

RUN MODE

1. Screen set up

- a. After threading up and ready to run, you will want to set up on Run Screen, it is a shortcut on most screens but you can also get to it by using screen select icon and clicking on run screen
- b. On this screen is a lot of information and a lot of potential adjustments.

2. Speed controls

- a. Winder speed is set by sliding the cursor on the bottom of the speed set point box (it is a little touchy but good for quick adjustments). If you tap on the speed set point box a pop up number scale will come up where you can enter your desired speed then hit enter.
- b. Each machine motor roll has the potential to change speeds, each uses the motor % to control speed differences. 1.00 is based off the bed rolls so lowering the % will slow the roll down adding drag/tension. Raising the % will speed up the roll loosening up the sheet in that area.
- c. The box below the reel is the control for sheet tension. We have found that 0.990 is very tight and 1.010 is very loose. A good middle is 1.003 to 1.006. It is useful to tighten the sheet up during a splice to reduce bagging while on thread.
- d. Calendar speeds have not been worked with yet.

- e. The first Mt. Hope roll was left at 1.00 because speeding it up or slowing it down did not seem to make a difference.
- f. The slitter bar is set for a faster speed than the drums so that the paper gets cut rather than dragged across the blades.
- g. The second Mt. Hope roll has been found to help with wrinkles if slowed down, it seems most effective in the 0.850 range.
- h. The drum speed does not change as that is the home speed and any changes to this would change the baseline of everything else.

3. Auto stops

- a. The programming of this winder has 2 auto stops that can be used, length and rewinder diameter.
- b. The icon down on the bottom left that says Auto stops shows length and rewinder dia with a box to the right of each, if you want to use either one, click on the box and select which one to turn on then the button should turn green and it will stop at that length or diameter.
- c. Using the length auto stop has been effective. By tapping the stop length icon on Run Screen you can set the length for auto stop, a couple thousand feet less than the reel length, it does a slow stop.
- d. Diameter auto stop is also easy to use, the one time we tried it, it shut off a little too early but that can get programmed differently. Push the rewinder diameter

box and a pop up should come up and you can change the stop diameter to the desired amount.

- e. Remember to turn them on after setting them. You can turn both on and it will do whichever reaches set point first.

4. Interlocks that prevent running

- a. There is a screen called prevents run that shows all of the interlocks that prevent running in run mode.
- b. All E-STOPS must be disengaged, J-Table needs to be up, drives need to be ok, no alarms currently detected, neither auto stop set point has been reached and no web break (if using automatic eye).

5. Running

- a. To run, turn off thread mode, top right corner, the winder will then start up to whatever speed you have set up.

Notes on Run Mode

- Auto eye feature is in the upper right hand corner, turn on if you want the winder to stop for a break.
- Length reset button on the bottom right hand side if doing multiple sets.
- When adjusting speeds/tensions make sure to get the right amount of zeros, 1.05 is much different than 1.005.
- Looking at simplifying tension adjustment.
- There are 6 emergency stops around the winder
- There are fast stops on the panel and on the console by the backstands.