

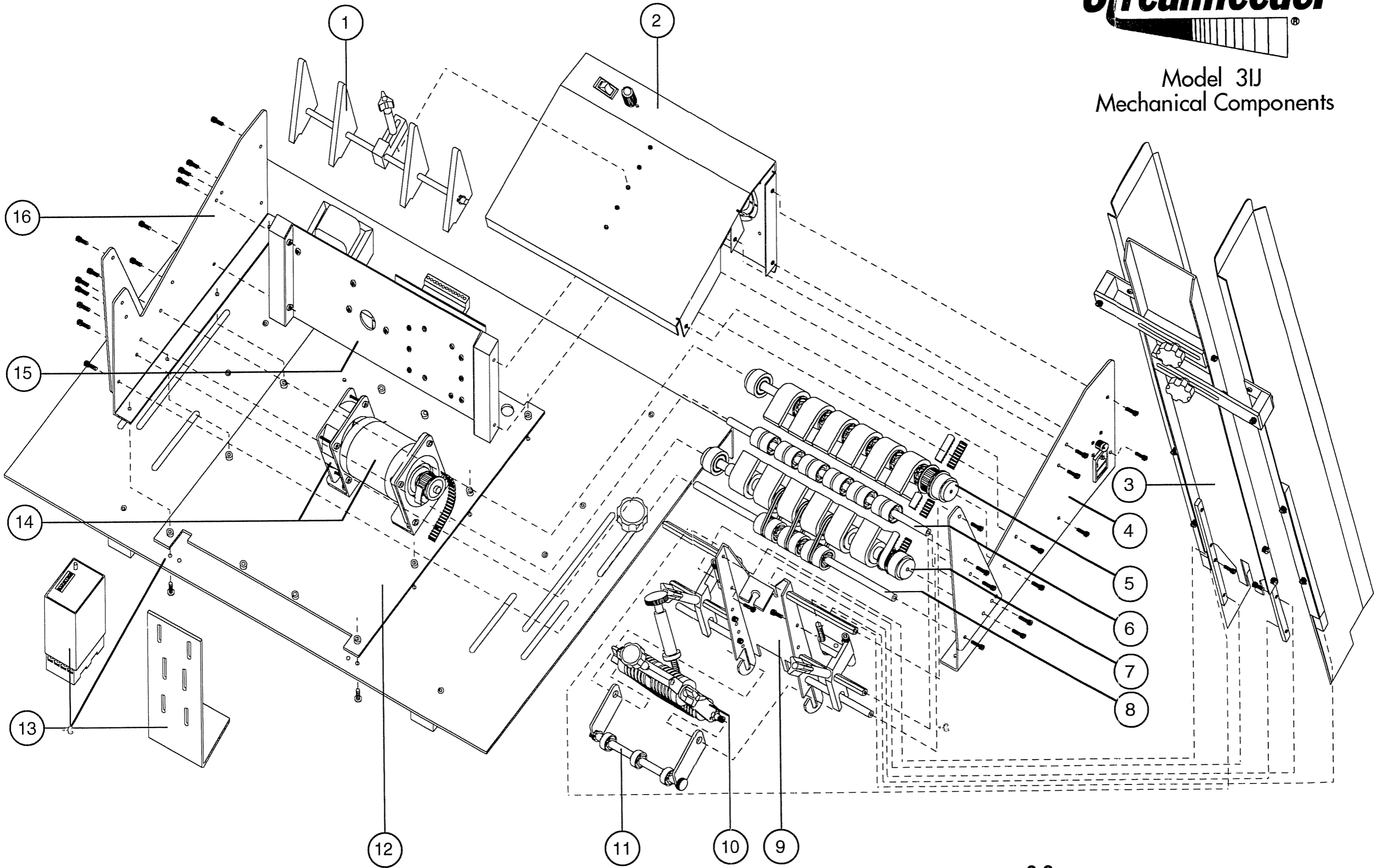


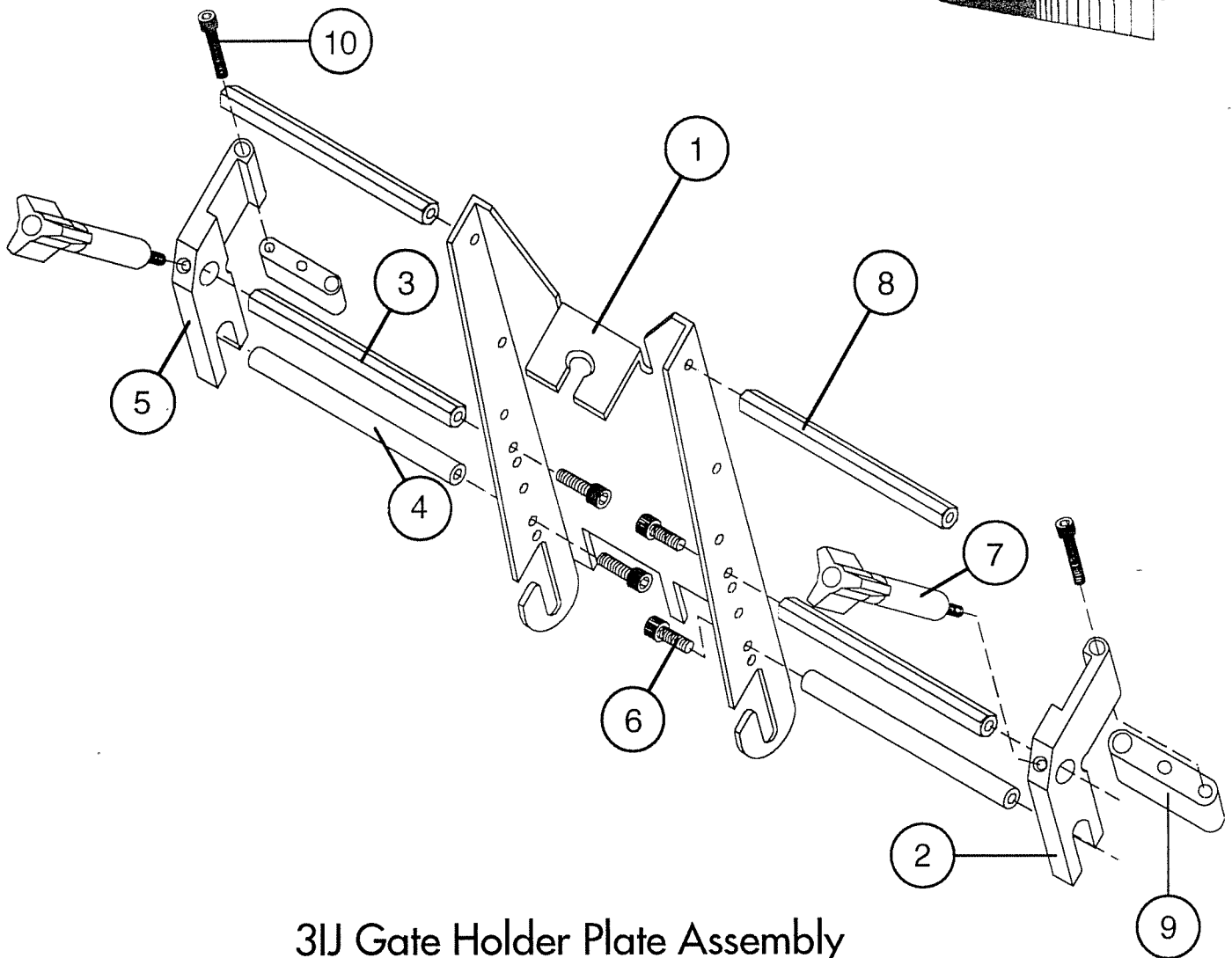
Model 3IJ Mechanical Components

<i>Item #</i>	<i>Page #</i>	<i>Description</i>
1	2-10	Wedge Guide Assembly
2	2-6	Table Top Assembly (110V)
	2-6	Table Top Assembly (220V)
3	2-7	Tall Insert Guide Assembly
4	2-5	Left-Hand Side Plate
5	2-13	Feed Driven Shaft Assembly
6	2-15	Belt Support Bearing Assembly
7	2-16	Feed Drive Shaft Assembly
8	2-14	O-Ring Discharge Assembly
9	2-3	Gate Holder Plate Assembly
10	2-11-12	Advancing Gate Cylinder Assembly
11	2-9	Discharge Assist Assembly
12	2-8	Base Plate Assembly
13	2-19	IJ Base Plate
14	2-17	Drive Motor Assembly (110V)
	2-17	Drive Motor Assembly (220V)
15	2-18	Driver Pack Assembly
16	2-4	Right-Hand Side Plate



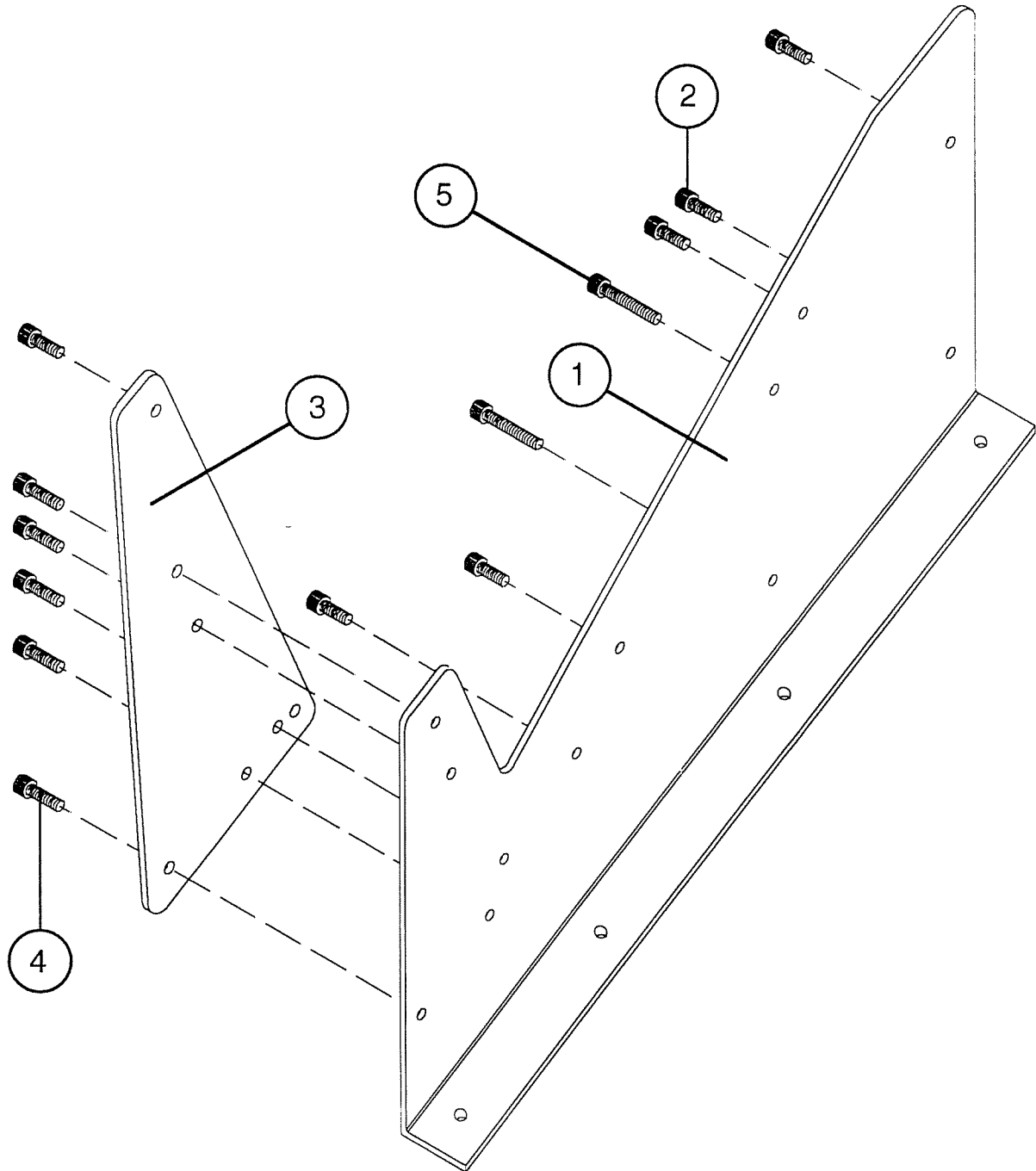
Model 3IJ
Mechanical Components





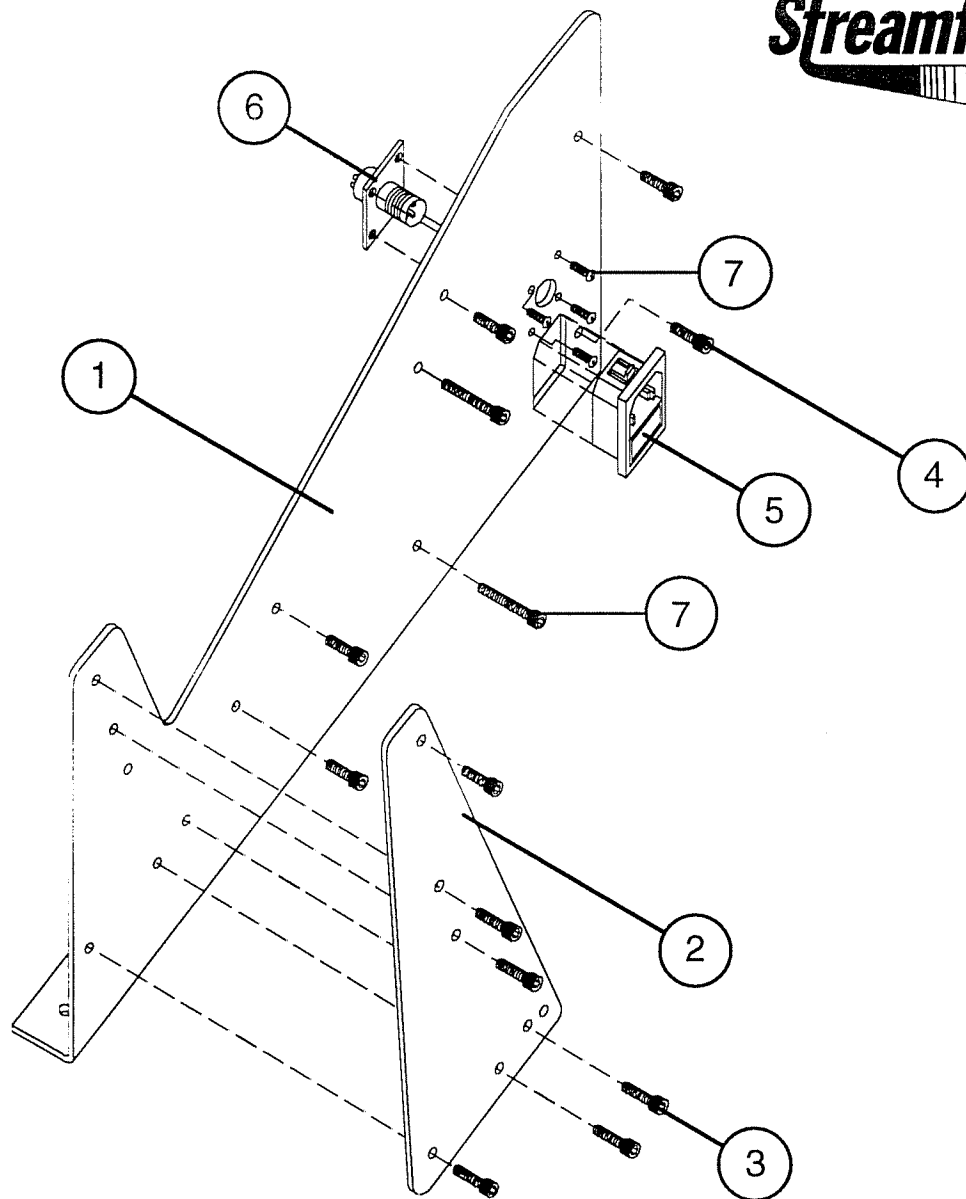
3IJ Gate Holder Plate Assembly

Item#	Qty.	Part #	Description
1	1	235-00-001	Gate Holder Plate
2	1	235-00-047	Left-Hand Side Guide Bracket
3	2	435-50-043	Gate Support Shaft
4	2	435-50-049	Lower Gate Support Shaft
5	1	235-00-048	Right-Hand Side Guide Bracket
6	4	2310	SHCS 10-32 x 3/8"
7	2	235-11-023	Knob Extension Assembly
8	2	435-00-161	IJ Upper Gate Support Shaft
9	2	335-00-040	Side Guide Extension Bracket
10	2	2390	1/4-20 x 1"



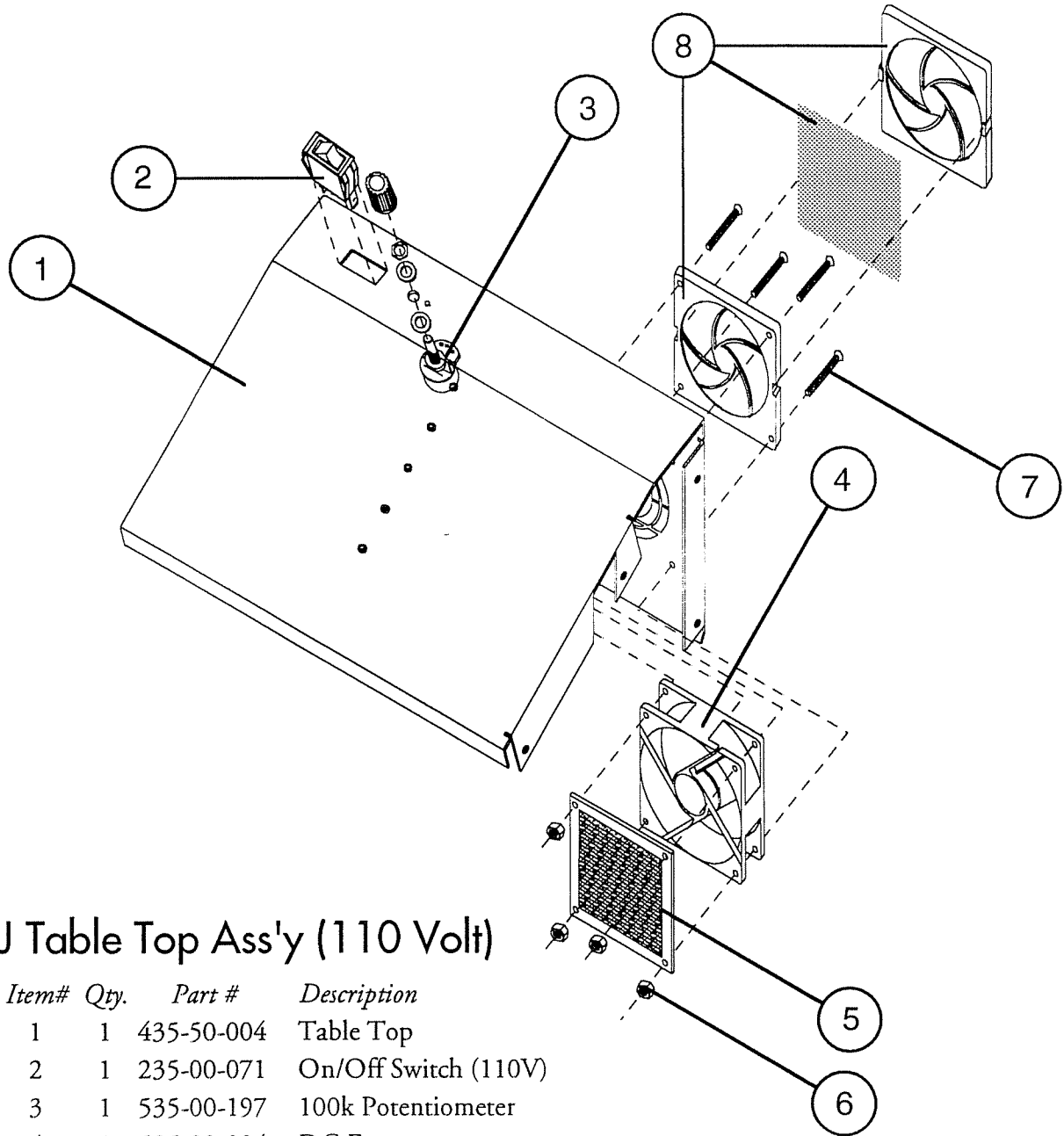
3IJ Right-Hand Side Plate

Item#	Qty.	Part #	Description
1	1	435-00-002	Right-Hand Side Plate
2	6	2310	SHCS 10-32 x 3/8"
3	1	435-00-107	Insert Guide Stabilizing Bracket
4	5	2315	SHCS 10-32 x 1/2"
5	2	2335	SHCS 10-32 x 1"



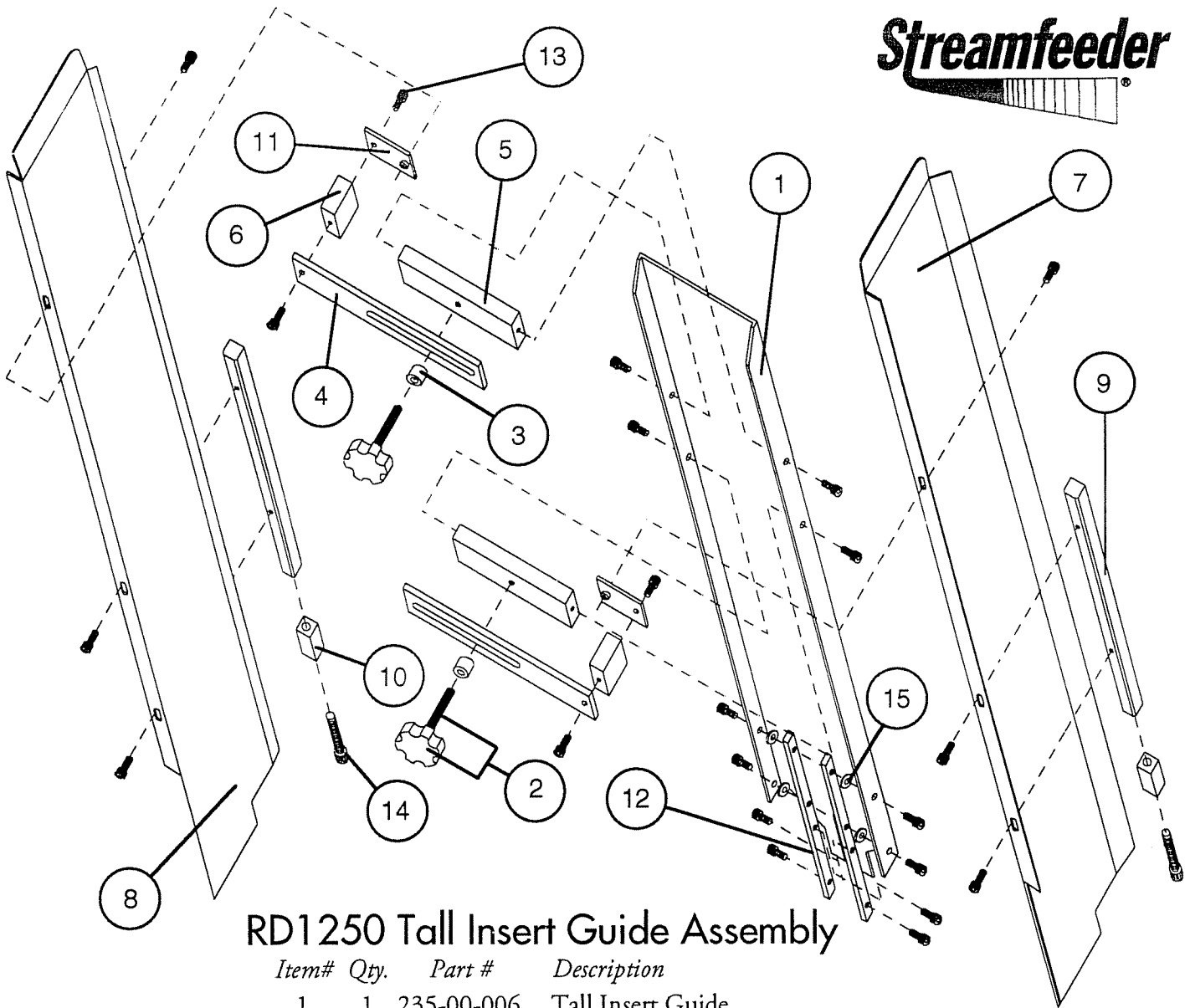
3IJ Left-Hand Side Plate

Item#	Qty.	Part #	Description
1	1	435-50-003	Left-Hand Side Plate
2	1	435-00-107	Insert Guide Stabilizing Bracket
3	5	2315	SHCS 10-32 x 1/2"
4	8	2310	SHCS 10-32 x 3/8"
5	1	535-11-135	IJ Line Socket Assembly w/ 2 3.0 Fuses (535-00-036)
6	1	535-00-077	Circular Connector Amphenol
7	4	2221	PHM 6-32 x 1/4" Phillips
8	2	2335	SHCS 10-32 x 1"
NS	1	535-00-002	Line Cord Carol
NS	1	535-00-024	Legend 115V
NS	1	535-00-076	Cap & Chain Amphenol



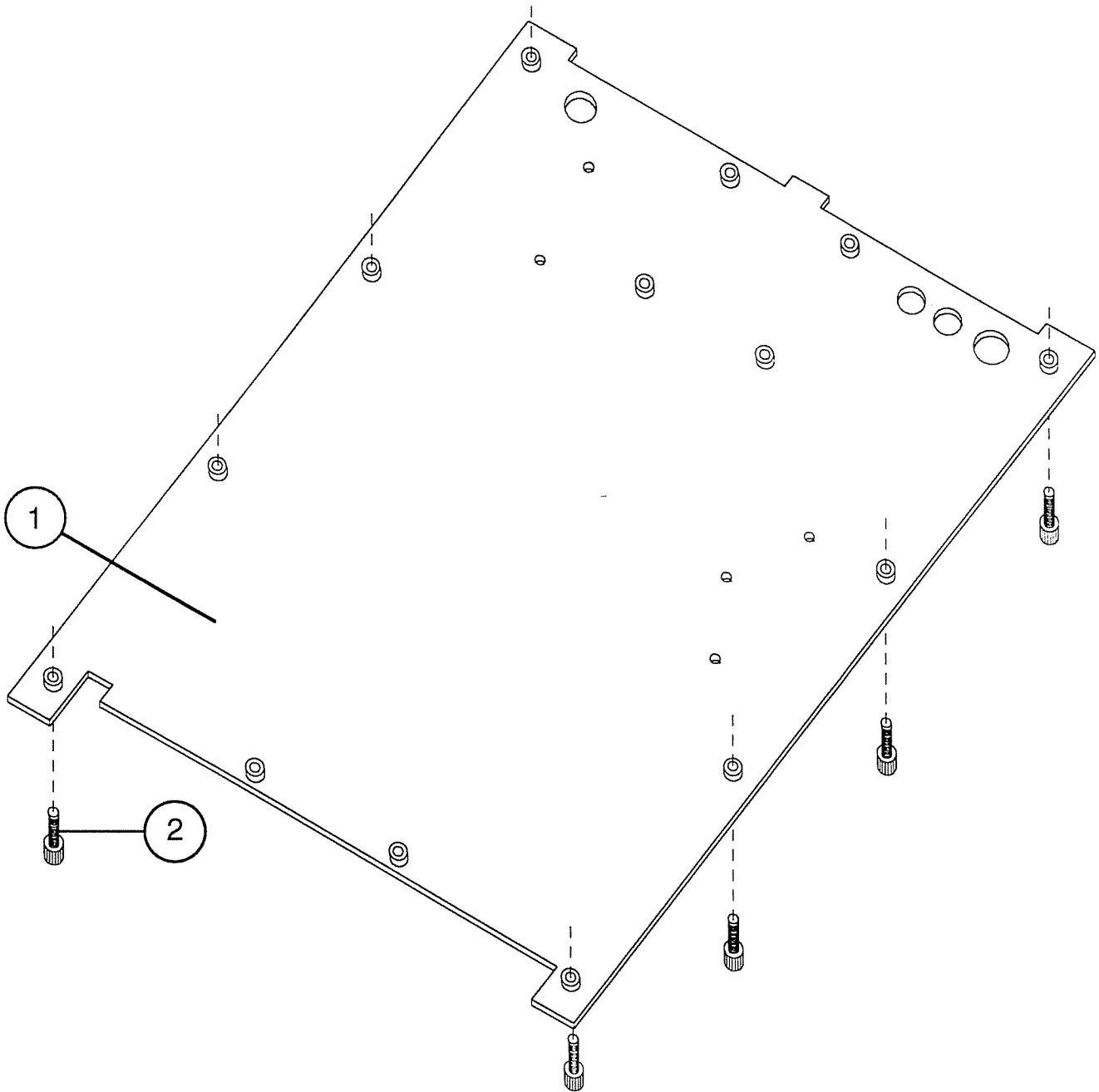
3IJ Table Top Ass'y (110 Volt)

Item#	Qty.	Part #	Description
1	1	435-50-004	Table Top
2	1	235-00-071	On/Off Switch (110V)
3	1	535-00-197	100k Potentiometer
4	1	535-00-004	DC Fan
5	1	535-00-105	Fan Gaurd
6	4	2113	6-32 Hex Nut
7	4	2232	FHM 6-32 x 1-1/2"
8	1	535-00-104	Fan Filter Holder
NS	1	535-00-020	Speed Legend
NS	1	235-00-064	USA Label
NS	1	235-00-066	Nameplate
NS	4	1101	Drive Screw
NS	Items Not Shown On Drawing		



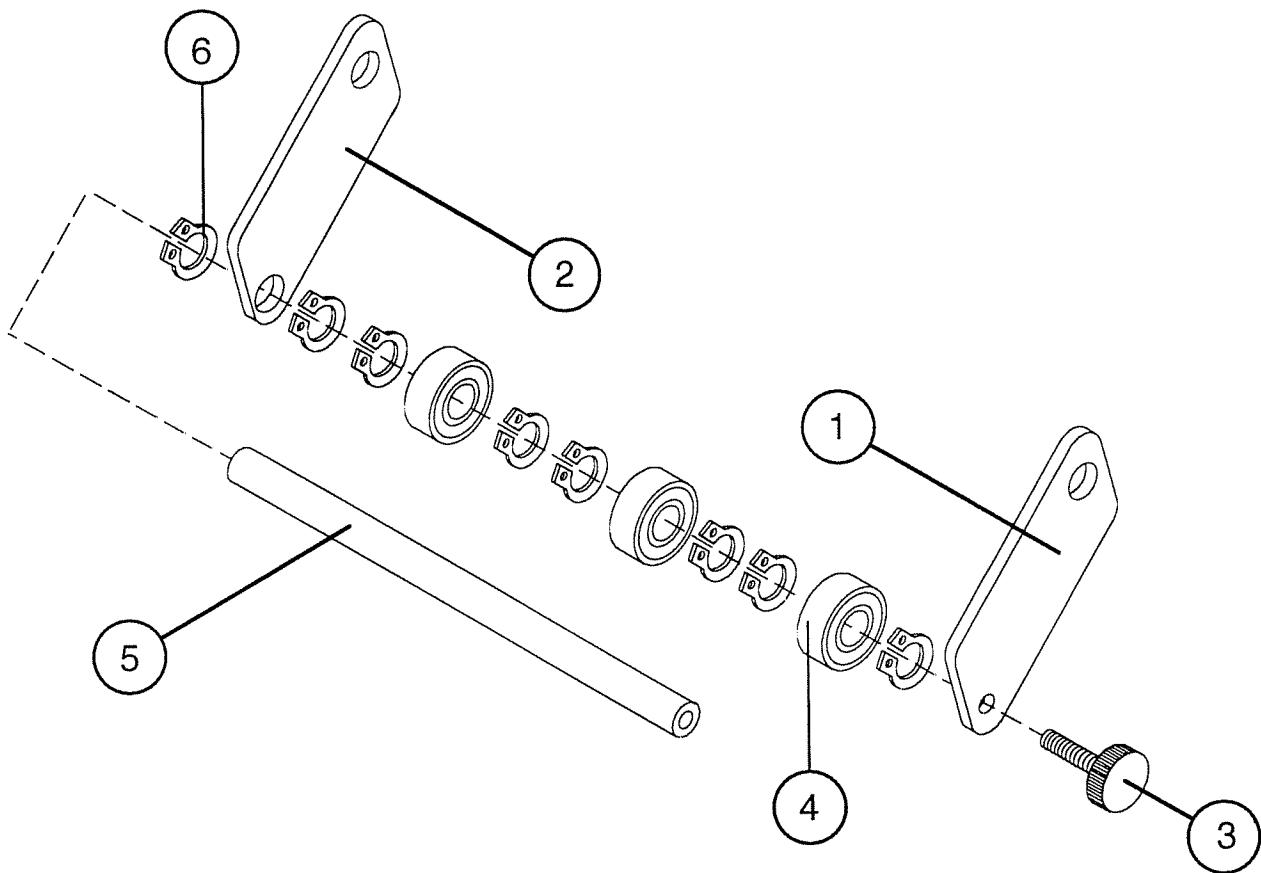
RD1250 Tall Insert Guide Assembly

Item#	Qty.	Part #	Description
1	1	235-00-006	Tall Insert Guide
2	2	235-00-093	Large Thumb Screw
	2	2390	SHCS 1/4"-20 X 1"
3	2	335-00-018	Sensor Extension Spacer
4	2	435-00-150	Adjusting Stabilizer Bracket
5	2	435-00-151	Center Stabilizer Mounting Bracket
6	2	435-00-152	Stabilizer Side Guide Spacer
7	1	435-60-208	Left Side Guide Extension
8	1	435-60-209	Right Side Guide Extension
9	2	435-00-157	Right/Left Side Guide Mounting Bracket
10	2	435-00-158	Side Guide Mounting Spacer
11	2	435-55-001	Stabilizer Side Guide Extension
12	2	235-00-024	Tall Mounting Strap
13	22	2310	SHCS 10-32 X 3/8"
14	2	2396	SHCS 1/4"-20 X 1-1/2"
15	4	2607	Flat Washer, #10



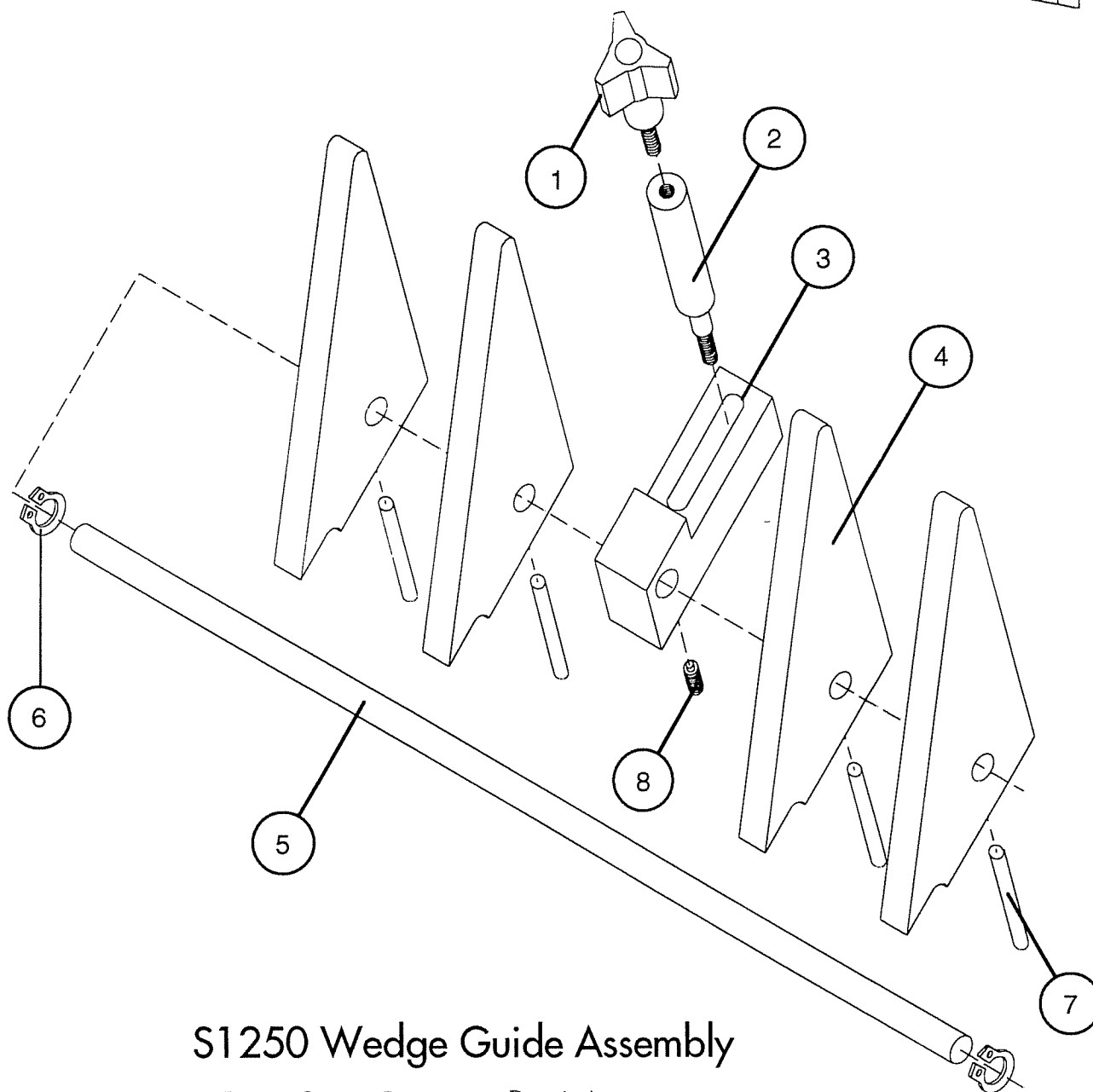
3IJ Base Plate Assembly

Item#	Qty.	Part #	Description
1	1	435-50-007	Base Plate
2	8	2315	SHCS 10-32 x 1/2"



3IJ Discharge Assist Assembly

<i>Item#</i>	<i>Qty.</i>	<i>Part #</i>	<i>Description</i>
1	1	235-00-014	Left-Hand Discharge Bracket
2	1	235-00-013	Right-Hand Discharge Bracket
3	1	235-00-091	Small Thumb Screw Knob
	1	2315	SHCS 10-32 x 1/2"
4	3	235-00-095	Ball Bearing R6ZZ
5	1	235-00-034	Discharge Bracket Shaft
6	8	1110	Grip Ring 3/8"

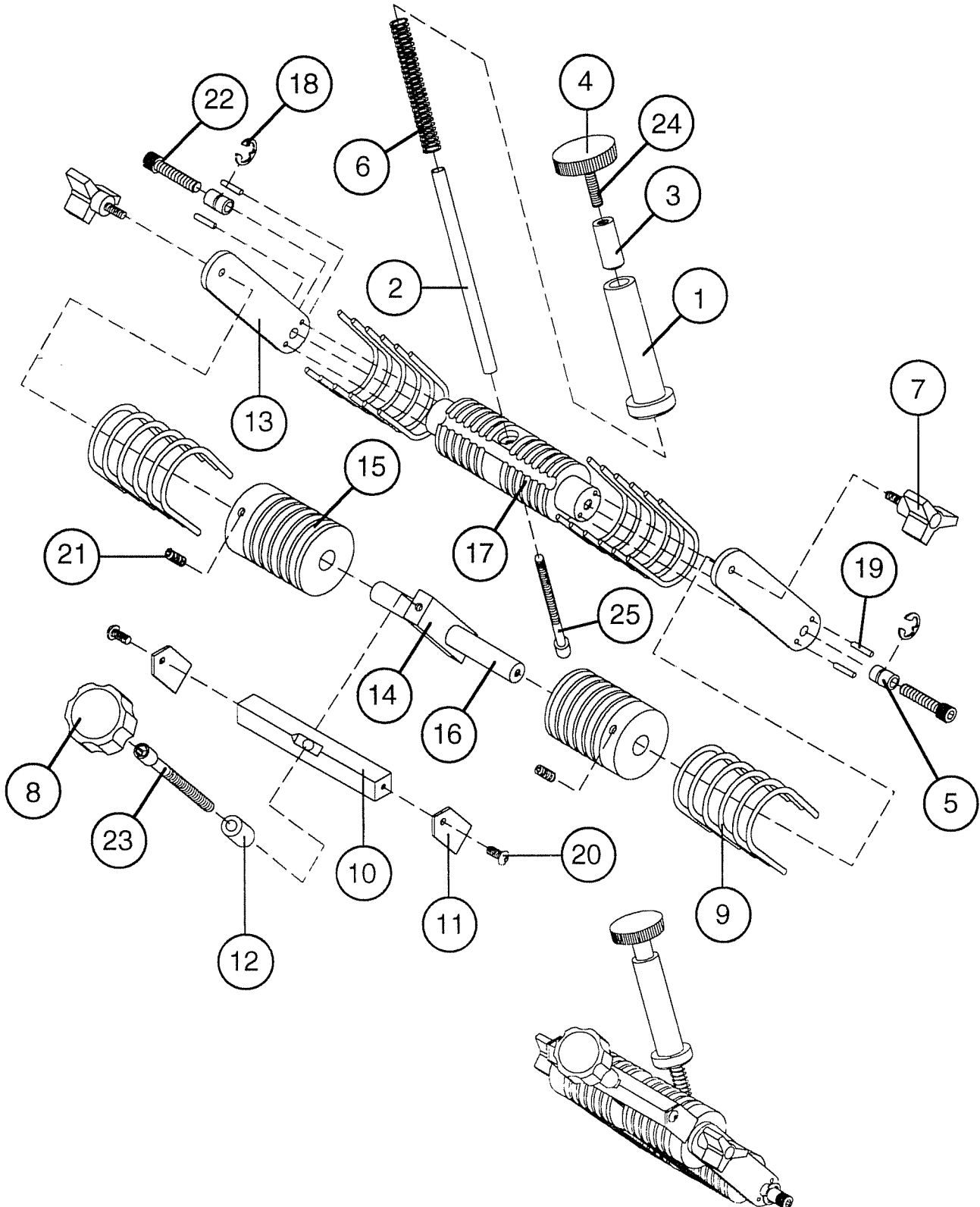


S1250 Wedge Guide Assembly

Item#	Qty.	Part #	Description
1	1	235-00-092	Medium Knob
2	1	235-00-023	Knob Extension
3	1	335-60-213	Wedge Hold Down Bracket
4	4	435-60-212	Material Support Wedge
5	1	435-55-214	Wedge Guide Shaft
6	2	1110	Grip Ring 3/8"
7	4	2702	O-Ring 3/16"Ø
8	1	2217	Set Screw 10-32 x 1/4" Brass Tip

3IJ Advancing O-Ring Assembly

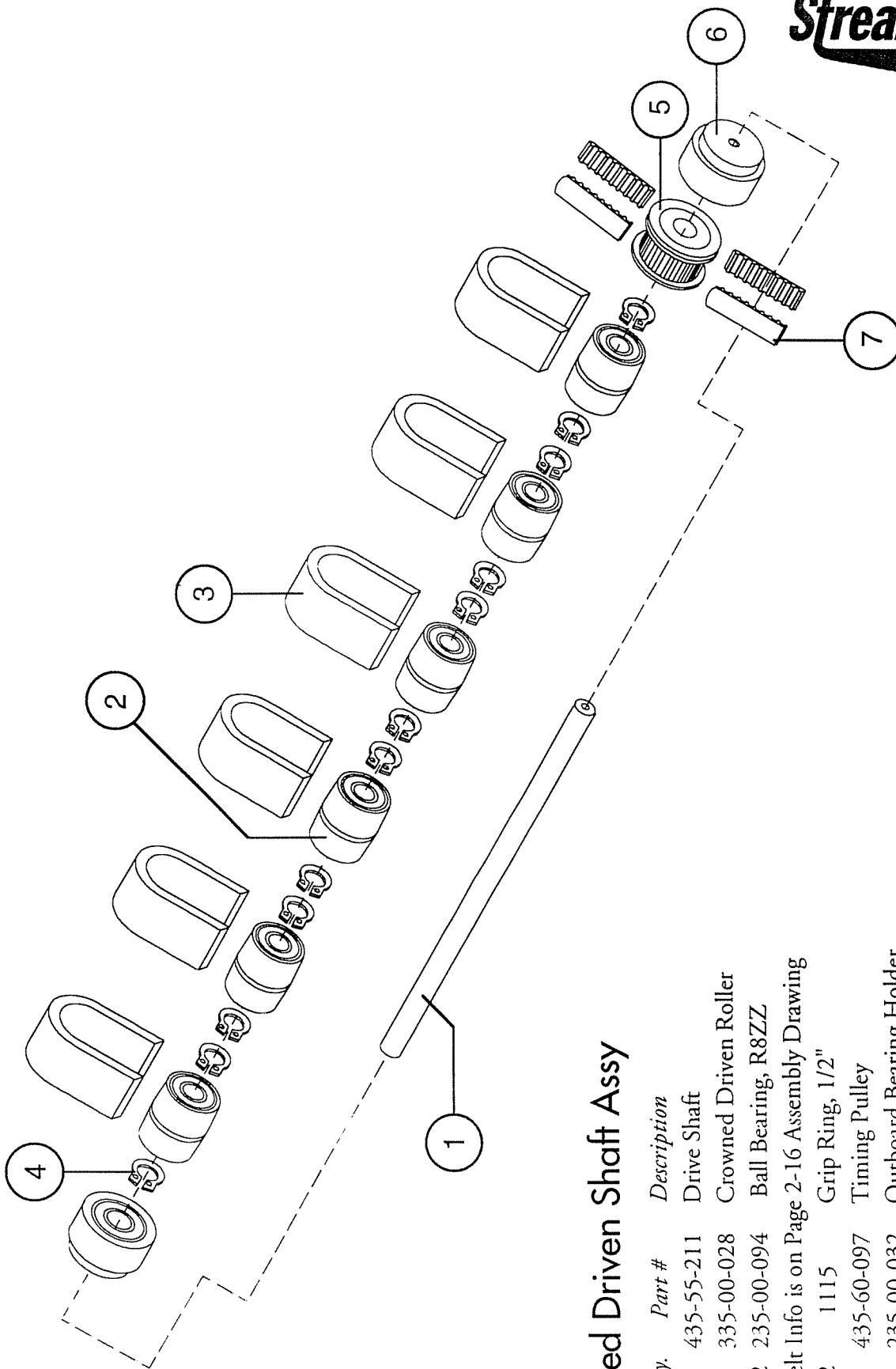
Component List On Next Page





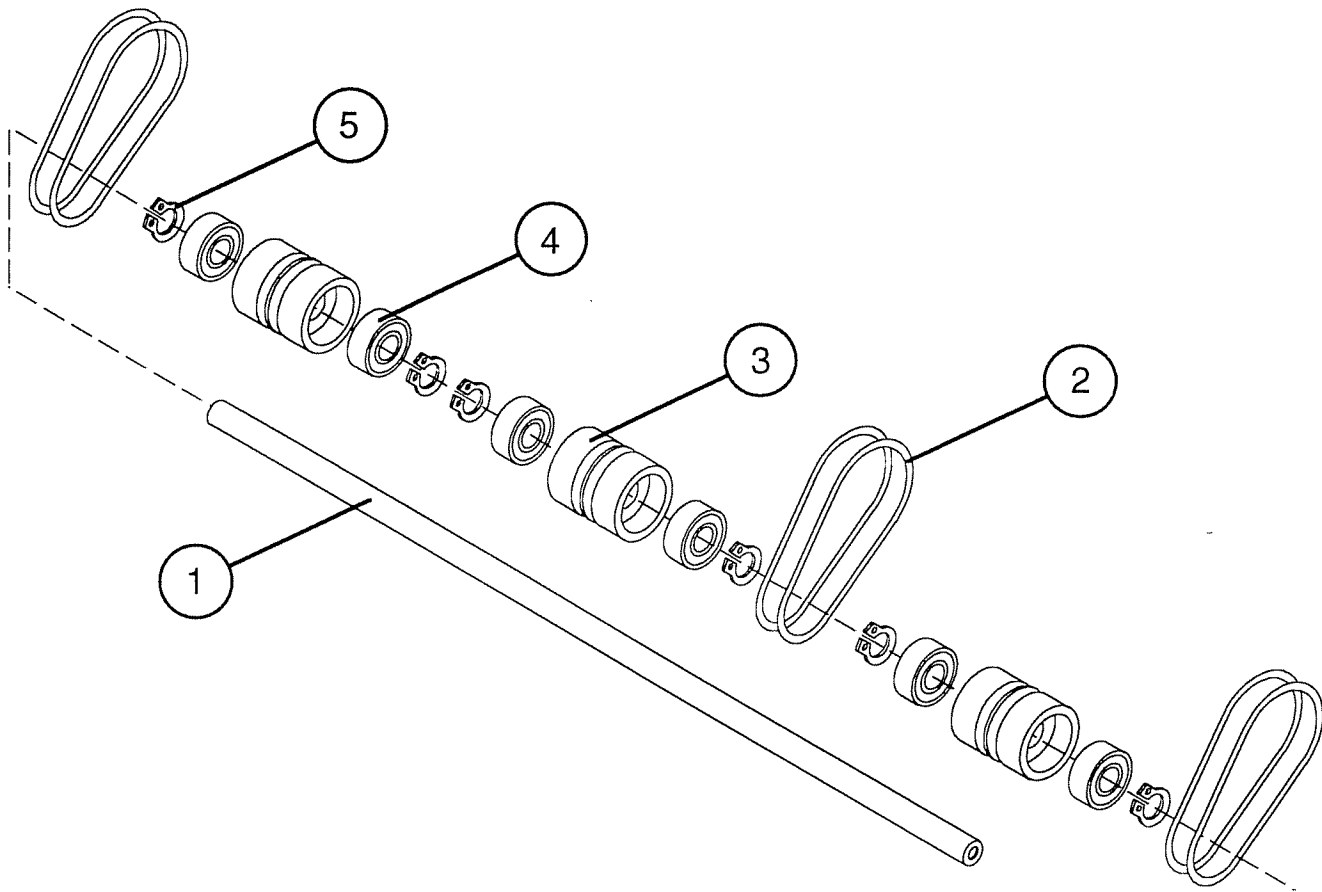
3IJ Advancing O-Ring Assembly

<i>Item#</i>	<i>Qty.</i>	<i>Part #</i>	<i>Description</i>
1	1	235-00-019	Gate Spring Tension Cylinder
2	1	235-60-084	Gate Lift Shaft
3	1	235-00-037	Adjusting Knob Sleeve
4	1	235-00-077	1" Thumb Screw
5	2	235-00-082	1/2" Spacer
6	1	235-00-083	Gate Compression Spring
7	2	235-00-092	Medium Knob
8	1	235-00-093	Large Thumb Screw
9	12	235-00-189	Advancing Gate Cylinder O-Ring
10	1	235-00-190	O-Ring Lock Bar
11	2	235-00-191	Lock Bar Side Plate
12	1	235-00-192	Knob Spacer
13	2	235-00-193	Adjuster Side Plate
14	1	235-00-194	Clamp Tie Rod
15	2	235-00-195	O-Ring Take Up Roller
16	1	235-00-196	Take Up Roller Shaft
17	1	235-00-197	Gate Cylinder
18	2	1150	E Clip 3/8"
19	4	1161	Roll Pin 1/8" x 1/2"
20	2	2210	BHCS 8-32 x 1/4"
21	2	2327	Set Screw 1/4"-20 x 3/8"
22	2	2390	SHCS 1/4"-20 x 1
23	1	2396	SHCS 1/4"-20 x 1-1/2"
24	1	2400	SHCS 1/4"-28 x 1"
25	1	2336	SHCS 10-32 x 1-1/2"



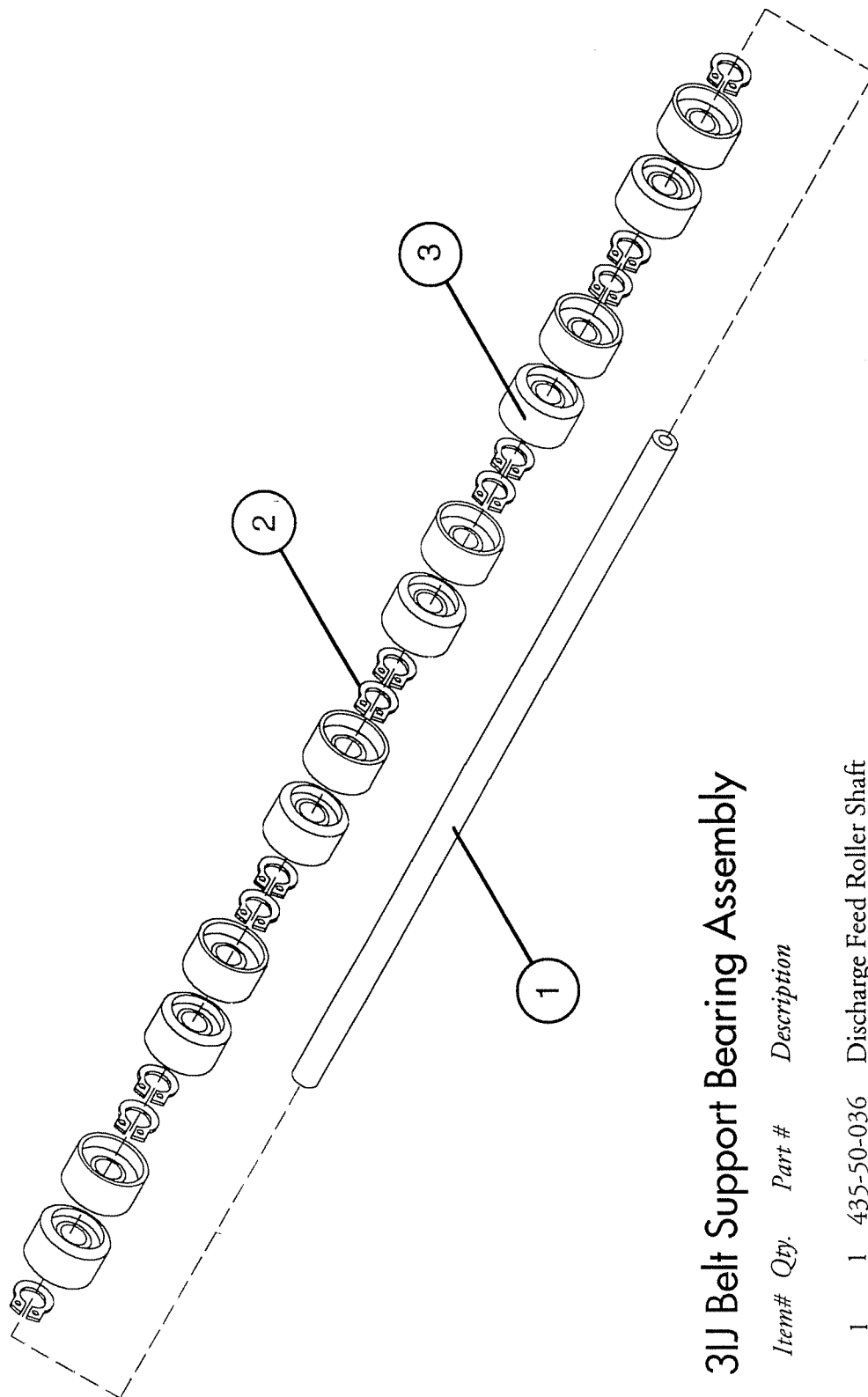
3IJ Feed Driven Shaft Assy

Item#	Qty.	Part #	Description
1	1	435-55-211	Drive Shaft
2	6	335-00-028	Crowned Driven Roller
3	12	235-00-094	Ball Bearing, R8ZZ
Belt Info is on Page 2-16 Assembly Drawing			
4	12	1115	Grip Ring, 1/2"
5	1	435-60-097	Timing Pulley
6	2	235-00-032	Outboard Bearing Holder
	2	235-00-094	R8ZZ Bearing
7	1	435-00-096	Drive Timing Belt
NS	2	2402	8-32 x 1/8", Set Screw



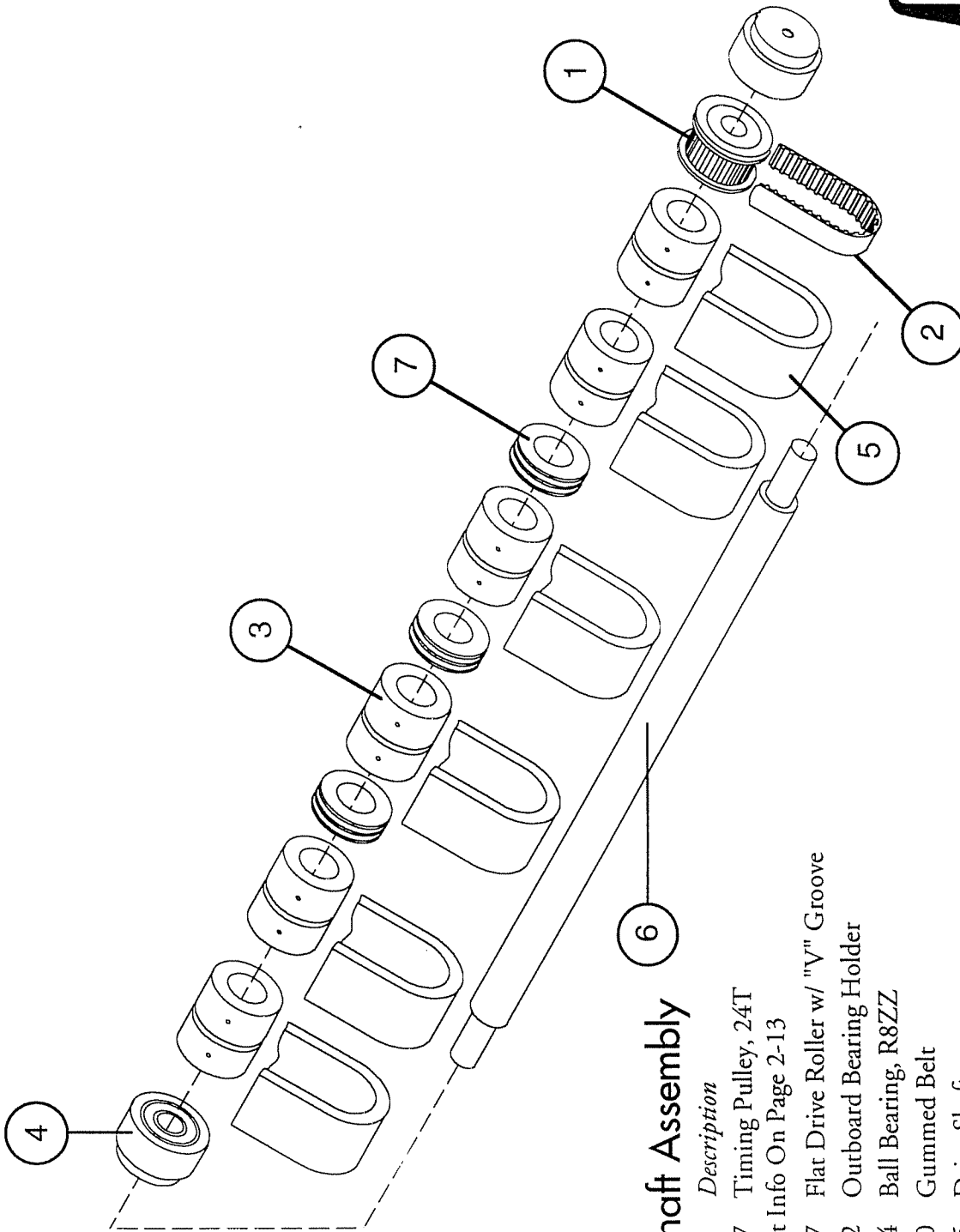
3IJ O-Ring Discharge Assembly

Item#	Qty.	Part #	Description
1	1	435-50-036	Discharge Shaft
2	6	235-00-090	Discharge O-Ring
3	3	235-00-029	O-Ring Bearing Pulley
4	6	235-00-095	Ball Bearing, R6ZZ
5	6	1110	Grip Ring, 3/8"



3IJ Belt Support Bearing Assembly

Item#	Qty.	Part #	Description
1	1	435-50-036	Discharge Feed Roller Shaft
2	12	1110	Grip Ring, 3/8"
3	12	235-00-030	Belt Support Bearing Holder
	12	235-00-095	Ball Bearing R6ZZ



3IJ Feed Drive Shaft Assembly

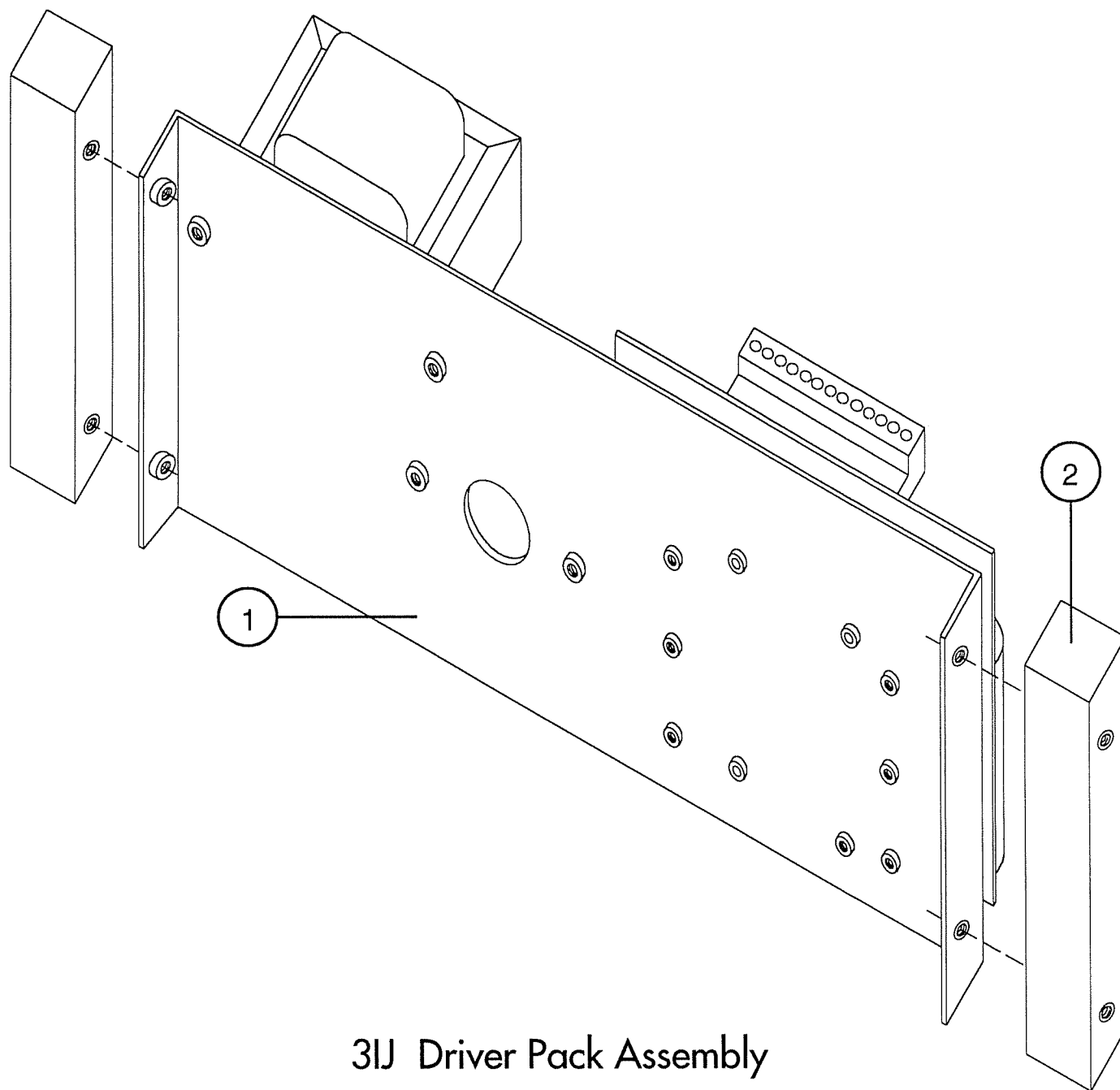
Item#	Qty.	Part #	Description
1	1	435-60-097	Timing Pulley, 24T
2	1	Timing Belt Info On Page 2-13	
3	6	235-60-207	Flat Drive Roller w/ "V" Groove
4	2	235-00-032	Outboard Bearing Holder
	2	235-00-094	Ball Bearing, R8ZZ
5	6	235-00-160	Gummed Belt
6	1	435-55-205	Drive Shaft
7	3	435-00-162	O-Ring Pulley
NS	15	2216	Set Screw, 10-32 x 1/4" Brass Tip
NS	2	2402	Set Screw, 8-32 x 1/8"

NS Items Not Shown On Drawing



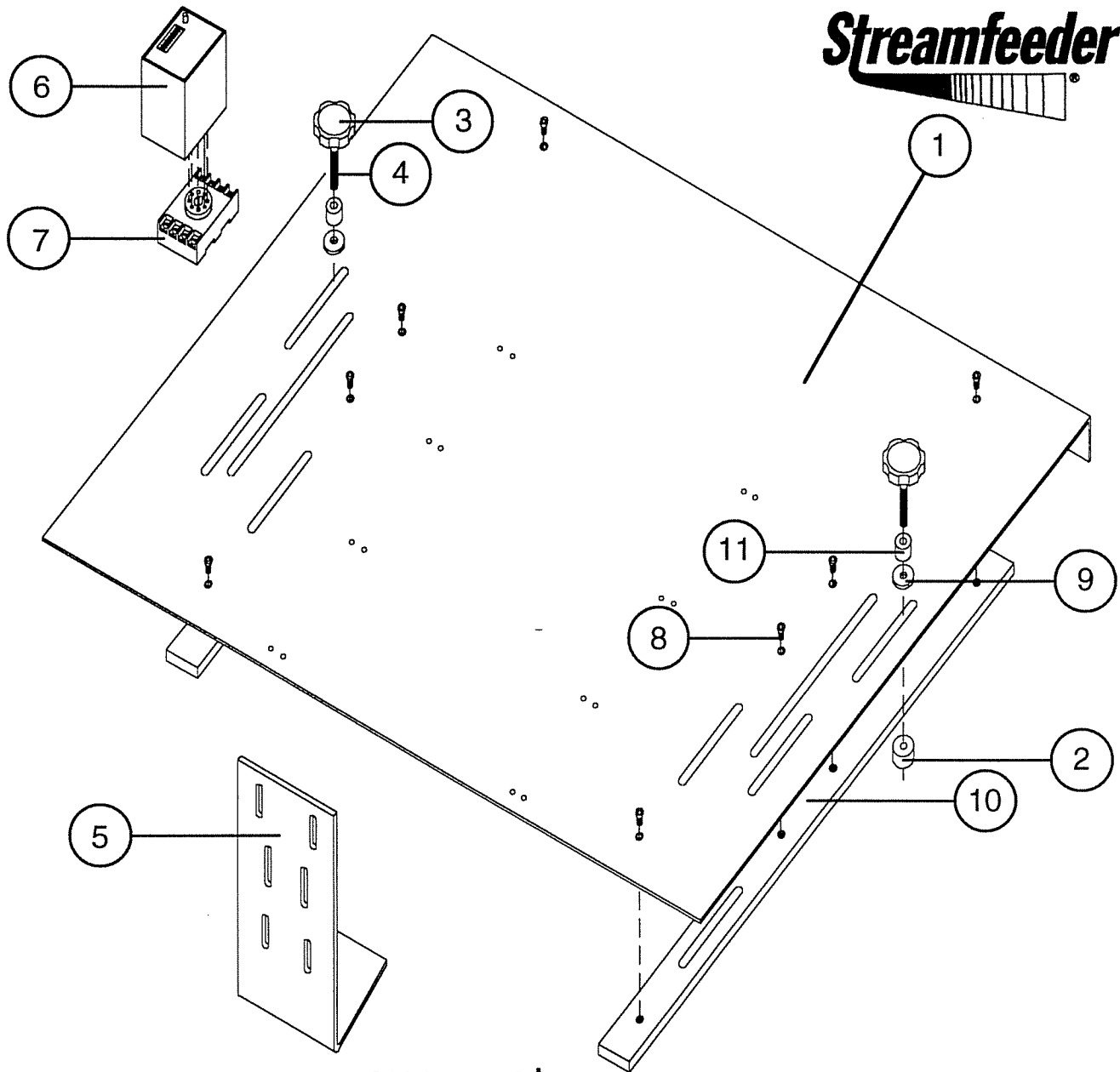
Item#	Qty.	Part #	Description
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10 Drive Belt Info. is on Page 2-13



3IJ Driver Pack Assembly

Item#	Qty.	Part #	Description
1	1	535-33-097	Driver Pack Assembly
2	2	435-50-051	Driver Motor Spacer
NS	1	535-00-115	Chase Nipple
NS	1	535-00-116	Lock Nut



3IJ Base Plate

Item#	Qty.	Part #	Description
1	1	435-00-159	Base Plate
2	2	435-00-160	Base Plate Spacer
3	2	235-00-093	Large Thumb Screw
4	2	2396	SHCS 1/4-20 x 1-1/2"
5	1	435-00-155	Adjustment Hopper Deflection Plate
6	1	535-00-108	Relay Time Delay
7	1	535-00-109	Relay Socket, 8 Pin
8	8	2326	FHSCS 10-24 x 3/8"
9	2	2610	Oversized Washer
10	2	435-00-156	Base Plate Spacer
11	2	335-00-018	Sensor Extension Spacer



Recommended Spare Parts Kit Model 3IJ

Qty.	Part #	Description
6	235-00-090	Discharge O-Ring
5	235-00-088	Tractor Belt
12	235-00-189	Advancing Gate Cylinder O-Ring
1	435-00-096	Timing Belt
4	435-00-084	Fuse, 2.5 AMP
1	435-00-096	Drive Belt
1	535-00-038	Proximity Sensor
6	235-00-160	Gummed Belt

Optional

1	535-00-090	Drive Motor Pac Sci HO
1	235-00-071	On/Off Switch
1	535-00-197	Potentiometer 100K
1	235-00-083	Gate Compression Spring
1	535-00-004	DC Fan
1	535-33-097	Driver Pack Assembly

Model III IJ Universal Friction Feeder

For Cheshire and Kirk Rudy Ink Jet Labeling Bases

The Streamfeeder Model III IJ efficiently replaces the shuttle feed apparatus on Cheshire and Kirk Rudy labeling bases. The Streamfeeder patented gate design allows it to positively separate and feed almost any material and every imaginable type and direction of fold. The Streamfeeder virtually eliminates miss-double problems often associated with difficult-to-feed material. The Model III IJ comes complete with installation kit including; mounting plate, special guide bracket, high-capacity side guides, high-volume gate assembly, high-speed drive package, time delay relay and complete installation instructions.

Features

- Variable spacing. Allows variable spacing on fixed-spacing address machines, resulting in faster throughput and addressing.

- Increased hopper capacity. Handles heights up to 24".
- Low maintenance. Sealed ball bearings on all rotating shafts. Bearings lubricated for life.
- Fast. Variable speed feeds up to 8,000 inches per minute.
- Versatile. Handles all types of material in a wide range of sizes and thicknesses, including products with open edges and non-uniform thickness such as prestuffed envelopes.
- Guaranteed. Limited 90-day warranty on parts and service. Fast and efficient service support from local authorized dealers or factory direct.

Specifications

Electrical:
120 Volt AC, 3 amp, 50/60 Hz.
Optional 220/240 Volt—50 Hz.

Gate Adjustment:
Single knob adjustment.

Material Sizes:
Minimum: 3½" x 4⅞"
Maximum: 9" x 12"

Material Thickness:
Minimum: Single sheet
Maximum: ¼" (modifications available for greater thicknesses).

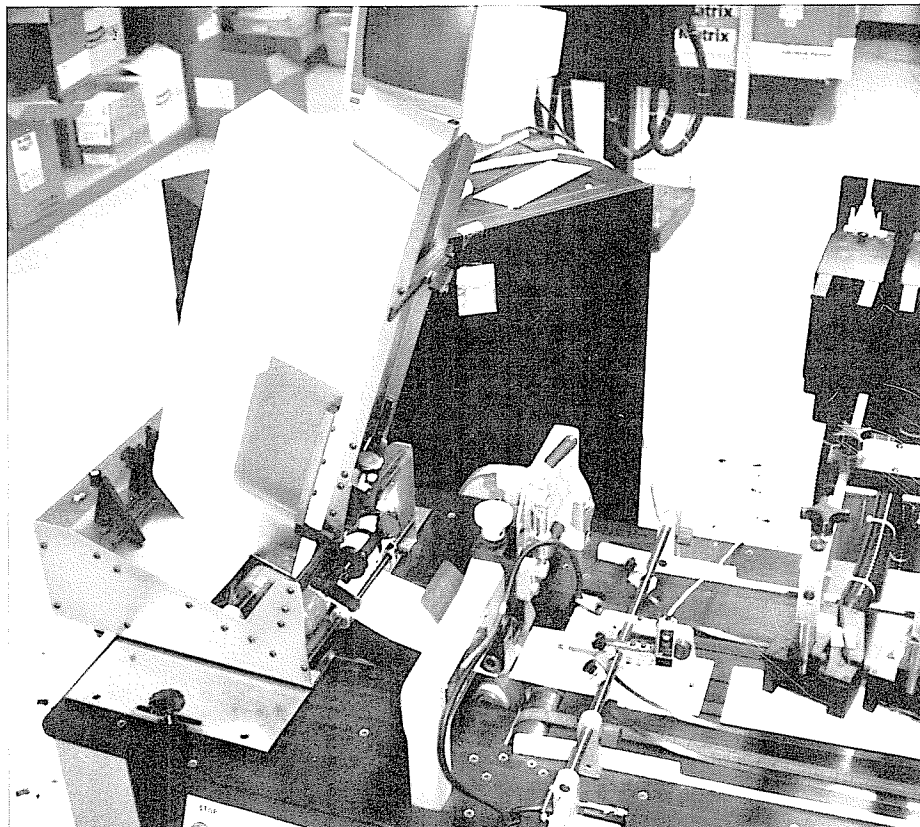
Material Type:
Booklets, annual reports, coated and slick stocks, Z-folds, gatefolds, fanfolds, etc.

Maximum Feeder Material Capacity:
Folded edge leading, 24" stack height; 20# bond letter fold, 1,800; single-sheet 50# coated stock, 5,000+; business reply cards (.007" thick), 3,400; envelopes, 1,200; open edge leading (most stocks), 12".

Feeder Width:
13"

Limited Warranty:
90 days, parts and service.

Your authorized Streamfeeder dealer is:



STREAMFEEDER®

Streamfeeder, Inc.
9150 Springbrook Drive
Minneapolis, MN 55433
(612) 784-7305
Fax (612) 784-1356

OPERATION OF FEEDER

1. Basic Setup.

The basic setup of your feeder is described in the accompanying manual, which pertains to all Streamfeeder models. The Model 3IJ feeder is equipped with an advancing "O" ring assembly. The "O" rings are rotated when necessary by loosening the two knobs on either side of the assembly; grasping the knobs and "O" ring clamping bar, and rotating this assembly a small amount; and then retightening the two side knobs. This rotates the "O" rings in unison to provide a new wear surface when necessary. When this procedure has been done several times, it will be necessary to reposition the clamping bar on the "O" rings for a new "bite." This is accomplished by loosening the "O" ring clamping bar knob to allow the knob and bar to rotate without moving the "O" rings to a new position over the "O" rings and then retightening the knob.

2. Positioning of Feeder.

Position the stainless steel deflector on the Kirk Rudy bridge to just clear the product to be run. Set up the feeder as described in the Instruction Manual with the material to be run. Turn the power to the feeder off, and manually rotate the feeder to feed the product to be run until the trailing edge of the product just passes the gate cylinder "O" rings. Position the feeder on the Kirk Rudy base until the leading edge of the material is just being gripped by the Kirk Rudy feed rollers. Lock the feeder in this position.

3. Speed Adjustment.

Run your Kirk Rudy base at the desired speed and then adjust the Streamfeeder speed by the speed control knob until the desired product spacing is achieved. You can now jog or run your base and Streamfeeder in unison.

INSTALLATION OF THE STREAMFEEDER MODEL 3IJ TO THE KIRK RUDY MODEL 215 BASE

The following steps are necessary to prepare your Kirk Rudy base for the Streamfeeder Model 3IJ:

1. Remove the rear jogger table including the jogger table brackets.

(Photo)

2. Remove the left and right material side guides which are attached to the feeder bridge, Part #500704.

3. Remove the left and right guides (Part #500805) and remove the feeder gate. Reinstall the left and right guides using screws in the top holes only. Install the stainless steel material deflector, provided by Streamfeeder, by mounting it over the lower holes in the left and right gate guides. Position the deflector so that the bottom of the deflector just clears the material to be run.

(Photo)

4. Disable the shuttle feed by removing the crank feed slide (Part #500750).

5. It is necessary to prevent the bottom feed rollers (Part #500746) from moving up and down. To accomplish this, remove the cam follower (Part #500734). It may be necessary to adjust the position of the lever spring (Part #500786) on the operator's side of the lower feed roller operating shaft to maintain the lower feed roller in the raised position. Slide the shuttle feed plate forward to allow the bottom feed roller bracket (Part #500729) to rest against the underside of the shuttle plate, thus positioning its upward travel. Adjust the upper feed roller to maintain light pressure on the material to be run when placed between the upper and lower feed rollers.

6. The Streamfeeder is held in position on the Kirk Rudy base by aligning the slotted hole in the Streamfeeder base plate with one of a series of holes in the table top. These holes previously located the jogger table. A corresponding series of holes should be drilled and tapped in the table top on the opposite side of the feeder shuttle.

7. Streamfeeder provides a time-delay relay that must be mounted inside of the Kirk Rudy electrical enclosure. The purpose of this relay is to allow the Kirk Rudy base sufficient time to reach its operating speed before the Streamfeeder starts to feed product. The delay time may be adjusted by dip switches on the time-delay relay. The time-delay relay is powered by 110 volts from your Kirk Rudy base, connected to terminals 2 & 7 of the relay socket.

ASSEMBLING YOUR STREAMFEEDER

Step 1. Front Base Plate Mounting.

Remove the six socket head screws (three each side) from the discharge end of the bottom of your Streamfeeder. Place the base plate, with the slotted holes on each side, onto the feeder bottom and replace the six screws.

(Photo)

Step 2. Rear Base Plate Mounting.

Remove the two socket-head screws (one each side) from the bottom rear of the Streamfeeder and install the remaining base plate with the right angle projection to point away from the feeder bottom.

(Photo)

Step 3. Side Spacer Bar Mounting.

Mount the spacer bars on either side of the base plate, aligned with corresponding slots and holes.

(Photo)

Step 4. Front Hopper Extension.

Mount the front hopper extension with the four screws provided and align so the material side of the extension fits flush with the gate retaining bracket.

(Photo)

Step 5. Side Guide Mounting.

Mount side guides with screws provided.

(Photo)

STREAMFEEDER MODEL III-IJ

RECENT INSTALLATION - GAGE LETTERSHOP, HOWARD LAKE MN.

- 1) REOSTAT AND ON-OFF SWITCH LOCATED ON TABLE TOP SEEMS MORE LIKELY TO BUMPED WHILE TENDING HOPPER.
- 2) THE CORD & FUSE HOLDER LOCATION ON BOTTOM OF FEEDER LIMITS FORWARD TRAVEL TO 6" FROM PINCH ROLLERS AND HAS POSSIBILITIES OF BEING BROKEN WHEN LAID FLAT.
- 3) BELT SUPPORT SHAFT. MATERIAL FEED BELTS SAG WITH WEIGHT OF PRODUCT.
- 4) MOUNTING PLATE TO ACCOMMODATE K/R BASE, THE OPERATORS HAVE CONCERN OF SHARP CORNERS. THE PLATE PROTRUDES AN ADDITIONAL 12" OR SO MAKING IT LONGER THAN ACCUSTOMED TO.
- 5) PROVIDE AN ADHESIVE SCALE TO PLACE ON BOTH LEFT AND RIGHT SIDE OF THE TABLE TOP OF K/R BASE TO ASSURE SQUARE PLACEMENT OF FEEDER.
- 6) PROVIDE LOCATION TEMPLATE FOR DRILL & TAP OF 1/4-20 HOLES.
- 7) ON EACH MATERIAL SIDE GUIDE, SOME KIND OF EXTENDING TABS TO PREVENT PRODUCT SKEWING.
- 8) ADDITIONAL GUIDES TO BE PLACED ON TABLE TOP OF K/R BASE BETWEEN FEEDER EXIT ROLLERS AND PINCH ROLLERS.
- 9) LOCATION SPRING PIN THE EXTENDING ARMS ON ADVANCING O-RING ASSEMBLY TO PREVENT MOVEMENT DURING O-RING ADVANCE.
- 10) LONGER 1/4-20 BOLTS WITH LARGE O.D. WASHERS FOR BASE PLATE HOLDDOWN.

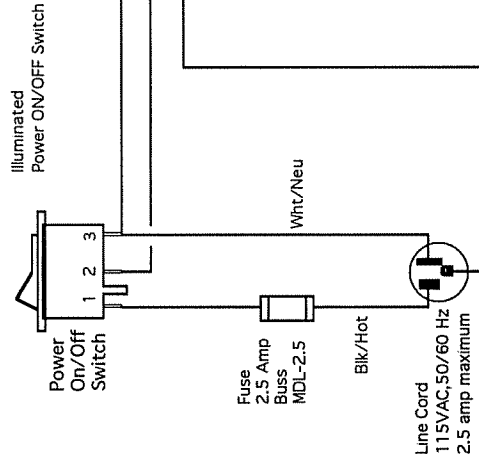
1. Replace fuse *ONLY* with Buss MDL 2.5 amp.

2. You **MUST** use a 3-hole, properly grounded outlet. DO NOT remove or otherwise disable the grounding lug on the plug!
3. Use only exact replacement parts when servicing the Streamfeeder™ machine.

Machine is shipped with pulse generator set at 6Khz. This produces 6000 0.9 degree half steps of the motor per second with the operator speed pot at maximum. This gives a continuous run feed speed of 900fpm. Do not adjust higher than 8Khz or stalling will occur. with a frequency counter.

to minimize start up
stalling of the step m
set ramp time to max
(longest ramp time)

Cooling Fan
12VDC
(See attached
Specification
sheet)



Run. Signal contact is supplied by customer. TB3 left terminal is a 5VDC logic level signal. Short signal to ground (0VDC) terminal TB3 right, to create run condition.

TB3 left HIGH (5VDC) = standstill condition
TB3 right LOW (0VDC) = machine run condition

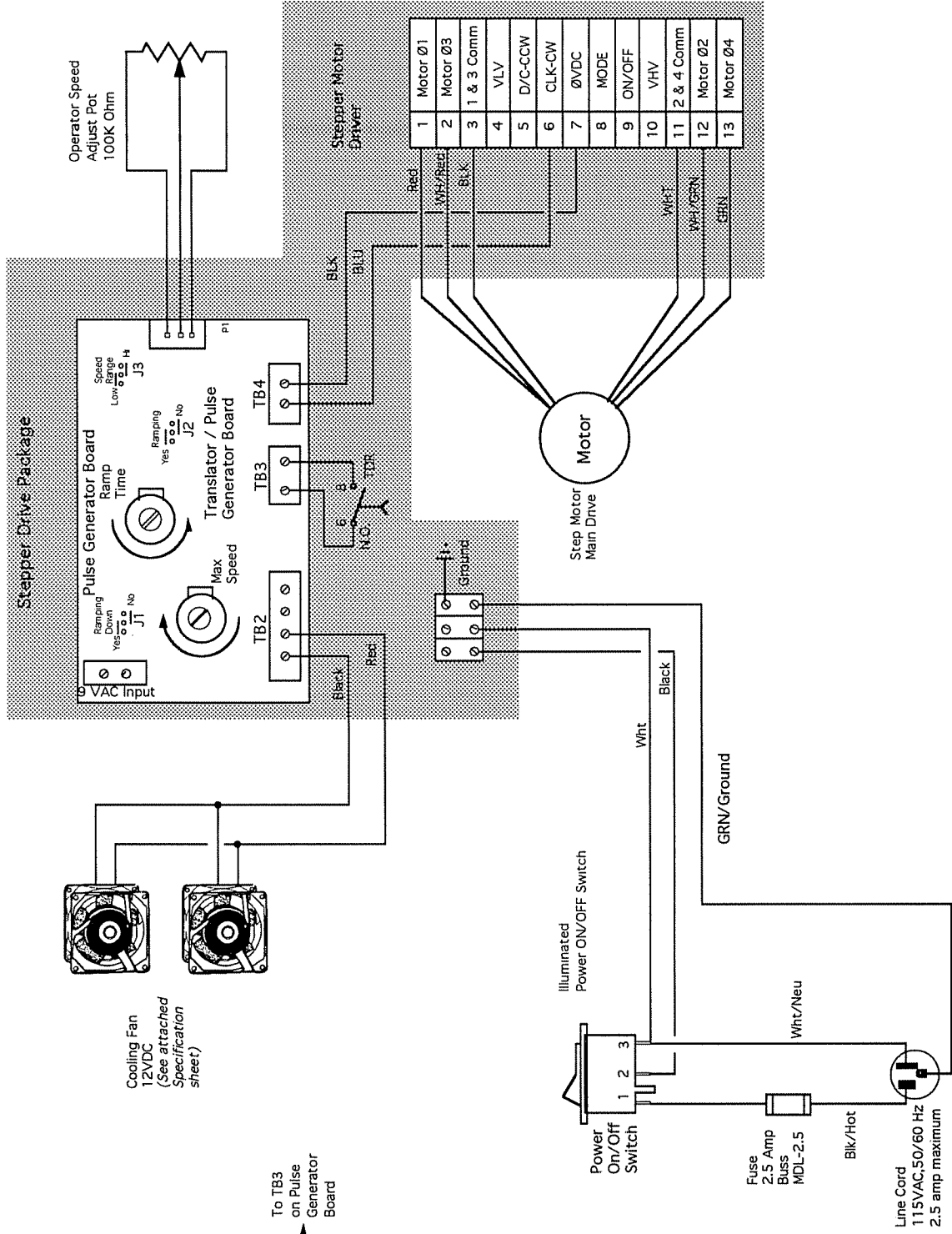
A switch closure could be used to initiate run, but consideration of mechanical switch bounce, contact scrape and electrical noise must be given. A solid state device is preferred.

This run signal is terminated to the MS Amphenol connector located on the left side panel of the feeder. Pin A of the connector is the RUN signal (TB3 left) and Pin B is the OVDC.

(Shorting these two pins on the Amphenol connector will cause the feeder to run)

Safety Warnings

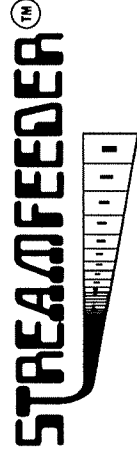
1. Replace fuse **ONLY** with Buss MDL 2.5 amp.
2. You **MUST** use a 3-hole, properly grounded outlet. **DO NOT** remove or otherwise disable the grounding lug on the plug!
3. Use only exact replacement parts when servicing the Streamfeeder™ machine.



Note:
Run Signal to activate timer is typically in parallel with the motor starter contactor coil. When the motor starter is "pulled in", the timer is activated

Date: Ø1 MAR 91

Drawn: KMN



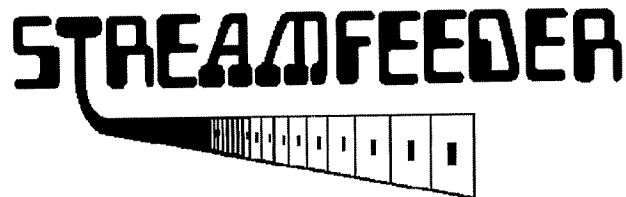
Title: Streamfeeder™ Model III LJ
Electrical Connection Diagram

Dwg. No.

Engineering Bulletin 056

© 1991

Part Number 235-00-900
version 1.0
Price: \$25.00



Streamfeeder Universal Friction Feeder

Mailing Series

Operating Manual

Troubleshooting Manual

Maintainence Manual



Table of Contents

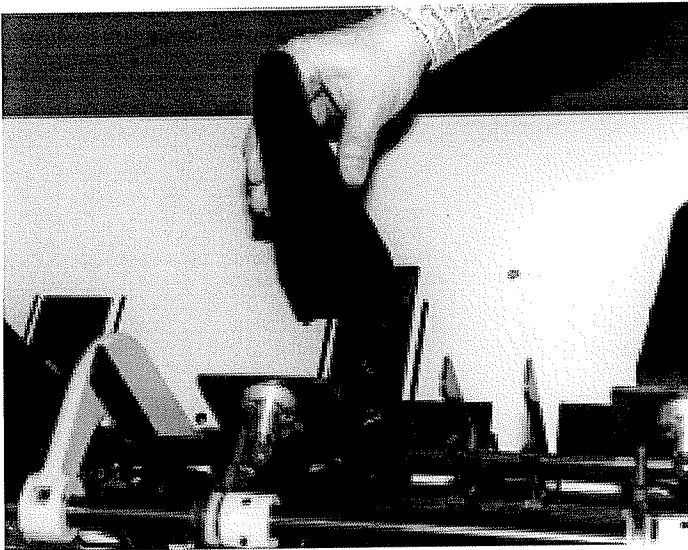
Section 1 - Operating Manual

Section 2 - Parts Manual

Section 3 - Electrical Schematic.

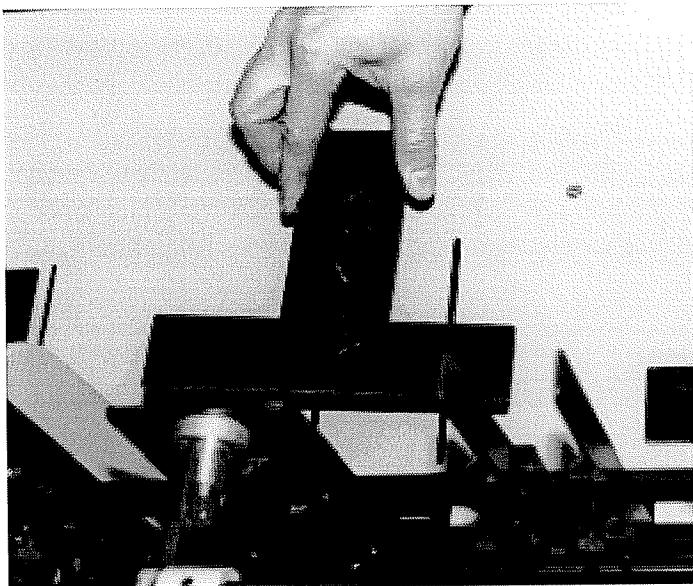
Operating the Streamfeeder® Universal Friction Feeder

Thank you for investing in the Streamfeeder® Friction Feeder. You will find installation simple to accomplish. These easy step-by-step instructions will “walk you through” the installation and set-up procedures to successfully get your Streamfeeder up and running.

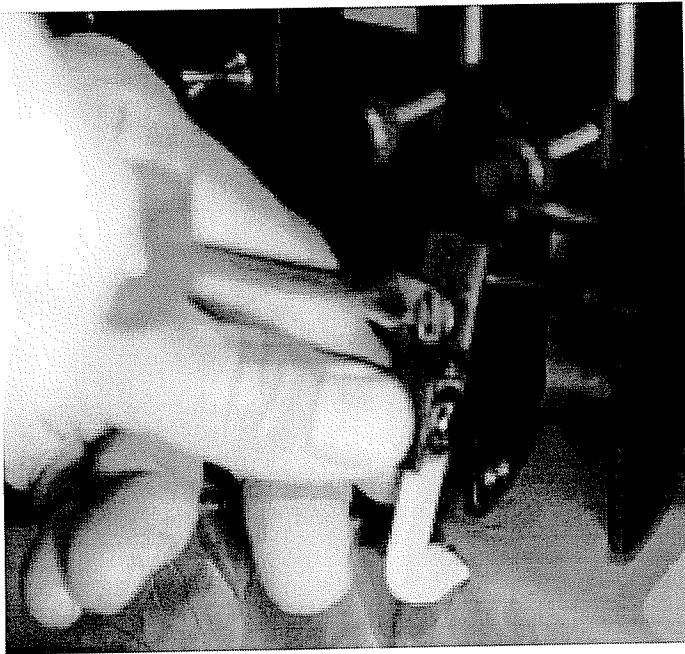


Preparing the inserter for the feeder.

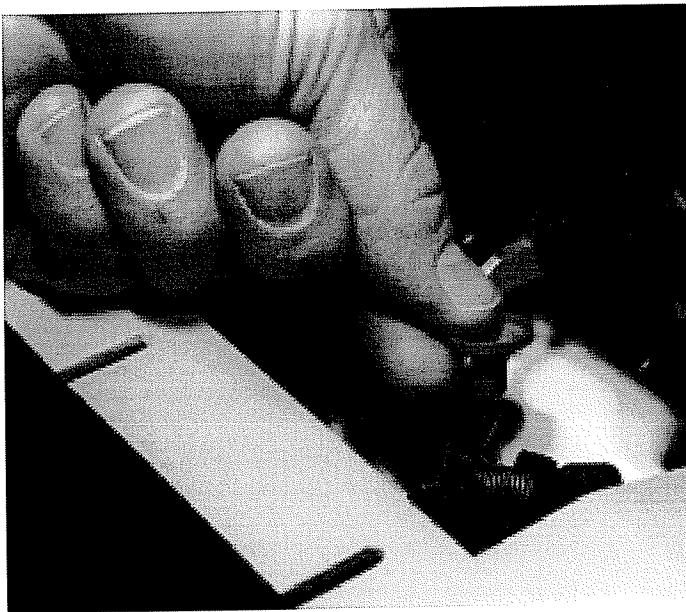
Step 1. Remove the guide assembly rear.



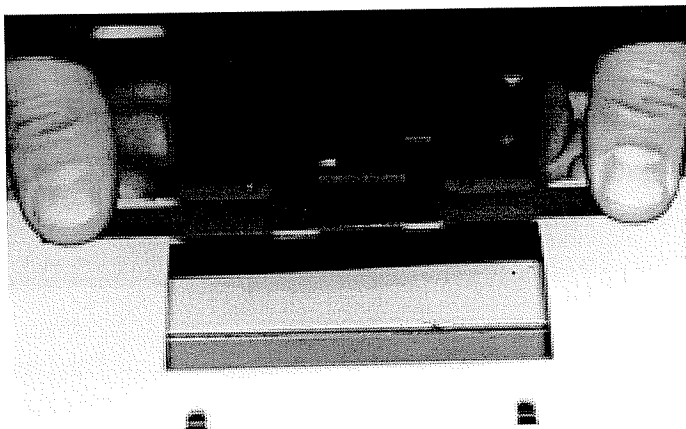
Step 2. Remove the plate insert box feed adjustment (“T” Plate).



Step 3. Loosen the separator foot and tilt it away from the insert station so the foot does not interfere with the material being run.

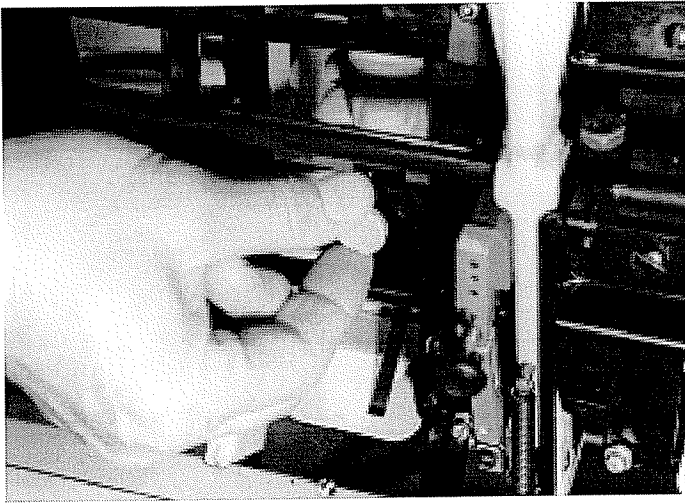


Step 4. Remove the insert suction cup. Lower and tilt the adjustable sucker assembly forward. Plug the sucker hose. The sucker assembly may be moved down and to one side if it interferes with the material being fed.



Step 5. Cycle the inserter until the insert gripper arm jaw is approximately 1/2" from the insert front plate. Locate the two material guide tabs that protrude from the front of the inserter rear table. Pull these guide tabs upward until their top surface is slightly above the bottom of the gripper arm jaw. The material that will be run rests on these guides. The bottom of the gripper arm jaw must pass under the material without making contact with it.

Note: Insecro machines only: Remove the two material guide tabs that protrude from the front of the rear table. Bend these guides approximately 1 3/8" from the tip and reinstall. Place the guide tab approximately 1 3/8" into the rear table

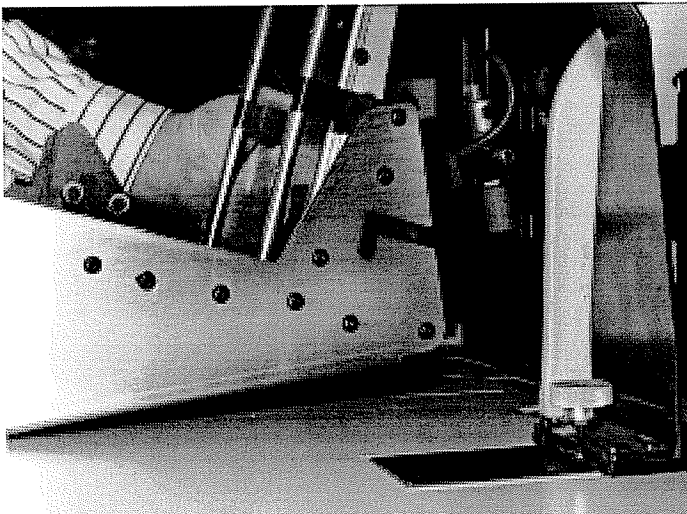


back guide adjusting slot and bend the guide.
Installing the Streamfeeder on the inserter.

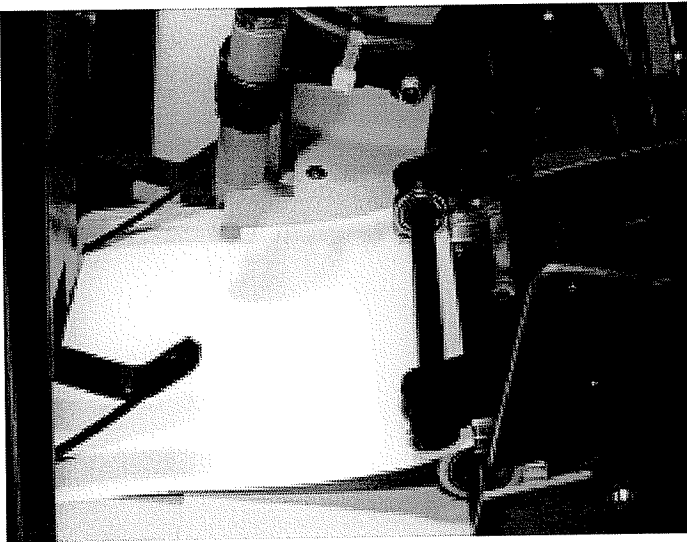
Step 6. Place the Streamfeeder guides on the left and right side of the front insert plate and tighten to the lower support rail.



Check the position of the Streamfeeder spring guides you just installed with a piece of the material you will be running. Adjust the springs to a light tension and locations near the inside edges of the piece. Leave this piece of material in place for further adjustments.



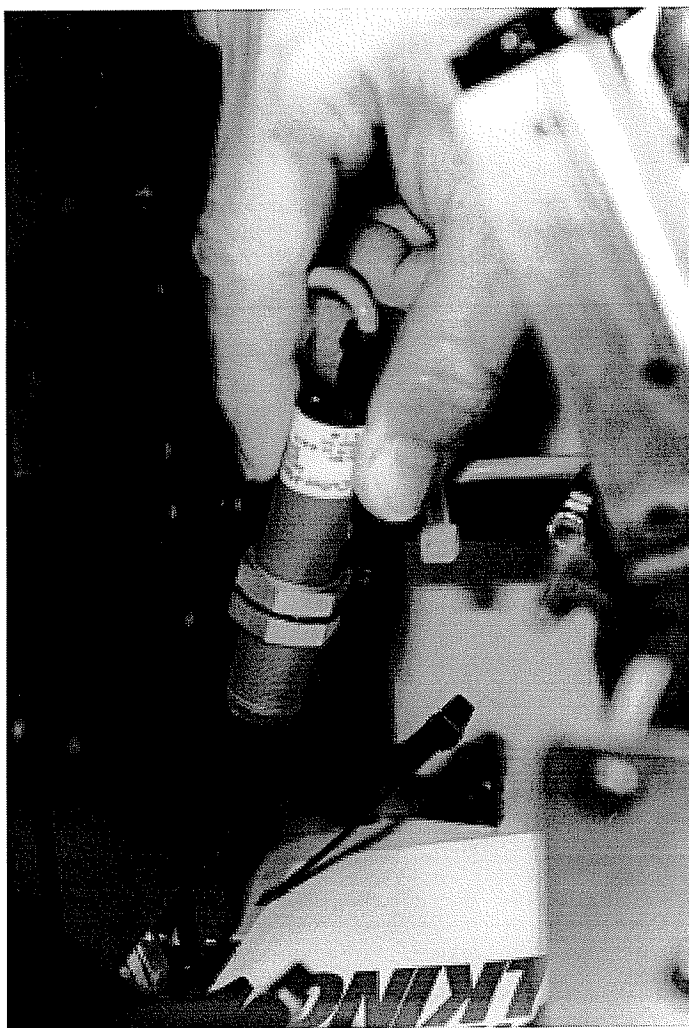
Step 7. Place the feeder on the rear insert table with the two screws that protrude from the bottom of the feeder aligned into the rear guide slots. Secure the feeder with the two "T" Handle nuts provided.



Step 8. Feeder positioning. Place a piece of material to be run under the spring steel guides. Have the front edge of the material aligned with the front of the insert plate. Slide the feeder toward the gripper arm until the trailing edge of the material held by the guides fits between the feeder's exit rollers.



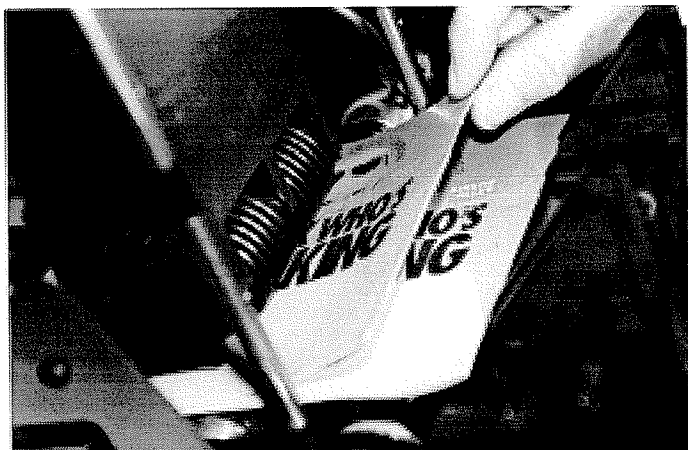
Then tighten the two "T" handle nuts to lock the feeder in place.



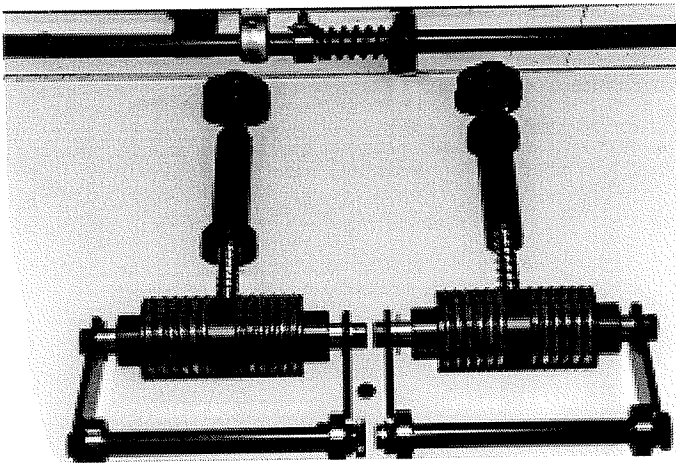
Adjusting the Streamfeeder.

Step 9. Aligning the photocell. Position the photocell by sighting along the tubular barrel. The photocell should “point” exactly at the leading edge of the piece of material that is held under the spring steel guides. The final photocell adjustment will align slightly to the rear of the leading edge. This is because when the photocell signals the feeder’s motor to stop, the motor will over travel slightly.

Step 10. Gate adjustment. Place two pieces of material to be run under the gate. To do this, pull up on the gate adjustment knob enough to slip the two pieces under the gate “O”-rings. Grasp the top piece of material and slide it back and forward under the gate. The proper adjustment is a slight amount of drag on the top piece. Use the gate cylinder adjust knob to set the amount of drag.



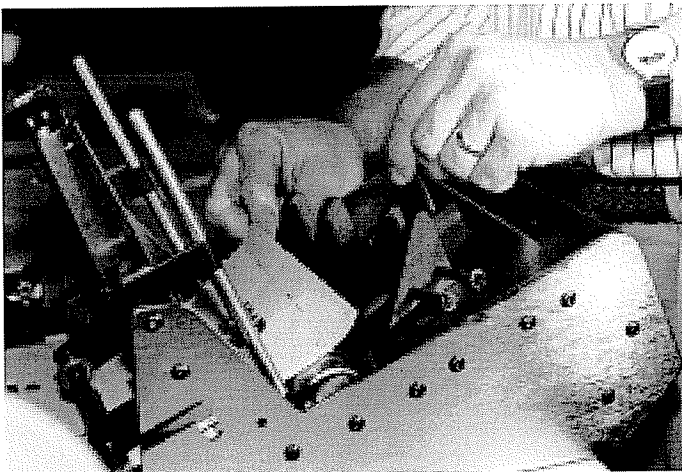
It is desirable to adjust the gate to the maximum opening without feeding doubles. This will allow the maximum tolerance for curled or bent edges, etc. If the feeder feeds doubles after feeding several pieces, you need to close the gate cylinder gap a little. Do this by turning the gate cylinder knob about 1/8 turn counter-clockwise. Retest and repeat the adjustment if necessary. If the gate cylinder is too tight, the material will have difficulty pulling through the gate and you will get missed feeds.



CAUTION: Before running the feeder, be sure that the gate cylinder is adjusted upwards enough that the "O"-rings are not contacting the feed rollers and belts. If the gate cylinder "O"-rings are in contact with the belts and rollers and the feeder is run with no material in it, you will damage the belts, rollers and "O"-rings.

You can also adjust the amount of spring tension holding the gate cylinder in position. The gate can move upwards slightly against the spring while material is being fed. This is useful in feeding irregular materials. The normal setting for the gate cylinder spring tension is with the collar on the barrel in the "down" position. This is shown in the left position in the photograph. This setting will work well for most materials and allows the greatest stack heights. It also gives the best performance in preventing doubles.

The cylinder can be turned to the "up", or low tension position for special feeding requirements. This would be especially useful in feeding irregular thickness materials that requires the gate to "float" more during the feeding process. The low tension setting can be used to minimize marking of the product by the gate cylinder or to prevent peeling back the top sheet of a booklet, for example.

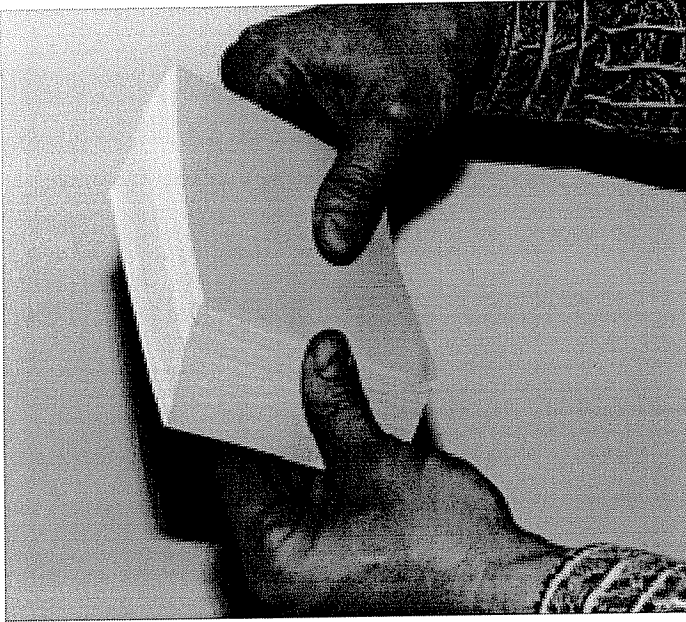


Step 11. Material Support Wedge Adjustment. The trailing edge of the material to be run *must* be supported by the material support wedges.

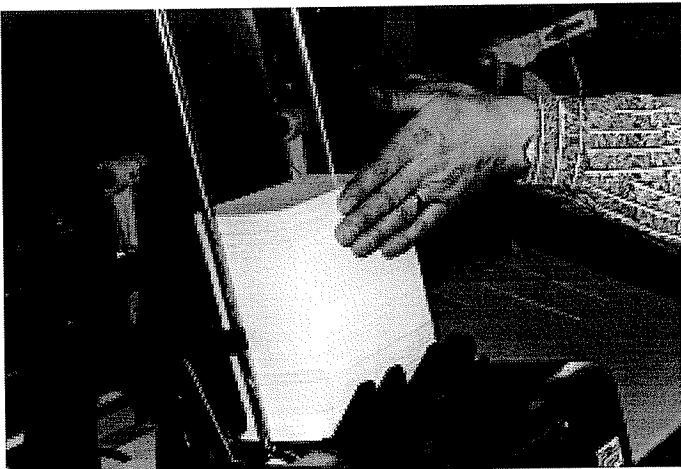
This adjustment is made by loosening the wedge assembly adjusting knob and sliding the wedge assembly under the trailing edge of the material to be run. Each individual wedge may be moved from side to side on its retaining shaft. This allows an adjustable spacing of the wedges to evenly support the material to be run. It should be understood that this feeder feeds in a shingled manner. As the bottom piece exits the gate area, the following piece of material starts to feed. It overlaps the first piece. The amount of

overlap can be adjusted by sliding the wedge assembly toward the gate for less overlap, or away from the gate for more overlap.

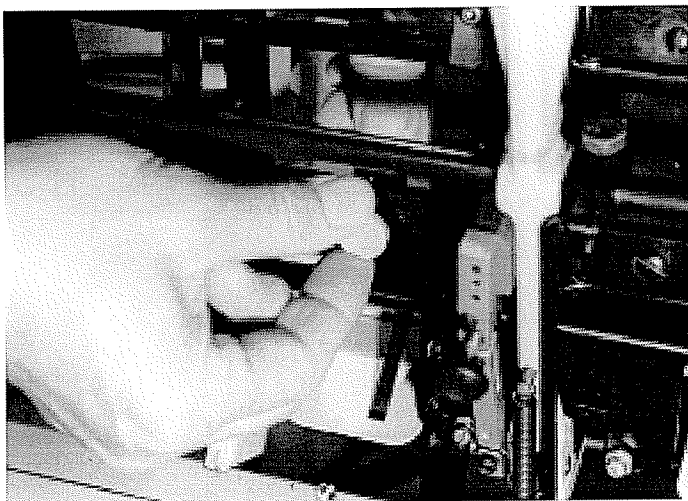
Function of overlap. More overlap allows the feeder to feed a greater amount of paper per revolution. This will serve better in high speed applications. The wedge assembly can be turned to the left or right to help compensate for skewed (twisted) feeding of the material. You can experiment with turning the wedge assembly one way or the other and observing the straightness of the material feeding.



Step 12. Loading the material to be run. The first handful of material should be fanned into a wedge and placed in the feeder to allow the bottom pieces of paper to conform to the curvature of the gate cylinder. By helping the first stack of material to form itself around the gate cylinder, you will help get the separation process started correctly. You only need to do this with the first stack going into the machine. From then on, the feeder will continue to form the material around the gate cylinder for proper feeding automatically.



As you add more material to the stack in the feeder hopper, pat the back edge of the material stack so that all of the material is pushed tightly up to the front plate. This helps to prevent miss feeds.



CAUTION: Electrical extension cords should be at least 16 Gauge wire. They MUST be 3 wire grounding type. You MUST use a 3 hole grounded outlet.

Feeder Start-up.

Turn the feeder on and adjust the spring tension of the material guides. This is done by sliding the guide bracket up or down on the support bar and then tightening the set screw. The spring tension on the material guides should not be so great as to distort the material as the gripper jaw of the inserter pulls the material through the springs.

Adjust the insert arm gripper jaw and detector to the material being run. The procedure for this is the same as for regular stations that are not equipped with the Streamfeeder. See your inserter owners manual for instructions about these adjustments.



Adjust the photocell to stop the material in line with the insert station front plate. This is done by aiming the photocell forward or backward to change the stopping point. See step 9 for more information about adjusting the photocell.

Run several pieces of material from the feeder before making your final gate adjustments to the Streamfeeder, if necessary. When adjusting the gate cylinder knob, make the movements in small amounts. Usually it is best to move the outside edge of the knob 1/8" or less with each adjustment.

Troubleshooting and Maintenance of the Streamfeeder

Problem

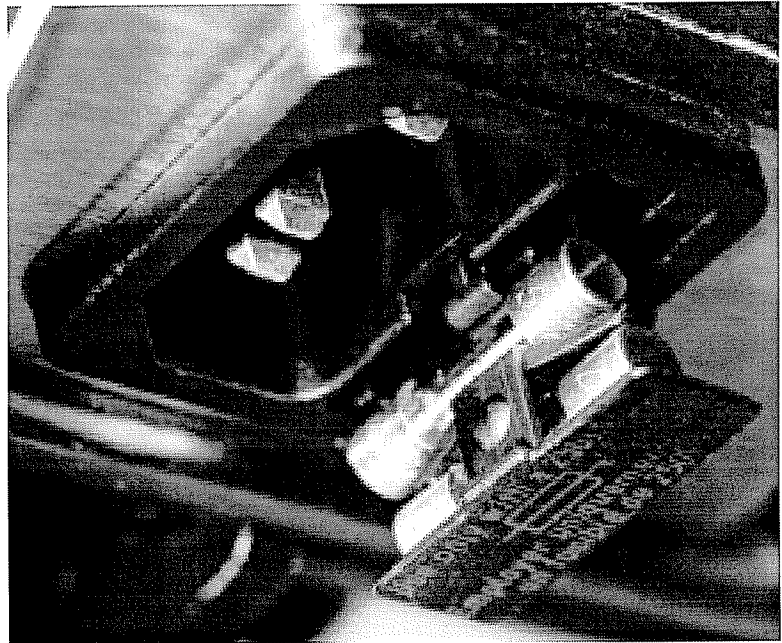
Cause and Solution

Feeder does not run, switch is turned on.

Is the main power switch light on (120 V models only)? If not, check the electrical supply by plugging in another device into the plug you are using to be sure there is power to the outlet.

The photocell may be detecting a background surface and does not turn the motor on. Realign the photocell to be sure it is not detecting a background.

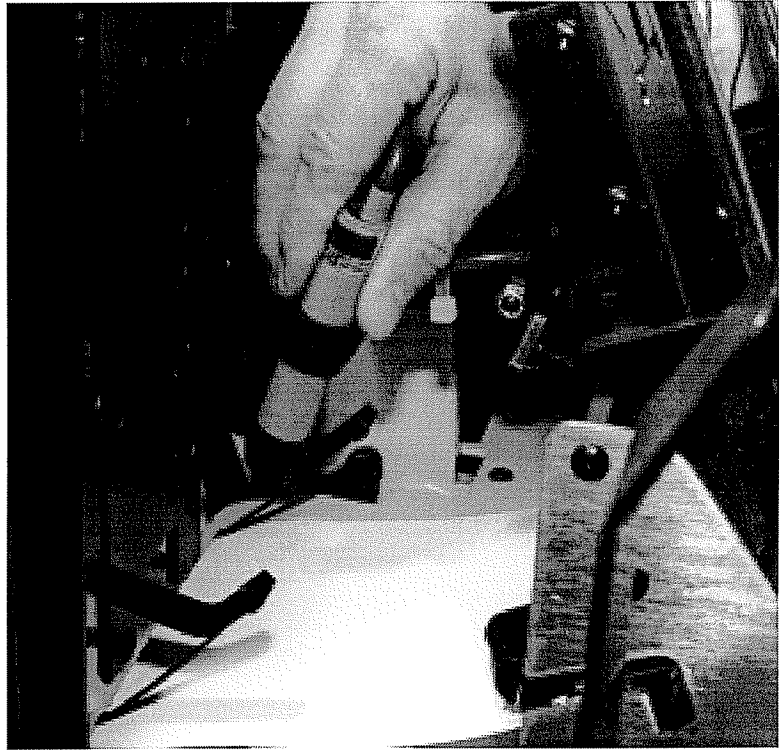
Check to see if the machine fuse is blown. If so, replace the fuse with the spare one in the fuse holder. Use only the proper size and type of fuse.



If the gate cylinder is set too tight, it will jam the machine and stall the motor. Also check for a paper jam in the machine. A stalled motor can blow the fuse.

Feeder will not stop (continuous feeding).

The photocell is not detecting the material being fed. Realign the photocell as discussed in step #9 of the set up instructions.



The photocell used on the Streamfeeder was chosen for its very broad range of sensing capabilities and ease of set-up. Occasionally, when running very black pieces, the standard photocell will not be able to sense the pieces. In this situation, contact Streamfeeder for technical support. Streamfeeder has optional, specialized photocells available for difficult sensing applications.

The material being fed does not advance far enough for the gripper jaw to pick up.

The photocell is not properly aligned. Realign the photocell to a focal point farther from the feeder. The feeder may not be the proper distance from the gripper jaw. Repeat the adjustment for proper feeder distance from the gripper jaw covered in Step #8 of the set-up instructions.

The material overshoots the guide springs and is too deep in the gripper arm jaw.

The photocell is misaligned and/or the feeder is not installed with the correct distance from the gripper jaw. The spring tension on the guide springs may be too low.

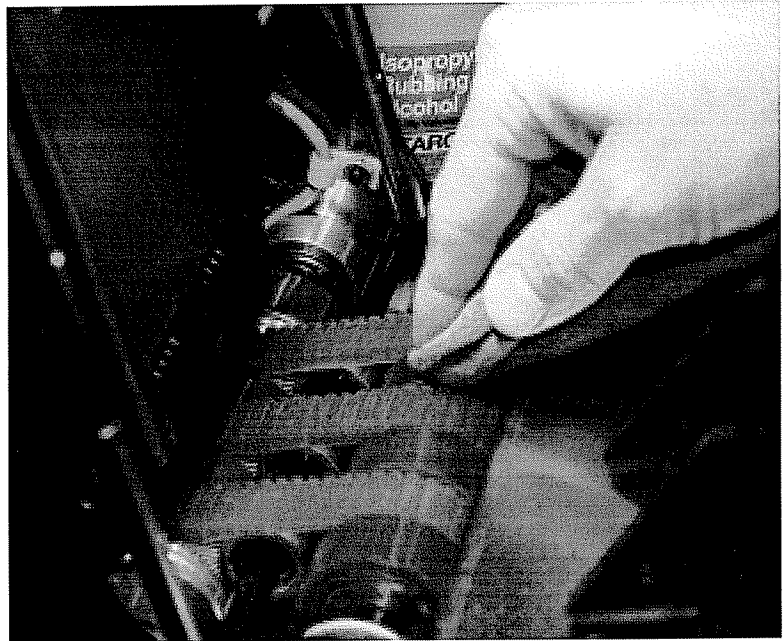
Move the photocell toward the feeder. Position the feeder the proper distance from the guide springs. Set the correct spring tension on the guide springs.

The feeder runs, but material does not feed.
Erratic feeding, roller slip.

The gate is set too tight. Loosen the gate.
The wedge assembly is too far toward gate. Move the wedge assembly away from the gate to allow more material contact with the drive belts and rollers.
The paper may be jammed. Clear the jam.
Material stack may be too high or heavy. Try removing part of the stack.
Rollers and belts may be dirty and glazed, causing the rollers and belts to slip on the material. Clean the rollers with rubbing alcohol.

CAUTION:

Isopropyl rubbing alcohol is FLAMMABLE! Unplug the machine before cleaning the rollers. Do NOT use near an open flame, sparks or any other source of ignition. Do NOT smoke in the vicinity of the alcohol fumes. Air dry the cleaning rag. Dispose of used rags properly. Only purchase consumer packaged rubbing alcohol. Only keep small quantities of alcohol on the job site (16 oz., 500 ml or less). Store alcohol properly.



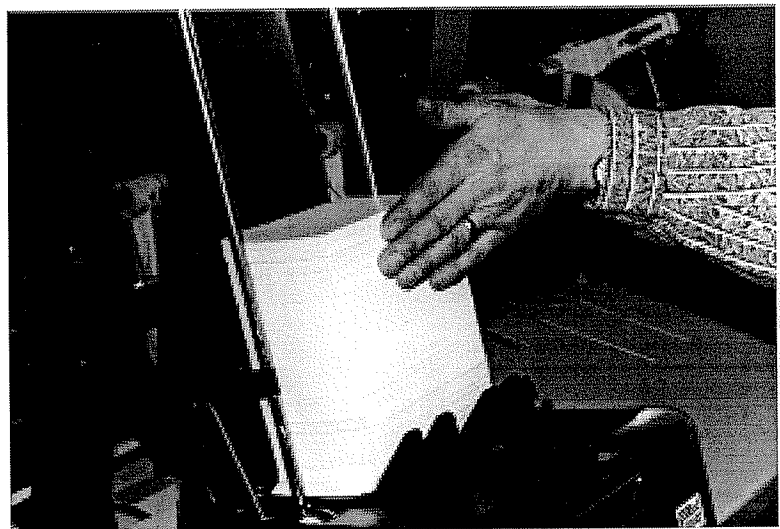
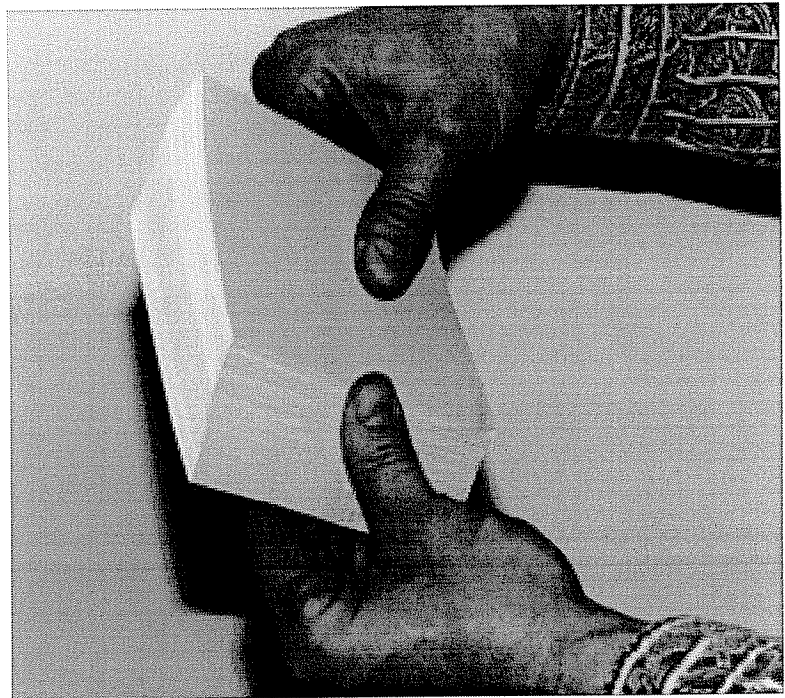
Clean rollers and belts are VERY IMPORTANT to the proper operation and feeding of the Streamfeeder!

Clean the rollers using a clean rag or towel and alcohol. Use **ONLY Isopropyl Rubbing Alcohol, 70% by volume.** This is the type of rubbing alcohol that is sold at drug stores. Do NOT use any other type of cleaners, such as Blanket Wash or other solvents. These may coat the rollers with plasticizers or destroy the rubber compound of the rollers.

DO NOT use any type of abrasive cleaner or cleaning cloth, such as Scotchbrite or sand paper on the rollers. This will destroy the sealed high friction surface and make the rollers useless.

The feeder runs, but material does not feed.
Erratic feeding, roller slip.
(continued)

Material not loaded properly in feeder hopper. Make sure the first stack of material is loaded with a fanned lead edge to conform to the gate cylinder. Make sure material is patted forward until it contacts the front guide.



Pieces interlock. Make sure there is no embossing, staples or other physical features of the product that cause the product to interlock one piece to the next. An example of a material with serious interlock would be credit cards with the same data embossed on every card.

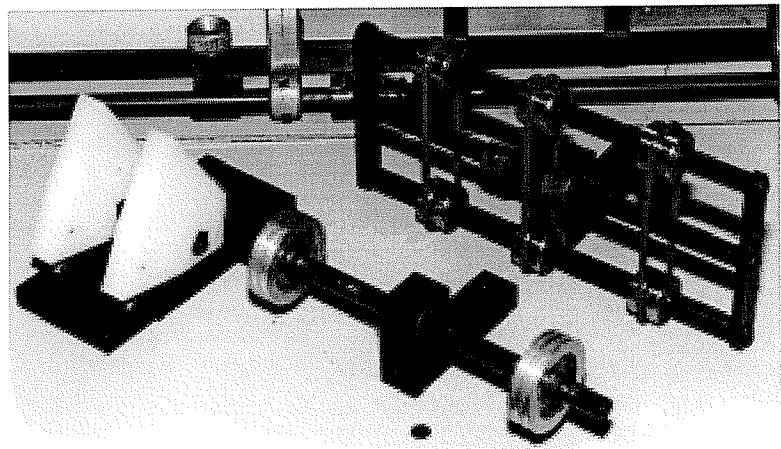
The feeder runs, but material does not feed.

Erratic feeding, roller slip.

(continued)

On unusual or irregular material, experiment with different directions of material feed. Some materials will feed better in one direction than the others.

If you are feeding some difficult materials, the standard wedge assembly may not provide sufficient support for the material, or it may cause the material to bind together. Streamfeeder has special, optional wedge assemblies for meeting these special requirements. Contact Streamfeeder for technical assistance. Some of the special wedges are shown in the photograph below.

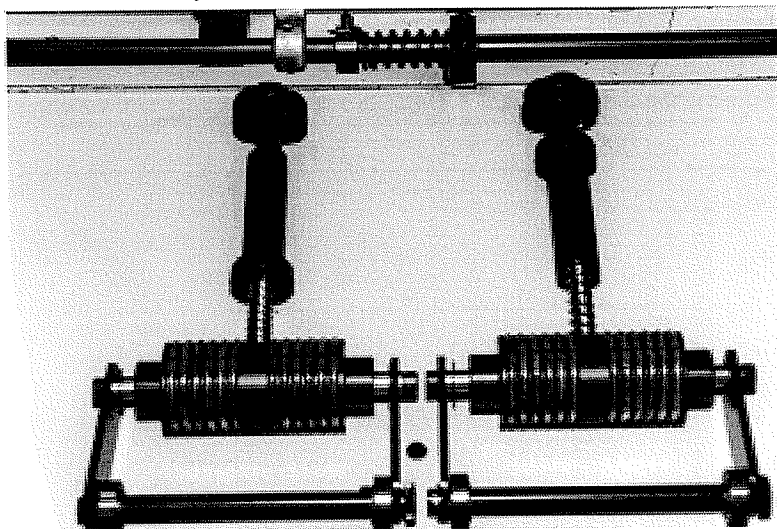


Paper skews when exiting the feeder (does not feed straight).

One side of the material being fed is contacting the feed belts before the other side. Turn the wedge assembly to offer more support under the leading edge of the material. The side of the material that is leaving the feeder first needs more support, or less belt contact. Turn the wedge on this side toward the gate cylinder to hold the material up from the belts. Experiment with different amounts of wedge twist to minimize or eliminate the skewing of the material feed.

With the feeder hopper full, the feeder cannot control doubles.

The spring tensioning cylinder may be turned for low stack height. Turn the cylinder over for higher spring tension and higher stack heights. In the high tension, the collar on the cylinder is down, or closest to the cylinder.



The "O"-rings are worn to the same height as the gate cylinder. Turn or replace all "O"-rings if they are worn.

Turning the "O"-rings on the gate retard cylinder may be done by inserting a small, 90° Allen hex wrench in the horizontal groove in the gate cylinder. With the hex wrench in the groove and the "O"-ring in the bend of the wrench, rotate the wrench one complete circle around the "O"-ring groove while pulling the wrench away from the cylinder. This lifts the "O"-ring out of its groove. Turning the wrench one complete turn will rotate the "O"-ring in the groove to a new wear position on the gate cylinder. Rotate all of the "O"-rings the same amount for an even retard surface on the bottom of the cylinder.

