Superior
PAPER HANDLING SOLUTIONS

Trigger Timing Reference – XM-1 Friction Feeder

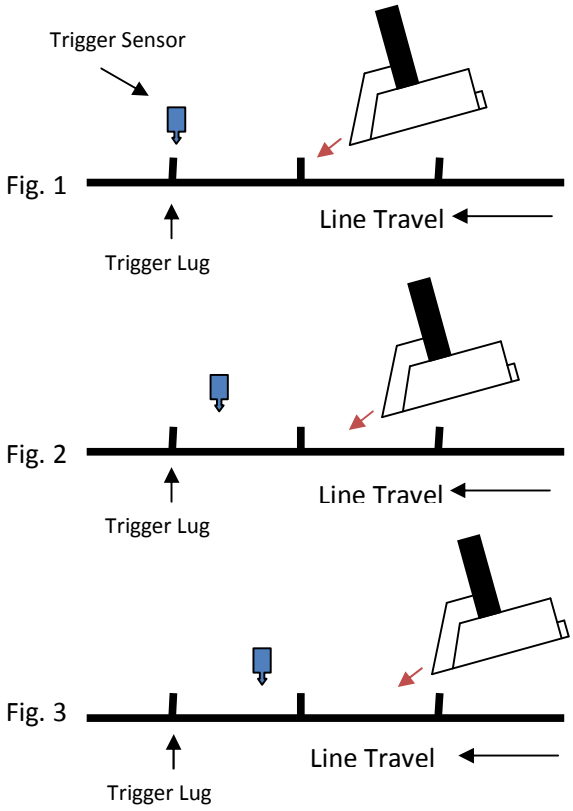
The XM-1 Friction Feeder comes standard with a feature called "Trigger Delay". The setting for this feature is located on the front controls panel. This feature allows the operator to offset products within the pocket of a lugged conveyor. Below are two examples (60ppm and 120ppm) to demonstrate how the Trigger Delay feature works.

Trigger Delay Setting – Line speed 60 per/min

Figure 1	Full Minimum (feeds the front of the pocket)
Figure 2	1/2 Setting (feeds half way into the pocket)
Figure 3	3/4 Setting (feeds the rear of the pocket)

Trigger Delay Setting – Line speed 120 per/min

Figure 1	Full Minimum (feeds the front of the pocket)
Figure 2	Approx. 1/4 Setting (feeds half way into the pocket)
Figure 3	Approx. 1/2 Setting (feeds the rear of the pocket)



Below you will see a timing chart of how the position of the trigger delay dial will affect each feed cycle. Figure 1 shows full minimum delay, thus an immediate feed cycle once triggered. Figure 2 represents feeding the middle of the pocket – at a line speed of 60 ppm, this dial position would be at ½. Finally, Figure 3 represents offset to the rear of the pocket.

TRIGGER DELAY TIMES (dial position)

Full Minimum = 8ms **1/4** = 250ms

1/2 = 500ms **3/4** = 750ms

Full Maximum = 1020ms (just over 1 second)

TIMING CHART