MACHINE INSTALLATION

Catbridge machinery manufacturing slitter/rewinders are shipped to the customer with all internal wiring, hydraulic and pneumatic piping completely functional prior to leaving our facility. Machine location should be established to allow a minimum of four feet of clearance on all sides. This will facilitate operator loading and unloading of roll material as well as performing maintenance.

UNPACKING

Upon receipt, carefully remove the machine from its shipping crate or skid by removing all tie-downs, blocks and lag bolts. Pay particular attention to any braces that may have been utilized to secure movable sections of the machine during transit.

ELECTRICAL HOOK-UP

The electrical installer should become familiar with the overall electrical system and its related components/connections by referring to the appropriate schematics.

PNEUMATIC HOOK-UP

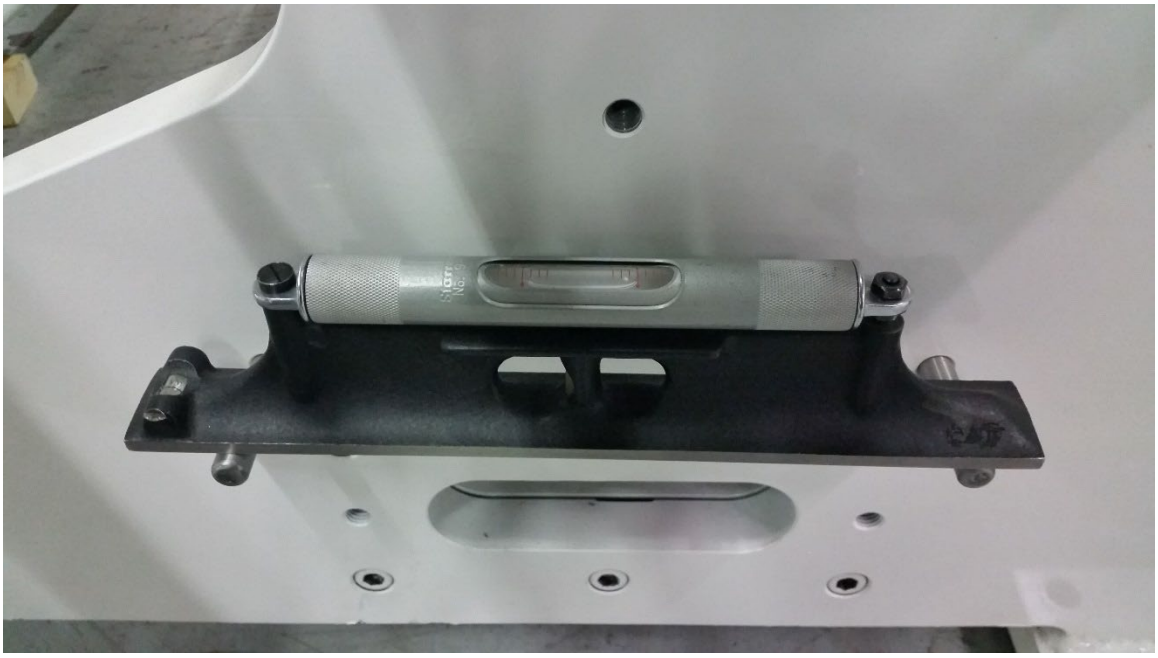
Plant air should be of instrument quality, with a minimum flow of 3 scfm. The air should be dry and maintained at a level of at least 80 psi. The main air supply line, copper tubing or pipe, should run from the plant air supply location to the vicinity of the pneumatic connection on the machine. The air hose running from the supply line to the machine should have a 3/8 inch i.d. connector. This connector couples to the air filter mounted on the side of the machine. Drain any accumulation of water on a daily basis. Refer to the pneumatic drawing that has been provided.

LEVELING AND SECURING MACHINE

Machine should be mounted on minimum 4inches (100mm) thick concrete floor. Some heavier machines may require thicker floor. Typically ½" x 5" long Wej-it anchor bolts are used for most installations. The length is dependent on the thickness of the floor. Some machines may require larger or smaller anchors.

The machine can be leveled by using a precision machinist level, such as a Starret number 97. Level within .002" per three foot of web width accuracy.
On machines with solid side frames.

1. Place the machinist level on side pins as shown in picture below. Adjust foot pads jack screws on each corner to of the machine until the machine is level front to back



2. Place the machinist level on a rear roll and on a front roll, using rolls that are at the furthest distance from one another. It is also preferable to use rolls that are resting in bearings that are bore mounted between the side frames. Pull rolls are good examples. Do not place the machinist level on brackets, load cells, rewind mandrels or spreader rolls.
3. Adjust the foot pad screws on each corner on the front and rear machine until machine lever side. Recheck leveling as per step 1.
4. Once machine is level from side to side and front to back, tighten jam nuts on each jack screw.
5. Follow the same procedure for all sections of the machine.

Machines with multiple sections must be positioned so that they are inline/parallel to each other within .002” per three foot of web width. Some of the rolls are fixed and some are adjustable. The fixed rolls are set by positioning and levelling the feet of each section. The adjustable rolls are then aligned.
Unwind stands equipped with the bag edge adjustment (skew roll) should be adjusted the same way as other machine sections. Neutral position of the skew roll should be determined after the complete unwind is aligned.
On the shaftless unwind stands; the same guidelines/procedure applies, with exception that the core chucks are used as points of reference.