

FUNCTIONAL DESCRIPTION

CORE STRIPPER WITH SLITTER

The machine is designed for unrolling paper from cardboard cores.

The paper roll is placed on the infeed table. After start, the roll is fed down to the belt bed of the machine and after a short time delay the unrolling starts. When all paper has been stripped from the roll and the photocells in the outfeed opening of the machine no longer indicate any paper, the belts stop and the empty core is automatically fed out to the collecting table for cores.

MACHINE DATA

Max. roll diameter	Ø 406 mm
Min. roll diameter	Ø 100 mm
Max. roll width	2300 mm
Min. roll width	406 mm
Max. core outside diameter	Ø180 mm
Min. core outside diameter	Ø90 mm
Voltage	3x480V, 60 Hz
Control voltage contactor	24 V DC
Control voltage solenoid valve	24 V DC
Control voltage sensor	24 V DC
PLC I/O	24 V DC
Stripping speed	61-183 m/min

OPERATING MANUAL CORE STRIPPER WITH SLITTER

1. Loading machine with rolls.

Put rolls with remaining paper on the top hopper table.

NOTE! The rolls must be turned as shown on the general drawing.



2. Operating mode

Select operating mode with switch, "1 Set" or "Cont.".

In position 1 Set the machine will feed one roll into the unwinding area, strip the roll and discharge after the start button is depressed.

In position Cont. the machine will work the same as in 1 Set but after the core is discharged a new roll will be automatically fed into the unwinding area and the process will repeat until no more rolls are present on the hopper table.

3. Running procedure

With rolls on the hopper table, in operating mode Cont, and the start button is depressed the following procedure will take act:

- a) The flap will lower one roll into the unwinding area.
- b) The motor will start and paper will strip from the core.
- c) A line of photocells in series cover the outfeed of paper. As long as any of them are energized, the motor continues to run.
- d) When no more paper is detected the flap will return to its up position, the motor will stop and the core will be discharged.
- e) If operation mode selector is in Cont position a photocell will sense the discharged core and automatically start a new cycle. The cycle will continue as long as there are rolls on the hopper table.

4. No paper is detected!

The roll is turned the wrong way or tape is holding the paper together. The machine will automatically stop. The flap will remain down to prohibit discharge of the roll. Main power circuit breaker Q1 must be locked out before entering or cleaning the machine. After the operator has cleared the error, the machine can be started again according to section 5.

5. Power up, Power down and Emergency stop.

- a) At emergency stop or power down and emergency valve will empty the pneumatic system from air pressure. The motor will stop. The flap will stay in the position it had before the emergency stop or power down.
- b) If power down and rolls are on the hopper table, a roll will be fed into the unwinding area due to emptying of the air pressure in the pneumatic system.
- c) At reset of emergency stop the flap will stay in its position. If a roll is already in the unwinding area start without feeding of roll should be depressed. This will start the motor and the core will be stripped as in 1 Set mode. If no roll is in the unwinding area, the start button should be pressed and the machine will operate as normal. If the flap was going up before emergency stop, then reset the emergency stop and activate the push button “ flap up”.

6. Alarm

- A. If the alarm light is illuminated if a piece of paper is jammed under one or more photocells. Open up the roll, clean from paper. The led on the photocell will be illuminated if it is sensing paper.
 - B. If the alarm lamp “Reset/alarm” is illuminated has an alarm or emergency stop appeared.
7. When loading the first roll on the feeding table, the flap has to be in its upper position. The flap can be moved upwards with push button "Flap up".

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8. By turning on the potentiometer "Roll speed" you can raise or lower the stripping speed.



CAUTION

Lock the main switch with a padlock in zero-position, before any maintenance job or repair work is done.



CAUTION

The operator must not touch or straighten the paper roll or the paper web when the machine is operating.