

USER MANUAL

RSW Dropper (Servo)

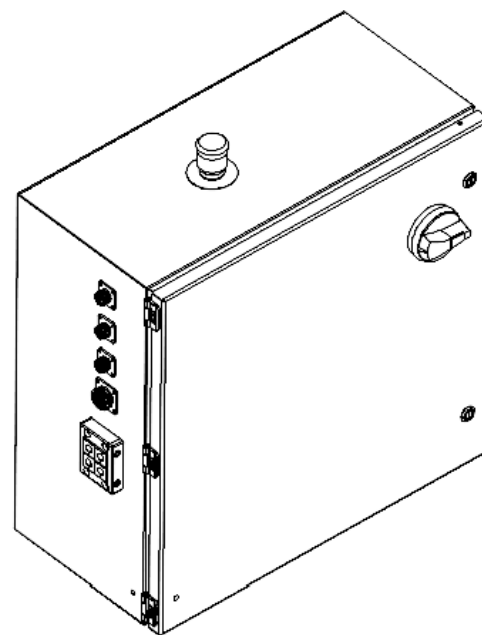
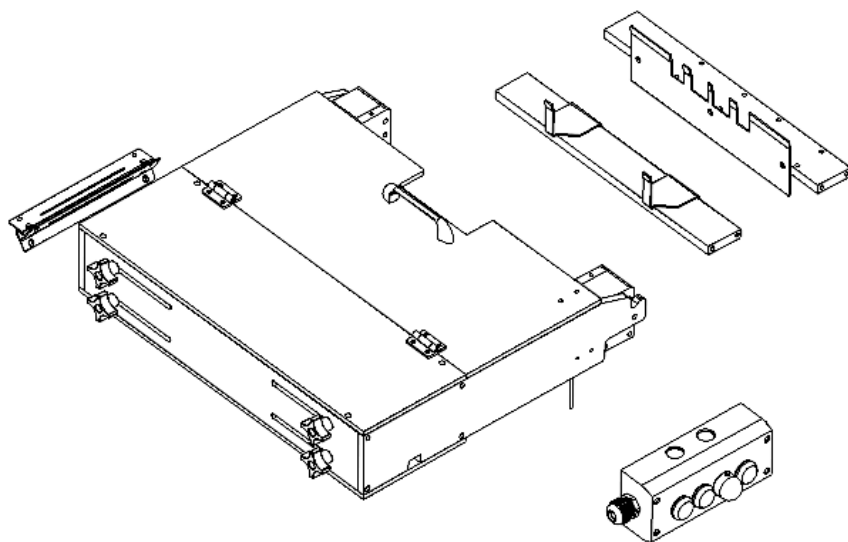


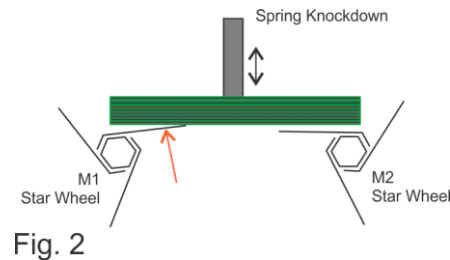
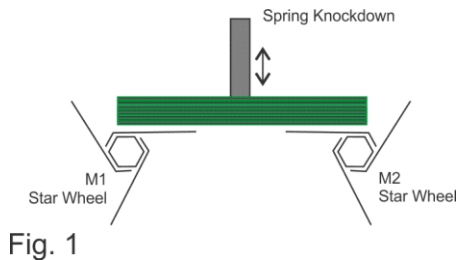
Table of Contents:

Product Setup: _____	3
<i>Setting up the Dropper:</i> _____	3
Maintenance: _____	4
<i>Machine:</i> _____	4
Operating: _____	4
<i>READY/FAULT modes:</i> _____	4
Parts: _____	4
<i>Order Placing:</i> _____	4
<i>Illustrated parts breakout:</i> _____	4
Schematic: _____	8
Panel Connections: _____	10

Product Setup:

Setting up the Dropper:

1. Set backstop to the length of the product as it would enter the dropper.
2. Loosen 4 back adjustable knobs and set both the left and right-side wings to be around 1/16th within the product width. Tighten the adjustable knobs.
3. With the unit powered, open the clear guard. (Status indicator will go to red)
4. Set the wings to be horizontal in relation to the product. FIG. 1
Fig. 2 represents an incorrect setting.



5. With the wings set horizontally and the clear guard open, press the blue HOME button on the remote operator station. (This will set the position for every drop sequence initiated)
6. Close the clear guard (Status indicator will go to green) and press the black DROP button to simulate a drop. Verify side wings advance 120 degrees and stop in the home position that was set in previous step.
7. Lastly, advance the product into the dropper and adjust the dropper knockdown spring using the slotted block alignment and by bending the spring manually. Also set the knockdown plate and stop position from the feeder in this step. These adjustments are critical to making sure the product advances into the dropper correctly and allows for a clean drop. NOTE: Remember to set these steps to cover the range of product batch sizes that will be collating in the dropper. (i.e. Batch size of 2-10 products)
8. The dropper is now set. Pressing the green CYCLE button with command a DROP command and send a feeder trigger to advance the next batch automatically.

Maintenance:

Machine:

Periodically blow the feeder off with compressed air. Paper dust should be clear so as not to impede the performance.

Operating:

READY/FAULT modes:

When powered and with the clear safety door closed, the dropper will show a green STATUS indication at the remote operator station. This is a ready condition. The dropper at this point can be cycled through a remote discrete signal or manually using its CYCLE push button on the operator station.

If the clear safety guard is opened or the servo motors go into a fault condition, the STATUS indicator will show red. This is a fault condition and the dropper will not operate if a cycled trigger is received.

Note: to set the servo HOME condition in step. 5 , the dropper must be in this fault condition

Parts:

Order Placing:

Contact Superior-PHS for all parts needed.

Our contact information can be found at: www.superior-phs.com

Illustrated parts breakout:

See the following pages:

RSW SERVO DROPPER

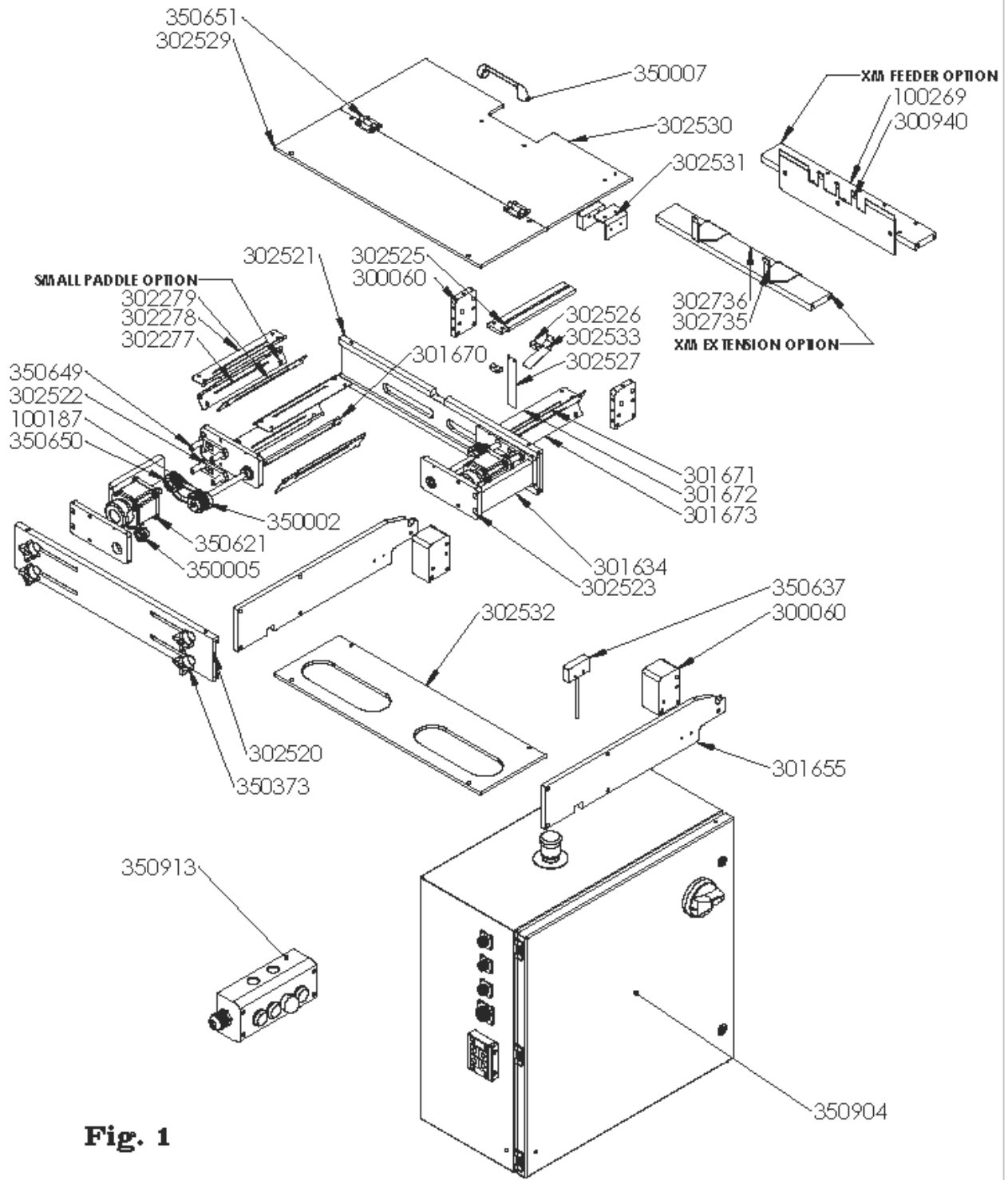


Fig. 1

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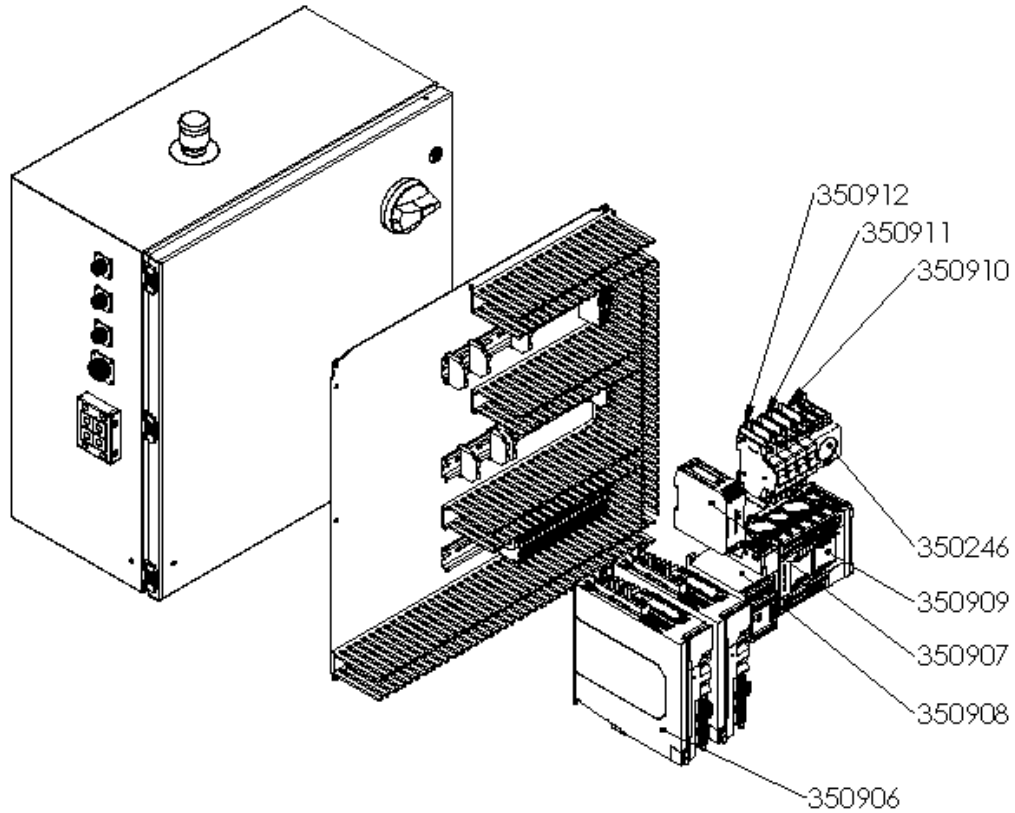
Assembly Number:
500053-S

RSW SERVO DROPPER

PART	DESCRIPTION	QTY
100187	TIMING BELT	1
100269	FRONT T CROSS BAR	1
300060	FRONT PIVOT MOUNT	2
301634	SPACER BAR	2
301655	SUPPORT WALL	2
301670	HEX SHAFT	2
301671	1.375 LANDING WEDGE	2
301672	1.375 LANDING WEDGE	2
301673	1.375 LANDING WEDGE	2
301685	SPACER BLOCK	2
301756	DROPPER PLATE	1
302277	1.000 LANDING WEDGE	1
302278	1.000 LANDING WEDGE	1
302279	1.00 LANDING WEDGE	1
302375	BACK STOP	2
302520	BACK CROSS SUPPORT	1
302521	FRONT CROSS SUPPORT	1
302522	MOTOR MOUNT SLIDE	4
302523	PADDLE ASSY ENCASE PLATE	4
302525	KNOCKDOWN ADJUSTMENT ARM	1
302526	ADJUSTMENT BLOCK	2
302527	BACK STOP	1
302529	TOP COVER	1
302530	DOOR COVER	1
302531	SAFETY SWITCH MAGNET BRACKET	1
302532	BOTTOM COVER	1
302533	SPRING STEEL KNOCKDOWN	1
302736	CROSS BAR	1
350002	TIMING PULLEY	2
350005	BEARING	4
350007	HANDLE	1
350373	ADJUSTMENT HANDLE	4
350621	SERVO MOTOR	2
350637	SAFETY INTERLOCK SWITCH/ACTUATOR	1
350649	SPACER	8
350650	MOTOR PULLEY	2
350651	HINGE	2
350904	RSW ELECTRICAL PANEL	1
350913	RSW OPERATOR BOX	1

Fig. 1

RSW ELECTRICAL PANEL



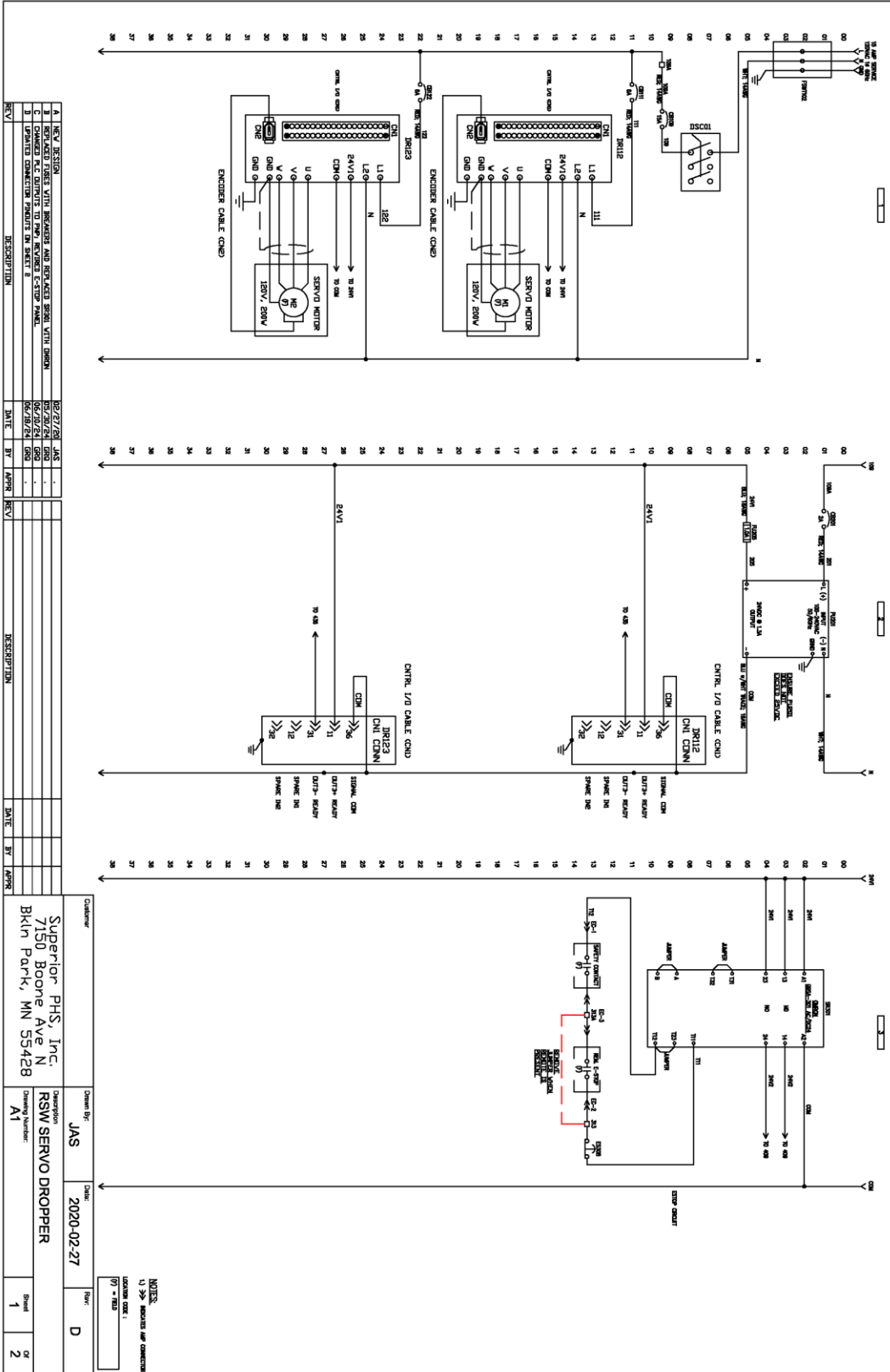
PART	DESCRIPTION	QTY
350246	DISCONNECT 40A	1
350906	AC SERVO DRIVER	2
350907	POWER SUPPLY	1
350908	SAFETY RELAY	1
350909	PLC	1
350910	CIRCUIT BREAKER 2A	1
350911	CIRCUIT BREAKER 6A	2
350912	CIRCUIT BREAKER 15A	1

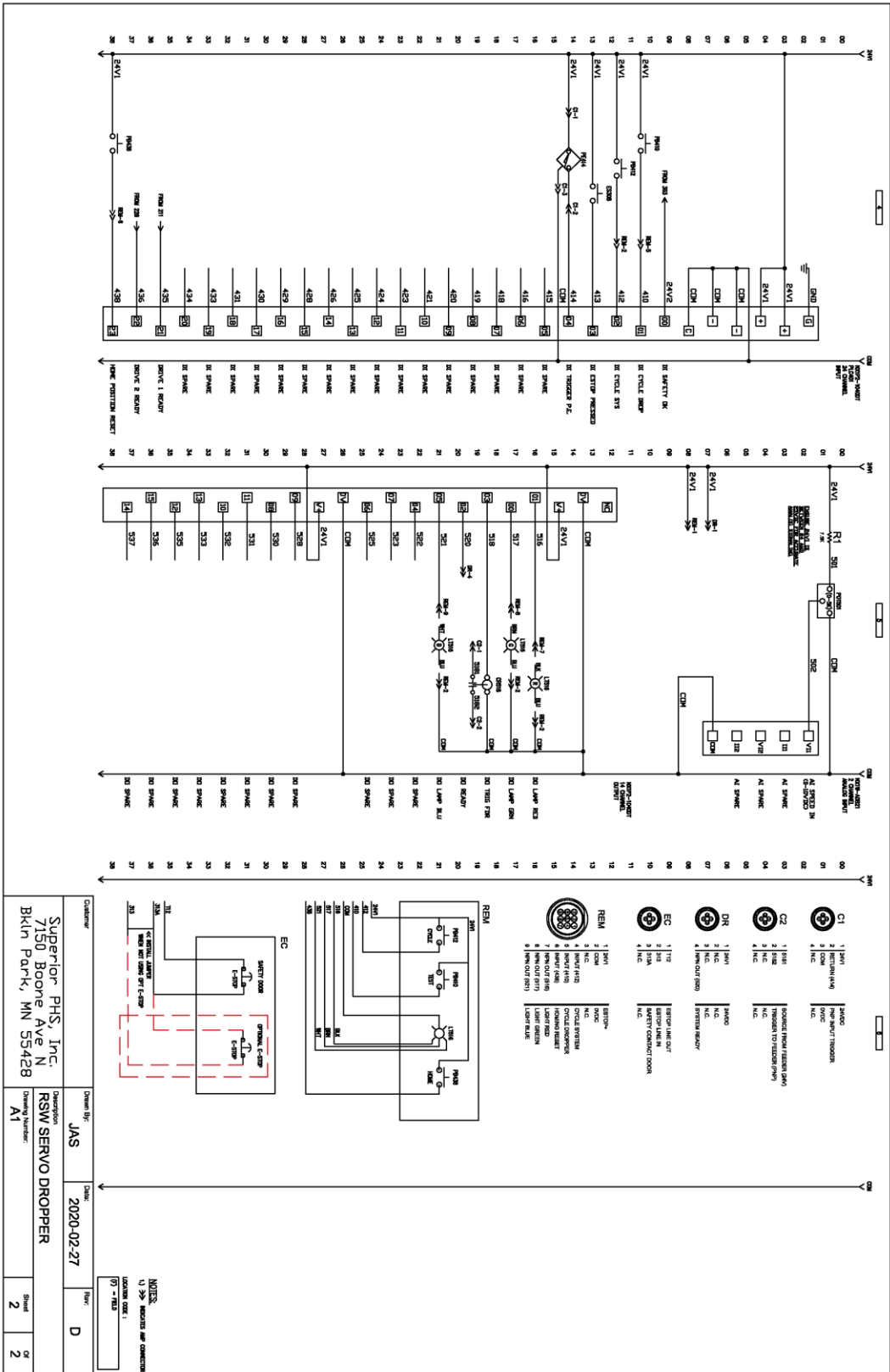
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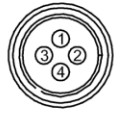
Assembly Number:
350904

Schematic:






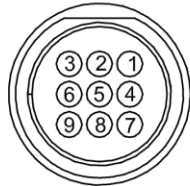
Panel Connections:

	C1	1	24V1	24VDC
		2	RETURN (414)	PNP INPUT TRIGGER
		3	COM	0VDC
		4	N.C.	N.C.

	C2	1	5181	SOURCE FROM FEEDER (24V)
		2	5182	TRIGGER TO FEEDER (PNP)
		3	N.C.	N.C.
		4	N.C.	N.C.

	DR	1	24V1	24VDC
		2	N.C.	N.C.
		3	N.C.	N.C.
		4	NPN OUT (520)	SYSTEM READY

	EC	1	T12	ESTOP LINE OUT
		2	313	ESTOP LINE IN
		3	313A	SAFETY CONTACT DOOR
		4	N.C.	N.C.

	REM	1	24V1	ESTOP+
		2	COM	0VDC
		3	N.C.	N.C.
		4	INPUT (412)	CYCLE SYSTEM
		5	INPUT (410)	CYCLE DROPPER
		6	INPUT (438)	HOMING RESET
		7	NPN OUT (516)	LIGHT RED
		8	NPN OUT (517)	LIGHT GREEN
		9	NPN OUT (521)	LIGHT BLUE