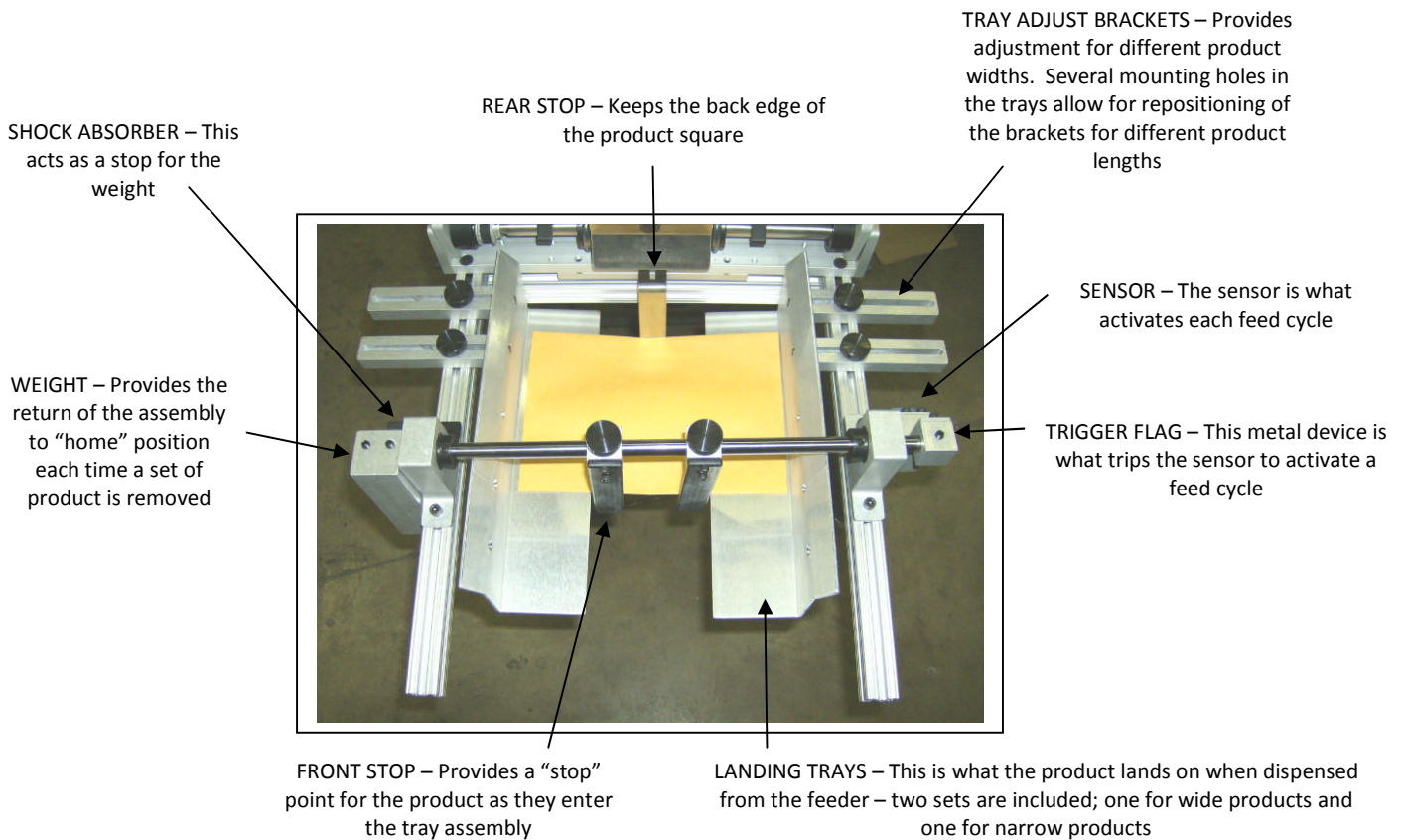




## BATCHING TRAY SET UP GUIDE

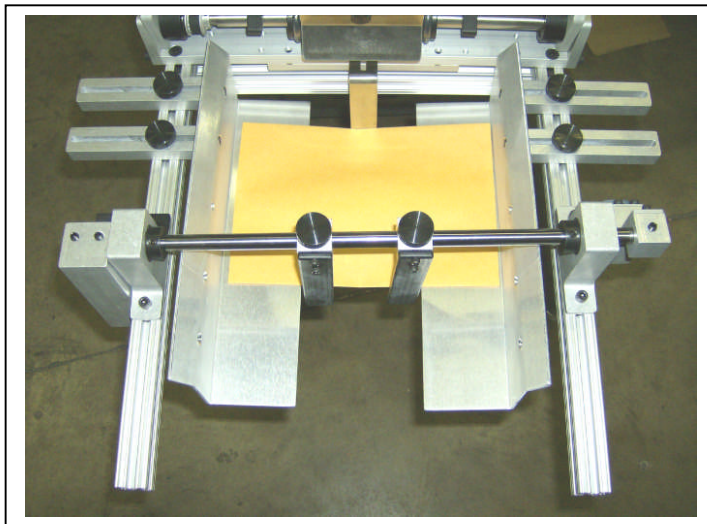
For detailed set up information for the XM-Series Friction Feeder, please refer to the Product Guide included on the Documentation DVD included with the feeder.

### OVERVIEW

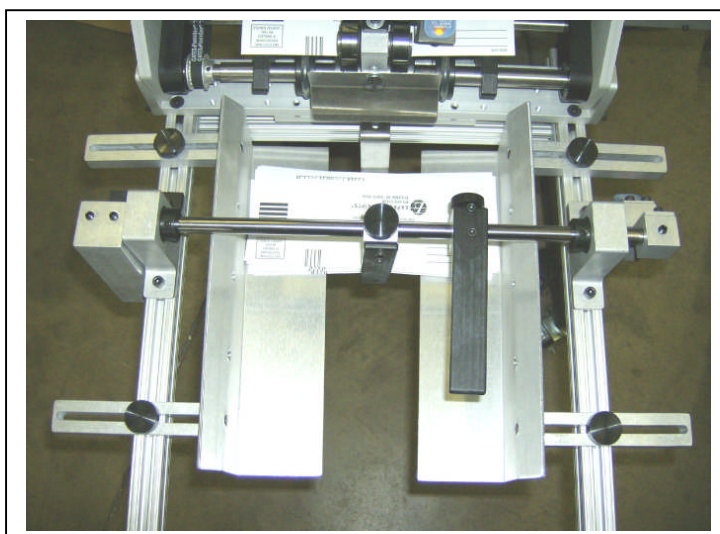




The view below shows a basic set up. The landing trays should be adjusted in line with the product coming out of the feeder. It is important to leave a little extra room on each side to allow the product to enter the trays without catching the sides. Note that both front stops are used for wider products.



The next view shows a basic set up of a smaller product. Using the wide trays, you will see that one of the front stops has been adjusted out of the way. The tray assembly has also been reconfigured; moving the Tray Adjust Brackets to the opposite end of the tray. Doing this requires removal and reinstallation of the shaft assembly.

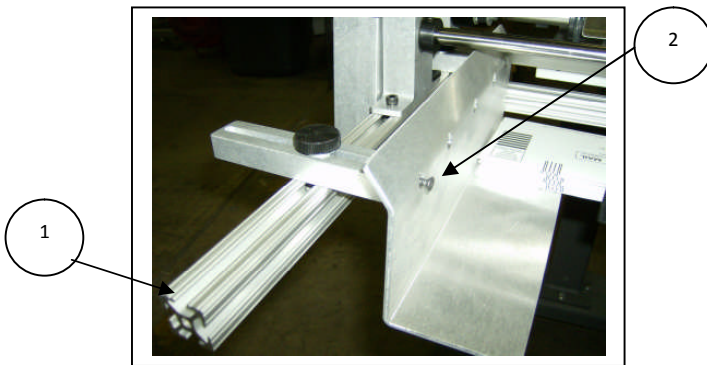




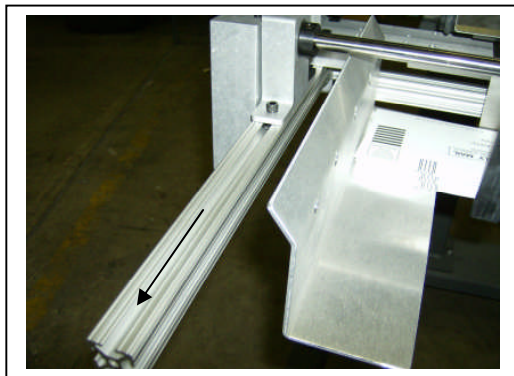
## TRAY RECONFIGURATION

To reconfigure the tray assembly from shorter products to longer products...

1. Remove black end caps from the rail mounts
2. Remove screws that fasten the landing tray to the adjust bracket

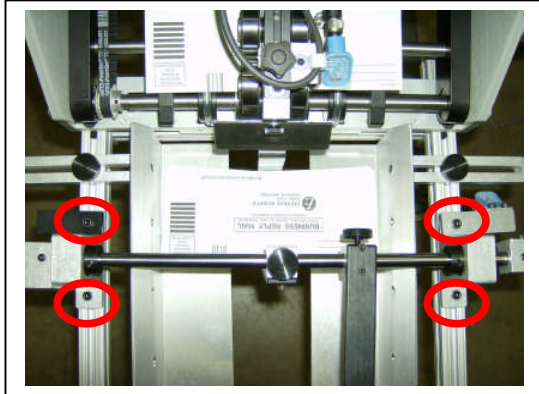


3. Loosen the knob on the tray adjust bracket and slide off the rail (both sides)

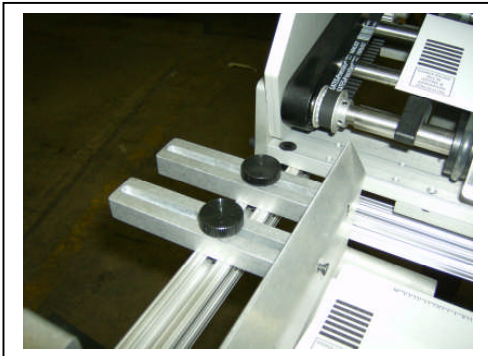




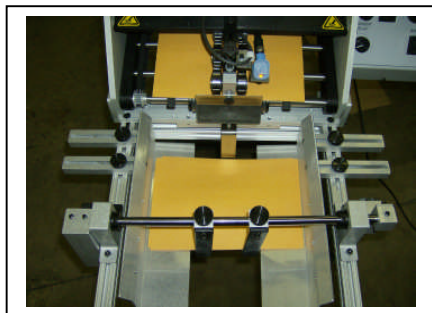
4. Loosen the four screws securing the shaft assembly to the rails and slide off the rails. Note: You may have to disconnect the sensor cable first. Make sure to power off the feeder prior to disconnecting any electrical items.



5. Reinstall the tray adjust brackets and fasten.



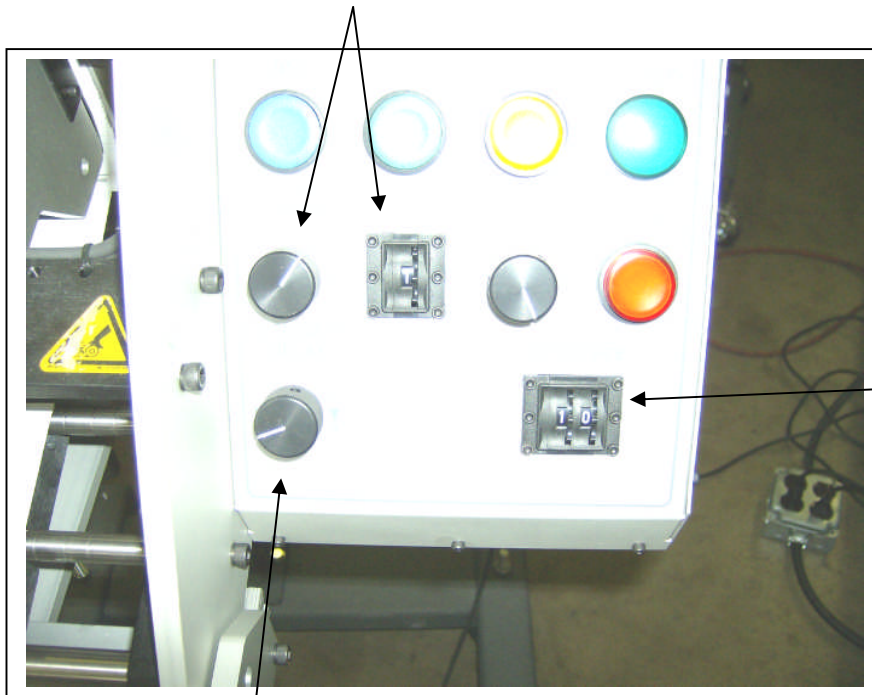
6. Reinstall shaft assembly and position for larger product, tighten and reconnect sensor.





**FEEDER SET UP NOTES**

END OF BATCH SPEED CHANGE – Typically only used for short length products. Prevents overshooting of the next batch by reducing the feeder speed at the end of the batch (refer to feeder product guide for detailed information)



BATCH SIZE THUMBWHEELS – To change the batch size, simply rotate the thumbwheels to the desired number (refer to feeder product guide for detailed information)

TRIGGER DELAY – It is important that this dial be set to the “8:00” position. This provides sufficient time for the tray assembly to return to home position before the next batch is fed.