

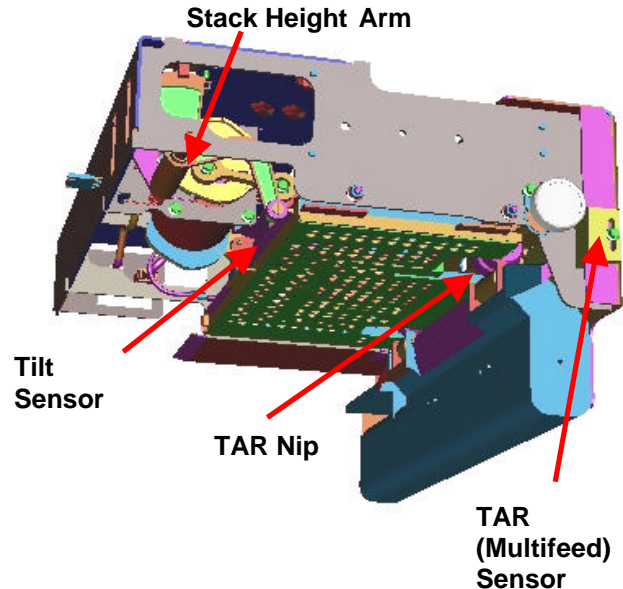
# High Capacity Feeder Module - HCF Operational Sequence

---

## Operational Sequence

### Prior to Feed (Power On)

- All Power Up activities completed,
- Initialization and Cycle Up activities have been completed.
- The paper supply has been loaded by the operator.
- The Elevator has been raised to the appropriate stack height.
- The air system turns on.
- The tray angle has been set using the Tilt Sensor.



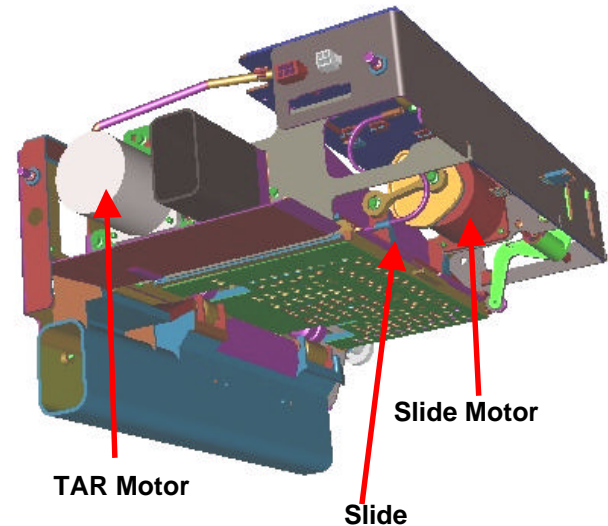
# High Capacity Feeder Module - HCF Operational Sequence

---

## Operational Sequence (continued)

### Feed Cycle (Start)

1. The Vacuum Valve opens.
2. The Top Sheet of Paper is acquired from the stack by the Slide.
3. The Slide drives the paper forward to the TAR nip.
4. The Vacuum Valve is timed to drop vacuum as the sheet Lead Edge reaches the TAR nip to avoid sheet marking and drag.
5. The TAR Sensor looks for the arrival of the Lead Edge and Trail Edge. The TAR Sensor is also a Multifeed Detector.
6. As the Slide returns to its home position, the Stack Height Arm drops onto the top of the paper stack after the trail edge of the sheet being driven out has passed. This prevents the SH arm from dragging on the out going sheet and marking it or causing skew.



## High Capacity Feeder Module - HCF Operational Sequence

---

### Operational Sequence (continued)

7. After the Trail Edge of the sheet has passed the Tilt Sensor, a measurement of distance from the top of the fluffed stack to the acquisition surface is taken.
8. The Feeder Module Exit Sensor looks for arrival of the sheet Lead Edge and Trail Edge.
9. At end of job or low paper the system goes to Normal Cycle Down. Low paper is determined by elevator stepper motor counts.
10. Each feed cycle, the tray may be incremented and/or angled based on feedback from the stack height and Tilt Sensor.

