

## **Repositioning the separating rollers – XM-1**

The purpose of repositioning the separating rollers off the belt is to create a “buckle” separation vs. nip point separation. This can be done with the separator mounted or removed from the feeder. The preferred method is to remove the separator.



### **With separator assembly removed from the feeder**

To remove the separator assembly, disconnect the motor cable from the top plate connector. Then, remove the 4 screws that fasten the top block to the cross plate.

Before removing the separator, remove all the product from the feeder and get an idea of where the rollers need to be moved to on the shaft. The inside edges of the rollers should be positioned approximately 1/8 – 1/4” away from the feed belt.

Each roller has two set screws (one fastens to the flat on the shaft). Loosen the set screws and slide the rollers to the desired location. Retighten the set screws making sure one of them is fastened to the flat on the shaft.

Reinstall the separator assembly and refer to the Product Guide for product set up. Note: since the rollers will now be adjusted slightly below the surface of the belt, the adjustment will be lower than previous setting.

### **With the separator assembly installed**

If performing this change with the separator installed, adjustments will need to be done from the rear. To access the set screws on the rollers, remove all product from the feeder, set the batch-size to 00, press the cycle button, and turn the main speed to zero (FCCW). You should hear the motor of the separator pulsing. Though hard to notice with the naked eye, the rollers will be “inching” in the direction as indicated on the top plate where the cable is connected to.

Once you have access to the first set screw, press the stop button and loosen the set screw.

To gain access to the next set screw, press reset and then cycle. Once you have access to the second set screw, press stop again. Loosen the set screw and slide the roller into position (approximately 1/8 to 1/4" away from the feed belt). Tighten the set screw you have access to.

Repeat for other roller.

To regain access to the first set screw, press the reset button and then the cycle button. It will take approximately 3-4 minutes for the first set screw to make it back for access. Once you have access, press stop and then tighten the set screws on both rollers.

Refer to the Product Guide for product set up. Note: since the rollers will now be adjusted slightly below the surface of the belt, the adjustment will be lower than previous setting.