

Semi-automatic Aluminum Foil Rewinder

Operation Manual

Warning:

1. This machine should be in good ground conditions, otherwise it will be possible for the safety of personnel and equipment damage;
2. Non-professionals, do not open the electronic control box, or conduct other operations. The maintenance will be performed by qualified personnel;

Note:

The machine uses 380v/50Hz 3 phase 4-wire power supply (or customized voltage).

Model and specifications:

1. Model FQ-450B
2. Specifications:
 - Rewinding width: 500mm
 - Parent roll diameter: 500mm Max.
 - Finish roll diameter: 120mm Max.
 - Line speed: 0 – 350m/minute
 - Unwinding core diameter: 76mm/152mm optional
 - Unwinding roll diameter: 600mm Max.
 - Rewinding core diameter: 1 – 3” optional
 - Motor power: Rewinding 3HP, Flip: 1/3 HP, Correction: 1/2HP
 - Air source: 0.4 – 0.6 Mpa

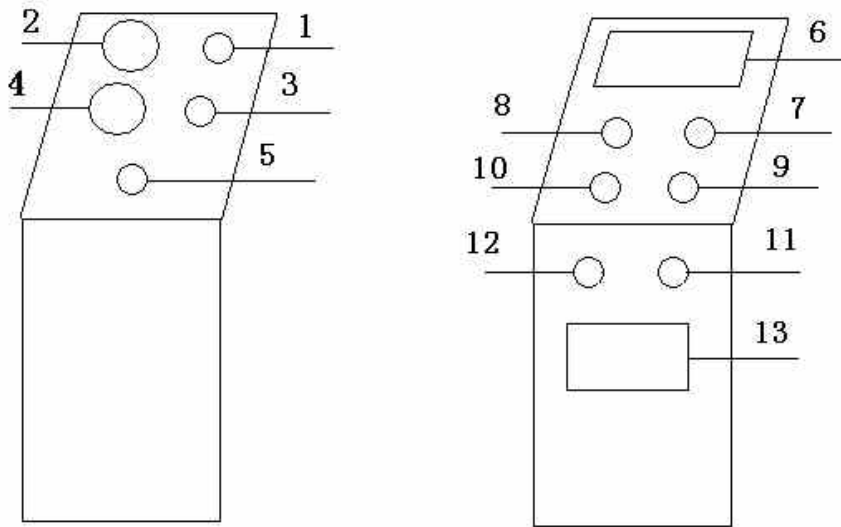
Before use:

1. Check the packing list. Parts and accessories are complete, whether the machine is damaged in transit (such as incomplete or damaged, please immediately contact the shipper to negotiate or to the transport sector).
2. Check the machine meets the requirement of your order. Read the instruction for installation and commissioning.
3. The machine on a flat surface, adjust the foot to keep the machine level (Figure 1).
4. Check the other coupling parts and electrical wiring, timely tightening loose or fall off parts and wires. Connect the power supply to the machine's power supply terminals. The machine is equipped with the wrong phase-phase protection relays. Please note the correct phase sequence.

(Figure 1)



Operation Panel



A: Rewinding regulator

1. Control rewinding cylinder driving pressure
Uprooted and rotating knob clockwise to increase pressure, counterclockwise decrease. After adjustment, knob should be pressed. (suggest 0.0Mpa)
2. Barometer

B: Cutter regulator

3. Control cutter cylinder driving pressure
Uprooted and rotating knob clockwise to increase pressure, counterclockwise decrease. After adjustment, knob should be pressed. (suggest 0.2Mpa)
4. Barometer

C: Roller pressure hand valve

5. Control pressure roller lift and down.

D: Tough screen

6. The fourth section details

E:

7. Stop
8. Start
9. Emergency stop
10. Speed regulating knob
11. Power switch
12. Unwinding tension in stop condition adjusting knob

13. Touch screen interface description

Turn on the power switch, interface display page.

1. **The first page:** home page, introduces the equipment and manufacturer information. Select the displaying language.



2. Work instruction interface



“Length set”: 0 – 1000m. To set how many meters of foil to be wound in finish roll.

“Brake length”: 0 – 1000m. To set how many meters of foil before “length set” meters when machine starts to decrease speed till stop.

“Length clear”: it can clear all the length of foil rewound by this machine.

“Rolls clear”: it can clear all the production quantity produced by this machine.

With this function, you can calculate the daily output in this machine.

3. Manual operating page



“Winder”: switch to control the winding shaft touching or leaving the central roller.

“Winder exchange”: switch to control the two shafts exchanging manually. One click makes the shafts exchange one time.

“Cutter”: switch to control the cutting blade manually. One click makes the cutting blade cuts one time.

“Continuous”: switch to select machine auto/semi-automatic working mode. Auto mode means the machine exchanges shafts and starts to wind next roll automatically when one small roll finishes. Semi-automatic mode means when one small roll winding finishes, users need to press the “start” button to exchange shafts and continue to wind the next small roll.

(**Note**: it is suggested that the user start to use the “continuous” mode when they become skilled in loading the paper cores.)

“Motor dotting” switch to control the winding motor manually. When press this switch, the winding motor runs. When finger leaves the switch, the winding motor stops.

“Winder open” switch to turn on or turn off the winding motor.

“Cutting blade” switch to turn on or turn off the cutting blade.

“Circle length” the circle length of the meter counter roller. No need to change.

“Fixed data”: A PLC calculating ratio. No need to change.

“Tension exchange”: Tension recover delay time after each small roll

winding finish. No need to change

“Exchange time”: shaft exchange delay time after each small roll winding finish.

“Rotary time”: winding shaft work delay time after each small roll winding finish.

“Cutting time”: cutting blade work delay time after each small roll winding finish.

4. Monitor Page:



This figure can supervise the every working status of the machine. The green color means the “working status”. If there is any problem, you can find it in this page.

Tension adjusting:



1. Turning the knob to adjust the unwinding tension in working condition.
2. When need to adjust the unwinding tension when unwinding shaft in stop condition, press down the emergency stop switch and turn knob 12 (in figure 1)

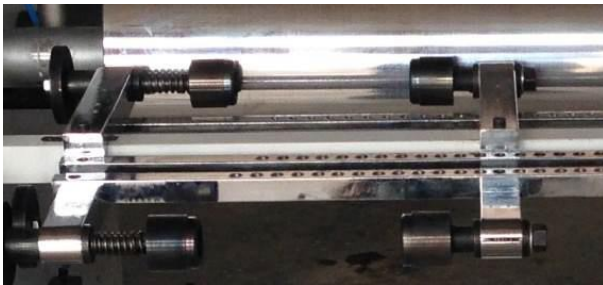
Trouble shooting:

If the foil has wrinkles, please check the place from where the wrinkle starts to occur:

- a) If it occurs after unwinding and before rewinding, please reduce the tension.
- b) If it occurs from the roller, adjust the place in below:



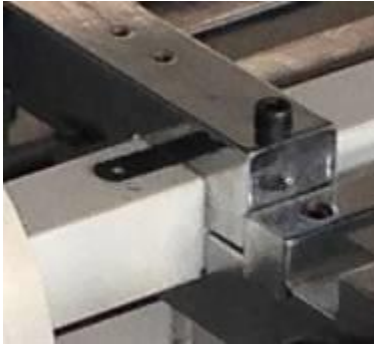
- c) If it is from the robber roller, adjust the air pressure of rubber roller. Reduce the pressure to 0.00Mpa.
- d) If it is from the winder, adjust the winding shaft



d-1: The two (left side and right side) clamping head should touch the steel roller at the same time. If it is different, adjust the place (insert a paper or a thin blade)



d-2: The two (left side, right side) clamping head should keep in same level. If it is in different level, adjust the head of shaft (insert a paper or a thin steel)



If the edge of finished roll does not go uniformly when it is rewound, adjust the place as below:



Loose the screw and move the steel to front or back.

Care Instructions

1. Regularly check the machine to avoid possible and potential problems

Daily maintenance as following:

- Don't let the oil leak from the conversion device
- Don't over operating belt, always check the tightness
- The belt cannot wear

2. Water must be discharged from oil-water separator

2.1.(A) unscrew the plug

2.2.(C) unscrew round of valve to discharge the water

2.3.Upwardly until the water is discharged

3. Clean the filter

3.1.(B) unscrew the container

3.2.Using air compressor to clean oil water separator, clean with gasoline if necessary

3.3.Motor and bearings must be checked and lubricated regularly (6 months), replace it if necessary.

