

THREADING UP

1. Screen set up

- a. The primary screen to use is the "Roll Change" screen
- b. Make sure the main slitters are off, trim slitters on, trim blower on, transfer level up and thread mode on (icon on the left side of screen).
- c. Have the thirdhand raise the backstand, at the panel next to the backstand, making sure the switch is in the correct direction to run. (under if spun, over if running straight)
- d. When ready the backtender will hit run, it will beep a couple times then thread mode will start.

2. Handing the tail

- a. The thirdhand will be positioned between the two aluminum rolls, between the reel and calendars. The backtender will be positioned between the calendar and slitters.
- b. The third hand brings the tail over the first aluminum roll, under the second aluminum roll and points tail through the open calendars, once backtender receives tail, thirdhand moves to the face of the winder in front of the bed rolls and gets the long grabber.
- c. The backtender grabs the tail from the thirdhand at the calendars and pulls the tail under the first bowed roll, then over the slit bar and drops the tail below the second bowed roll.

- d. Third hand retrieves the tail with the grabbers and pulls the tail under the core shaft and begins to flatten the sheet out.
- e. Backtender can now hit stop (it delays a little while on thread mode to stop)

3. Starting the roll

- a. Spread sheet out and lower the transfer lever. Once lever is lowered rip the tail end off at the edge of the winder and tuck the remainder into the back of the core shaft so that it will wrap.
- b. Turn on the main slitters, lower counter load, and close core grippers, then you can push run (still on thread mode), check sizes, move reel north/south as needed for trim and or sizes.
- c. When ready to run, bring J-table up, two people needed, one on each button. One console is located on the I-beam near the panel, the other is located on the cantilever control console.
- d. You are ready to run, switch screens to run screen, check adjustments and speeds, then tap icon to turn thread mode button to off, which will start the winder up to the desired speed. (see next section run mode)

4. Jogging vs. thread

- a. Thread mode is good for starting the reel but due to starting slow and a long delay in stopping it has not been great for splices.
- b. Jog is a good tool to use during splices, it starts quick and stops quick, the downfall is that someone has to be holding the button in to use. It takes some getting used to.

Notes on threading up

- While winder is on thread mode you can walk on mats in front of the winder
- With most motors on direct drive thread mode speeds and tension look much different than run speeds and tension. Motor % of 50fpm is much different than 3000fpm.
- Trying to make adjustments on thread mode is not helpful because when the machine speeds up it changes.
- If using thread mode after a splice it is better to tighten up the draws to start then loosen back up when going to run mode.
- J-Table must be up to run, grippers must be down and closed to run, the light curtain must be free of objects, and nothing can be on the mats.