using a level or electronic leveler (including phone based apps), adjust the length of the feet on the front of the machine so the front is level left to right.
3. Adjust the rear feet so the sides are level front to back.
4. Double check that all sides are level and torque the jam-nuts against the base of the machine.

## Connect the Airline and Electrical

**Note:** All airlines must be connected prior to your commissioning. If airlines are not connected, a change order and additional install fees may be assessed. Please find additional information in your Site Preparation Guide or To Read First document. It may be advantageous to install your lift before performing this step, since the lift also requires a compressed air connection.

1. Using either the provided line or locally sourced line, insert the line into the push-connect elbow located on the front of the Pearl's airtrain (usually located on the left side of the machine).
2. Run the airlines in your preferred manner
3. Connect the airline to your shut-off valve installed in accordance with your Site Preparation Manual.
4. Validate the power plug on the Pearl matches the outlet your electrician installed.
5. Validate that the power cord reaches your provided outlet.

## Next Step: Install the Lift

Congratulations, you have completed the assembly of your Pearl Mini! The next step is to install your lift system onto your Pearl. Information on this can be found in your To Read First document provided by your TBA.