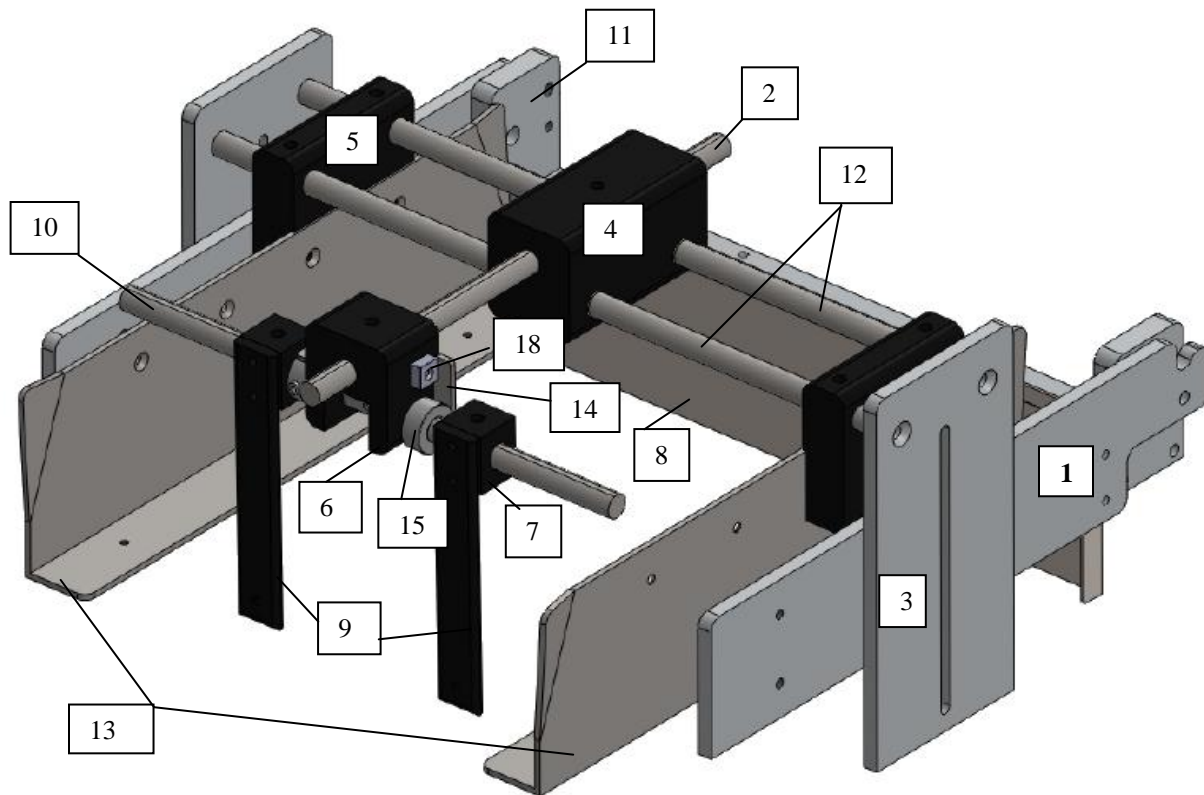




BATCHING TRAY SET UP GUIDE

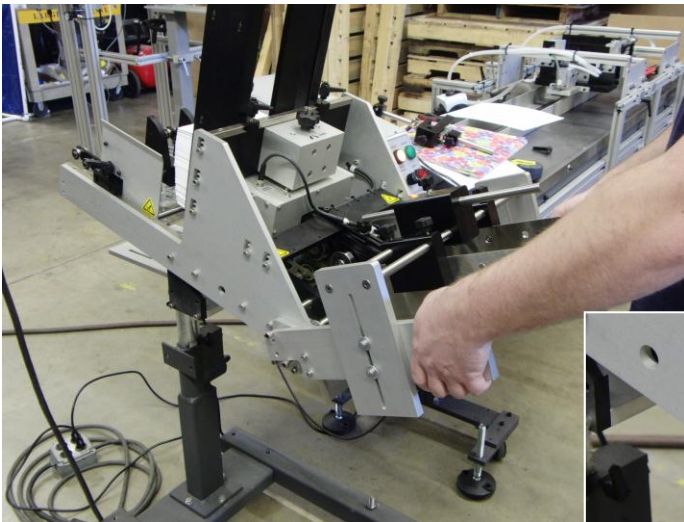


	Part Number	Description	Qty.
1	300050	Extended Slide on Pivot Mount	2
2	300051	Shaft with Flat	1
3	300052	Support Block	2
4	300053	Adjustment Block Side to Side	1
5	300054	Side Guide Mounting Block	2
6	300055	Support Block Rear	1
7	300056	Block Stopper Rear	2
8	300057	Back Stop	1
9	300058	Stopper Rear	2
10	300059	Cut Shaft with Flat	1
11	300060	Front Pivot Mount Extended	2
12	300061	Shaft Side Guide	2
13	300062	Side Guide	2
14	300064	Prox Detect Tab	1
15	300066	6462K160 Modified	2
-	100391	Lobe Knob 10/32 x 1/2 (not pictured)	8
-	100482	Prox Sensor (not pictured)	1
18	300067	Magnet	1



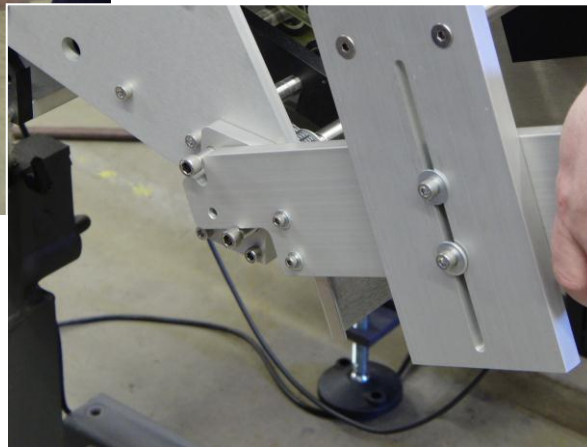
For detailed set up information for the XM-Series Friction Feeder, please refer to the Product Guide included or visit www.superior-phs.com/feeding.htm.

OVERVIEW

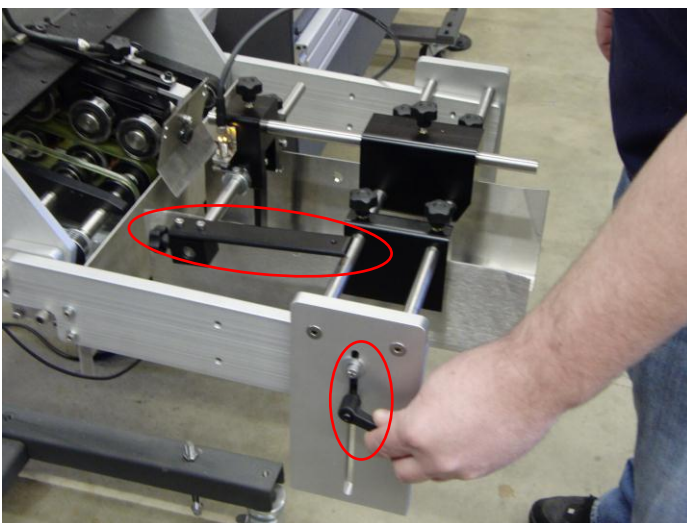


For models purchased in 2012 and newer, simply slide the Batching Tray over the Pivot Mount bracket to rest on the screws provided.

Note: Be sure the feeder deflector plate is in the most upright position prior to installation then reposition the deflector plate to the desired angle.

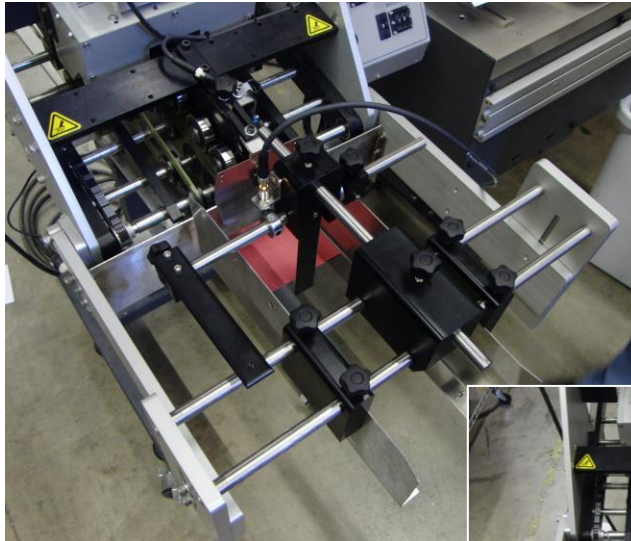


SMALL PRODUCT SETUP (Less than 6")



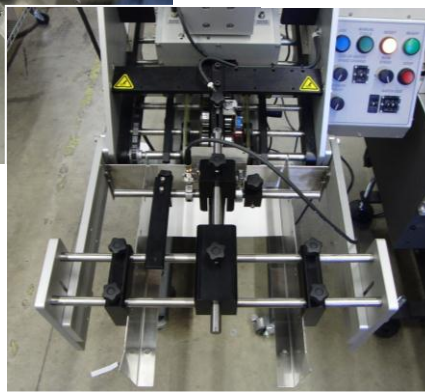
For products less than 6" in length, the Support Blocks should be mounted to the end holes on the Extended Slide. The sensor assembly should be nearest to the feeder while the Adjustment Block is positioned away.

Position one of the Stoppers horizontally (circled) outside of the Side Guides by loosening the Knob. Only one Stopper will make contact with the product.



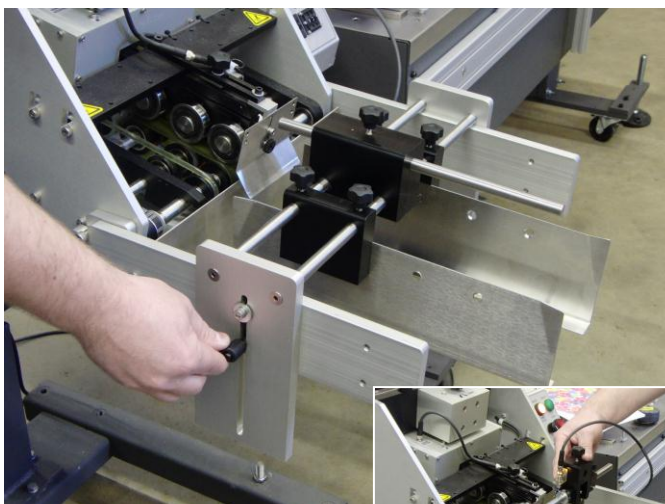
Pictured left is the basic Batching Tray setup for smaller products. The Side Guides should be adjusted in-line with the product coming out. It is important to leave a little extra room to allow the product to enter the Batching Tray without catching the sides.

Position the sensor assembly to the size of the product by loosening the Knobs and adjusting.



Left – Setup for 4 x 9” envelopes feeding the short way.

LARGE PRODUCT SETUP (Greater than 6”)



For products greater than 6”, the Support Block should be mounted to the center holes on the Extended Slide.

If necessary, move the sensor assembly to the end of the Shaft as shown in Figures 3.1 and 3.2.

Both Stoppers should be positioned in the downward position between both Side Guides.

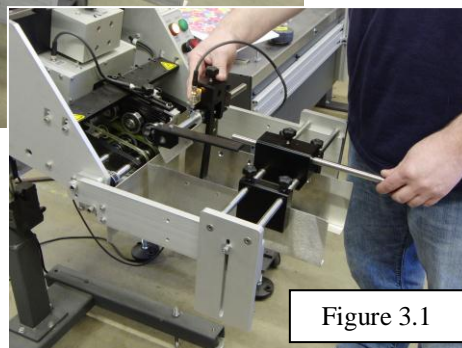


Figure 3.1

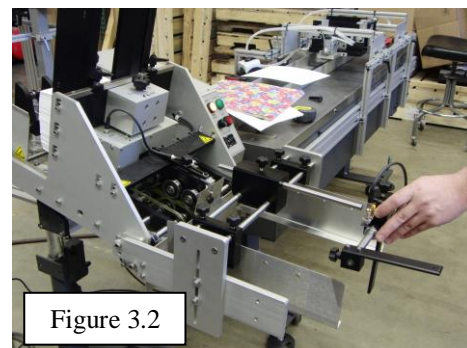


Figure 3.2



Depending on product consistency, the two plastic support guides can be attached to the Side Guides to support wide product that may sag in the middle.



Pictured is the basic Batching Tray setup for larger products. The Side Guides should be adjusted in-line with the product coming out. It is important to leave a little extra room to allow the product to enter the Batching Tray without catching the sides.

Position the sensor assembly to the size of the product by loosening the Knobs and adjusting.

ADJUSTING FOR STACK HEIGHT

Depending on stack height, the Side Guides can be adjusted up and down by loosening the screw/handles located on the Support Blocks. Adjust Side Guides to the desired height then retighten as shown in Figures 4.1 and 4.2.

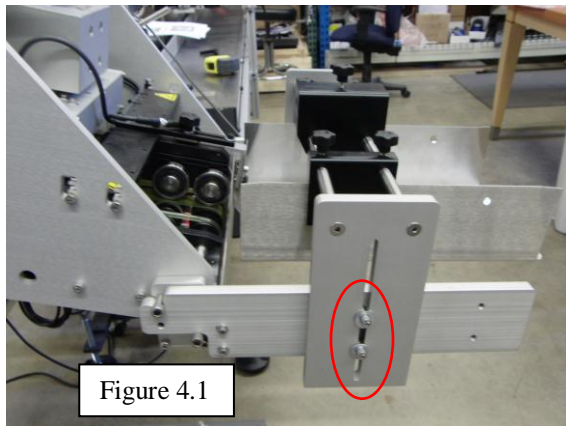


Figure 4.1

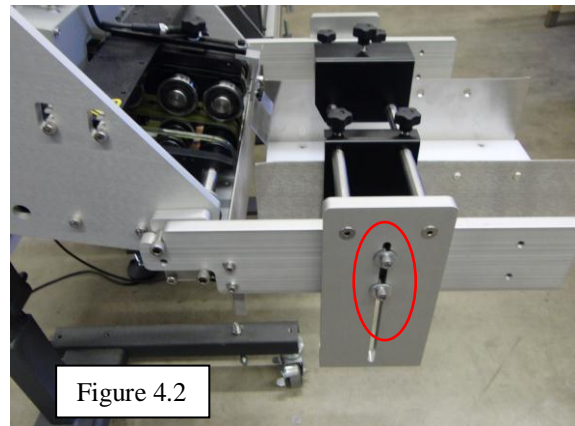


Figure 4.2

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.