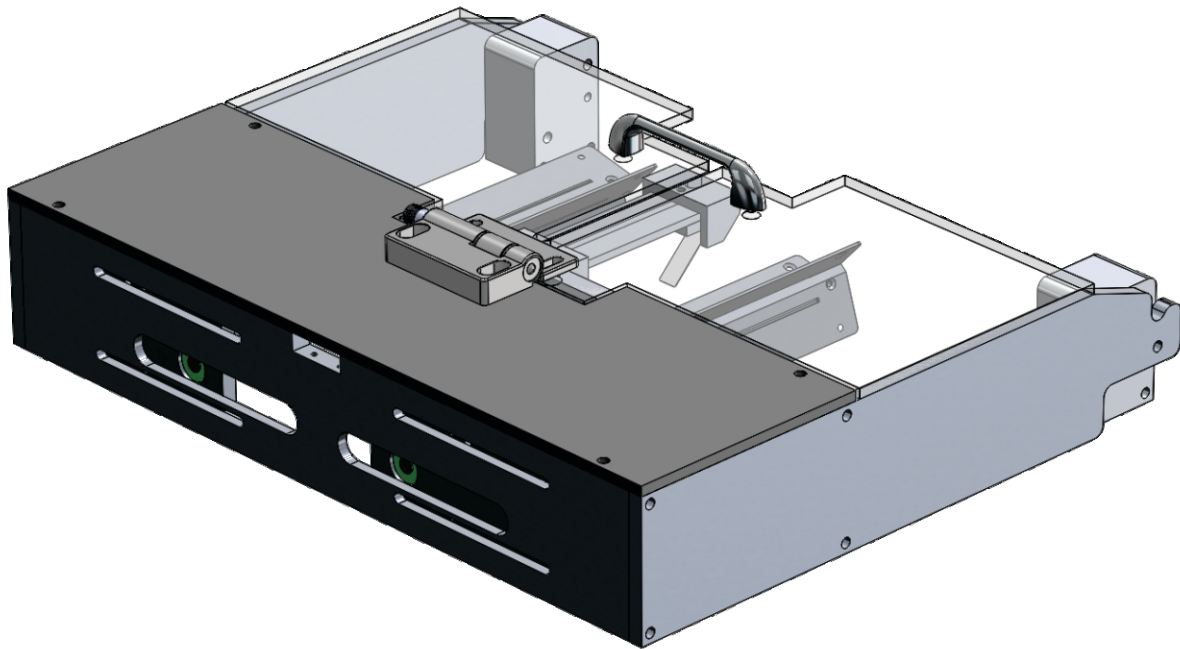


VICTORY RSW Dropper

Operation Instructions and Technical Information Guide



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

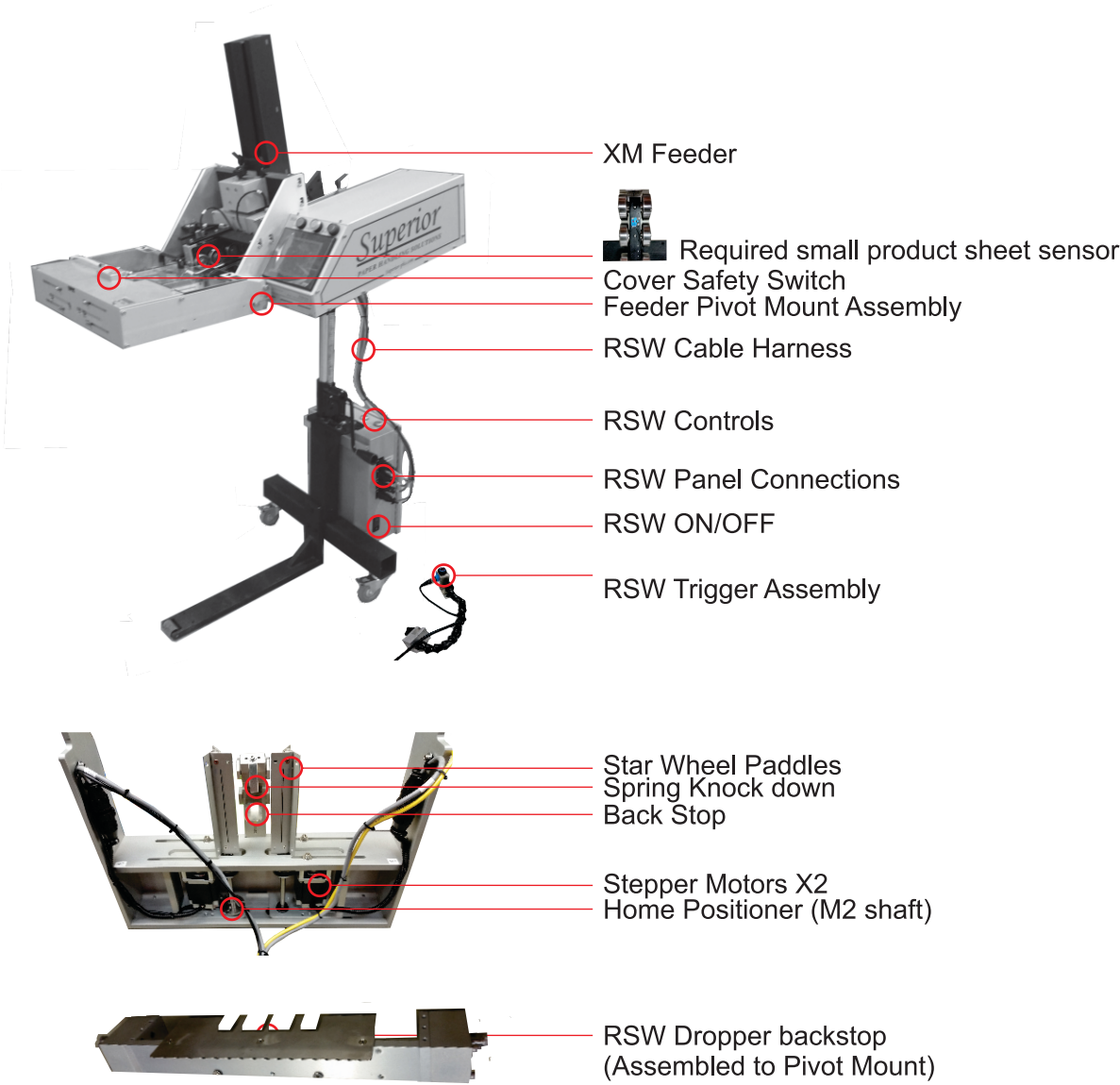
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Section 1 Machine Overview

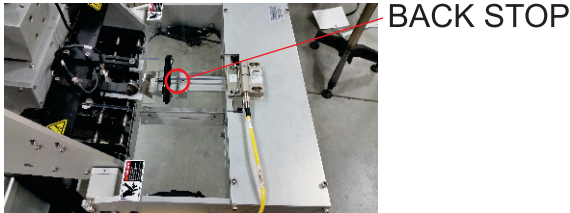
Please review the components and descriptions to become familiarized with the Victory RSW Dropper.



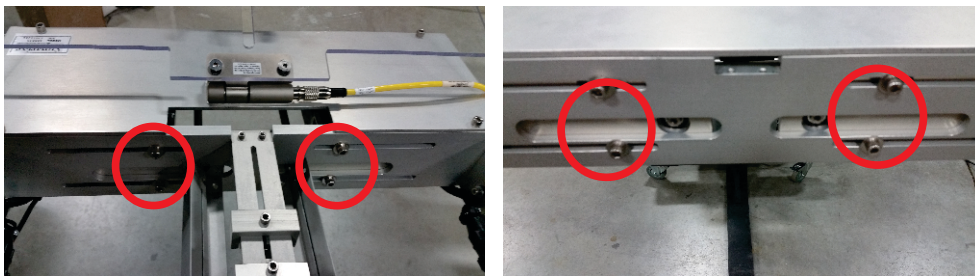
Section 2 Setup and Operation

Manually set up the dropper to the product size.

Move the back stop out of the way of the product you are going to setup.



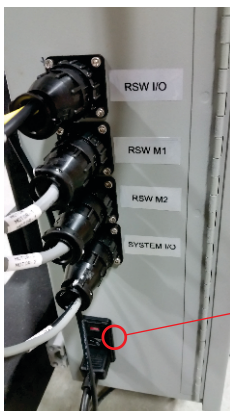
Loosen the bolts to adjust the starwheels to the product width. Make sure to leave at least a 1/16" on each side of the product to prevent binding during the drop cycle. Tighten the bolts, making sure to have the starwheels centered on the product.



Reset the back stop to accommodate the length of the product.

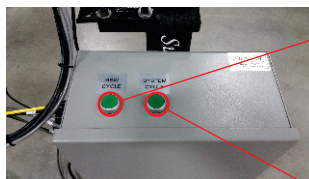
Adjustment of the spring knock-down is product dependent. Start by centering the spring contact to the center of the product and fine tune adjust after manually running some cycles. NOTE: manually bending the spring can be done here

Refer to the Product Guide for the set up instructions of the Xtreme XM Series Feeder. Once the feeder is set up, proceed to power up of the Rotary Star Wheel Dropper.



RSW POWER

Power up the unit by moving the on/off switch to the "on" position (switch located on controls enclosure panel).



RSW CYCLE - This pushbutton will cycle only the RSW dropper. Used for setup.

SYSTEM CYCLE - This pushbutton will cycle the RSW dropper and send a trigger signal to batch feed the next set.

Key SETUP and OPERATION Notes:

When setting up the star wheel positions, the goal is to control the stop position to Fig. 1. If M2 is needing correction, adjustment of the Home positioner will be required (refer page 3). Adjust the Spring Knock down to control the product once in the dropper.

M1 can be adjusted independent of M2. (Fig.2) To set this position, lift the safety cover and position the star wheel by hand and then close cover. This positioning can be useful for added product support under the stack, and useful for switching between different stack counts and not having to readjust Spring Knockdown.

When setting up the feeder, it is ideal to control the stop position of the product as shown in Fig.3. This is important for efficient operation of the star wheel paddles (not clipping overhung product) and for accurate, repeatable batch counts

The XM feeders are designed with a under carriage sheet sensor in the discharge. (refer page 3) This sensor has multiple mount positions as seen in Fig.4. Note the stop position moves in relation to that sheet sensor position. There are also program features in the XM control (Machine speed, Slow-down speed and count, and stop delay) that will control where this product will stop between batch feeds. Familiarize your knowledge of the feeder controls.

Fig 5. represents a WRONG setup. In this scenario, the product has passed the sensor in its stop position. The feeder will assume that stopped product is in the RSW dropper, and your counts will show off for each dropped set. Every stopped position setup must have the stopped product under the sensor before beginning another batch set.

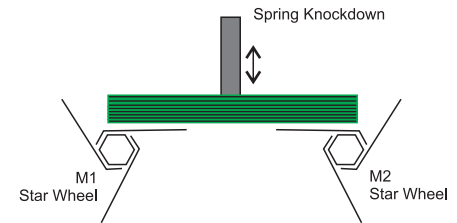


Fig. 1

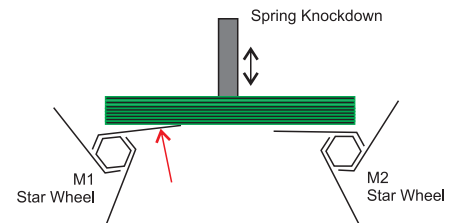


Fig. 2

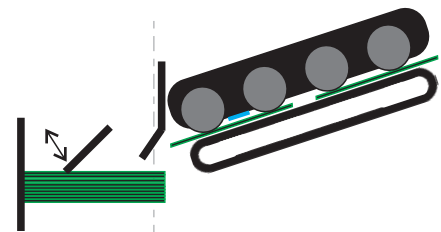


Fig. 3

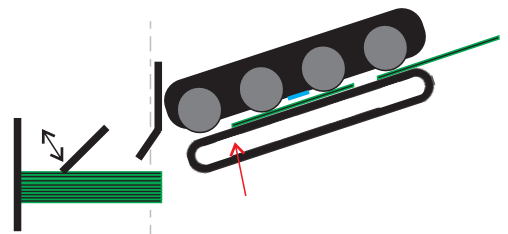


Fig. 4

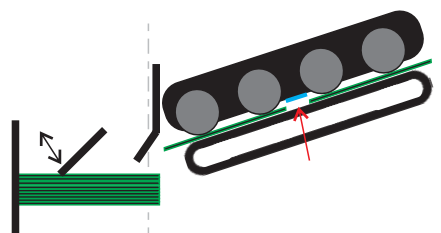
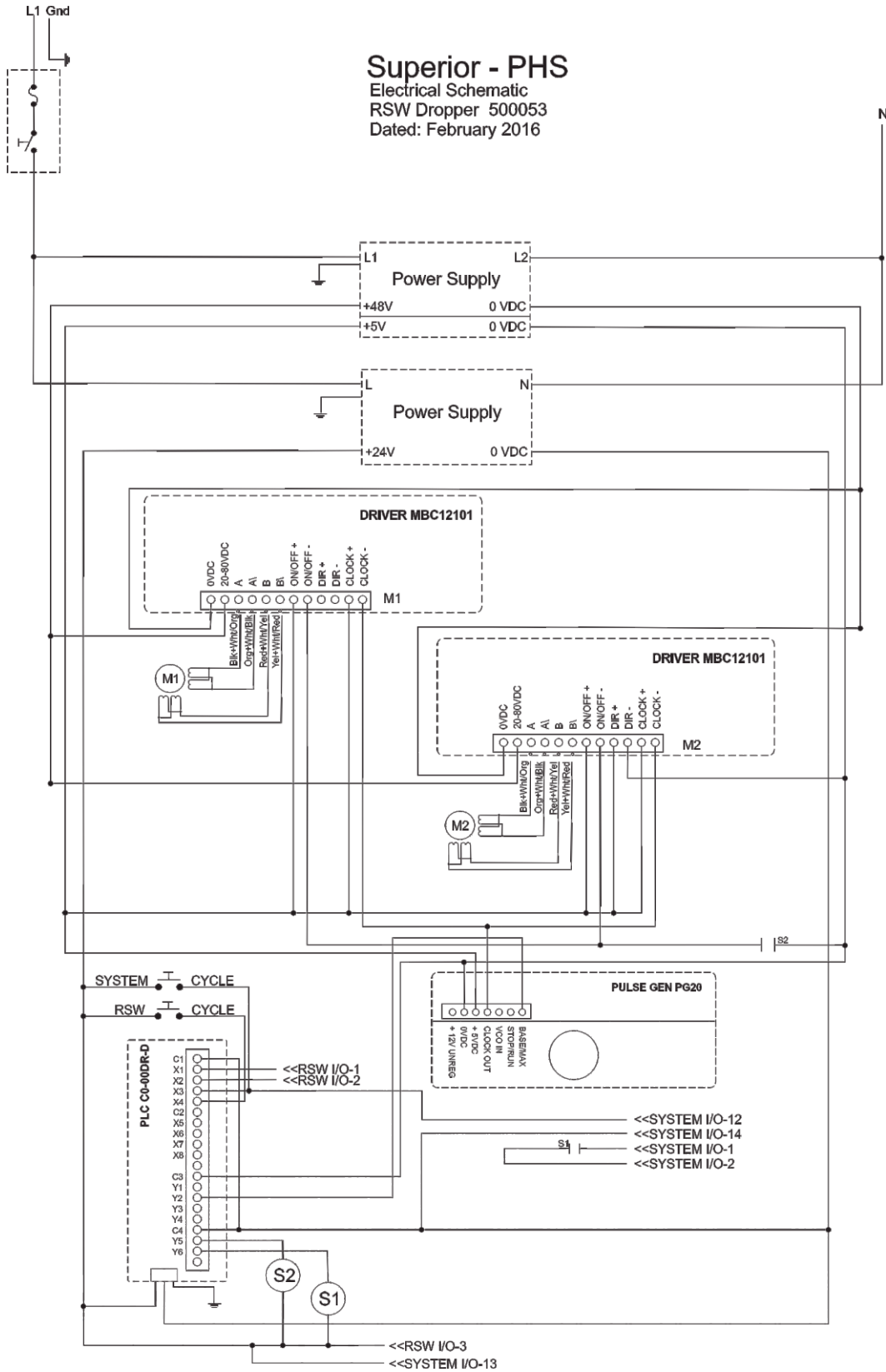


Fig. 5

Section 3 Operational / Technical Assistance

Problem	Probable Cause	Corrective Action (Actions must be verified in numerical order)
No AC power to the unit	1. On/Off switch in Off position (O) 2. Power cord loose or not plugged into AC source 3. Blown Fuse(s)	1. Move switch to ON position (-). 2. Check connection to AC source and to unit. 3. Replace Fuse(s) (consult technician)
Star wheel paddles will not rotate when cycled	1. Safety cover open 2. Safety hinge or cable has open 3. Cycle command is present at PLC 4. Pulse Generator Output at PLC is present 5. S2 relay Output at PLC is present 6. Power at Stepper Drives is present	1. Close Safety Cover 2. On PLC verify X1 has +24 when cover closed NO - Check 24V Power Supply; Check Safety Switch and cable YES - Check X1 is lit on PLC NO - If 0V at C1, replace PLC YES - next 3. On PLC verify X3 has +24V when cycled either with pushbutton or trigger sensor NO - Verify and replace bad cycle mechanism YES - Replace PLC 4. Verify Y2 is on after a cycle is received YES - Replace Pulse Generator NO - If 0V (5V logic) at C3 then replace PLC, otherwise check 0V wiring 5. Verify Y5 is on after a cycle is received YES - Replace S2 Relay NO - If 0V (24V logic) at C4 then replace PLC, otherwise check 0V wiring 6. Verify Power indicator LED is lit on Stepper driver NO - Verify 48V Power supply operable or replace YES - Replace Stepper Driver

Section 4 Wiring and Electrical Detail



Section 5 Maintenance

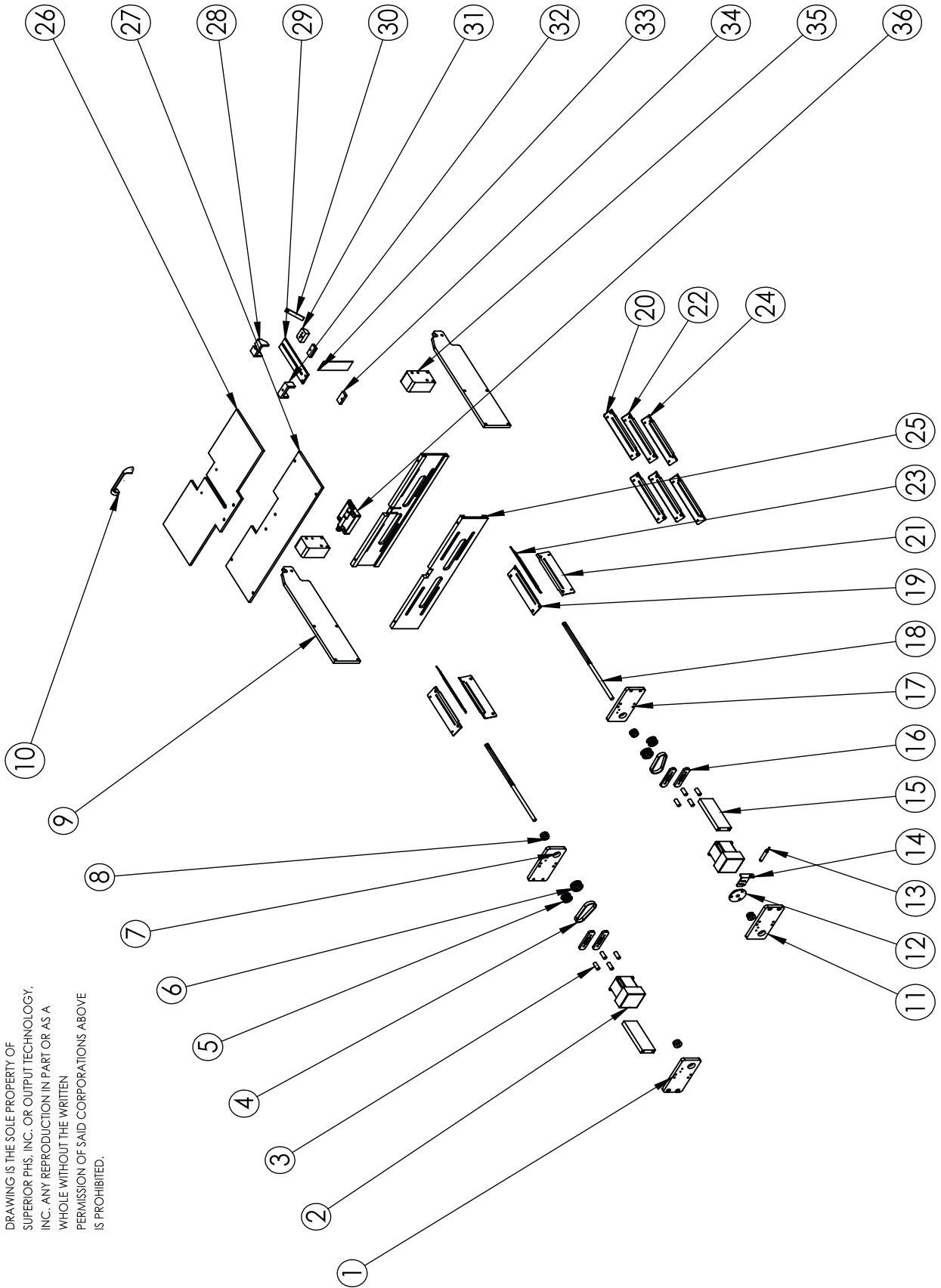
Please remember that all maintenance and service to the Victory BatchDrop-RDS should only be performed by qualified technicians. Always disconnect power before attempting any maintenance or service procedure.

- Gently blow off dust accumulation or wipe with a dry cloth
- Inspect for worn parts and replace immediately

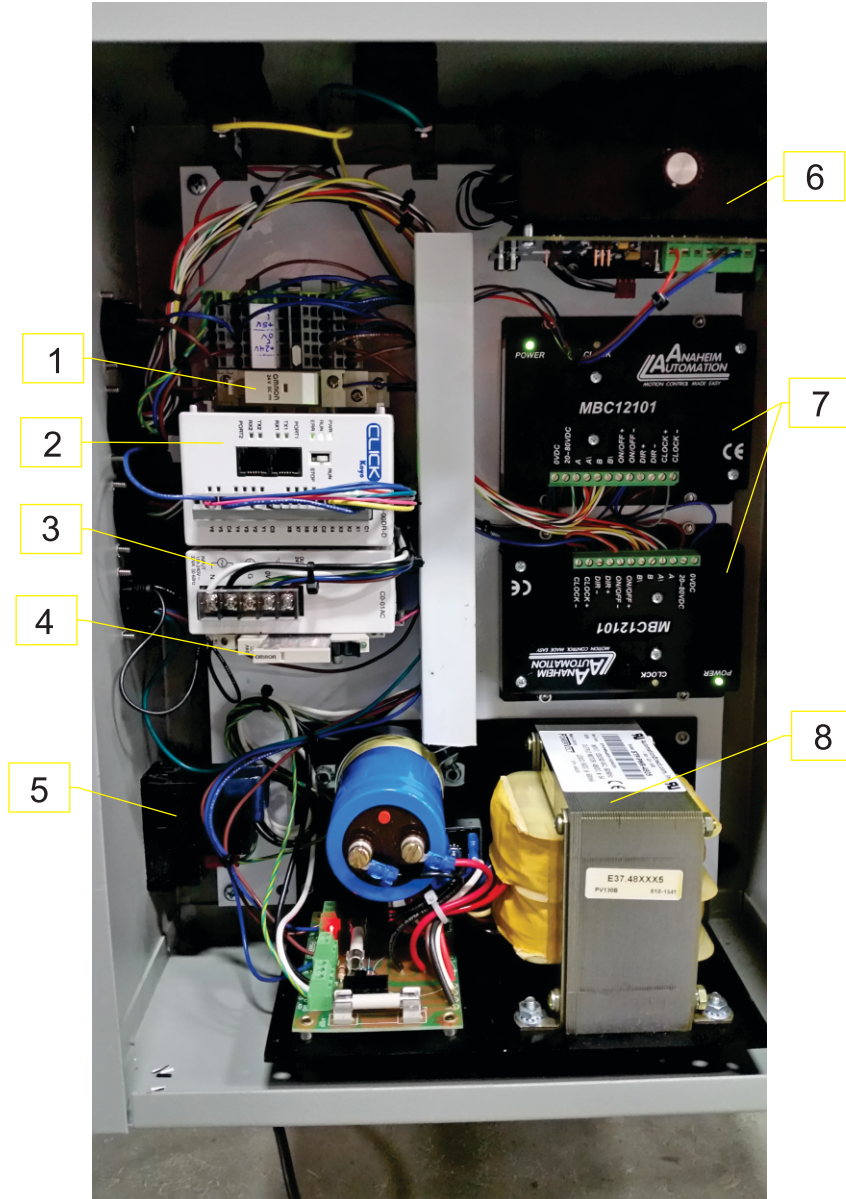
Section 6 Components

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	301644_A	SMALL STAR WHEEL BEARING SLIDER MOUNT	1
2	350001_XX	23Y SERIES STEPPER MOTOR	2
3	301636_X	MOTOR STAND OFF SHAFT	8
4	350004_XX	RWS TIMING BELT	2
5	350003_XX	14 TOOTH TIMING PULLEY	2
6	350002_XX	20 TOOTH TIMING PULLEY	2
7	301643_A	SMALL STAR WHEEL BEARING SLIDER MOUNT	1
8	350005_XX	RSW BEARING	4
9	301655_A	STAR WHEEL DROPPER SIDE SUPPORT WALL	2
10	350007_XX	RSW COVER HANDLE	1
11	301633_A	SMALL STAR WHEEL BEARING SLIDER MOUND, STANDARD	1
12	301675_A	3 SLOT HOME WHEEL HUB	1
13	350008_XX	RSW HOME SENSOR	1
14	301637_A	PROX MOUNT BRACKET, RIGHT	1
15	301634_A	0.500IN SPACER BAR	2
16	301635_A	NEMA 23 STEPPER SLIDE ADJUSTMENT BRACKET	4
17	301632_A	SMALL STAR WHEEL BEARING SLIDER MOUNT, MIRROR	1
18	301670_A	.375IN HEX SHAFT 7IN	2
19	301671_A	7IN #1 MEDIUM LANDING WEDGE	2
20	301686_A	7IN #1 SMALL LANDING WEDGE	2
21	301672_A	7IN #2 MEDIUM LANDING WEDGE	2
22	301687_A	7IN #2 SMALL LANDING WEDGE	2
23	301673_A	7IN #3 MEDIUM LANDING WEDGE	2
24	301688_A	7IN #3 SMALL LANDING WEDGE	2
25	301674_A	STAR WHEEL DROPPER BRIDGE	2
26	301684_A	RSW INSIDE COVER	1
27	301683_B	RSW OUTSIDE COVER	1
28	301677_A	FLOATING SPRING SHROUD	1
29	301676_A	LARGE SRING MOUNT BRACKET	1
30	301653_A	SPRING KNOCKDOWN	1
31	301678_A	WIDE SPRING ANGLED MOUNT BLOCK	1
32	301679_A	FLOATING SPRING SHROUD	1
33	301682_A	SPRING STEEL BACK STOP	1
34	301680_A	FLOATING SPRING SHROUD	2
35	300060	RSW SPACER BLOCK	2
36	350006_XX	RSW COVER SENSOR	1



Item	Qty	Description	Part Number
1	1	24VDC Block relay and base	350009
2	1	PLC	350010
3	1	Power Supply	350011
4	1	24VDC slim relay and base	350012
5	1	AC Power Entry module	100243
6	1	Pulse Generator	350013
7	2	Stepper Driver	350014
8	1	Stepper/TTL Power Supply	350015

Section 7 Warranty

Limited Warranty

Superior Paper Handling Solutions (Superior) warrants this product to be free from defects in materials and workmanship, when used under recommended operating conditions for a period of one year from the date of original retail purchase.

If a defect is discovered during the warranty period, Superior (or authorized agent) will make the repairs at no charge. If the defect is not field repairable, the entire unit should be returned to Superior who will, at its sole option, repair or replace the product at no charge, other than shipping expenses to and from the Superior facility in Minneapolis, Minnesota, USA. All returns require prior approval by an authorized Superior employee and must have a Return Goods Authorization number.

This warranty applies only to products manufactured by Superior. The warranty is void if the product has been damaged by accident, abuse, misuse, neglect, improper maintenance, misapplication, or as a result of being attached to equipment not supplied by Superior; if the unit has been modified without the written permission of Superior; or if the units serial number has been removed or defaced. This warranty does not apply to the failure of any rubber based or consumable components including, but not limited to, "o" rings, belts, rollers, fuses, or lamps.

Superior is not responsible for special, incidental, or consequential damages resulting from any breach of warranty or under any other legal theory, including lost profits, downtime, goodwill, or damage to or replacement of equipment or property.

This warranty and the remedies set forth above are exclusive and are in lieu of all others, oral or written, expressed or implied. There are no warranties that extend beyond the description on the face hereof. No Superior employee or authorized agent is authorized to make any modification, extension, or addition to this warranty.