

# HCI

## FSL-V1300

DELUXE SLITTER / REWINDERS

OPERATING MANUAL

華周工業股份有限公司

HCI CONVERTING EQUIPMENT CO., LTD

NO.26,7<sup>TH</sup> ROAD, TAICHUNG INDUSTRIAL PARK, TAICHUNG, TAIWAN  
P.O.BOX 46-9 TAICHUNG, TAIWAN



## PREFACE :

THIS OPERATING MANUAL IS SO DESIGNED TO SIMPLIFY THE OPERATION SMOOTHNESS. IF THERE HAPPENS TO HAVE ANY MISUSED WORDS OR INSUFFICIENT DATA, PLEASE DO NOT HESITATE TO INFORM US. WE FORWARD OUR APPRECIATION FOR ANY INPUT SUGGESTION AND WILL TAKE CARE OF IT AS SOON AS POSSIBLE. ANY INCOMPLETE DATA FORWARDED TO US WILL BE SETTLED TO A SATISFACTION DEGREE BY OUR PARTIES ( ONLY TO OUR ACHIEVABLE RANGE OF GETTING THE DATA REQUIRED BY OUR ENGINEERS ) .

THANK YOU FOR YOUR KIND ATTENTION !

HCI CONVERTING EQUIPMENT CO. LTD  
26,7<sup>TH</sup> RD. TAICHUNG INDUSTRIAL PARK  
TAICHUNG, TAIWAN.

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## OPERATIONAL PROCEDURES FLOW CHART

1. Work Order
2. Preliminary Set Up
  - 2-1. Load material onto product (unwind) shaft.
  - 2-2. Calibrate the EPC or LPC unit.
  - 2-3. Adjust cutter unit.
  - 2-4. Guide material through rollers to the product (rewind) shaft.
  - 2-5. Turn power on.
  - 2-6. Slowly let the machine roll out 2m worth of material.
  - 2-7. Load both top and bottom product (rewind) reels with the cut material.
3. Manual Shaft  
Tension Adjustments Determine the tension needed on all shafts using the width and material and the amount of material on the reel. Also use previous records and experience.
4. Counter Set Up
  - 4-1. Set total length wanted (in meters)
  - 4-2. Set the length when you want production to slow down.
5. Production Speed Adjust working speed to desired.
6. Production Checks
  - 6-1. Check that the working speed is correct in the indicator.
  - 6-2. Check rewind tension.
  - 6-3. Check unwind tension.
7. Eliminate any errors.
8. PRODUCTION
9. Production speed will decelerate once slowdown length is reached.
10. Production will come to a complete halt once total length has been achieved.
11. Record pertinent information.
12. Remove finished product. Begin again.

NOTE : Be very careful when machine is in operation. The moving parts are Very dangerous. Unnecessary sudden stops while the machine is in Operation may be detrimental to the machine.

## IMPORTANT POINTS

1. Material **【Unwind】** Shaft – Brakes  
The brakes use between DC 0 – 24V. Actual power depends on the width, thickness, and actual material being used. Keep a record of settings used in order to obtain maximum brake efficiency.
2. Product **【Rewind】** Shaft  
There are two main forms of adjustment
  - A. Clutch
    - A-1. The clutch uses a power source of DC 0 – 24V. Again, the actual setting depends on the width, thickness, and actual material being used.
    - A-2. Torsion generated by the clutch must equal or be more than the frictional force between the bakelite grips and the product **【rewind】** shaft. If not, unnecessary wear and tear will occur on the grips.
  - B. Bakelite Grip Tension
    - B-1. The frictional force between the grip and the shaft may be adjusted using the nut-spring apparatus located on the end of the shaft of air cylinder. (Near the release handle.)
    - B-2. Each individual bakelite grip is free to rotate along its own axis. Multiple product **【rewind】** reels may be attached to the shaft. Any variation in thickness or tension across the material will make no difference; the individual grips will correct this.
    - B-3. Under optimal frictional conditions the grips will tend to slip a little bit. If there is too much friction the grips will wear away, if not enough, too much slippage will occur and the shaft will be over heating.
3. Use of Cutting Assemblies  
Different blades are best suited for different materials.  
Fixed blades  
Best for paper and thin plastic films.

4. Wrinkles

Wrinkles occur when there is an uneven distribution of tension across the width of the material. There are three types of wrinkle conditions:

A. Stationary wrinkles

A-1. Material may not be flat enough. Use the brake control to flatten the material out.

A-2. If the brake does not help, the front fixed rollers may need to be replaced with an adjustable roller assembly.

B. Wrinkles that move to the left.

B-1. Not enough tension on left end. Turn the regulating handle counter-clockwise until wrinkles a

C. Wrinkles that move to the right.

Cause and remedy for each case:

Not enough tension on right end. Turn the regulating handle clockwise until wrinkles are smoothed out.

5. Optional Accessories

For a detailed discussion or any optional accessories you may have ordered, please refer to their own operation manuals.

6. Area, Payment and methods of after-sale service:

Machinery or accessories produced/sale by HCI Converting Equipment Co, Ltd Will be responsible by us fully for its after-sale service.

A. METHOD OF SERVICE:

A-1. Responses made by fax, via telephone or telex.

A-2. Repaired or explanation held at your company.

A-3. Spare-Parts sent by mail, and to be replaced by your parties.

A-4. Spare-Parts maintenance sent by your parties.

A-5. Repairment/maintenance of your machinery at our factory.

B. Area of service:

B-1. Pre-sale suggestion with necessary planning.

B-2. Pre-sale explanation of machinery characteristics.

B-3. After-sale of machinery maintenance guidance.

B-4. After-sale service and maintenance.

C. Responsibility area:

C-1. Our factory is only responsible for the usage conditions as stated on the contract agreement for the machinery structure.

Problem arises due to alteration of structure made at will by clients is not the responsibility of our company.

C-2.Operation techniques:

Receiving payment of operation techniques:

Our factory will provide every necessary numerically based production in reality as the movement of slitting, rewinding, laminating, cutting and etc.

Not receiving payment of operating techniques:

Our company will to the best of our knowledge inform our clients the operation techniques of the related machinery. Please be informed that the inadequate informations Is due to our company features as the manufacturer.

Our company will not take any responsibility of the structure or any spare-parts damaged due to incorrect operating techniques.

C-3.Products produced by the machinery:

The specification characteristics of the products must be responsible by the clients fully.

Our company will not by responsible for the products produced by the machine.

D. Payment:

D-1.Free provisions of the necessary spare-parts by our company due to malfunctions of the control systems and spare-parts of the machinery ( Calamity or human cause in exception ) within one Year as of the date the machine out of factory.

\* However, Our company has the right to demand our clients to pay the amounted sum in advance and will be refunded after the cause of malfunctions is being approved by us.

D-2.The payment term on the maintenance and repairment of techniques cause and operation guidance are as follows ( with condition considered ) :

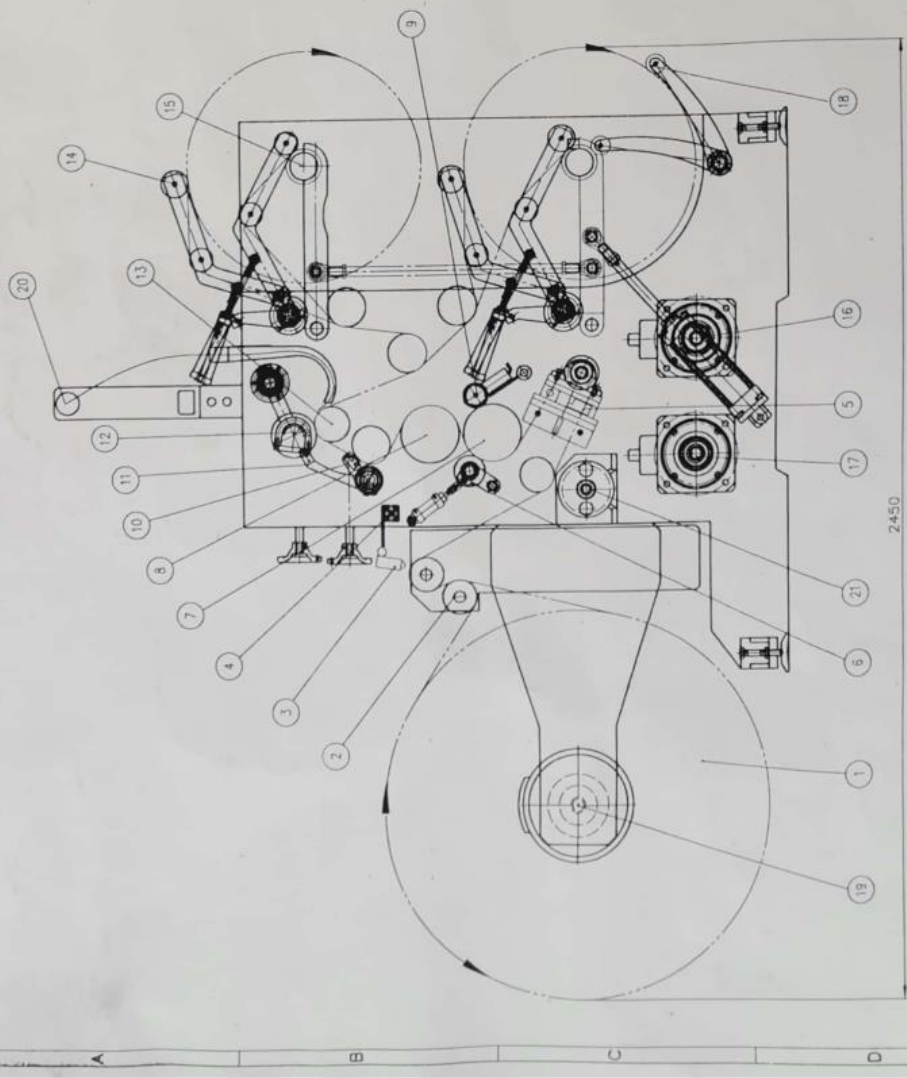
2-1.Reture transportation, Lodging and Mealing.

2-2.Wages:US\$200/Day/Person.

D-3.The main consideration to suggfst clients to purchase wasily broken spare-parts is to minimize loss due to time used in mailing and stop producing, free parts that are easily broken due to unqual, if ication will be replaced within one year as of date goods out of factory.

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1. 原料1000 (UNWIND 1000)
2. 調整輥 (ALUMINUM ROLLER)
3. 感線修正控制 (LINE POSITION CONTROL)
4. 鉛軌 (ALUMINUM TRACK)
5. 張力輸出器 (TENSION CONTROLLER)
6. 膠輥 (RUBBER SQUEEZER ROLLER)
7. 主動輥 (MAIN ACTIVE ROLLER)
8. 主動輥 (ACTIVE ROLLER)
9. 計米器 (MEASURE SENSOR)
10. 平刀 (FLATE KNIFE)
11. 薄輪平刀 (RABBIT ROLLER)
12. Ø118 上刀 (UPPER KNIFE)
13. Ø92 下刀 (LOWER KNIFE)
14. 壓輪 (SQUEEZER ROLLER)
15. 成品 Ø600 (REWIND Ø600)
16. 捲取馬達 (REWIND MOTOR)
17. 主動馬達 (MAIN MOTOR)
18. 直徑輸出器 (DIAMETER SENSOR)
19. 煞車 (BRAKE)
20. 風管 (PIPE)
21. 擴張式展開輥 (EXPENDING ROLLER)



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註: 以下為特殊選用配件  
11. 薄輪平刀  
21. 擴張式展開輥

REMARKS: OPTIONAL ACCESSORIES  
(11). RAZOR GROOVE CUTTING SYSTEM.  
(21). EXPENDING ROLLER.

零件名稱		圖號	比例	1:10	HCL	
零件名稱	圖號	材料	數量	備註	備註	備註
原料	1000	FSL-V1300(特)				
調整輥	2					
感線修正控制	3					
鉛軌	4					
張力輸出器	5					
膠輥	6					
主動輥	7					
主動輥	8					
計米器	9					
平刀	10					
薄輪平刀	11					
Ø118 上刀	12					
Ø92 下刀	13					
壓輪	14					
成品 Ø600	15					
捲取馬達	16					
主動馬達	17					
直徑輸出器	18					
煞車	19					
風管	20					
擴張式展開輥	21					

取件請洽:

工廠: 青島

青島

