



EXTRUSION



COATING



PELLETIZING



WINDING



SERVICE/SPARE PARTS
/INSTALLATION



RESEARCH AND
TECH CENTER



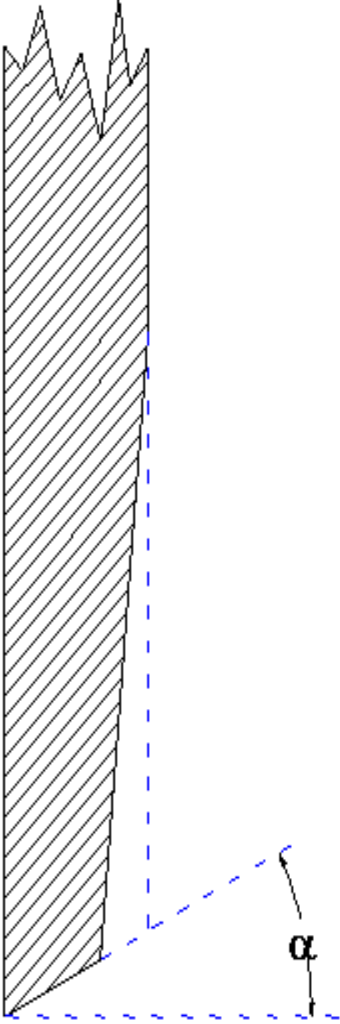
DRIVES AND
CONTROLS

FOR SLITTERS

1. **Grind Primary Bevel** of top Slitter Knives to the attached chart.
2. **Reduce** the amount of **web deflection** by adding a 15° degree off vertical secondary bevel starting after .04" horizontally from tip of primary bevel.
3. Have top slitter knives **honed** to 8 RMS. Minimum surface finish to be 12 RMS.
4. Check blades for small nicks with a Q-Tip around sharp edge.
5. **Inspect** both top slitters and bottom bands to insure **axial** run out is within .003" total and bottom bands for .006" total **radial** run out after grinding.
6. Knives should be **dipped in plastic** to protect the edges from damage and for handling safety.
7. **Always** thoroughly **clean** mounting surfaces when mounting slitter knives.
8. After installing, **check** both top slitters and bottom bands to insure **axial** run out is within .004" total and bottom bands for .008" total **radial** run out.
9. Check blades for small nicks with a Q-Tip around sharp edge.
10. Set proper penetration of top knife = .03" plus web thickness. Use **overlap template** to insure consistent top slitter overlap to bottom knife.
11. When slitter jump occurs, **always inspect bottom** knife for damage, and change out the top slitter.
12. Set side load force according to below:
 - Nonwovens 5-10 pounds
 - Plastic Films 5-10 pounds
 - Fine Paper 5-10 pounds
 - Light Board 8-12 pounds
 - Heavy Board 10-15 pounds

13. Once top slitters are mounted, engage knives and rotate opposite direction of web path 10-15 times to ensure proper blade seating.

**- Cutting Edge Geometry –
top knife**

CUTTING BEVEL	ANGLE OF BEVEL " α "	APPLICATION AREAS
	0 – 10°	Metals, laminates, plastic materials, low edge distortion
	30°	Paper, foils, laminates, fleece, cardboard
	45°	Nonwovens
	60°	Special cases, film industry, sensitive cutting edges