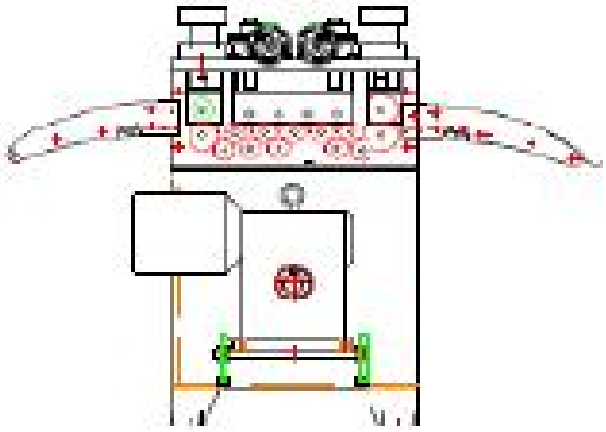
SKI

FEEDERS & ACCESSORIES

STRAIGHTENER

OPERATION –INSTRUCTIONS



SKI Straightener

SKI AUOTMATION PVT LTD

SKI ENGINEERS

NEW DELHI, INDIA

www.skifeeder.com

www.servofeeder.in

Compliment

First of all, thanks for kindly choosing this SKI product as peripheral equipment for press machine. We hope that this machine will bring great contribution for your production.

SKI is a professional manufacturer of press machine peripheral equipment. With strong technical strength, excellent technical equipments, strict test instruments and perfect quality management system, we will make sure that our products meet your need.

Our products are tested and inspected strictly before sending out our company. But in order to make sure safety, safe running and durable usage, so before you use this machine ,please must read this operation manual, we will inform you that all kinds of features, installing, operations ,running, maintaining and so on

If you have any questions about this operation manual, please contact our company directly, we are glad to serve for you.

SKI Automation Pvt Ltd

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Technical Specification

Item	: Combination Decoiler with Straightener
Model	: Right to Left
Max. Strip Width	: 300 mm
Roller Dia Ø	: Ø60 mm
Material Thickness	: 0.5~2.0 mm
Feeding Speed	: Fix without VFD
Release method	: Manual Screw Type
Electrical Controls	: 440 V AC, 3 Phase
Motor & Gearbox	: 3 HP, 3 inch

INSTALLATION

The Straightener that you just received is fully assembled and tested and ready to be put into Position.

CAUTION: Due to shipment vibration, the Straightener should be checked to be sure that all screws and bolts are secure and all electrical components are in place inside the cabinet. Visually inspect the complete machine for physical damage due to shipment and handling. If the straightener was damaged in shipment, contact the carrier first and then SKI .

Install the straightener on a level surface with sufficient clearance for loading the material and adjusting the roller pressure for straightening. Align and center the Straightener to the device that it will be supplying the straightened stock. The straightener should then be bolted to the floor especially when used to pull stock from a non-powered reel.

CAUTION*:* Before bolting the straightener down, check for the longest feed length to be run. The straightener should be set so that there will be about 3 times feed lengths in storage in the loop.

Please check your local safety codes.
The medium and high speed straighteners require 440 VAC, 3 PH as the supply voltage.

MAIN CONSOLE AND CONTROLLER

The main control console with controls is mounted on the cabinet of the Straightener. Located on the face of the console are five switches,
One potentiometer (speed variable optional)
One Push-Button for Jog/Inch
One Reverse/ Forward Rotary Switch,
One Auto /Manual Selector Switch
One Mail Light/Phase Indicators

. ON/OFF SWITCH

This illuminated switch is the main power switch for the controller. On the 440 VAC straighteners, it will be a toggle switch and on the 230 VAC version it will be a mushroom Push-button, It must be "ON" for the straightener to function.

. SELECTOR SWITCH

This switch will be used to select direction of the straightener

. SPEED POTENTIOMETER (Optional)

The speed potentiometer adjusts the maximum speed that the straightener rolls can rotate regardless of the dancer arm height. It should be set to maintain a constant material feed rate through the straightener.

LOOP ARM / EXTERNAL SWITCH

This switch is used to select whether the material loop is controlled by the dancer arm or an external loop control.

ENTRANCE & EXIT GUIDE ROLL BLOCK

All Straightener are shipped with an entrance guide roll. This contains a roller and two adjustable edge guides.

ADDITIONAL STRAIGHTENER COMPONENTS

ENTRANCE CASCADE ROLL

The entrance cascade roll assembly is used to maintain a support arc for stock entering a feed. The cascade roll has three extra rollers to help the material flow better.

EXIT CASCADE ROLL

The Straightener is shipped with the exit side pre-drilled for the cascade roll or guide roll block. The entrance and exit use the same components**.**

OPERATION

Once the Straightener has been tested and all the functions work then it should be tested for what it was designed to do and that is to remove coil set.

Retract all of the idler rolls and the exit pinch roll to a position so when the cover is closed the material is not being deformed.

Open the cover of the Straightener and position the edge guides for maximum width.

Cut and place about a four foot length of the material onto the Straightener rolls with the exit end of the material

Adjust the exit pinch roll enough to grip and hold the material.

Adjust the edge guides so that they just touch the material.

Adjust the first idler roll knob, so that it roller touches the material- not more than the thickness of the material. (Please refer to the scale)

Adjust the second idler roll knob so it is lightly on the roll. on the material, readjust if necessary (Please refer to the scale)

This piece will still have coil set in the first two feet of the material as it was not run through the Complete straightening cycle.

Use reference scale on the side plates of the straightening rollers.

A good check is to guide the exiting material, keeping it parallel to the rolls, until the run is complete and then hold one end of the material in the air while peering down the length of the material. If the material still has “coil set” then readjust roll pressure on the last roll, towards the exit end but before the pinch roll, until the material is straight. Run one or more short length setups while making final adjustments. Once the proper setting has been determined, the quick release top maintains the adjustment during loading.

Set the speed potentiometer to 50% for a starting position and start the pulling device to have the material feeding. If the Straightener gets finished and stops before material is needed again then the Straightener is set to feed too fast, slow it down by adjusting the % speed potentiometer. The ideal straightening is to have the Straightener slightly exceed the feed rate required. This minimizes the starting and stopping and resultant stock deformation.

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LUBRICATION

Gear transmission:

The Gear Box oil capacity is about 2~3 lts. The Gear Box oil should be changed /fill every six months and should be filled the oil level site gauge. Use HP 90W oil or equivalent.

Rolls:

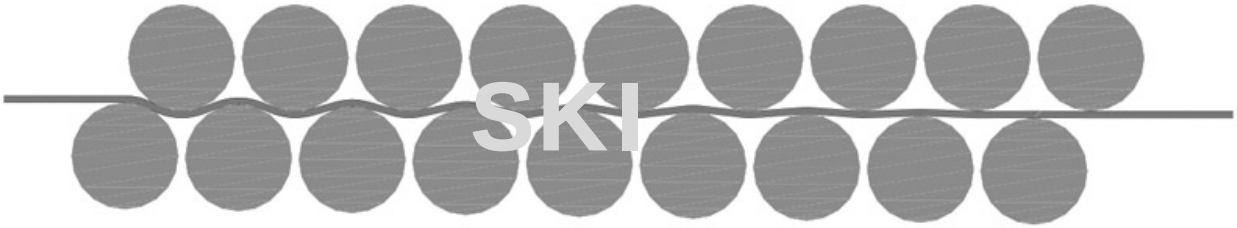
The rolls should be cleaned periodically
The gear train has to be greased & oiled.
All the rolls have bearings on each side with grease nipples
Grease them monthly.

Bearing Used: NK 30/30 (Make –)
NK 30/20
BeF-208
Thrust Bearing -51208
Linier Bearing-35*52*70

Drive Chain/Belt:

At the grease/oil change interval, check for chain/belt tension and wear.

Metal Strip Working Through Rollers



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