

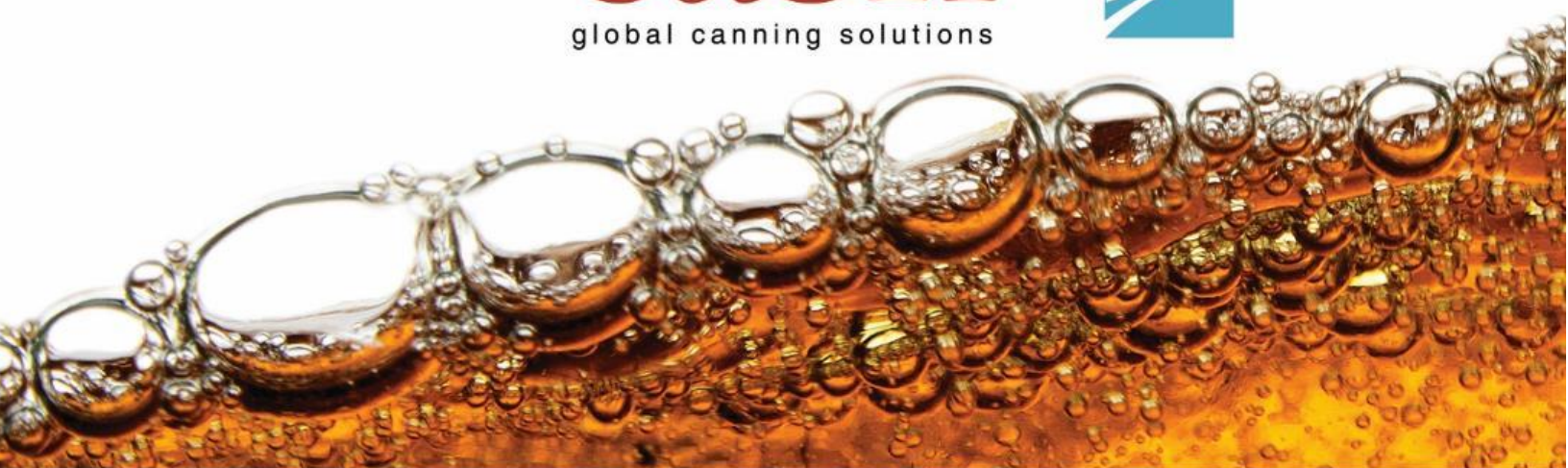
# Automated Depalletizer V3.0 Operation Manual

CASK BREWING SYSTEM INC.

First Edition, March 2020



**cask**  
global canning solutions



Toll Free: [1-800-661-8443](tel:1-800-661-8443) Direct: [+1-403-640-4677](tel:+1-403-640-4677) Fax: [+1-403-640-4680](tel:+1-403-640-4680) e-mail: [info@cask.com](mailto:info@cask.com)

## Technical Service & Support

[1-800-661-8443](tel:1-800-661-8443) Option #4  
[support@cask.com](mailto:support@cask.com)

## Parts Order

[1-800-661-8443](tel:1-800-661-8443) Option #4  
[parts@cask.com](mailto:parts@cask.com)

**cask.com**     

Official supplier of Ball Corporation for the supply of printed aluminum cans to our customers

# Confidential

## Automated Depalletizer V3.0 Installation Manual

First Edition March 2020

### Copyright

© 2020 Cask Brewing Systems Inc. All rights reserved.

### Disclaimer

The information presented in this manual has been reviewed and validated for accuracy. The included set of instruction and descriptions are accurate for the Cask Brewing Systems Inc. Automated Depalletizer Version 3.0 (Depal V3.0) in its stock condition as supplied by Cask Brewing Systems Inc., at the time of this manual's production. However, subsequent products and manuals are subject to change without notice. Therefore, Cask Brewing Systems Inc. assumes no liability for damages incurred directly or indirectly from errors, omissions, or discrepancies between any subsequent or altered products and this manual.

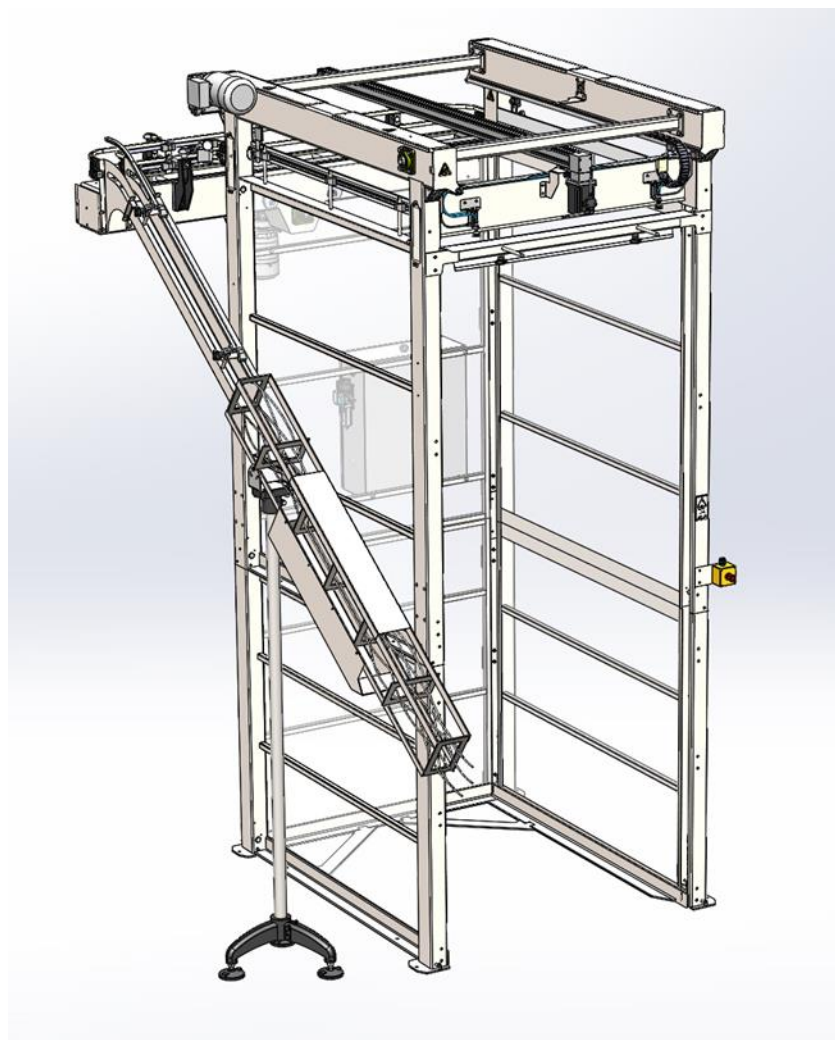


Figure 1 - V3 Depal and Twist Rinse



## Table of Contents

Section A.	Before You Begin.....	5
A.1	Safety and Precautions .....	5
A.2	Safety Warnings Symbols.....	5
A.3	Lock Out/Tag out Procedure .....	5
A.4	Safety Interlock Doors.....	8
A.5	Unit Diagram .....	9
A.6	System Requirements .....	10
Section B.	Introduction .....	11
Section C.	Pallet Insertion and Pre-Run Set-up.....	12
C.1	Inserting the Pallet.....	12
C.2	Powering Up.....	13
C.3	Height and Initial Tier Sheet Settings.....	14
Section D.	Starting & Running .....	18
D.1	Start-up Procedure.....	18
D.2	Pusher Settings.....	19
Section E.	Tier and Pallet Changes.....	21
E.1	End of Tier .....	21
E.2	End of Pallet .....	22
Section F.	Half Height Depal Vibrator .....	23
Section G.	Company Information .....	24



## Table of Figures and Tables

Table 1 - Revision and Document History.....	4
Table 2 - Safety Warning Symbols .....	5
Table 3 - Electrical Isolation and Lock-Out.....	6
Table 4 - Air Supply Isolation and Lock-Out .....	7
Table 5 - V3 Depal System Requirements .....	10
Table 6 - Control Pages Overview .....	11
Table 7 - Pallet Insertion Instructions .....	12
Table 8 - Powering Up the Depal .....	13
Table 9 - Height Sensor Setup .....	15
Table 10 - Tier Sheet Timer Setup .....	16
Table 11 - Setting Suction Cups.....	17
Table 12 - Start-up Procedure .....	18
Table 13 - Pusher Settings.....	19
Table 14 - Function and Setting the Backup Sensor .....	20
Table 15 - End of Tier Instructions .....	21
Table 16 - End of Pallet Instructions .....	22
Table 17 - Half Height Depal Vibrator Instructions .....	23
Figure 1 - V3 Depal and Twist Rinse.....	1
Figure 2 - Interlock Mechanism (Highlighted) - Door Open.....	8
Figure 3 - Interlock Mechanism (Highlighted) - Door Closed.....	8
Figure 4 - Interlock Mechanism (Highlighted) - Right/Photo Eye Side .....	8
Figure 5 - Interlock Mechanism (Highlighted) - Left/Reflector Side .....	8
Figure 6 - Automated Depal V3.0 Unit Diagram & Dimensions .....	9
Figure 7 - Initial Setup Screen .....	14
Figure 8 - Initial Tier Sheet Timer Settings .....	16
Figure 9 - Start-up Procedure Overview .....	18
Figure 10 - Pusher Settings .....	19



## Revision History & Document Control

Manual Version	Release Date	System	Updates
First Edition	March 2020	DEPAL V3.0	<ul style="list-style-type: none"> <li>Initial installation manual release</li> </ul>

*Table 1 - Revision and Document History*

## Future Updates

As we evolve future iterations of this Manual, we will post the most recent versions and updates on-line at our website.

[www.cask.com/customer-login/](http://www.cask.com/customer-login/)

Password: CaskCanning123

Note: you will also require the below username to download the PDF version of the manuals.

Username: CaskCustomer



## Section A. Before You Begin

### A.1 Safety and Precautions

#### Safety and Precautions

- Any and all operations, including but not limited to maintenance, troubleshooting, and normal machine operation should only be performed by authorized, trained employees.
- Be advised, at no time should any operators or persons enter the carriage/lift area while control is enabled on the Depallitizer. Depallitizer should have the emergency stop engaged and be locked out at principal power source/switch, and deenergize the air supply at the regulator by following the lock-out procedure.
- Power should also be closed and deenergized before entering the control panel for any reason to avoid any risk of electric shock.
- Only certified electricians should attempt to connect or work on the power supply to the Depalletizer.
- Should, for any reason, entry to the Depalletizer be required while the carriage is raised, under load or otherwise, a mechanical block is to be placed to prevent the load/carriage from falling should mechanical/electrical control fail.
- Failure to follow these safety guidelines may result in serious harm or death so absolute caution should be exercised at all times.

### A.2 Safety Warnings Symbols









<p>Electrical Shock Hazard</p> 	<p>Hand Crush from Two Sides</p> 	<p>Hand Entanglement Chain Drive</p> 	<p>Safe Working Load</p> 
<p>Hearing Protection Required</p> 	<p>Connect Earth Terminal to Ground</p> 	<p>Lock Out Electric Power</p> 	<p>Lock Out In De-energized State</p> 

Table 2 - Safety Warning Symbols

### A.3 Lock Out/Tag out Procedure

Any maintenance performed on your equipment should be done so with the utmost safety in mind to prevent any and all injury or death. To prevent energized and automated equipment from causing such hazards during maintenance, the energy sources should be locked out and tagged to prevent any unwanted activation, actuation, or re-energizing from occurring. This Depal has electrical, mechanical, and compressed air hazards that can cause serious harm if not isolated prior to performing maintenance. The following section will outline the guidelines that should be used to perform proper lock out and tag out of your Depal.

It is important to know that when any lock is placed on a piece of equipment that the person who locked it out **MUST** keep the key on them for the duration of the maintenance and they can be the only person to remove the lock.



### A.3.1 Electrical Isolation

Any time maintenance is being performed on the Depal it should be isolated from electrical power by locking out the main electrical switch on the front of the electrical panel. To isolate, deenergize, and lock out the main power you need to follow the instructions below. Instructions on how to isolate energy sources but these are not a substitute for a lock-out/tag-out procedure. Appropriate lock-out and tag-out policies and procedures for your jurisdiction should be researched and used by the end user.

<p>1. Turn main power switch to the off position by turning it counter clockwise.</p> <p>Give the power supply and machine a few moments to de-energize before beginning maintenance operations.</p>	
<p>2. Once in the off position push the red lockout tab from the inside of the handle to expose the lockout point and apply a lock. This will prevent the switch from turning into the "ON" position.</p> <p>You may need to wiggle the switch a little to allow the lockout tab to slide out.</p>	

Table 3 - Electrical Isolation and Lock-Out

### A.3.2 Air Supply Isolation

Any time you are performing maintenance on the air system it is required that you isolate and de-energize the air supply to avoid unwanted actuation that may cause injury. Below are instructions on how to isolate energy sources but these are not a substitute for a lock-out/tag-out procedure. Appropriate lock-out and tag-out policies and procedures for your jurisdiction should be researched and used by the end user.

<p>1. Turn air supply off by turning the dial on the left 90 degrees clockwise so it is perpendicular to the air inlet direction like in the photo on the right. The dial will have a diagram on the top of it showing how to turn it as well.</p> <p>You should hear the supply bleed off and release the pressure. The needle on the pressure gauge should now be at zero.</p>	
<p>2. Once in the off position push the blue lockout tab from the inside of the dial to expose the lockout point and apply a lock. This will prevent the dial from turning into the "OPEN" position.</p> <p>You may need to wiggle the switch a little to allow the lockout tab to slide out when you push/pull on it.</p>	

Table 4 - Air Supply Isolation and Lock-Out

## A.4 Safety Interlock Doors

Your Depal may come with a safety interlock door option that places doors connected to an interlock system which prevents the machine from operating when any of the doors are open. This is to prevent unauthorized entry during operation and when paired with proper lock-out procedures will prevent the machine from moving or energizing while maintenance is being performed. If your machine has the Safety Interlocks, they will be located at three points: The Main Door/Pallet Entrance where you insert and remove pallets for depalletization (Figures 2 and 3 below), and both Top Side Doors where you can access the Height Sensor and Reflector (Figures 4 and 5 below). The side doors are identified using left and right relative to the left and right side of the machine when facing the pallet entry door.

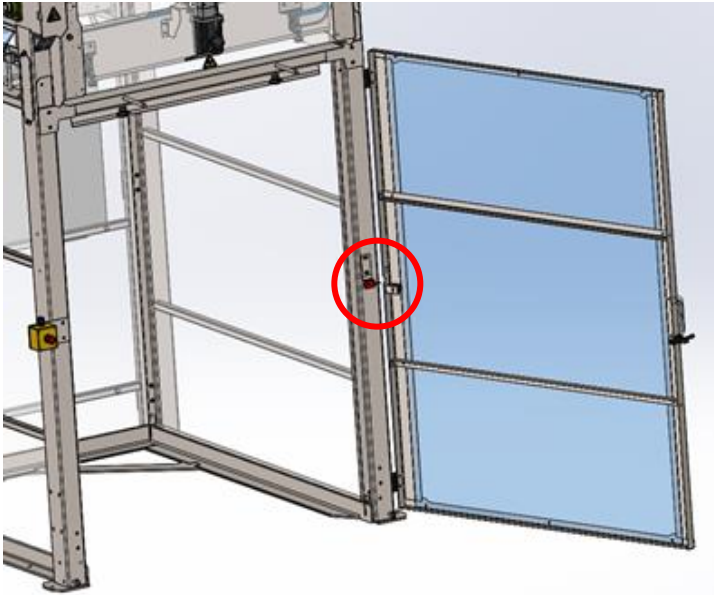


Figure 2 - Interlock Mechanism (Highlighted) - Door Open



Figure 3 - Interlock Mechanism (Highlighted) - Door Closed

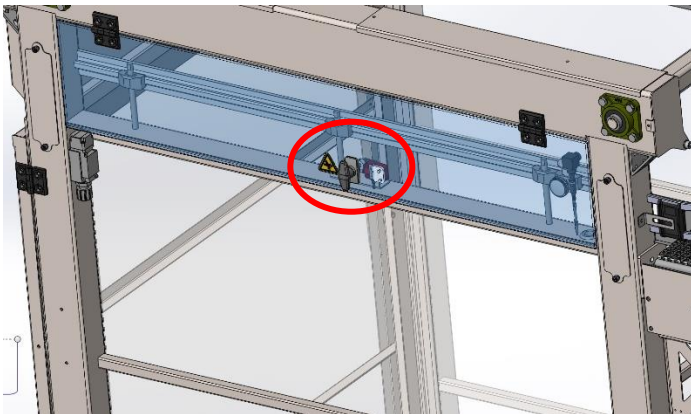


Figure 4 - Interlock Mechanism (Highlighted) -  
Right/Photo Eye Side

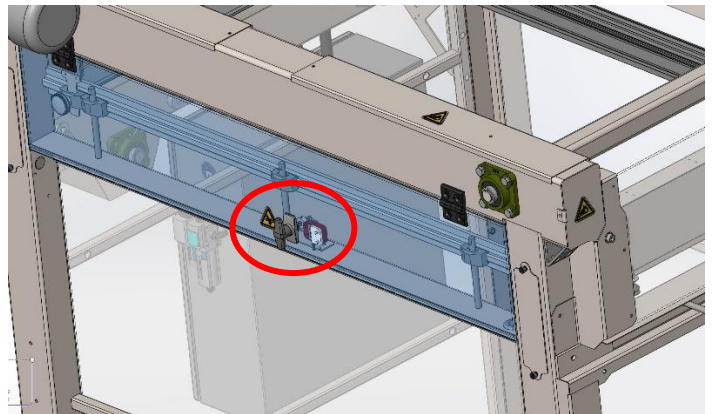


Figure 5 - Interlock Mechanism (Highlighted) -  
Left/Reflector Side

A.5 Unit Diagram

⚠ AS BUILT DIMENSIONS MAY VARY  
BASED ON REGIONAL PALLET SIZE.

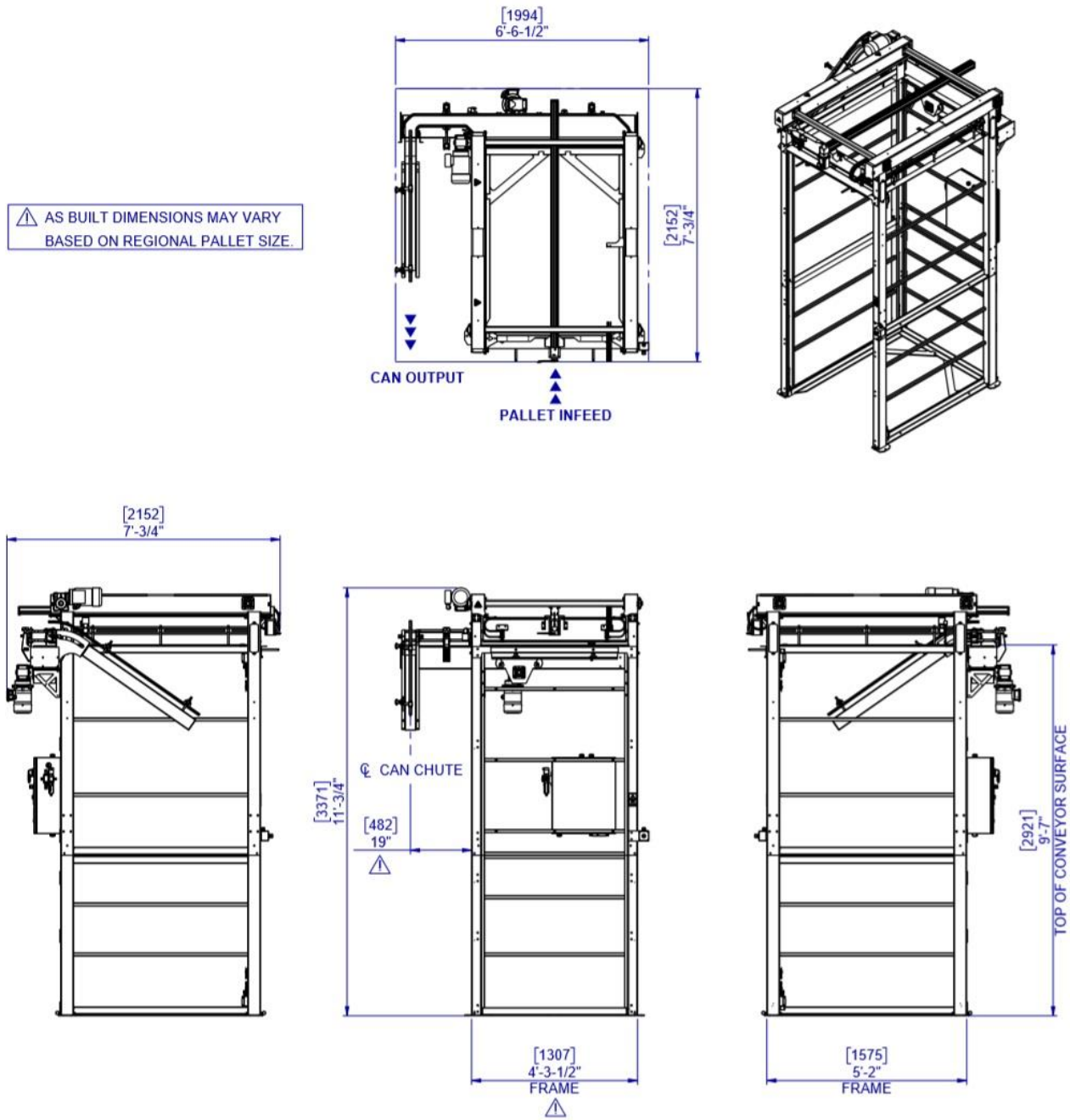


Figure 6 - Automated Depal V3.0 Unit Diagram & Dimensions



## A.6 System Requirements

Your Cask Automated Depal requires the following utilities.

	Power Requirement	220VAC, 50/60 Hz, 15 amps, Single Phase
	Compressed Air	Less then 1 cfm(28L/min) @ 60psi (4 bar) and minimum 3/8" (10mm) hose connecting compressor to Depal/canning system.
	Cans	You will require at least a half pallet of cans to facilitate testing of the Depal

*Table 5 - V3 Depal System Requirements*

**Note:** a forklift will be needed to unload the equipment on arrival. Note that the Cask Automated Depal V3.0 requires 1cfm (28L/min) @ 60psi (4 bar) for just the Depal itself. The vast majority of our Depal installations feed into a mACS, ACS V5 or Flex2 which have their own air volume and pressure requirements.



## Section B. Introduction

This section will provide an overview of the main control pages of the Depal and provide some insight on where to go for operational set up and running. Each of their functions are displayed in their own sections between this operation manual and the setup and installation manual.

The order of this manual will take you through the order in which to get running and apply operational needs, which doesn't necessarily follow the order of the control pages.

Control Pages Overview	
<h3>Main Controls</h3> <p>This page will be the page you'll likely have as the default page when running the Depal. It gives you access to starting, stopping, pausing, and manually controlling most of the functions of the Depal.</p> <p>See section D for this information.</p>	
<h3>Pusher Controls</h3> <p>This page will allow you to access all the controls needed for controlling the push arm and its related settings.</p> <p>See section D.2 for this information, as well as refer to the install and setup manual for further instruction.</p>	
<h3>Initial Setup</h3> <p>This page will allow you to set the tier sheet and height sensor settings and will help with getting the Depal up and running from the first start up. Any can size changes that are made should be followed by adjusting the settings here accordingly.</p> <p>See section C.3 for information on this page.</p>	

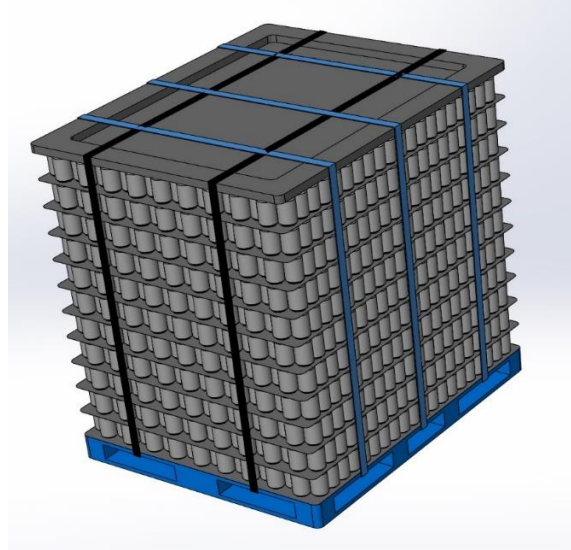
Table 6 - Control Pages Overview

## Section C. Pallet Insertion and Pre-Run Set-up

## C.1 Inserting the Pallet

### Pallet Insertion

1. Pallets will usually come wrapped in some form of plastic and tied down with strapping for shipping. Since the pallet will be inserted with the short-side facing the back, you'll need to remove the plastic and **ONLY** the straps on the long side (Blue Highlighted Straps) before inserting the pallet.
2. Have a look around the pallet and **REMOVE** all dented cans and throw away.



3. Use a forklift or pallet jack to push the pallet **all the way to the back** of the carriage and set it down.



4. With the pallet in place, you can now cut the remaining strapping and remove the tier weight on the top layer of the pallet (shown in blue on the left).

NOTE: Leave the top tier sheet on the pallet – only remove the weight.

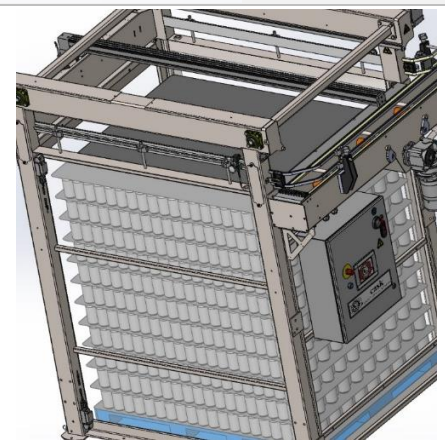
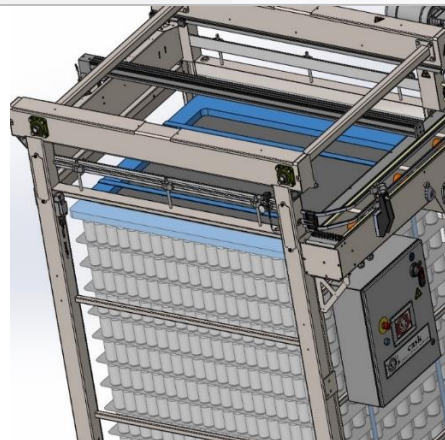


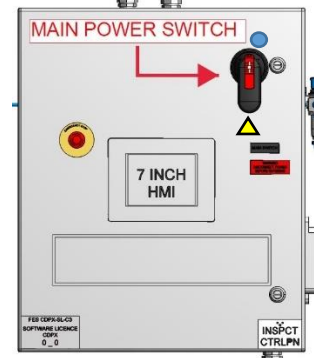
Table 7 - Pallet Insertion Instructions



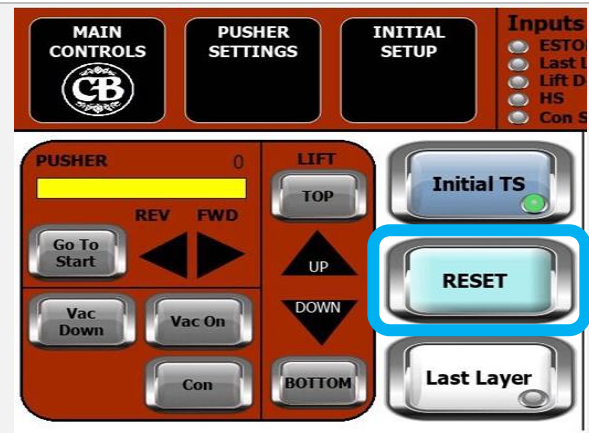
## C.2 Powering Up

### Power-up Procedure

1. Turn on main power and air supply to the Depal.



2. If there is no pallet inside the machine upon start up, reset the machine by pressing reset on the main page. This will bring you to a screen asking you to home the push arm. Press “Home Motor” and observe the push arm move slightly back and forth until it settles. The arm is now homed and you may proceed. Be aware that pressing the reset button will also lower the lift to the bottom/floor level so be certain nothing is blocking this area prior to resetting.



Pusher Motor Requires Homing



If there is a pallet in the machine when you start up, simply go to the Pusher Settings Page and press “Home” in the lower left area of the menu to home the push arm.

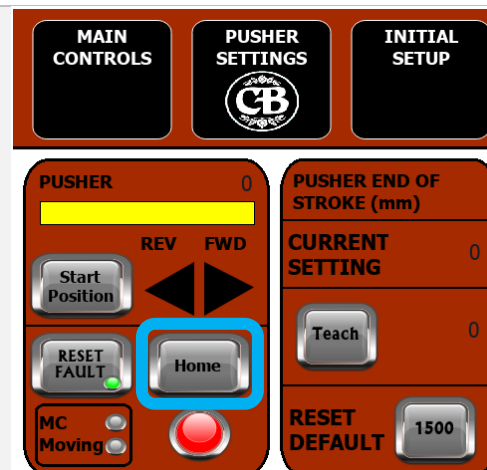


Table 8 - Powering Up the Depal



### C.3 Height and Initial Tier Sheet Settings

Setting the height for the pallet to stop at, as well as the timer that allows for automatic initial tier sheet removal is a crucial part to the automation of the Depal. These settings are found under the “Initial Setup” Page on the HMI.

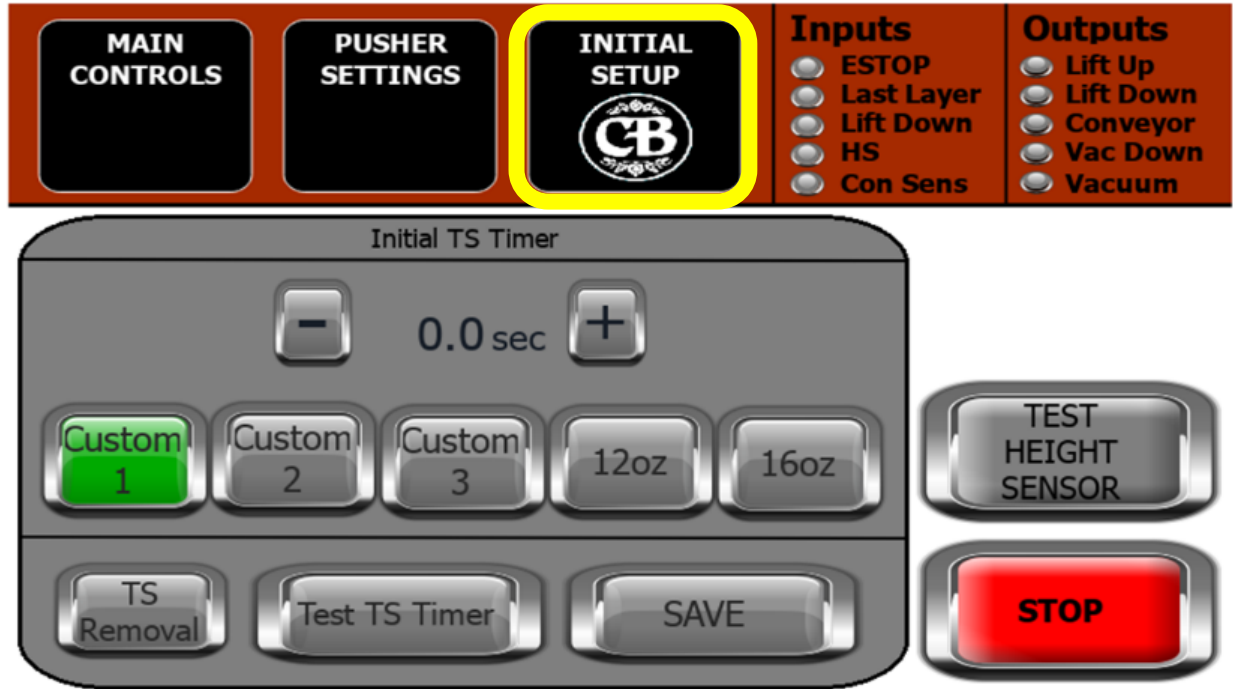


Figure 7 - Initial Setup Screen

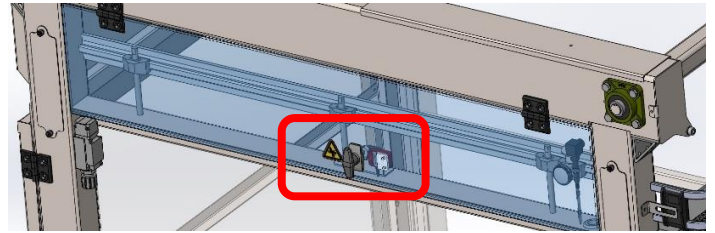


### C.3.1 Setting the Height Sensor

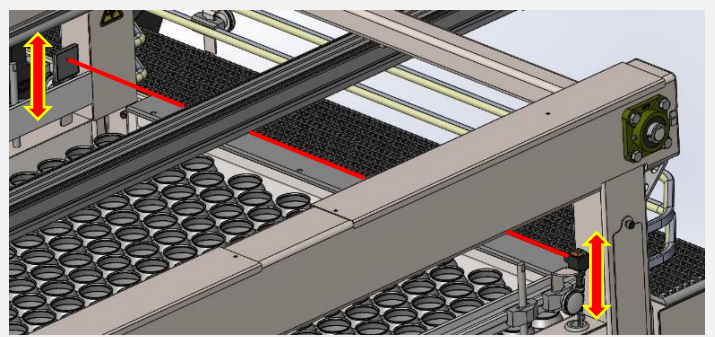
Before running the Depal in auto mode, you'll need to teach it when to stop raising after each tier is removed and sent to your canning line. The Height Sensor will do just that and is adjustable for any can size you may use.

#### Height Sensor Setup

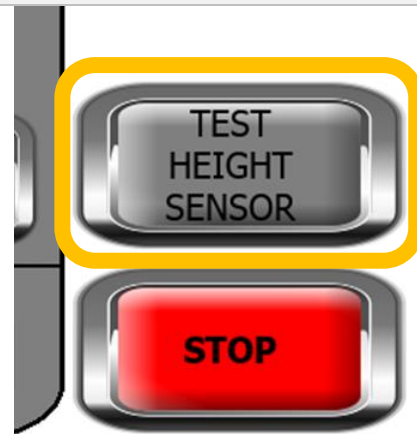
1. Your Depal may come with safety interlock doors to prevent access to the inside of the machine while it is in operation. If you have interlocked doors, you'll need to open the interlocked door to access the Height Sensor. This will put the machine into an e-stop state and no functions will work until the interlock is closed again and the e-stop state is reset.



2. The Height Sensor is a photo eye found on top of the Depal on the left side when facing the control panel. The sensor and reflector both have height adjustability which will be key to setting the correct raise height for each size of cans. To adjust the height, simply loosen the hand nut and slide the sensor/reflector up and down. The sensor will shine green and orange lights on top of the photo eye when it sees anything and when the pallet is seen only a green light will show.



3. Setting the Height Sensor height is done by pressing the test height sensor button. This will raise the pallet until the top breaks the photo eye of the sensor, then stop.
4. Depending on what size cans you have, you may have to adjust the sensor height a few times. If the tier sheet under the first layer of cans is above or below the conveyor, simply adjust the sensor up or down and repeat the "Test Height Sensor" calibration until the tier sheet is flush with conveyor.



5. When the tier sheet under the first layer of cans is level and flush with the conveyor belt (along blue line in illustration) the sensor is at the correct height to ensure a smooth transfer of cans.

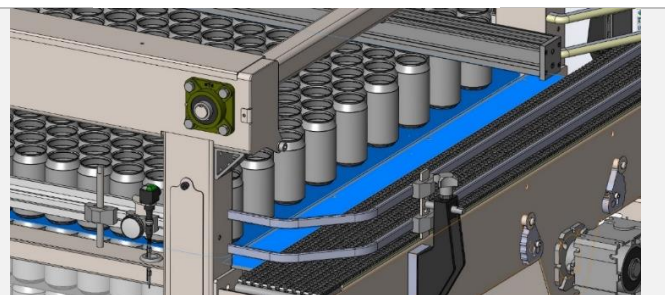


Table 9 - Height Sensor Setup

NOTE: Inspect all tier sheets before completing this set up for damage. Tier sheets that are damaged, bent, wrinkled, or otherwise deformed may break the plane of the photo-eye early causing the pallet not to rise to the flush-with-conveyor position, or interfere with the smooth transfer of cans onto the conveyor.

### C.3.2 Initial Tier Sheet Timer Setup

Once the Height Sensor is set correctly, we can set up the automated initial tier sheet removal by setting the Initial Tier Sheet Timer. The initial tier sheet timer function will raise the pallet until it breaks the plane of the height sensor then lower it for the number of seconds we set the timer for.

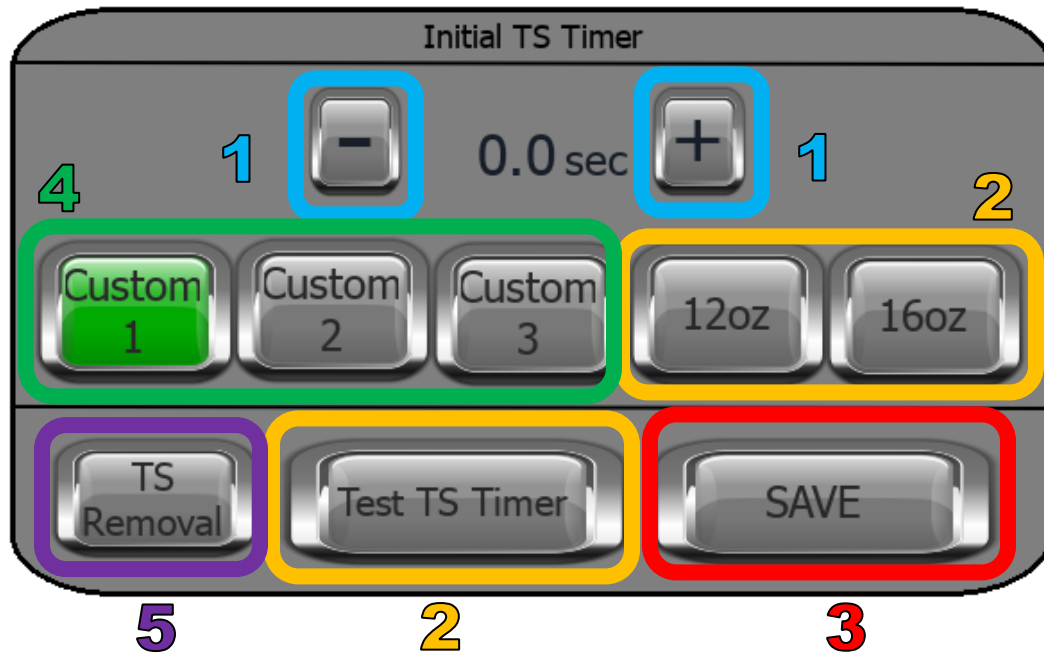


Figure 8 - Initial Tier Sheet Timer Settings

#### Initial TS Timer Setup

1. You can set the timer manually using the +/- buttons, or use the default quick-set buttons. There 3 customizable slots, and two standard 12oz. (355ml) and 16oz. (473ml) settings.
2. To start, press/highlight the 12oz button (if your cans are near 12oz/355ml) or 16oz button (if your cans are closer to 16oz/473ml) and press "Test TS Timer". This will raise the cans until the height sensor plane is broken then drop the pallet for the number of seconds displayed on the timer.
3. If you use a can size other than the pre-set 12 and 16, you can program a different time into the custom slots then hit "Save"
4. You want the top tier sheet to stop within a millimeter or two above or below the conveyor, or flush with it when the timer finishes. If this isn't the case, adjust the timer and repeat the timer test.
5. Once the timer is set you can press "TS Removal" and the Depal will go through a Tier Sheet Removal process and slide the tier sheet away.

Table 10 - Tier Sheet Timer Setup



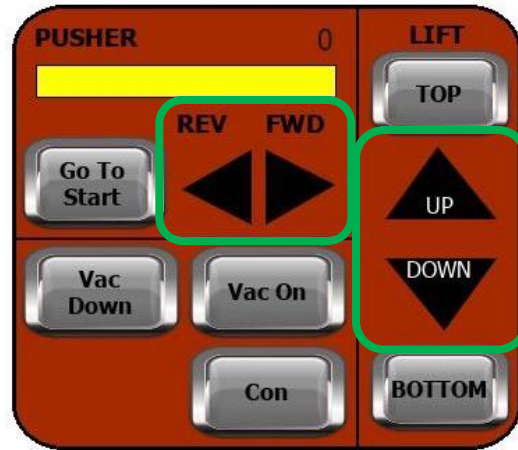
### C.3.3 Setting Suction Cups

Setting the suction cup cylinder height is important in ensuring that the tier sheets are removed from the tops of the tiers after each level on the pallet is cleared. To complete this setup ensure there is a tier sheet in place. We want to have the cups lower to the point where the suction cups absorb some impact and squat into the tier sheet, but not too low that it could damage the tier sheet or cans.

#### Suction Cup Settings

Return to the main page and use the up and down arrows to move a pallet upward until its top sheet is flush with the conveyor.

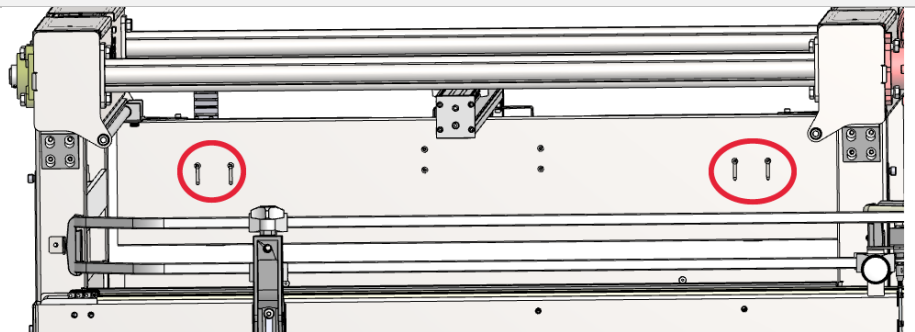
Once the pallet is in place, move the push arm forward enough so the suction cups are over the tier sheet/pallet.



Still on the Main Controls Page, press "Vac Down" and have someone observe if the suction cups do indeed squat into the tier sheet.



If the suction cups are uneven, or do not squat into the tier sheet, loosen the two bolts and slide the cylinder assembly up or down accordingly.



Press the TS Removal button on the Initial Setup Page and observe if the tier sheet gets removed and dropped off the back/entrance to the Depal.



Table 11 - Setting Suction Cups

## Section D. Starting & Running

### D.1 Start-up Procedure

We are now ready to run the Depal in auto mode. Be aware some further adjustments to the conveyor rails and can chute may be necessary for smooth operation.

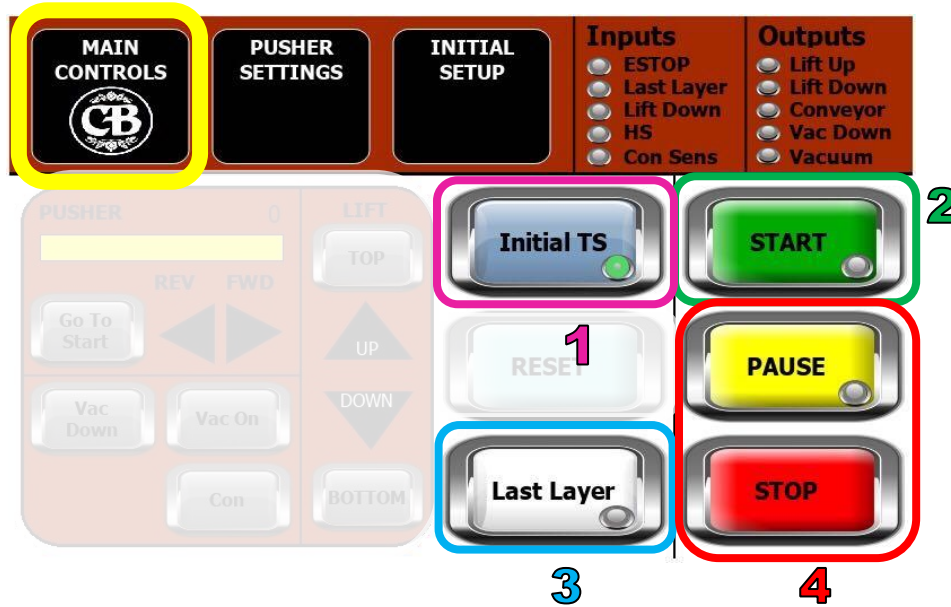


Figure 9 - Start-up Procedure Overview

#### Start-up Procedure

1. If you haven't removed the top tier sheet using the TS Removal function mentioned in the previous section, activate the Initial TS button and once you press "Start" the pallet will rise to the height sensor, lower for the TS Timer, then remove the tier sheet before rising to the height sensor once again.
2. To start the automated operation of the Depal, simply press start and the pallet should start to rise, stop when it breaks the plane of the height sensor then start its pusher arm sequence, sending cans to the conveyor and on to your machine.
3. When you wish to end a run after any layer finish throughout the process, simply press "Last Layer" and look for the green light in the bottom right hand corner to illuminate. This will finish the tier you are on and then drop the pallet as if it were finished.
4. At any point if you wish to stop, or pause the Depal simply press the pause or stop buttons. Also, at the end of a run you, lower the carriage if not done so, hit the stop button, press the e-stop in, then turn off the main power to the machine.

Table 12 - Start-up Procedure

## D.2 Pusher Settings

The pusher settings required for pusher and sensor delays, as well as push force, will need to be adjusted once you have cans on the line and the Depal is running. Below is an explanation on what those settings do, and how you should apply them.

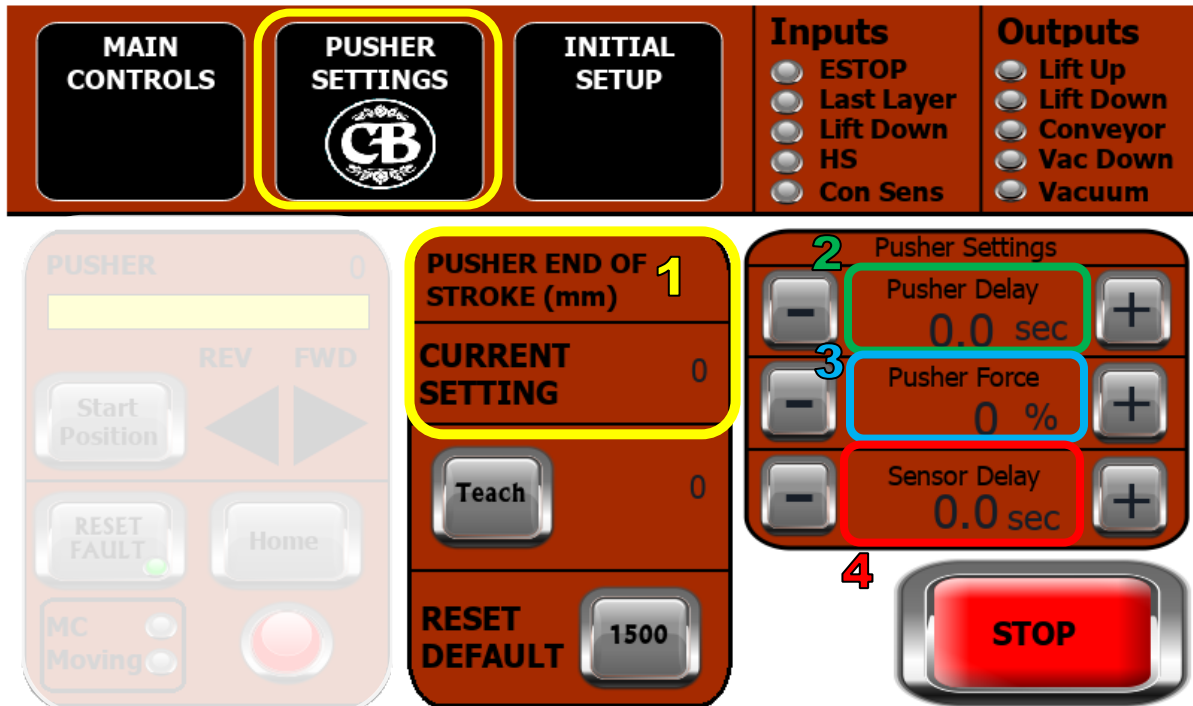


Figure 10 - Pusher Settings

### Pusher Settings Procedure

1. The Pusher End of Stroke section allows you to teach the machine what distance (in mm) the pusher will travel before ending its stroke and starting the tier-sheet removal process. 1500mm is the default setting but you can change that to whatever you wish simply by pressing teach at the position that best suits your set up. The progress bar is associated with a number next to it to show the current position.
2. Pusher delay is a timer that will be activated when the push arm detects resistance due to a jam or back up of the cans while its pushing forward. When the pusher senses resistance it will retract slightly and wait for the time set here and then begin pushing again. This will prevent the push arm from crushing cans any time there's resistance present. It will continue this retract, wait, push sequence until the jam or can back up is cleared.
3. Pusher Force % is the percentage of maximum push force required to be reached before initiating the pusher delay sequence mentioned in step 2 above.
4. Sensor Delay is the time that the can back-up sensor is blocked before the pusher stops pushing cans. Typically for 30-40 cans per minute a setting of 0.0-0.2sec is sufficient. Anything above 40 cans per minute adjust accordingly. For a detailed visual explanation of this how this sensor works please see the next page.

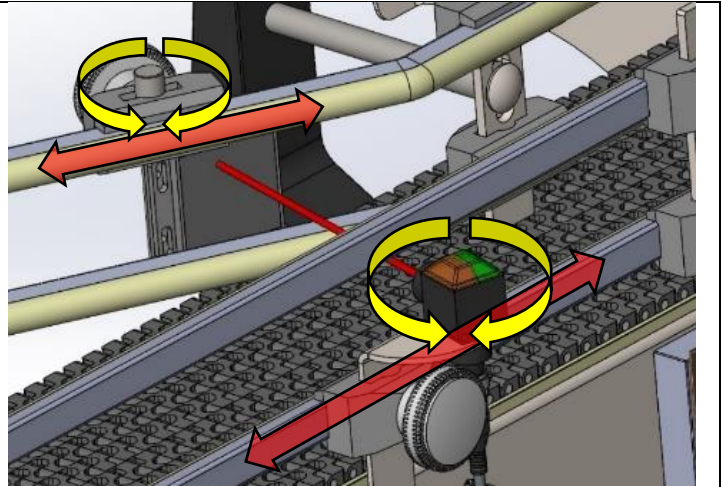
Table 13 - Pusher Settings



### D.2.1 Function and Setting the Can Back Up Sensor

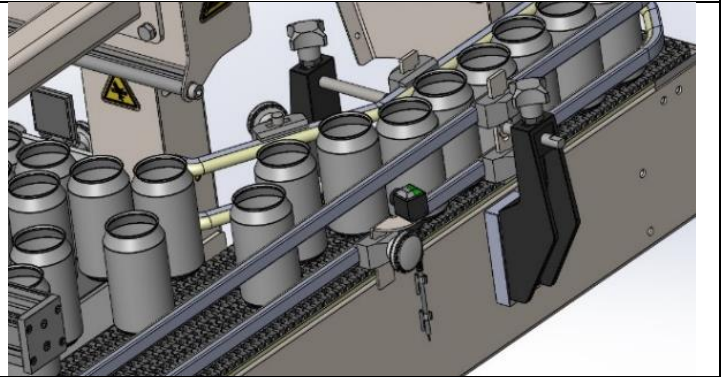
The can back-up sensor is a photo eye that shoots a beam of light onto a reflector and reads it as it returns. When the sensor is clear from being blocked the amber and green lights will be lit up on top of the sensor. When it is blocked only a green light will be illuminated.

This sensor and reflector can be moved forward or backward along the rail, as well as rotated on a swivel, to allow the end user to adjust the cut off point of where the cans can back up to on the conveyor before pausing the push arm can feed.



Once the push arm pushes cans onto the conveyor, they will continue to feed the line until the cans back up and block the sensor like in the illustration on the right.

Once the back-up sensor is blocked for the duration set out in the “Sensor Delay” timer on the HMI’s “Pusher Settings” Page, the push arm will stop pushing cans until the sensor is cleared again.



Once the cans clear the back up sensor the push arm will resume pushing cans until it is again blocked for the amount of time set on the “Sensor Delay” timer input on the HMI’s “Pusher Settings” Page.

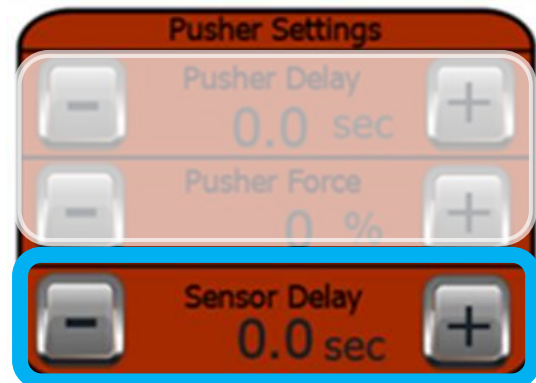
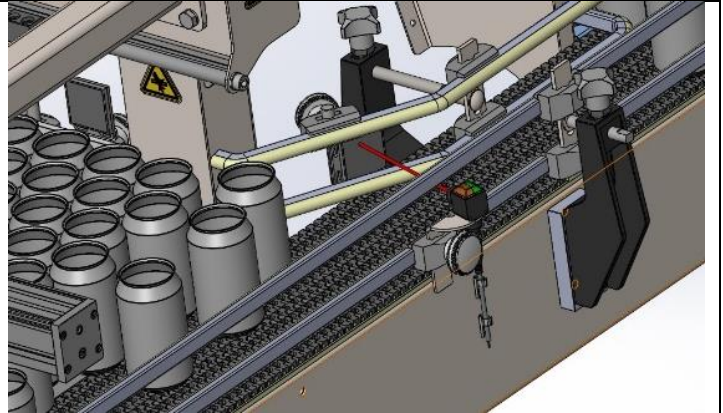


Table 14 - Function and Setting the Backup Sensor



## Section E. Tier and Pallet Changes

This section will discuss what will happen at the end of a tier (level of cans on the pallet), how to end a run after a layer is complete but the pallet is not finished, and what will happen and how to end a run after a pallet is emptied.

### E.1 End of Tier

<p>When the push arm fully empties a tier/level of cans the suction cups on the back of the push plate will lower, suction onto the tier sheet, and then lift it up before returning the push arm to the rear position.</p>	
<p>Once the tier sheet and push arm is approximately 80% of the way back the push arm will stop, release the suction and the tier sheet will fall down to the floor.</p> <p>The push arm will then return the rest of the way and a new tier/level will raise to the up position and the sequence will commence again.</p> <p><b>CAUTION: Stand clear of the front of the Depal to avoid the tier sheet from falling on you.</b></p>	
<p>If you'd like to end a tier before it is completed you can simply push the cans from the transfer plate/conveyor back onto the pallet, retract the push arm to its start position ( 1 ) and lower the lift ( 2 ) using the controls on the Main Controls Page on the HMI.</p>	

Table 15 - End of Tier Instructions

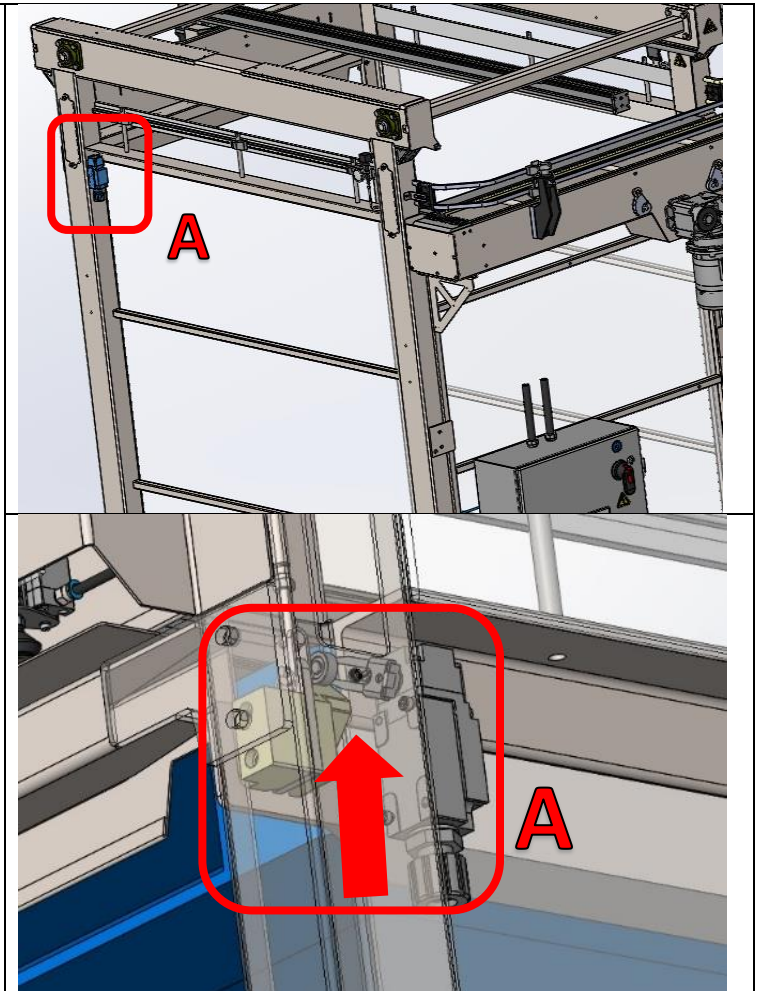


## E.2 End of Pallet

At the end of a pallet the lift carriage will trip a limit switch with the white Delrin switch dog (shown in “A”) that lets the controller know the pallet is at the top of the lift and to trigger the lowering function.

The Depal has another limit switch at the bottom of the lift carriage stroke inside the same tubing as the top one and that is what communicates to the controller that the lift is at the bottom.

Once the pallet stops at the bottom of the Depal, remove it and you can now place a new pallet in.



If you’d like to end your run after 1 full tier is finished but there are still cans on your pallet you can activate the “Last Layer” override on your HMI and the Depal will treat that current layer as if its the end of a pallet and lower the pallet once the current layer finishes.

You’ll know this function is activated if there’s a green light lit up in the bottom right corner of the “Last Layer” button.



Table 16 - End of Pallet Instructions



## Section F. Half Height Depal Vibrator

To aid cans along the twist rinse of the half height version of the Depal we've installed a small pneumatic vibrator. Below are instructions on how to operate and control the vibrator.

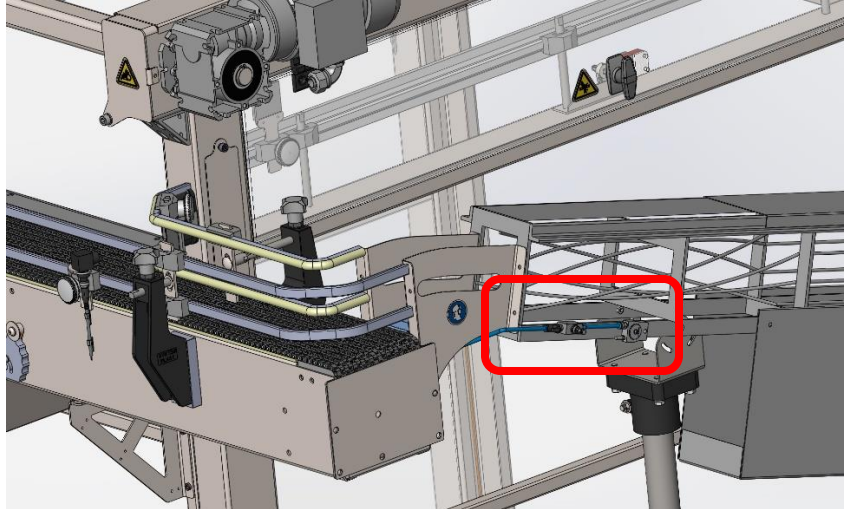
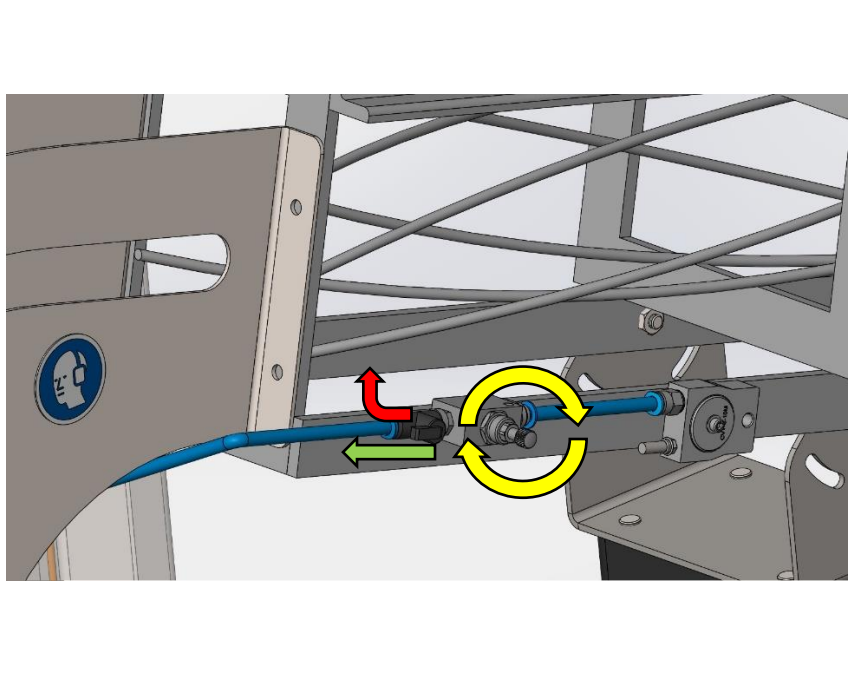
<p>You can find the vibrator on the outside of the twist rinse near the top where the cans enter. This vibrator is pneumatically powered and controlled and will tie directly into the Depal's main air supply via a 4mm blue air line.</p>	
<p>To turn the vibrator on the air supply will need to be opened. To do so, turn the black lever next to the flow control dial so it is parallel with the air line like the green arrow shows and to turn it off, twist it perpendicular to the air line like the red arrow shows.</p> <p>Once the air supply is turned on you can throttle and control the vibration level by turning the flow control dial (yellow circular arrows).</p> <p>You may need to make adjustments before or during each canning run to get the ideal vibration frequency.</p> <p>You may also need to adjust the vibrator higher for shrink sleeved cans, and lower for printed or bright cans as well.</p>	

Table 17 - Half Height Depal Vibrator Instructions



## Section G. Company Information

### North American Office

Cask Brewing Systems Inc.  
Bay 60, 5100-64 Ave SE  
Calgary, Alberta, T2C 4V3  
CANADA

### European Office

Oldcourt, Templeorum, Piltown  
Co Kilkenny, Ireland  
E32 PP52

Toll Free	+1-800-661-8443
Direct	+1-403-640-4677
Fax	+1-403-640-4680
Email	<a href="mailto:info@cask.com">info@cask.com</a>
Website	<a href="http://www.cask.com">www.cask.com</a>



### Parts, Technical Service & Support North America

Direct:	+1-403-640-4677	Option #4
Toll Free:	+1-800-661-8443	Option #4
<a href="mailto:support@cask.com">support@cask.com</a>		

Hours: 5AM-6PM MST (UTC -7)

### Parts, Technical Service & Support Europe

Support Desk:	+353-5678-07026	Option #4
<a href="mailto:support@cask.com">support@cask.com</a>		

Hours: 7AM-3:30PM Irish Standard Time (UTC +1)

