

Xtreme-1200™ Series Touchscreen Manual



Have this information ready when calling in about your equipment:

Model: _____ Serial #: _____

PLC firmware version: _____ HMI firmware version: _____

Warranty Start Date: _____

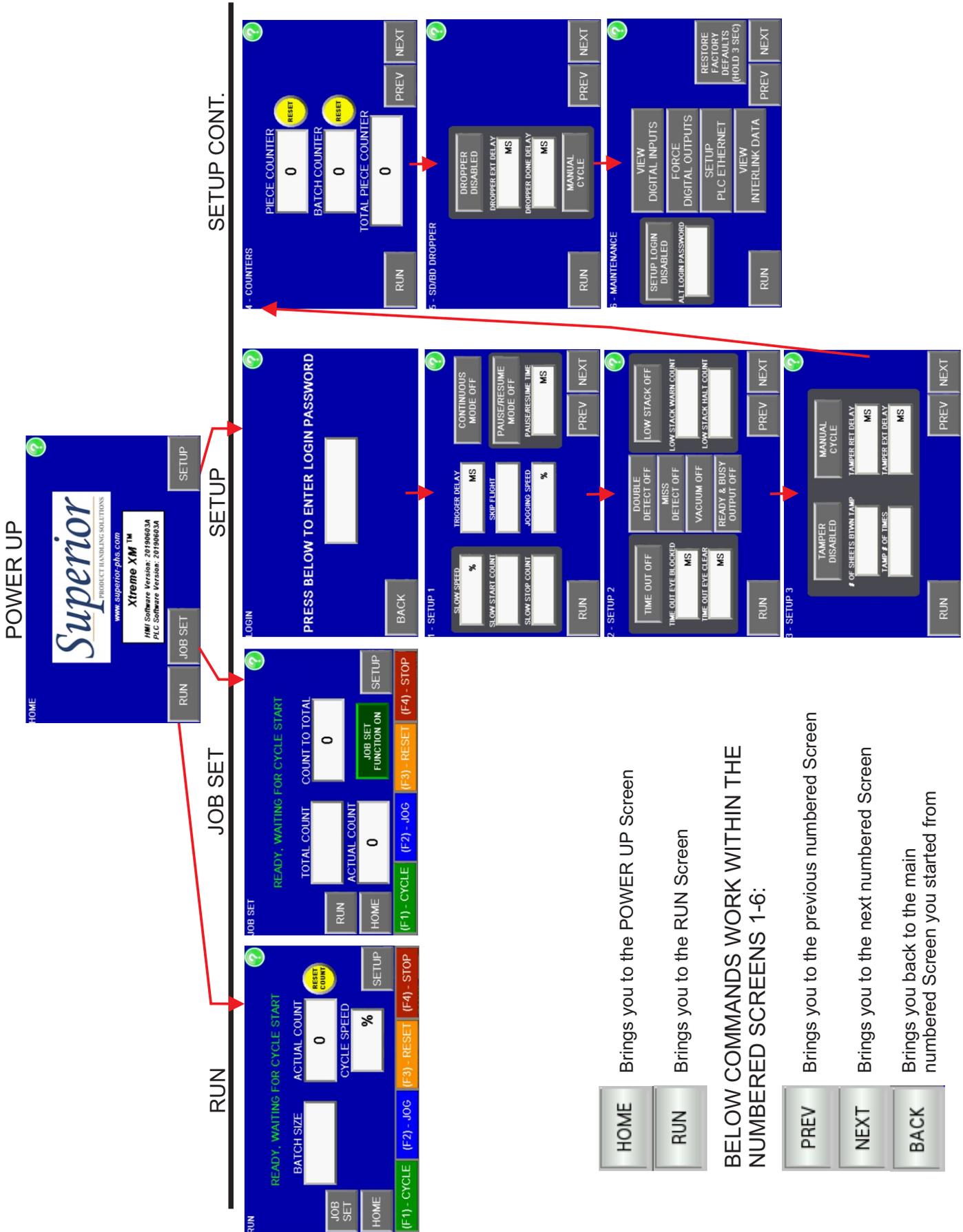
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Illustrations in this guide are for reference only and may depict optional features that are available at additional costs.

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Why Would You Go Anywhere Else?



MECHANICAL FRONT PANEL PUSH BUTTONS



Jog Button The feeder will advanced when the Jog button is pressed. The feeder will continuously run when the jog button is activated. This option is typically used when setting up product in the feeder or clearing any product under the Separator. While holding down the Jog button, you can adjust the Separator and feed product until the product feeds consistently.



Cycle Button If the feeder is Ready than this push button will illuminate. From here pressing the button will command a start cycle.



Stop/Reset Button If an error occurs this push button will illuminate. It will also light when the stop is used to stop the feeder. Clear all errors if present and push this button to move the feeder to a Ready stage.

HOME [POWER UP SCREEN]

NOTE: All settings from previous power down will be retained



RUN: Takes operator directly to Run Screen
JOB SET: Takes operator directly to Job Set Screen
SETUP: Takes operator directly to Setup 1 Screen

HMI and PLC firmware versions

RUN



JOB SET: Takes operator directly to Job Set Screen
(ONLY AVAILABLE ON XM1200-BC)

CYCLE SPEED: Allows user to set feeder speed. 100 is equal to maximum speed. [MIN: 0 / MAX: 100]

F1 thru F4: The four indicators at the bottom of the screen display the assignment of the physical push buttons on the operator interface. These F Key's can be used in place of the mechanical push buttons mounted on the back of the feeder.

RESET COUNT: Pressing this button will reset the Actual Count display. If the feeder has stopped in the middle of completing a Batch, pressing this reset will start the batch count over.

(ONLY AVAILABLE ON XM1200-BC)

BATCH SIZE: Pressing this button will allow a user to set the batch size.

[MIN: 0 / MAX: 999999]

(ONLY AVAILABLE ON XM1200-BC)

ACTUAL COUNT: Display only. Displays the count as the feeder is running. It will count up to your batch size and reset to zero when the batch is complete. If the feeder errors or stops before the batch cycle completes, this number will reflect what has been counted. Starting the feeder again will finish the batch.

(ONLY AVAILABLE ON XM1200-BC)

NOTE: If using the EXT I/O to remotely STOP, RESET and CYCLE the feeder; Upon an error or remote stop, the Actual Count will always reset to zero and not retain the partial batch. If required to retain the partial batch, then remotely PAUSE/RESUME the feeder through the EXT I/O.

5 - JOB SET

NOTE: Job Set is only available on the XM1200-BC.

When the Job Set is turned on and the Total Count reaches zero a display will appear stating the Job Set is complete. In order to initiate another batch cycle you must turn the Job Set off.



TOTAL COUNT: Enter the Job size. [MIN: 0 / MAX: 100]

JOB SET ON/OFF: When using the Job Set function, you will be able to set a Total Count that will stop the feeder when reached.

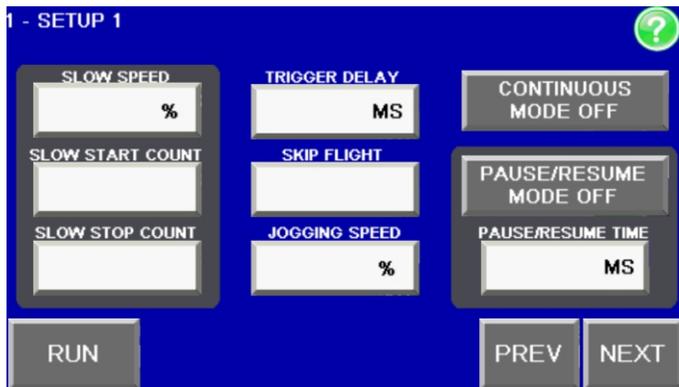
F1 thru F4: The four indicators at the bottom of the screen display the assignment of the physical push buttons on the operator interface. These F Key's can be used in place of the mechanical push buttons mounted on the back of the feeder.

NOTE: If Total Count is at zero when Job Set is turned on it will display Job Complete. Enter count first

ACTUAL COUNT: Display only. Does not function in Continuous Mode. This will display the Actual Count where the feeder is at within a batch. Mirrored display to the Actual Count from the Run Screen.

COUNT to TOTAL : Display only. Displays the quantity left until the Job Set is complete. If the feeder faults during a batch, Clear all product from that Batch and press the Reset Button. The Count to Total will then return to the previous Count to Total number. You can then resume feeding and the Count to Total will be correct.

1 - SETUP 1



TRIGGER DELAY: Enter the delay time in milliseconds. Used only with trigger sensor or external CYCLE input. Ethernet/IP, ModBus TCP and the CYCLE push button will not utilize this delay.

[MIN: 0MS / MAX: 9999MS]

SKIP FLIGHT: Enter the number of skips per trigger. Used only with trigger sensor or external CYCLE input. Ethernet/IP, ModBus TCP and the CYCLE push button will not utilize this delay.

[MIN: 0 / MAX: 100]

SLOW START or STOP function: *The next three functions control the settings with regards to setting a slower speed when starting or stopping the feeder. At high speeds this will assist controlling product to stop consistently and also limit the possible skewing of product as the feeder advances at startup to a high speed.*

SLOW SPEED : Set the speed of the feeder when staging the first piece or Slow Start/Stop is activated.
[MIN: 0 / MAX: 100]

SLOW STOP COUNT: Set how many pieces at the end of a batch will run at the slow speed.
[MIN: 0 / MAX: 100]

SLOW START COUNT: Set how many pieces at the beginning of a batch will run at the slow speed.
[MIN: 0 / MAX: 100]

NOTE: The slow function is turned ON when a value of 1 or greater is set at either of the two count setpoints above. In order to not use the slow function, a value of zero must be recorded in those settings. A value of 1 in the SLOW STOP COUNT with a batch size of 1 will make the feeder stage the next piece at the slow speed.

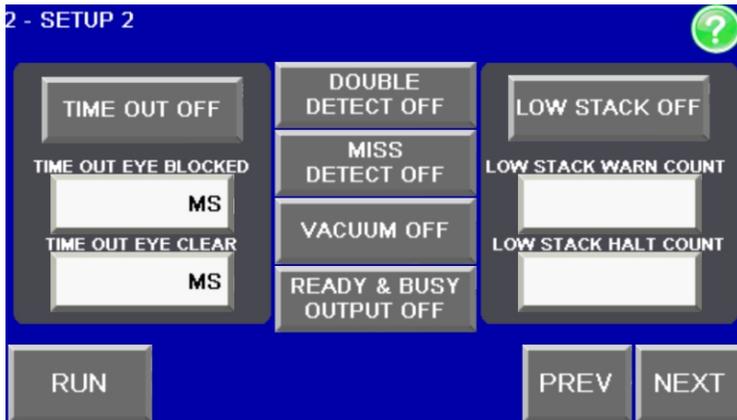
JOGGING SPEED: Set the speed of the feeder when the blue mechanical jog button is pressed.
[MIN: 0 / MAX: 100]

CONTINUOUS MODE: Set ON/OFF from here. The Run Screen will display this button illuminate green when the condition is ON.

PAUSE RESUME: Set ON/OFF from here. The Pause/Resume function is used to automatically keep cycling the feeder with a period of time between batches. The Run Screen will display this button illuminate green when the condition is ON.

PAUSE RESUME TIME: Enter the time value in milliseconds. This represents the time between the batch cycles. The Run Screen will display this button illuminate green when the condition is ON.
[MIN: 1MS / MAX: 9999MS]

2 - SETUP 2



DOUBLE DETECT: Allows user to turn ON/OFF the Double Detect. Green illumination when ON.

MISSED DETECT: Allows user to turn ON/OFF the Miss Detect. This function monitors that the batch cycle has completed before receiving another trigger or remote START. Green illumination when ON

VACUUM: Allows user to turn ON/OFF the Vacuum function.

Ready & Busy function: There are particular I/O point's in the Ext Interface that will change its state with regards to whether the motor on the feeder is running or not. Thus a system controller could monitor the feeder and know when it has completed its batch cycle. The Ready signal can be used by a system controller to monitor if the feeder is ready to feed.

TIME OUT function: The next three functions control the settings with regards to setting the Time Out function. This is used to monitor the sheet sensor for clear and block conditions. (Feeder empty or Jammed conditions)

TIME OUT: Allows the user to turn ON/OFF the Time Out function

TIME OUT EYE CLEAR: Enter the time in milliseconds. An error will occur if the sheet sensor stays open the duration of time set. [MIN: 1MS / MAX: 9999MS]

TIME OUT EYE BLOCKED: Enter the time in milliseconds. An error will occur if the sheet sensor stays blocked the duration of time set. [MIN: 1MS / MAX: 9999MS]

NOTE: The time set for blocked has to be large enough to allow one piece to advance completely through the sheet sensor. This may have to set bigger for large product running at slow cycle speeds.

LOW STACK function: The next three functions control the settings with regards to setting the Low Stack function. This function is only used if the feeder was purchased with a Low Stack eye.

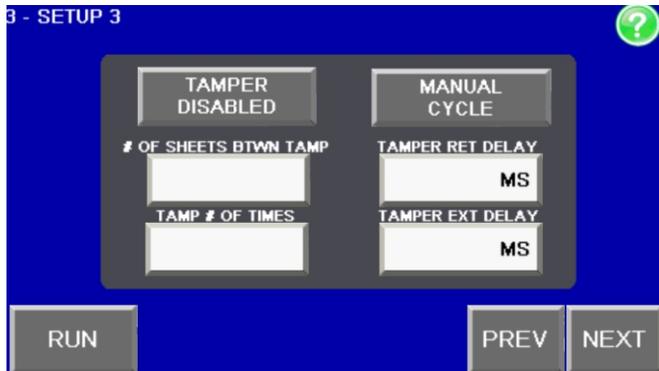
LOW STACK: Allows the user to turn ON/OFF the Low Stack function. Green illumination when ON

LOW STACK WARN: Set how many pieces once the Low Stack eye clears to when the warning amber light will flash (Requires purchase of light tower with feeder) [MIN: 1MS / MAX: 300]

LOW STACK HALT: Set how many pieces once the Low Stack eye clears to when the feeder will stop. Product must be filled again to cycle the feeder. [MIN: 1MS / MAX: 300]

3 - SETUP 3

NOTE: If you did not purchase a Wedge Tamper, disregard this setup page and leave it disabled.



MANUAL CYCLE: Manually activates the wedge tamper and cycles at the speeds programmed below.

TAMPER RETURN DELAY: Enter the return time in milliseconds for the actuator arm. [MIN: 1MS / MAX: 9999MS]

TAMPER EXTEND DELAY: Enter the extend time in milliseconds for the actuator arm. [MIN: 1MS / MAX: 9999MS]

NOTE: General settings will have these extending and returning times around .2-.5 seconds, dependent on the air volume and tamping speed requirements.

WEDGE TAMPING function: *This function along with the mechanical assembly will tap the product while stacked in the hopper. This assists in funneling the product down into the separator assembly for better performance.*

TAMPER DISABLED : Turn the Tamper ON/OFF. Green Illuminate when the function is enabled.

OF SHEETS BETWEEN TAMPS: Set how many pieces will run between tamping cycles.

[MIN: 1 / MAX: 999]

TAMPS # OF TIMES : Set how many times the tamper will extend and return during its tamping cycle.

[MIN: 1 / MAX: 10]

4 - COUNTERS



PIECE COUNTER: Display only. Counts the number of products through the sheet counter. RESET button sets to zero

BATCH COUNTER: Display only. Counts the number of batches completed through the sheet counter. RESET button sets to zero

TOTAL PIECE COUNTER: Display only. Counts the number of products through the sheet counter.

NOTE: This Display is not resettable. It will reflect the number of pieces through the feeder at any given time

5 - SD/BD DROPPER

NOTE: If you did not purchase a dropper, disregard this setup page and leave all OFF.



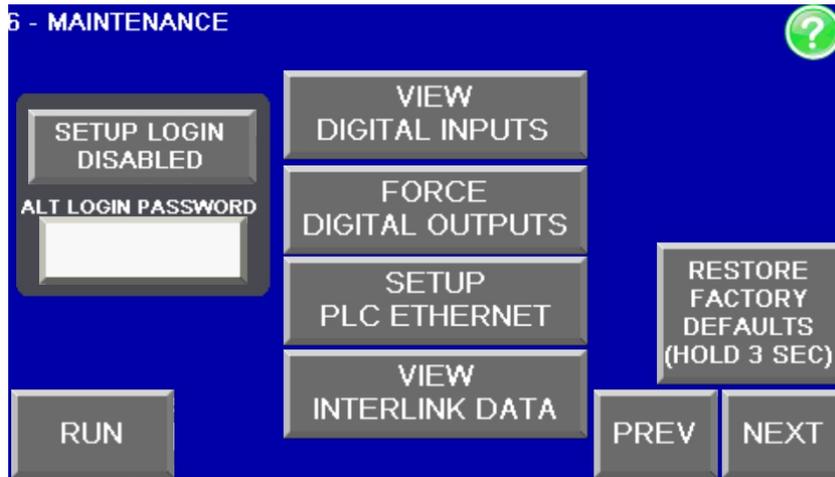
DROPPER: Allows user to turn ON/OFF. Green illumination when ON.

DROPPER EXTEND DELAY: Sets the time in milliseconds the period the dropper stays open.
[MIN: 1MS / MAX: 9999MS]

DROPPER DONE DELAY: Sets the time in milliseconds the feeder will delay before feeding the next batch.
[MIN: 1MS / MAX: 9999MS]

MANUAL CYCLE: Cycles the dropper once.

6 - MAINTENANCE



Restore Factory Defaults: Hold this button down for 3 seconds (Green LED light on the feeder will Flash when done) and it will restore all settings back to the way you received the machine.

View Digital Inputs: Takes the operator to the Digital Inputs Screen.

View Digital Outputs: Takes the operator the Digital Outputs Screen.

Setup PLC Ethernet: Takes the operator the Ethernet Setup Screen.

View Interlink Data: Takes the operator the Ethernet/IP Data View Screen.

LOGIN FUNCTION: A password can be configure to protect access to the setup screens. When enabled a login screen as shown below will require a password to be inputted before access to setup is allowed.

Login Enable/Disable: Turns ON/OFF the requirement for a password login to access the feeder setup screens.

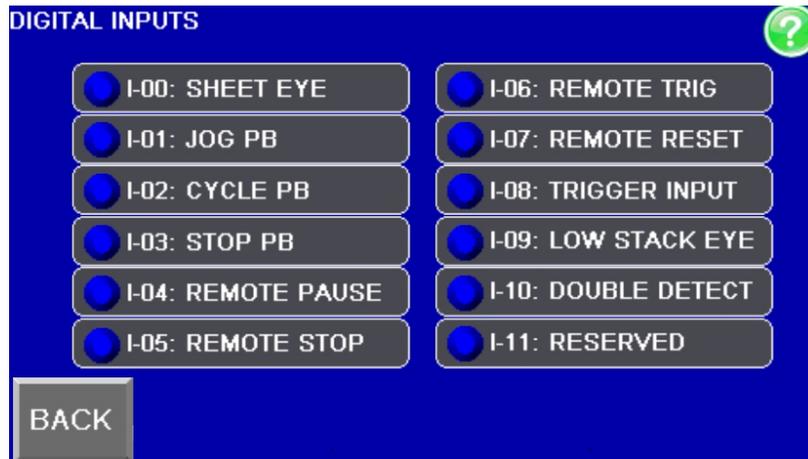
Alternate Login Password: Allows entry of an alternate password that can be used to access the feeder setup.

LOGIN SCREEN

NOTE: The default login password is 777. The alternate password may also be entered.

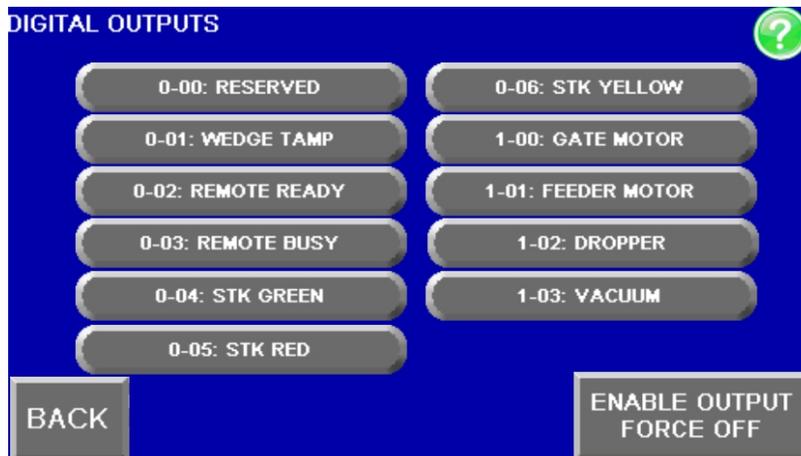


DIGITAL INPUTS



Viewing Digital Inputs is used by maintenance to troubleshoot the PLC inputs. Each line item represents an input on the controller. A positive read is when the indicator light on screen illuminates next to the item you are troubleshooting. For assistance please contact the manufacturer.

DIGITAL OUTPUTS



Forcing Digital Outputs is used by maintenance to troubleshoot the PLC outputs. Each line item represents an output on the controller. To activate, you must turn ENABLE OUTPUT FORCE ON. The button will illuminate green when on. Here you can test certain indicator lights and motor commands within the feeder and droppers. For assistance please contact the manufacturer. *WARNING***do not leave the ENABLE OUTPUT FORCE ON for it will affect the feeder performance.**

ETHERNET SETUP

ETHERNET SETUP

PLC IP ADDRESS

PLC DEFAULT GATEWAY

PLC SUBNET

BACK APPLY

The Ethernet Setup Screen allows configuration of the PLC Ethernet Network interface. From this screen the IP Address, Default Gateway, and Subnet can be inputted. Press the "APPLY" button to save changes after inputting new values. After pressing APPLY if the setup was successful a GREEN confirmation message will appear. If the setup fails a RED error message will appear. If a failure occurs recheck the inputted values and try pressing APPLY again.

INTERLINK

INTERLINK

B01: HEART BEAT

B02: TRIGGER

B03: STOP

B04: RESET

B05: PAUSE

B06: JOG

B07: GREEN LED CTRL

B08: GREEN LED ON

B09: YELLOW LED CTRL

B10: YELLOW LED ON

B11: RED LED CTRL

B12: RED LED ON

BACK BATCH COUNT INPUT 0

The Interlink View Screen allows an integrator to view the Ethernet/IP & ModBus TCP input data currently being read by the PLC. Refer to the Interlink specification for additional information.

MESSAGE DISPLAYS

READY, WAITING FOR CYCLE START	- Waiting for a trigger
FEEDING SHEET TO STAGED POSITION	- First trigger will stage a piece if there is not one staged.
WAITING FOR DROPPER TO CLEAR	- Feeder is waiting for the dropper to drop its stack before it can initiate another cycle
CYCLING	- Feeder is running.
BATCH COMPLETE	- Last triggered batch has completely fed
PAUSE/RESUME WAITING FOR TIME DELAY	- PAUSE/RESUME Timer is active, feeder will feed when time is complete
WAITING ON REMOTE PAUSE	- External Remote Pause Signal is active, remove remote signal to continue feeding
JOB SET DONE, TURN OFF JOB SET TO CLEAR	- You have completed a Job Set, turn it off on the Job Set Screen
WARNING, LOW STACK	- Low Stack has approached its warning stage

ERROR DISPLAYS

FEEDER STOPPED, RESET FEEDER

Feeder is in a stop state. This occurs when the RED Stop Button is press and when setup variables are change.

DOUBLE DETECT, CHECK PRODUCT SEPARATION

The double detect sensor mounted at the discharge of the feeder detected a thickness greater than one piece. Reset your mechanical setup to pull only one piece or adjust sensor sensitivity.

TIME OUT, CHECK IF PRODUCT IS LOADED AND CHECK PRODUCT SEPARATION

Ensure there is product separation when jogging the feeder. Adjust hold down pressure with knob on separator if more separation is required. Also check that your timeout settings on Setup Screen #2 are set long enough for the entire product to be fed.

MISS DETECT, TRIGGER OCCURRED BEFORE LAST FEED WAS COMPLETE

Another trigger occurred that could not be performed because a feed was in progress. Increase cycle speed to feed piece faster or increase timing between triggers.

LOW STACK, FILL THEN PRESS CYCLE TO RESUME

The Low Stack Photo Eye detected a lack of product. Product should be reloaded when the yellow/amber light turns on. If the feeder is not reloaded in time this fault will occur.