

STANFORD MODEL 152 Jr REWINDER



SECTION 3. PURPOSE AND LIMITATIONS

The Model 152 Jr rewinder has been designed to salvage (doctor) rejected or partially spoiled rolls of material without interrupting your regular production equipment. The Model 152 Jr rewinder will unwind, inspect, and rewind rolls that are telescoped, unevenly wound or rejected for other reasons. A splicing station is mounted on the machine to allow the removal of bad sections and the splicing of the material.

This forward/reverse rewinder is furnished with a drive motor for each of the unwind and rewind positions.

Due to the "open end", cantilevered design of the rewinder the machine is limited to the following:

Web Width	10" (254 MM)	Unwind Roll Dia	24" (610 MM)
Web Speed	1500 FPM (457 MPM)	Rewind Roll Dia	24" (610 MM)
Roll Weight	200 lbs (91 KG)		

SECTION 4. INSTALLATION

- A. UNCRATING: Using caution, remove the protective crate (covering) from the shipping base and at this time, check the unit to see if any damage occurred during transit. The rewinder is bolted to the base with two bolts on each end of the rewinder. Care should be exercised in removing the rewinder from the base so as not to turn the rewinder over or throw it in a twist. The rewinder is shipped with three eye bolts in the top of the side frames. These are used in moving the rewinder by attaching a chain to them and lifting the rewinder. Care must be taken to insure that the chain does not come into contact with the control panel or instrument panel
- B. POSITIONING: Locate the rewinder where it is to be installed and anchor it to the floor with 1/2" anchor bolts (using angle iron feet at each end of the rewinder). Leveling screw holes (1/2" – 13) are located in floor angle feet to assist in leveling the machine.

To obtain best operational results, care should be taken in leveling the rewinder. This is done with a precision level (graduated to .0005 of an inch) and when level the web idler rolls should read level.

- C. ELECTRICAL HOOKUP: All internal wiring has been furnished and connected. Connect main power leads to the circuit breaker located in upper right corner of the drive control cabinet. It is very important that power leads enter the cabinet from the top, so they do not run in close proximity to low voltage control components inside the cabinet. (Refer to electrical diagram furnished with the rewinder). The rewinder drive control is located on or with in the machine and require no additional connections.
- D. WEB GUIDE: All internal wiring has been furnished for the web guide and no additional connections are required.
- E. PLANT AIR CONNECTION: Connect plant air to the rewinder at the rear of the machine. Connect the airline to the airline lubricator. The air supply should be between 80 - 100 PSI at 1/8 CFM

SECTION 5. OPERATION ADJUSTMENT CHECK

- A. POWER: With power leads attached to the drive control circuit breaker and all wiring connections have been made according to wiring diagrams for the machine, power may then be turned on. A status stack light assembly is mounted on the machine. These lights indicate the following:
 - Power on – green pilot light
 - Machine Running – amber pilot light
 - Drive Fault / E-Stop – red pilot light

SECTION 6. RUNNING THE MACHINE

- A. The operation of this machine is simple and easy to operate. IMPORTANT there are many things you must do every time you operate the rewinder. Stanford assumes that the operators of this type of equipment know the basics of operating machinery safely. However, we will restate some important safety considerations for your information.

1. Be sure that the air shafts are inflated (80 PSI) before you start the machine in operation. **CAUTION:** Never inflate airshaft without core on air shaft.
2. Do not bring your hand or loose clothing near a rotating shaft or roller while machine is running.
3. Do not touch the edge of the moving web or the side of a rotating roll.
4. Do not operate the machine with any of the access covers open, removed, or the electrical cabinet open.
5. Do not put your hand or arms between any rollers for any reason while the machine is running. Stop the machine first.
6. Whenever the machine is left unattended, turn off the main power (circuit breaker).
7. Slitting is an optional feature. Your machine may not contain slitting knives.
CAUTION: Be careful around slitting knives. Avoid contact with cutting edges.

B. FUNCTIONS AND DESCRIPTIONS OF CONTROLS ON REWIND OPERATOR PANEL (Refer to Figure 3)

1. Emergency stop push button: THIS PUSHBUTTON IS ONLY USED IN AN EMERGENCY SITUATION. Actuation will cause the rewinder to come to a fast stop. Note: After actuating the E-stop push button, it must be twisted clockwise (reset) before rewinding will again run. When push button is actuated the button lenses is lighted, when reset light is off.
2. Operator interface touch screen module: is used to enter data for operation of the machine and the processing of the product. It also displays set parameters and processing values (speed, length etc.) Also see operator touch screen instructions.
3. Speed potentiometer: Controls the rewind drive by turning the dial clockwise the speed of the rewinder will increase. This control is optionally selectable on the touch screen so that speed adjustment can be made through the touch screen.

1. Place a roll on unwind shaft with the edge of roll aligned with web guide running position. Inflate shaft with selector button on touch screen.
2. Web the machine. (See Figure 1) or press "Web Path Screen" button on main screen.
3. Make sure rewind edge is in alignment with sensing head guide point.
4. Tab material to rewind core so that web is not slack or drooping.
5. Make sure both shafts are inflated and the rider roll is down.
6. (Optional Equipment) Set slitting knives locations for desired slitting or trimming application. Engage knives at this point or just before web is started. Turn screw handle knob Item "SLITTING", Fig. 1 counter clockwise then carefully rotate knives to be sure that blades mate with the slitting grooves. Then re-tighten knob to lock slitting bar in the engaged position. Once slit or trimmed web(s) reach the rewind core(s) it may be necessary to remove un-slit web and re-tab the individual webs to the cores

F. CONTROL PANEL CHECK PRIOR TO RUNNING

1. Tension: At the operator interface touch screen verify tension data, enter and reset roll diameters. Also verify web width setting.
2. Stop Length: Set stop length value on "Setup Screen". Also see operator touch screen instructions.
3. Web guide: Set to "AUTO" position if web direction is reverse. Set to "MANUAL" position if web direction is forward.

G. TO RUN UNIT

1. Push web tension button on and allow the dancer to assume center position. Also see operator touch screen instructions
2. Push "RUN" button on and turn speed dial up slowly to desired running speed. The machine will accelerate smoothly to the set speed when "RUN" is pressed.
3. The Amber pilot light on the machine stack light is on anytime run is active. This is to indicate that machine is in a run condition even if the speed potentiometer is set to zero and the web is not moving.

H. TO STOP THE UNIT

1. Turn speed dial slowly to "0" position if necessary however in most instances when line stop is pressed the machine will decelerate smoothly to zero speed then stop.
2. Press the line stop button on the touch screen to deactivate run.

SECTION 7. DOCTORING OR SALVAGE (EDITING) APPLICATIONS

This machine has a splice board mounted at the left side of the machine.

As previously described in this manual, the original method of operation was to mount the roll on the unwind shaft (left side of machine) and wind the material onto the rewind shaft (right side of the machine) until defective material was reached. At which time, the machine could be stopped and defective material removed at the unwind.

SECTION 8. OPERATION PROCEDURE

- A. Position roll to be salvaged on unwind shaft so that distance from edge of roll to side frame is the same as guide point arrow on web guide sensor.
- B. Position core on rewind shaft so that distance from edge of core to side frame is same as roll on rewind.
- C. Press the "SERVO CENTER" mode button located on the web guide control screen when doing initial setup. Once set up and web alignment is complete set web guide to "AUTO" if web direction is reverse or set to "MANUAL" if web direction is forward.
- D. Thread material through machine and attach to core. (See Figure 1)
- E. Lower rewind rider roll.
- F. Run roll down to defect slowing machine down with speed pot for visual observation.
- G. When defect appears, stop machine, place splice board clamps down.
- H. Unwind Hold may need to be turned off to release bad material from unwind roll.
- I. Remove bad material; make splice, raise splice clamps, turn unwind hold on, restart machine, and run slowly.
- J. It may be necessary that after running 25 feet of material following a splice, to adjust guide point. Also see page 12 and 13 for more details on guide point setting.

and the MAIN screen will be replaced by your choice.

Note: Anytime you are making a selection on the touch screen, please touch with your finger only. Using foreign objects may damage the screen.

Touching the RUN or STOP buttons will allow the line ramping up to the speed dial setting or stopping at a controlled rate to zero line speed.

WEB SPEED-AUTO(FPM) value is entered in foot per minute. This is the speed setpoint entered/changed by using keypad or the DEC and INC buttons.

WEB SPEED-MANUAL(FPM) setpoint is changed by turning speed pot on the operator control panel. This setpoint can not be changed using keypad or DEC/INC buttons. The web speed setpoint can be selected between auto and manual values by touching SPEED REF SELECT button located in the SETUP screen.

The WEB WIDTH(INCH) setpoint value is entered in inches. This value can be changed by using keypad or the DEC and INC buttons.

The WEB TENSION (PLI) setpoint is an entered value in pounds per linear inch, PLI. This value can be changed by using keypad or the DEC and INC buttons.

The TOTAL WEB TENSION (LB) value, which is a product of the web tension value and the web width value, is displayed in units of pounds.

The RIDER ROLL PRESSURE (PSI) is an entered value in pounds per square inch. This value can be changed by using keypad or the DEC and INC buttons. The rider roll can be raised up or lowered down by touching the RIDER ROLL button.

The ROLL LENGTH(FEET) displays the accumulated line measurement. The displayed value can be reset to zero by touching the RESET button. The HOLD button, when touched, will hold the currently displayed COUNT or length value. To resume counting, touch the HOLD button again. The button label should now display "RELEASE" to indicate that the counter is released to count.

The LEFT ROLL DIAMETER RESET button, when touched, will reset the left diameter to its start value. The left roll diameter start value is set in the SETUP screen by entering the LEFT START DIAMETER (INCH) value. The LEFT DIA. RESET button must be touched at the beginning of each new roll on the unwind shaft.

The LEFT SHAFT AIR button deflates or inflates the left shaft.

The RIDER ROLL button moves the rider roll up or down.

Part Number	Rev	Description	Quantity
5413-152JR	000	MODEL 152 REVERSIBLE DOCTOR JUNIOR	1.000 EA

Component Part	Rev	Component Part Description	Quantity Required
ASBY 1264-B	00	SIDE ELEVATION-152JR (ALCAN)	1.000 EA
ASBY 1264-C	00	FRAME & CABINET ASSY. - 152 JR	1.000 EA
ASBY 1264-D	00	UNWIND ASSEMBLY - 152JR	1.000 EA
ASBY 1264-E	00	SPLICE TABLE - 152 JR.	1.000 EA
ASBY 1264-F	00	IDLER ROLL ASSEMBLY - 152 JR.	4.000 EA
ASBY 1264-G	00	DANCER ROLL ASSY. - 152 JR.	1.000 EA
ASBY 1264-I	00	RIDER ROLL ASSY. - 152 JR.	2.000 EA
ASBY 1264-J 152 JR	00	AIR PIPING DIAGRAM	1.000 EA
ASBY 1264-K 152 JR	00	ENCLOSURE ASSEMBLY	1.000 EA
ASBY 1264-L 152 JR	00	AIR SUB-PANEL ASSEMBLY	1.000 EA
ASBY 1264-M 152 JR	00	ELECTRICAL SUB-PANEL ASSEMBLY	1.000 EA
ASBY 1264-N 152 JR	00	OPERATOR CONTROL ASSEMBLY	1.000 EA
ASBY 1264-P	00	REWIND ASSEMBLY - 152JR	1.000 EA
ASBY 1264-Q 152 JR	00	ELECTRICAL SUB-PANEL ASSEMBLY	1.000 EA
ASBY 1264-R	00	WEB GUIDE ASSY. - 152JR	1.000 EA
ASBY 1264-S	00	ENCODER ASSEMBLY - 142/152 JR.	2.000 EA
ASBY 1264-T	00	IDLER ROLL ASSEMBLY - 142/152 JR.	1.000 EA
ASBY 21241	00	WIRING DIAGRAM 152JR -01 THRU 14	1.000 EA
ASBY 21242	00	WIRE CHART 152JR -01 THRU 04	1.000 EA

Part Number	Rev	Description	Quantity
Y 1264-K 152 JR	00	ENCLOSURE ASSEMBLY	1.000 EA

Component Part	Rev	Component Part Description	Quantity Required
166109		HOF #T-FP41 FAN KIT	1.000 EA
166110		HOF #T-EP4 EXH KIT	1.000 EA
180127-D		ELECTRICAL ENCLOSURE	1.000 EA

Part Number	Rev	Description	Quantity
ASBY 1264-L 152 JR	00	AIR SUB-PANEL ASSEMBLY	1.000 EA

Component Part	Rev	Component Part Description	Quantity Required
141313		NORG #18-025-003 REG WALL BRKT	3.000 EA
143558		FAIRCHILD #EB09921 MTG. BRACKET	1.000 EA
161516		NORG #18-013-211 1 1/2 PRESS GA 1/8	5.000 EA
161713		SCHDR FLOW CONT #3251-0125	2.000 EA
166012		NORG R07-100-RNKA REG	3.000 EA
173458		SCHDR #PS2946J79P SOL VALVE CONN	4.000 EA
173466		AIRTROL F-4200-100-FM-B85 PRESS	1.000 EA
173640		MSI #100100-SN-00000-20125-AL	1.000 EA
173818		FCHLD #20812 VOL BOOSTER	1.000 EA
175656		O'KEEFE #E-40-BR (.040") ORIFICE	2.000 EA
177414		PARKER #MKH0NB549A VALVE	2.000 EA
179715	00	NORGREN FLT/REG #B72G-2AK-QD1-RMG	1.000 EA
179716	00	NORGREN C-FLT #F72C-2AD-QDO	1.000 EA
179717	00	NORGREN SHUT OFF #T72E-2AA-PIN	1.000 EA
179718	00	NORGREN Q-CLAMP #4214-52	2.000 EA

179651		IDEC SPDT 10A RELAY #RH1B-UDC24V	5.000 EA
179653		IDEC RELAY BASE #SH1B-05	5.000 EA
179697		IDEC 4PDT 10A RELAY #RH4B-UAC120V	2.000 EA
179698		IDEC RELAY SOCKET #SH4B-05	2.000 EA
179699		ABB OFF DELAY TIMER #TRB-120A2Y10	1.000 EA
179700		IDEC 8PIN SOCKET #SR2P-06	1.000 EA
179701		LITTLE FUSE JLS 10A #JLS010	6.000 EA
179702		LITTLE FUSE BLOCK #LJ60030-3-PR	2.000 EA
179704		LITTLE L70S 10A FUSE #L70S010	4.000 EA
179705		LITTLE FUSE BLOCK #LH25030-2PR	2.000 EA
179727		IDEC STAND OFF 3" #BNS4	2.000 EA
179804		AB 1769-IF4 ANALOG INPUT MODULE	1.000 EA
180101		CT UNIDRIVE SP 2HP #SP1402-LED	2.000 EA
180102		CT LINE REACTOR #LR4-L-008-C	2.000 EA
180104		AB 1769-HSC HIGH SPEED COUNTER MOD	1.000 EA
180290	000	AMPHENOL#17-1657-09 15HD BACKSHELL	2.000 EA
180318	000	CT #SM-ETC ENCODER TERMNL CONNECTOR	2.000 EA

Part Number	Rev	Description	Quantity
ASBY 1264-N 152 JR	00	OPERATOR CONTROL ASSEMBLY	1.000 EA

Component Part	Rev	Component Part Description	Quantity Required
112986		OHMITE CU5021 5K 2W SPEED POT	1.000 EA
142194-A		SPEED NAME PLATE	1.000 EA
142512		REID #CKB17 BK PLASTIC DIAL KNOB	1.000 EA
179598		MAPLE-SYSTEMS TS KIT #HMI530C-KIT	1.000 EA
179599		MAPLE-SYSTEMS CABLE #7443-0040-12	1.000 EA
179650		IDEC E-STOP LEGEND #NWAR-27	1.000 EA
179710-C		CONTROL ENCLOSURE	1.000 EA
180115		IDEC ILLUM E-STOP #AVLW49911R-120V	1.000 EA

Part Number	Rev	Description	Quantity
ASBY 1264-Q 152 JR	00	ELECTRICAL SUB-PANEL ASSEMBLY	1.000 EA

Component Part	Rev	Component Part Description	Quantity Required
180128-B		SUB PANEL	1.000 EA

Part Number	Rev	Description	Quantity
ASBY 1264-C	00	FRAME & CABINET ASSY. - 152 JR	1.000 EA

Component Part	Rev	Component Part Description	Quantity Required
143534-A		LEVELING BLOCK	1.000 EA
161339		HOF #A-PA6AXFN FAN KIT	1.000 EA
164573		3/4-10 EYEBOLT #EB-8T WILLIAMS	2.000 EA
173463		LATCH, SOUTHCO #C5-11-35-3	1.000 EA
177613		DECAL, 6", CIRCLE "S" LOGO	2.000 EA
177615		DECAL, 4", STANFORD	1.000 EA
178423		AD #E26XWWL392W-V2 STACKLIGHT 24V	1.000 EA
178425		AD #E26S109 STACKLIGHT MTG BASE	1.000 EA
179544-D		MAIN FRAME - DOCTOR JUNIOR	1.000 EA
179550-C		TOP PANEL	1.000 EA

Part Number	Rev	Description	Quantity
ASBY 1264-E	00	SPLICE TABLE - 152 JR.	1.000 EA
Component Part	Rev	Component Part Description	Quantity Required
171731		LEE SPRING #LC-049H-6 COMPRESSION	4.000 EA
177235		MCMaster CARR #4050T32 STEEL TRAY	1.000 EA
178896		MCMaster CARR #7584A12 DISPENSER	1.000 EA
179033-B		TAPE DISPENSER MTG BRKT	1.000 EA
179605-B		CUTTING BAR	2.000 EA
179606-B		SUPPORT BAR	2.000 EA
179607-B		CLAMP BAR	2.000 EA
179608-A		SHAFT, KNOB	2.000 EA
179609-A		LOCKING CAM	2.000 EA
179610-A		SPACER	4.000 EA
179612-B		GUARD, ANGLE	1.000 EA
180081-B		BRACKET, SUPPORT	1.000 EA
180082-C		SPLICE BOARD	1.000 EA
390462-B		REID #B-21 KNOB	2.000 EA

Part Number	Rev	Description	Quantity
ASBY 1264-F	00	IDLER ROLL ASSEMBLY - 152 JR.	4.000 EA
Component Part	Rev	Component Part Description	Quantity Required
180091		AMI #UR 206-20 BALL BEARING 1.1/4"	4.000 EA
180092		SKF 6001-Z DEEP GROOVE BALL BEARING	4.000 EA
180093-B		IDLER SHAFT	4.000 EA
180094-B		IDLER ROLL, ALUMINUM	4.000 EA
180095		MCMaster #98541A119 12MM RETAINING	4.000 EA

Part Number	Rev	Description	Quantity
ASBY 1264-G	00	DANCER ROLL ASSY. - 152 JR.	1.000 EA
Component Part	Rev	Component Part Description	Quantity Required
149087-A		VOLTRONICS C158-3LA-100-10K V200001	1.000 EA
152265-A		GEAR ASBY.	1.000 EA
168750-B		GEAR	1.000 EA
170265	000	BIMBA D-231-3 ROD CLEVIS W/ NUT	1.000 EA
174508		SEALMASTER #ER24T BRG	2.000 EA
179617-B		DANCER ROLL ARM	2.000 EA
179619-B		TORQUE ARM, DANCER ROLL	1.000 EA
179624-A		STOP BLOCK - DANCER ROLL	2.000 EA
179625-A		CLAMP COLLAR - DANCER ROLL	2.000 EA
179626-A		CYLINDER MOUNTING - DOCTOR JUNIOR	1.000 EA
179684		BIMBA LOW FRICTION AIR CYLINDER	1.000 EA
180092		SKF 6001-Z DEEP GROOVE BALL BEARING	2.000 EA
180095		MCMaster #98541A119 12MM RETAINING	2.000 EA
180105-B	B	POTENIOMETER MOUNTING BRACKET	1.000 EA
180106-B		COUNTERWEIGHT - DANCER ROLL	1.000 EA
180107-B	B	PIVOT SHAFT	1.000 EA
180108-B	B	RIDER ROLL	1.000 EA
180109-B	B	SHAFT, RIDER ROLL	1.000 EA

179707	000	MOUNTING PIVOT	1.000 EA
180131		FIFE PIVOT WEB GUIDE ASSEMBLY	1.000 EA
180376	000	FIFE #CDP-01, SIGNAL PROCESSOR	1.000 EA
180377		FIFE MAINTENANCE MANUAL	3.000 EA
180384-A		STAND-OFF, CDP-01	4.000 EA
180385-C		SIDE PANEL, LEFT	1.000 EA

Part Number	Rev	Description	Quantity
ASBY 1264-S	00	ENCODER ASSEMBLY - 142/152 JR.	2.000 EA
Component Part	Rev	Component Part Description	Quantity Required
180121		EPC INCREMENTAL ENCODER 2" 665PPR	2.000 EA
180336		MEASURING WHEEL # MW-1-10MM	2.000 EA
180337		REID KNOB # JCL-225	2.000 EA
180338		SNAP RING A-38 - DIN471	2.000 EA
180339		LEE EXTENSION SPRING # LE-041C-2	2.000 EA
180340		HUB, MOUNTING	2.000 EA
180341		ENCODER PIVOT ARM	2.000 EA
180342		SHAFT, MOUNTING	2.000 EA

Part Number	Rev	Description	Quantity
ASBY 1264-T	00	IDLER ROLL ASSEMBLY - 142/152 JR.	1.000 EA
Component Part	Rev	Component Part Description	Quantity Required
165251		BRG SEALMASTER #ER-16T	2.000 EA
180092		SKF 6001-Z DEEP GROOVE BALL BEARING	1.000 EA
180095		MCMaster #98541A119 12MM RETAINING	1.000 EA
180350-B		IDLER ROLL, ALUMINUM	1.000 EA
180351-B		IDLER ROLL SHAFT	1.000 EA
180352		AMI #SER 205-16 FSX	1.000 EA