

# ***VICTORY BATCHDROP***

## ***UNIVERSAL ACCUMULATING SOLUTIONS***

---

### **Operation Instructions and Technical Information Guide**



© Superior Paper Handling Solutions, Inc. All rights reserved.

**Illustrations in this guide are for reference only and may depict optional features that are available at additional costs.**

Superior Paper Handling Solutions, Inc.  
9921 – 13<sup>th</sup> Avenue North  
Plymouth, Minnesota 55441 – USA

Tel. 763-546-9140  
Fax. 763-546-8883  
Email. [Info@Superior-PHS.com](mailto:Info@Superior-PHS.com)  
Web. [www.Superior-PHS.com](http://www.Superior-PHS.com)

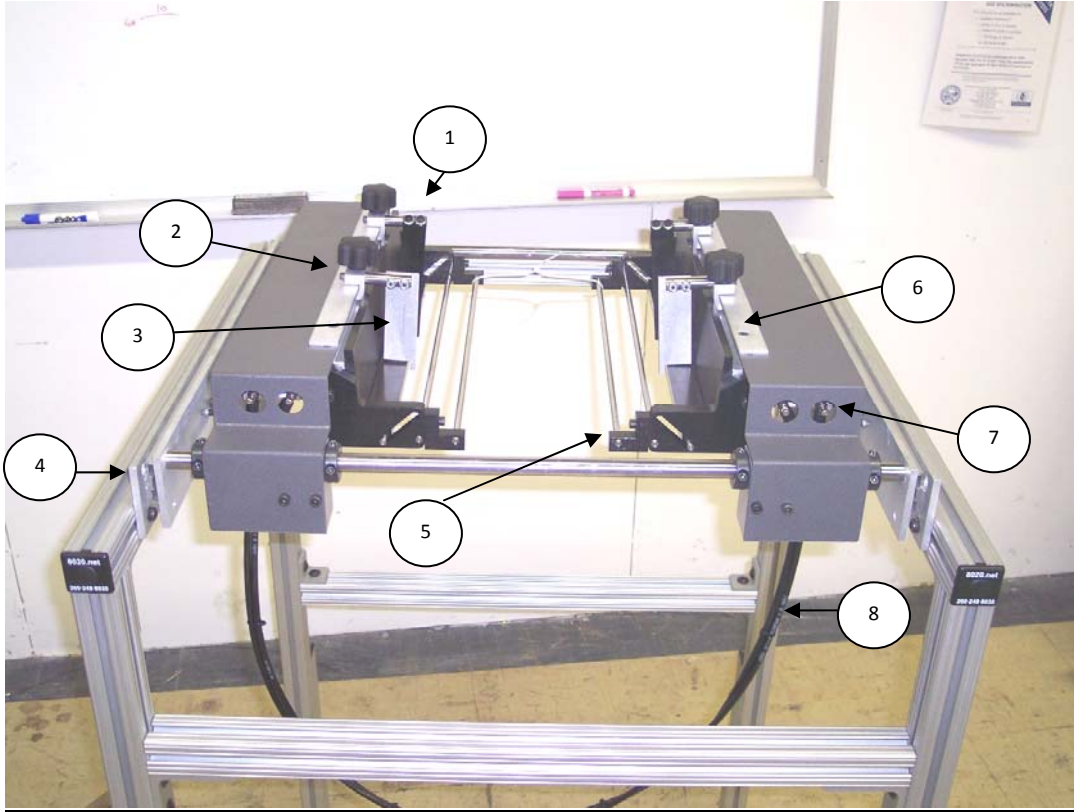
## **Table of Contents**

---

<b>Section 1:</b>	<b>Machine Components &amp; Specifications</b>
<b>Section 2:</b>	<b>Operation and Adjustments</b>
<b>Section 3:</b>	<b>Electrical Panel</b>
<b>Section 4:</b>	<b>Cabling and Wiring Detail</b>
<b>Section 5:</b>	<b>Warranty</b>

## Section 1: Machine Components & Specifications

### Overview:



Item	Part Number	Description	Qty
1	104017	5904-93 Spring Steel Knockdown 1" x 6" (.010)	2
	104015	5904-14 Knockdown / Back Stop Post	4
2	104014	5904-13 Slider Block	4
3	104020	5904-96 Back Stop	2
4	104029	Guide Rail 500mm L	2
	104030	Plain Bearing Guide Block 50mm L	4
5	104022	5904-99 Delrin Extension Block	4
	104009	5904-08 Main Support Rail	4
6	104019	5904-95 Aluminum Slide Rail	2
7	104028	1/2" Cylinder 1" Stroke	2
	104026	Flow Valve w/o knob	4
8	104047	1/4" OD Hose, 18" L	4
	104048	1/4" OD Hose, 36" L	2
	104033	"T" fitting air hose	2
NP	104021	5904-98 Stop Tab	2

**Specifications:**

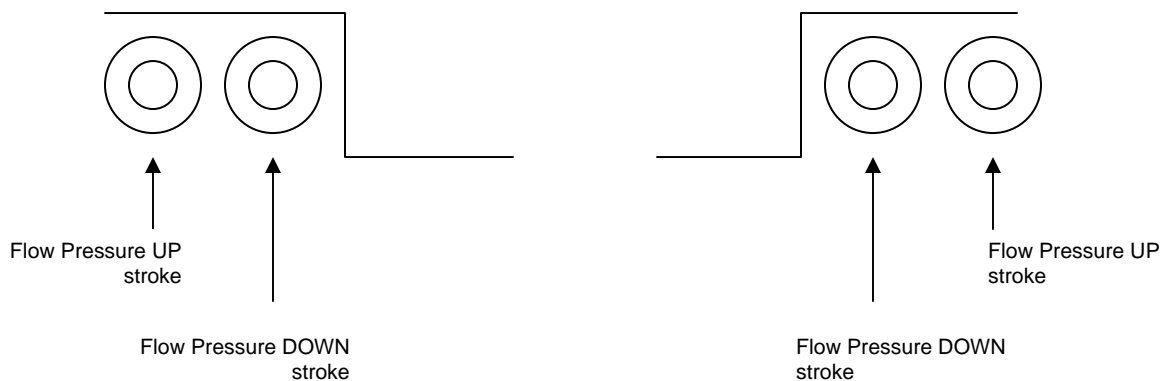
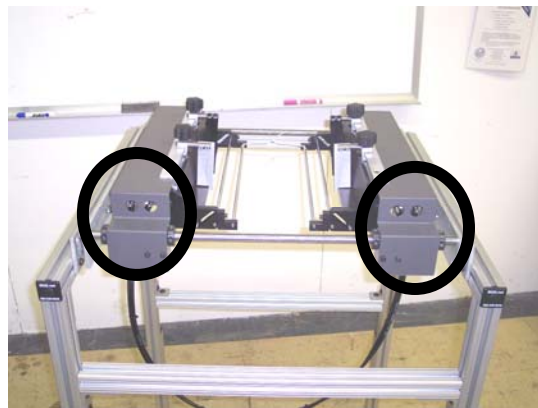
Minimum product size:	3"W x 4"L
Maximum product size:	12"W x 12"L
Minimum accumulation thickness:	.003"
Maximum accumulation thickness:	2.50"
Electrical:	115vac / 60Hz / 1 Amp
Air:	80psi, 1cfm
Height:	Adjustable, 35-45"

## Section 2: Operation and Adjustments

### Set-up

1. Loosen split collars to adjust the width
2. Set back stops to allow for 1/8 to 1/4-inch front to back
3. Adjust spring steel knock downs to gently capture the product as it is received from the feeder.

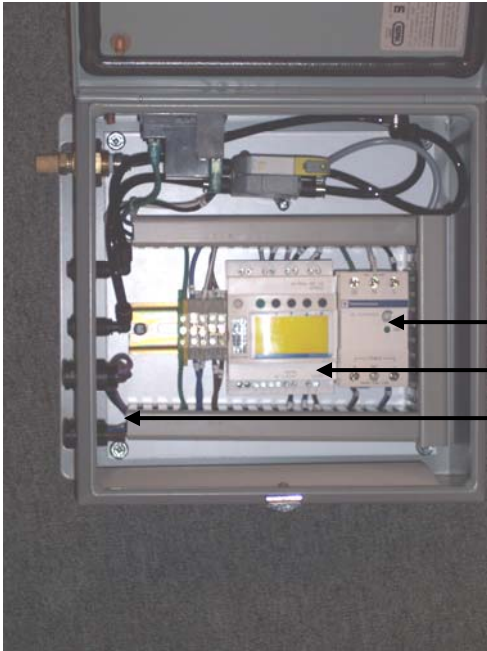
### Air Flow



The air flow settings are adjusted at the factory for proper settings and are covered with hot melt glue to prevent adjustments.

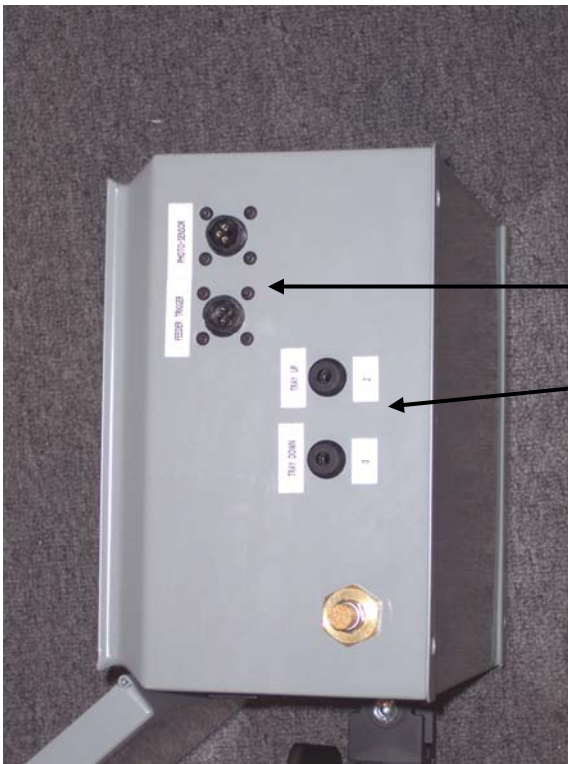
**NOTE: If there is too much flow, additional wear and tear will happen that may lead to premature failure of some parts. Please adjust with discretion and caution.**

**Section 3: Electrical Panel**



**Internal view**

- Power Supply
- Controller
- Connections



**Bottom View, Connections**

- Sensor and Feeder Connections
- Air Connections

## Section 4: Cabling and Wiring Detail

### INPUT / OUTPUT SIGNALS

#### XM-1 Feeder / Dropper I/O Cable

<u>16 pin Connector</u>	<u>4 pin Connector</u>
-------------------------	------------------------

1 - +V -----	# 1
7 - Trigger -----	# 2

2 - -V -----

8 - Trigger

4-pin connector on dropper box is a contact closure. The above circuit utilizes the XM-1 feeder power to energize the Solid State relay for the external trigger circuit.

Pin 1 and 7 go out to the dropper box and pins 2 and 8 get tied together.

#### Alternate Feeding Device

##### Trigger Input Connection

Typically this is a photo-sensor input to detect passing lugs on a conveyor. If an alternative trigger solution will be used, it is important that the alternative signal is DRY CONTACT only. This contact closure will close power (pin1) and signal (pin 2) on the connector.

##### Trigger Output Connection

This signal is DRY CONTACT. If the alternate feeding device requires power to create a trigger signal, the power must be supplied from the feeding device.

## Wiring Detail

See enclosed Technical Documents