Service Report 4058216

ELECTRO VOLT
SUSTAINABLE ENERGY

Electro Volt Technician	Jan Meyer
Functional Location Description	Ebersberg, Bayern
Code Word Equipment	US-2410011-01
Description Equipment Number	A3202847

Subject Service	Splicer Repairs 4058216
Order Customer	2410011
No. Operation	0020
No. Notification	000300113570
No. Type	Field Service
Period	25.02.2023 - 01.03.2023

Description of the problem / maintenance / inspection

Customer is experiencing splicing difficulties on both SP XSplicers

Reason and solution of the problem / accomplished work

25 February 2023
Travel to Ebersberg, Germany.

26 February 2021
Observation of splicers in production.
Both the liner and medium splicers exhbited dificulty in obtaining proper attachment of the new to the old running paper.
The severity of the non contact area (Pressure roll to splice roll / attachment of the paper to the double faced tape varied in severity form one side to the other.
The majority of the missed splices / broken apart / torn splices were generated when running the left side and splicing into the right side on both splicers.
Customer is using a thicker splicing tape than normal to compensate / obtain adequate splicing.
Customer to run the machine through the night / production to be concluded on Saturday morning.
Initially I was told the machine would be run until 0800.
At the point I left the plant on Friday I was told the machine was scheduled to run till 1000 hours.

27 February 2021
Inspection of the medium and liner splicer.

28 February 2021
Inspection of the medium and liner splicer.

01 March 2021
Travel to Munich, Germany.

Checks performed:

1. Check splice roll / pressure roll engagement with splice tape three places across web OK
2. Check splice roll for crown wear / tir , check pressure roll for TIR
   Splice Roll Crown Tolerance 1 mm TIR Tolerance 0.05 mm
   Op Side Center Dr Side 0.0397 Op Side Center Dr Side 0.0019
3. Check knife sharpness / cover clearance OK
4. Check knife center cut / check slots in clamping carriage for cleanliness OK
5. Check clamp carriage top rubber plate Liner new / Medium slightly worn
6. Check clamp carriage Teflon tape OK
7. Check brake bar clamp three places across web OK
   All four brake pad assemblies had SHCS / bolts should be reduced height Cheeseheads / replaced with stainless BHCS
   All four pads were hitting only one leading edge of the brake pad. Medium pads exchanged / all four adjusted for proper engagement.
8. Check pressure roll pivots / some noticeable clearance in all four pivots
   Liner left side / operator side had the most noticeable clearance.
9. Check pressure roll proximity switch for operation / adjustment OK
10. Check pressure roll pneumatic cylinders OK
11. Check brake bar pneumatic cylinders
    Five of the eight cylinders have noticeable power loss (Able to compress the cylinder under pressure)
    (The liner splicer operator side cylinders / medium side operator side right side were acceptable condition)
12. Check E to P transducer release (Less than 2 secs) OK
13. Brake balance check on the reel stand brake assemblies OK
14. Check for air leaks in the splicer cabinets.

* Numerous 8 mm T fittings leaking / no replacements available.

15. Check knife pneumatic cylinders for blowby OK

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Operation successful No

Signature Supervisor	**Signature Technician**
	

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