

*Superior* PAPER HANDLING SOLUTIONS

**SMARTCOUNT**  
*BATCH COUNT CONTROLLER*

Model ST-1  
User Guide & Technical Information

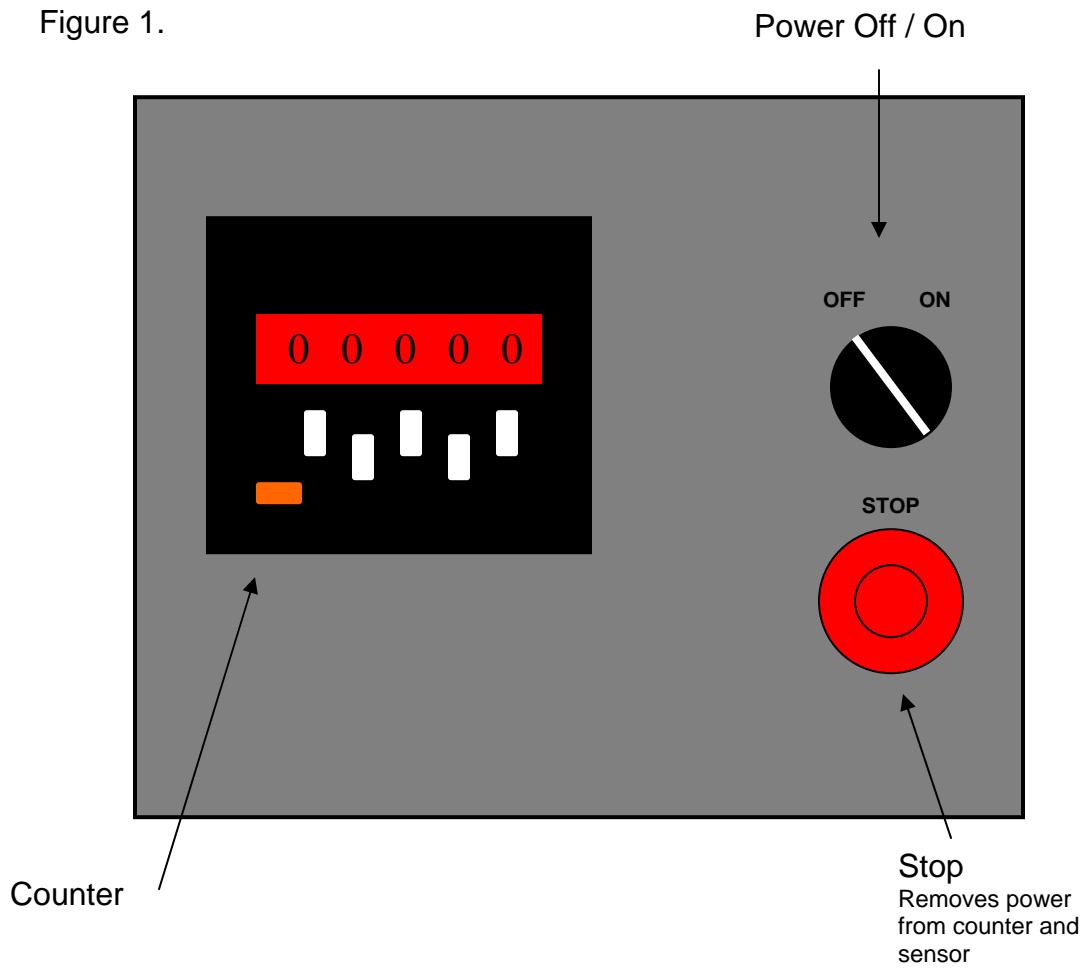
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# 1. Overview

## Operator Interface ST-1 Model

Figure 1.

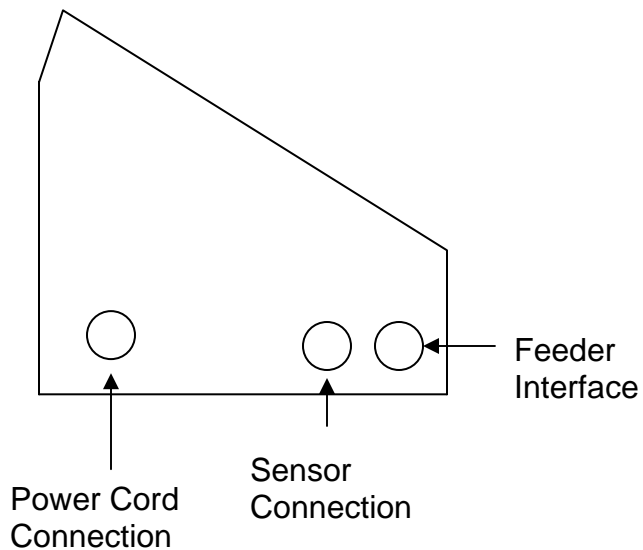


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Table 1- Figure 1

Feature	Description
Counter	The counter provides the interface to select the desired batch size per job. Counts can range from 00001 piece up to 99999 pieces.
Delay Time (Internal Setting)	ST-1 - This setting controls the length of time before the output signal is energized (0-15 seconds)
Power On / Off	Main power on / off interface
Stop	This button will illuminate when pressed and will remove power to the counter and sensor. Simply pull up to disengage the stop.

Figure 2.



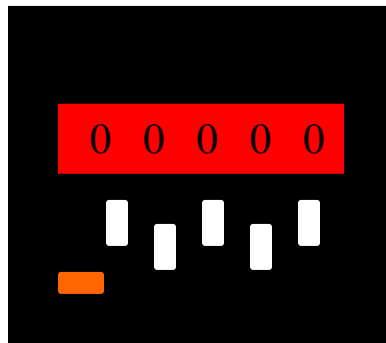
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Table 2- Figure 2

Feature	Description
Sensor Connection	The sensor connection is the interface for the sensor that is used to count the material.
Power Connection	This connection provides 115vac power to the controller.
Feeder Interface Connection	This interface is used to signal the feeder to repeat the feed cycle.

## 2. Settings

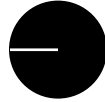
### Counter



The counter is equipped to count from 1 up to 99,999 pieces. To change the count, press any of the digit buttons. All digits will illuminate and display current setting. Pressing the digit buttons will increment the ones, tens, hundreds, thousands, and ten thousands digits. If you do not press any of the digit buttons within 3 seconds, the counter will return to the previous screen with the original count setting. Once you have set the new count, press and hold the red set / reset button for approximately 3 seconds. The display will then reset back to zero.

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## Delay Between Cycles



ST-1 Model – The Delay Between Cycles time setting (located inside the control box) is used to control the length of the pause between cycles. This signal is dry contact, normally closed when activated. The length of time can be set from 0 – 15 seconds. It is recommended that this be set to approximately 1-2 seconds and then use the Trigger Delay feature on the XM-1 feeder to create additional delay.

## 3. Operation

1. With **all** connections made, power on the unit by moving the Off – On switch to the On position. If the Stop button is illuminated, pull up to disengage.
2. Set the batch size on the counter to the desired count. Press any of the white digit buttons and then press the buttons to the desired count. Press and hold the red set / reset button to accept the change.
3. Set the Delay Between Batches time about a  $\frac{1}{4}$  turn up from zero (zero is fully counter clockwise on the dial). This will be used as the starting point. For maximum performance of the system, you will need to then adjust the trigger delay feature on the feeder to create additional delay.
4. Position the counting sensor inline with the product flow (best position is within close proximity of the sensor used in the discharge of the feeder). Make sure that the sensor is not sensing any background. The indicator lamp on the sensor should only come on when product passes by it. The location of the sensor should be relatively close to the feeding device to ensure that the first piece of the next batch is not dispensed onto the conveyor.

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5. Start up the system by moving the conveyor switch from Off to Forward and set the speed. The speed will depend on the desired production. Please refer to the Xtreme XM-1 Product Guide for instructions for set up.
6. As product is dispensed to the counting sensor, the counter display will increment until it reaches the set count. For the ST-1 Model, as soon as the count is reached, the output signal will energize. This signal will stay energized until the Delay time is reached. When the Delay time is reached, the signal will de-energize and the counter will automatically reset to zero and send a trigger signal to the feeder.

NOTES:

## 4. Wiring Diagram

See other