



Bochsler Grafische Maschinen

OPERATING INSTRUCTIONS

Stream Delivery



SAB 550/750

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Machine Assembly and Maintenance

Assembly

The machine is delivered completely assembled. The delivery table can easily be pushed on rollers behind the preceding machine. It will be positioned and secured by the two pedestals.

Electrical Connection 400 Volt

1. Connect machine to power
2. Main switch ON
3. Power circuit ON

If the power circuit doesn't work, ***than you have to change 2 phases in the power plug 400V.***

(That's cause of a safety switch)

Maintenance

Only the four (4) bearings of the guide rods need to be greased for the delivery table lift movement. The grease nipple is found at times under the yellow covering hood. Machine grease once a year (1 x yr).

Consumables:

Grease for bearings of the guide rods:

NLGI-2, DIN K2 / K-30

Control Panel and Switches

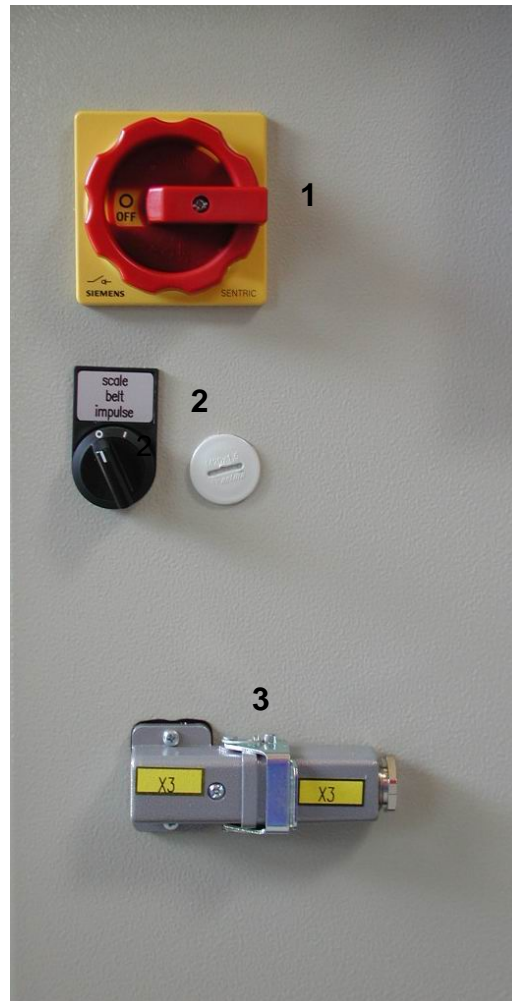
Control Panel



Nr.	function	description
1	Control circuit ON	Switch on Control circuit.
2	Control circuit OFF	Switch off Control circuit.
3	Transition belt ON / OFF	Switch ON / OFF the Transition belt at the infeed.
4	Scale belt ON / OFF	Switch ON / OFF the scale belt.
5	Height adaption UP	Push that bottom to move the stream delivery up.
6	Height adaption DOWN	Push that bottom to move the stream delivery down.
7	Speed gear Scale belt	Push that bottom to speed up the scale belt for unloading.
8	Emergency-Stop	Switch off the power of the stream delivery.
9	Transition belt Speed	With this potentiometer it is possible to set the speed of the transition belt at the infeed.
10	Scale belt speed	With this potentiometer it is possible to set the speed of the scale belt.

Control Panel and Switches

Switch Box Operating Elements



Nr	function	description
1	Main Switch ON / OFF	Power ON of the stream delivery
3	Switch for counting	0 = Fixed Cycle Copy Stream 1 = Photo Cell Copy Stream
4	Stop Circuit Connection	Release for the machine in front

Parameter Settings

Control Field E 100



Nr.	function
1	Display Screen
2	Function Keys F1 - F4
3	Cursor Key
4	Correction Key
5	Numerical Input Selection Key
6	Selection Key for Time Input below 1.0 sec.
7	Enter Key

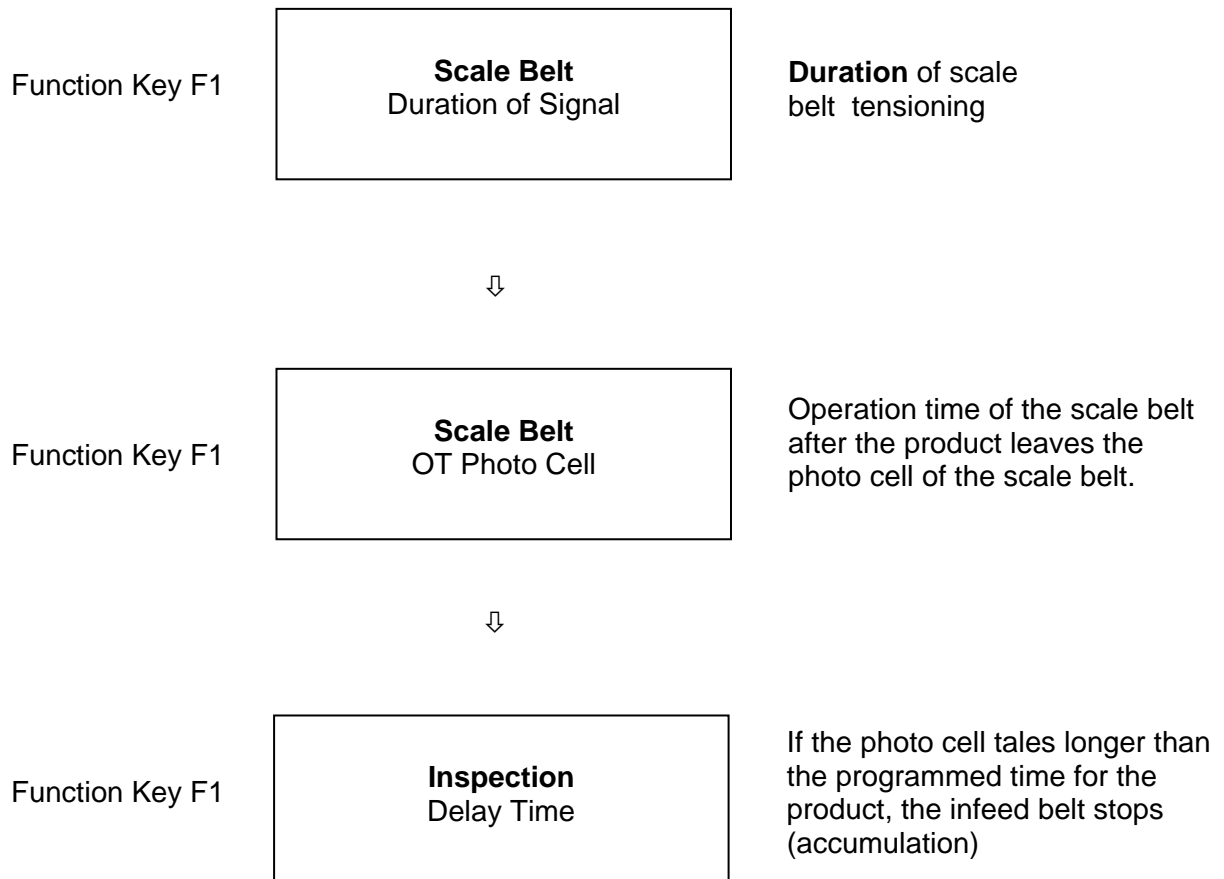
Parameters Setting

Program Writing and Value Changes

- 1) **Number of corresponding Parameters on keys F1 – F4**
- 2) **For instance, if changing Mode F1 to F3**, the Parameter must be connected through in F1 Mode till "SAB wishes you a pleasant day" can be seen on the screen.
- 3) **Programming Time Values:**
 - a) **Time values preceding the comma position (e. g. 1 Second)**
 - ◆ Press and hold down the key NUM
 - ◆ At the same time press the corresponding time unit (e. g. 1 = 1 Second)

Important: do not press again the key NUM, if you save the programmed time with 'Enter'!
 - b) **Time values following the comma position (e.g. 0,5 Seconds)**
 - ◆ Press twice (2 x) in brief succession the key 0-
 - ◆ Press and hold down the key NUM
 - ◆ At the same time enter the selected time value
 - ◆ Save it with the key 'Enter'
 - c) **Time values preceding and following the comma position (e.g. 1,5 Seconds)**
 - ◆ Press and hold down the key NUM
 - ◆ At the same time press 1 (=1 Second)
 - ◆ Do not press again the key NUM
 - ◆ Press twice (2 x) in brief succession the key 0-
 - ◆ Press and hold down the key NUM
 - ◆ At the same time press 5
 - ◆ Save with the key 'Enter'
- 4) **Time value changes** can be done whilst the equipment is operational, without interrupting the Production.
- 5) **The max. time value is 9,99 seconds**
- 6) **Usually the time values are always below one (1) second**
- 7) **Changing item counter of counter and preset counter:**
 - ◆ Press and hold down the key NUM
 - ◆ At the same time write over the number shown on the Display
 - ◆ Save with the key 'Enter'

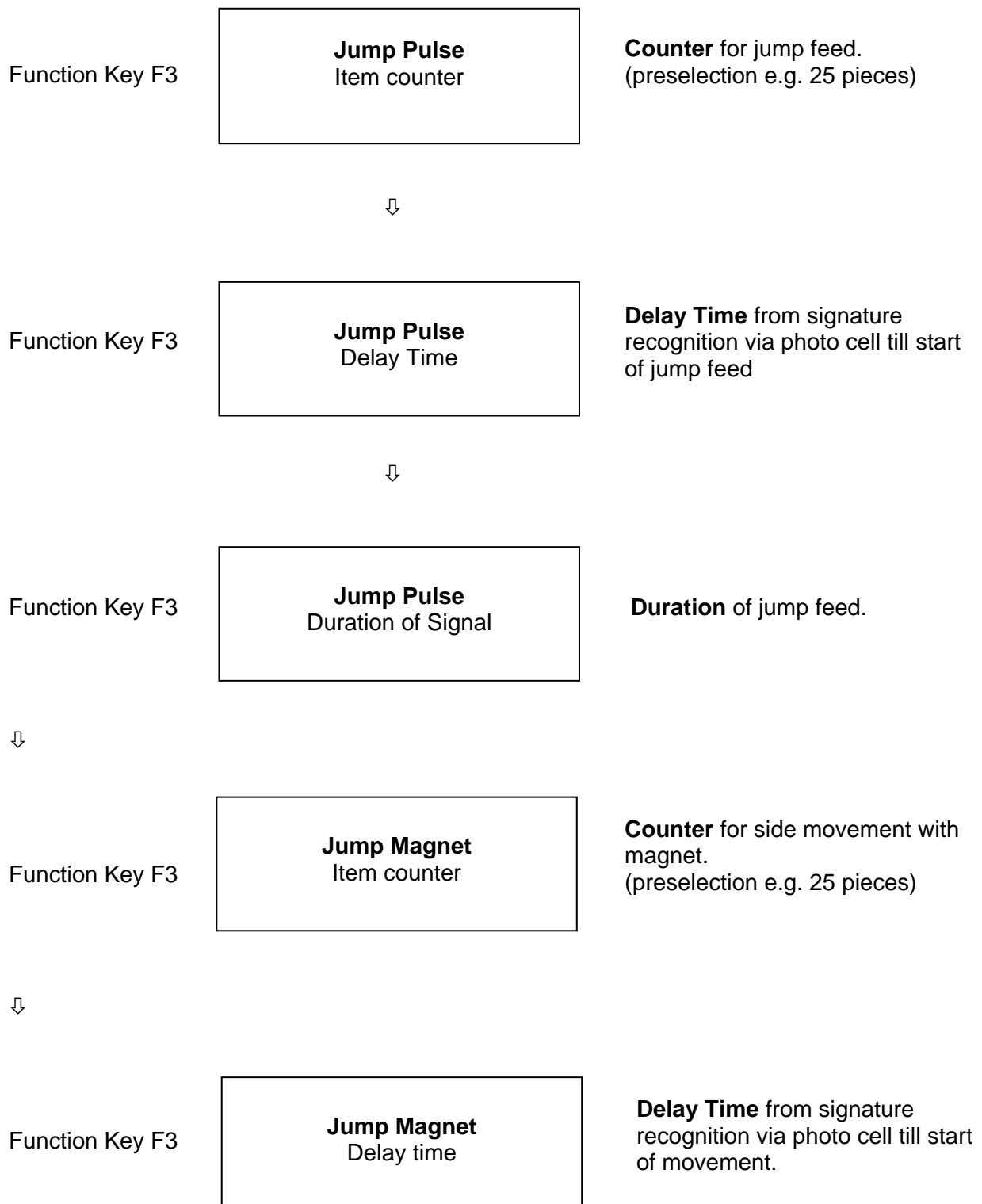
Display Reading F1



Display Reading F2

Function Key F2	<div style="border: 1px solid black; padding: 10px; text-align: center;">Item Counter Unit/Day</div>	Counter for unit per day with resetting to zero.		
	↓			
Function Key F2	<div style="border: 1px solid black; padding: 10px; text-align: center;">Item Counter Unit/Order</div>	Counter for unit per contract with resetting to zero.		
	↓			
Function Key F2	<div style="border: 1px solid black; padding: 10px; text-align: center;">Power Display Cycles/Hour</div>	Display of hourly capacity.		
	↓			
Function Key F2	<div style="border: 1px solid black; padding: 10px; text-align: center;"><table style="width: 100%;"><tr><td style="text-align: center;">Impulse 0</td><td style="text-align: center;">Magnet 0</td></tr></table></div>	Impulse 0	Magnet 0	Counter for Impulse and / or magnet moves. With the key F1 and F4 it is possible to set the counters to zero.
Impulse 0	Magnet 0			

Display Reading F3



Display Reading F4

Function Key F4

Service
Hours of operation
counter

Function Description

When running at a capacity of < 8000 Pr./h (selector switch # 3 on position 0), each product passing the 1st photo cell releases a count impulse and a scale belt movement. The delay and length of the scale belt space can be freely programmed on F1. The 2nd photo cell will not be activated in this mode.

When running at a capacity of > 8000 Pr./h (selector switch # 3 on position 1), the 1st photo cell releases a count impulse. The scale belt runs at a constant speed as long as photo cell # 2 is covered.

Use function key F3 in order to program after how many products the scale belt should jump feed. The duration of the signal and the delay time can also be exactly selected in relation to the last impulse.

Additional Intake-Shaft

The lower additional Intake-Shaft is for an optimal cut off disposal by die-cutted products.



The moveable shaft pieces can be set on the whole working wide. That is important to separate the waste from cutted products. The products will be optimal guided from the punching machine to the stream delivery.

Spare Parts List

♦ Motor	Infeed	M2A 71A6 071	
♦ Motor	Scale Belt	M2A 71 C4	
♦ Motor	Stroke Drive	ME 90 S8	
♦ E-Magnet		GE-60.15-100K-24	
♦ Photo Cell		FHDK 10P5101S35A	
♦ Cable to Photo Cell		ESG32AH0200	
♦ Limit Switch		Z-15 G W2	
♦ Toothed Belt	Scale Belt	PU 450-TS/16	
♦ Toothed Belt	Scale Belt	PU 750-TS/16	
♦ Toothed Belt	Stroke Drive	PU 390-TS/16	
♦ Round Belt	Motor ⇔ Rollers	Ø 4 x 580	
♦ Round Belt	Roller ⇔ Rollers	Ø 4 x 425	
♦ Round Belt	Infeed up	Ø 4 x 1050	
♦ Round Belt	Infeed down	Ø 4 x 1050	
♦ Transport Belt	for Belt Lever	MAT-02H 15 x 595	
♦ Transport Belt	for Belt Lever Drive	GG4E 20 x 2260 mm	