



005 Tin plates are out of square!

Possible cause:

=> Check also FAQ – Canmaking - 002. “blank tolerances”

To check before the 1. cutting operation:

- Check the squareness of a couple sheets:
  - From corner to opposite corner, and other corner distance also
    - => Compare both measures: The difference must be < 1 mm!
- Make sure that the lateral position of the sheet stack is correct:
  - Correct the stack position by the handle, until the sheet has no lateral movement till the final position before 1. Cutting operation!
- Stop 1 sheet before the 1. Operation - with centering rollers closed – and check the pressure on the spring roller:
  - => Too much load on the spring can damage the sheet!
- Regulate the position of the entire centering system by the hand wheel, till both trim measure the same width!
- Check the parallelism of each trim: Bend the trim, and compare both width and compare them.
  - => If the trims are not parallel, it is needed to adjust the alignment of the sheet by resetting both centering wheels on the left side!
- The speed of the first cutter shaft must be a bit less compared with to the speed of the driven rubber rollers.
  - => E.g.: 1.operation speed 59 m/min and rubber shaft speed 60m/min.
  - => How to reset the rubber shaft correctly read FAQ – CM33.004
- Check the pressure of the rubber wheels mounted on the top of acceleration belts before 2. Cutting operation:
  - The two rubber wheels must be set to the right position and have sufficient pressure.
- Stripe movement from final position under the rubber rollers into the 2. Cutting operation has to be straight:
  - => The final position of the stripes - after they passed the rubber rollers –, can be changed by moving the center support with the sensors B253 and B254. If you move the support forward, the stripes will stop also later.
  - => Stripes should not move more than 1 mm laterally, when being clamped by the centering system!
  - Make sure the rollers are dry and not oily!
- Correct setting of the centering rollers before the 2.operation:
  - When the stripe is clamped between both rollers, the tensioned roller must be about 3 mm pre-loaded, not more!

