

SLITTERS

1. Setting up bottom slitters

- a. Both slitter sides are sharp and can be used on either side. Found that it is easiest to set all of the bottoms up then do the tops after.
- b. Currently the home slitter on the drive side is set at 11" from the edge of the slitter bar. This is where the cut starts and the place to start setting up.
- c. The slitter mandrel (bottom slitter bar) is an air shaft. It has two settings, setup mode (5 psi) and run mode (40 psi). Using set up mode, the slitters can be moved, rocked into position for whatever sizes needed.
- d. Push the screen icon to change slitter mandrel to setup and turn both the trim and main slitters off.
- e. Starting at the home slitter, set up right to left, cutting on the right side until the end. (Can use either side but it is easier to measure if sticking to one side until the end.) Use a clump of dust to mark your cut points or set the top slitter down next to your cut but not close enough to move the bottom slitter.

2. Setting up top slitters

- a. Once bottoms are all set up, change the slitter mandrel from set up to run mode, increasing the air pressure so that they won't move. Turn on the top slitters icons, trim slitters and main slitters.

- b. Make sure you are setting the top slitter on the correct side that you marked. The long metal knob in the back of the top slitter is for tightening onto the slitter bar. Loosen it to move slitters to desired location, leave loose for now.
- c. Make sure the slitter cartridge arrow is pointing towards the cut, also want the cant key pointed in the same direction, cant keys add the angle to the blades, they can be removed and flipped if the slitter needs to go the other way, but both arrows should always face the same direction.
- d. Change the front knob to yellow (down with 1/2 side load) and carefully push the slitter snug up to the desired bottom slitter. Once snug, tighten the back knob to lock the top slitter in place. Check the depth of the slitter.
 - i. If the slitter is too deep switch the front knob to red (up position) and adjust the depth knob clockwise, if it was too shallow turn it counterclockwise. Refer to the picture next to the knob.
 - ii. Check the depth by flipping the knob back to yellow and looking at it, adjust further as needed.
- e. Once depth looks right turn the front knob to green (down with full side load) and spin the bottom slitters to see how it turns. You can also check by trying to turn the top slitter and it should give some resistance.

3. Removing slitters

- a. To remove a splitter turn the front knob to red. Lift the front locking bar up. Pull down on the small brass locking clips and pull out towards you.
- b. To re insert, make sure it is on red, locking lever is up then slide it in, adjust cant key if turning splitter around to cut on opposite side.

4. Changing slitters

- a. To change a dull top splitter, remove the cartridge and bring over to a flat surface.
- b. Press the lock button located on the backside of the cartridge to hold the splitter in place while you loosen the 3 nuts and spin off the cover on the splitter side.
- c. Remove old/worn splitter and replace with similar size, re attach the cover and nuts, using the locking pin to make sure they are tight.
- d. When putting the cartridge back in, check the depth of the new splitter and adjust accordingly.

Notes on slitters

- Wear gloves when handling slitters, they are very sharp
- There are 2 airlines that ride across the splitter bar, one is for trim slitters and one is for main slitters
- When running a stub on the tending side cover up the trim blower and plug that housing into the main splitter air supply so that it comes on with the main slitters.
- Try to leave airlines and ports plugged in at all times so that dust does not build up in the tips.