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Splicer defects and cures

Scope

Ever-increasing productivity and waste reduction demands on the corrugator are prompting converters to place more requirements on their equipment. Also, their crews are increasingly required to not only operate equipment, but to trouble-shoot as well.

The splicer has been designed to permit a change in roll stock width or grade without having to slow down to idle running speeds. During normal operation of the splicer, the paper unwinding from a roll stand passes up and through the splicer and into the single facer or glue machine. The paper passes through a splicer head and idler rolls, and around either a set of dancer rolls or through a driven carriage assembly. The dancer rolls (stationary type splicer) and the driven carriage assembly (driven type splicer) provide the method by which the paper from the newly spliced-in roll is permitted to run and accelerate up to the corrugator's running speed without having to stop or slow down the corrugator.

Safety precautions

Insure power and air is off when working on the splicer. Use knife with caution when preparing liner/medium for splicing.

Purpose

This Technical Information Paper provides a simplified, easy-to-use trouble-shooting chart. The most important step is the initial identification of the problem. Through the process of elimination, the problem can be properly identified and then corrected.

Every minute of down time saved increases productivity and helps to maintain unit costs.

Content

<i>Observation</i>	<i>Cause</i>	<i>Corrective Action</i>
Paper wrinkles/tension warp	Worn brake shoes	Make necessary brake adjustment or repair.
	Slipping brakes	
	Web tension	
	Elephant-skin paper with significant caliper variations	Web tension is too high. Trim off the outer layers to eliminate bad paper.
	Festoon roll misalignment	Align all festoon rolls and the carriage assembly.
	Carriage misalignment	Parallel the roll stand chuck arms.
Web slack on one side	Roll stand	Align preheater and preheater's wrap/fixed idler rolls.
	Preheater/preheater idler rolls	Level and align if necessary.
Missed splices	Roll stand	Check the roll stand arms for proper level and alignment to the splicer.
	Paper roll	
	Paper preparation	Check that the roll of paper is wound evenly and not telescoped. Check for correct paper preparation. Adjust for uneven tension across prepared web. When preparing and out-of-round roll, a tight edge may be seen even though the splice preparation has been done correctly. Pull up the loose edge by approximately 1/8 in. (6 mm) and hold in place. Prepare paper for splicing.
	Failure to remove damaged outer layers on edge tears	Trim off any damaged outer roll layers. Trim out all edge tears, nicks using moon-shaped cuts as trained.
	Failure to remove a tight edge	See above procedure for slack web removal. Shift the paper in the head to align the web to the paper roll. Pull the web tight and press the clamp button to activate the paper stop bar. The web is now securely anchored and properly aligned to the preparation bar.
	Improper paper slack on the new roll	Each manufacturer will recommend how much slack (if any) can be left in the new roll before the splicer is actuated. Either too little or too much slack will reduce the chances of a successful splice.
		Brake not set properly during paper preparation - set as directed in splice preparation procedure.