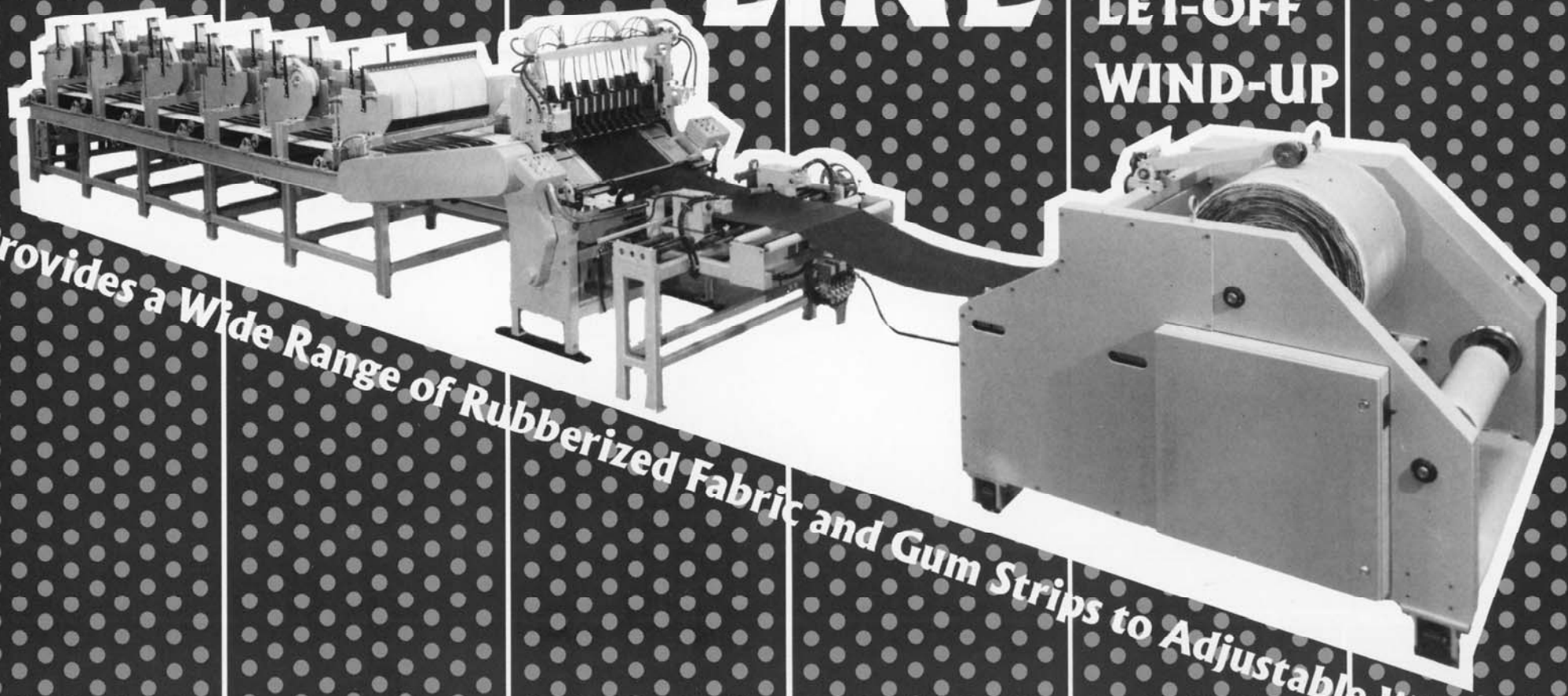


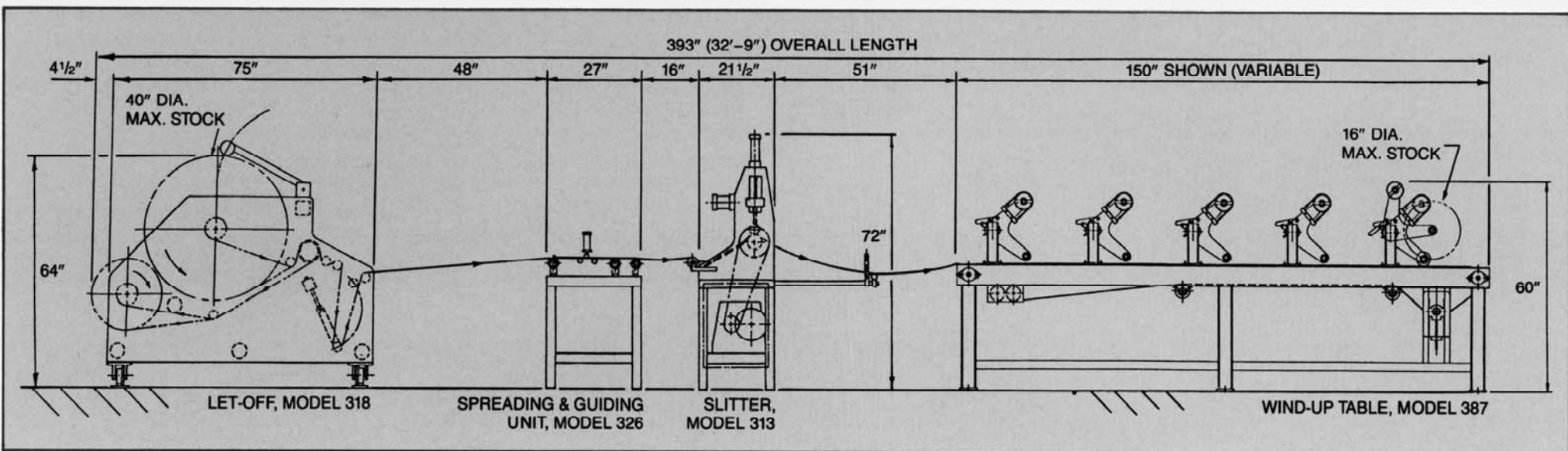


SLITTING LINE

SLITTER
LET-OFF
WIND-UP



Provides a Wide Range of Rubberized Fabric and Gum Strips to Adjustable Widths



SLITTER LINE, FIGURE 1

DESCRIPTION

The Model 313 Slitter, in Figure 1, is a compression-type slitting machine employing rotary slitting knives bearing against a hardened steel anvil roller.

The slitter is intended to cut calendered fabric, for the production of chafer strips and the like, or calendered gum, for the production of gum strips.

Available in three width sizes to accommodate maximum stock widths of 36" (914 mm), 48" (1219 mm) or 60" (1524 mm), the slitter is provided with an adjustable knife crossbar, slitting knife assemblies, hardened anvil roller, adjustable stock guides, 5 horsepower motor mechanical drive, pneumatic and electrical accessories. Slitter speed is approximately 106 feet (32 M) per minute.

OPERATION

Slitter knives bear against a 6 1/4" (159 mm) diameter anvil roller, which is chain-driven by a gear reducer.

The knife crossbar pneumatically raises and lowers the knife assembly 4 1/2" (114 mm) to allow loading of fabric or gum. Two lock cylinders engage the crossbar in the down (cut) position to hold the knives against the anvil roller.

H.D. KNIVES (Standard)

Twelve (12) sets of heavy duty (H.D.) knife assemblies are supplied as standard. Each knife is pneumatically loaded for cutting. Minimum knife spacing is 1" (25.4mm) wide and maximum cutting force at each knife is 250 lbs. (114 kg) at 60 psi (4 bar). The knives are hardened steel. Additional assemblies may be ordered as needed.

L.D. KNIVES (Optional)

Light duty (L.D.) knife assemblies may be ordered in addition to or in lieu of the H.D. standard knives. These are pneumatically-loaded knife holders which allow a minimum knife spacing of 1/2" (12.7 mm) and a maximum cutting force at each knife of 60 lbs. (27 kg) when operated at a pressure of 60 psi (4 bar). This option requires the use of a dovetail support bar, which is ordered at the time the L.D. knife holders are ordered. While the slitter may use either the H.D. or L.D. knife holders, both cannot be used simultaneously.

RAPID CHANGE FEATURES

Rotary knife blades on the H.D. assembly can be replaced on the machine in less than one minute, without tools. Both H.D. and L.D. knife assemblies can be added, removed or relocated quickly and easily. Hardened sleeves, which comprise the wear surface of the anvil roller, can be replaced without removing the roller from the slitter.

PNEUMATICS

Knife cutting force is supplied by pneumatic pressure. Standard supply is with all knives receiving uniform pressure from a single adjustable source.

Optional supply is with each knife receiving pressure from its own adjustable source.

ACCESSORIES

Below are descriptions of standard RJS products that can be selected as accessories in a complete slitter line. A typical slitter line layout is shown in Figure 1.

1. Make-up Table, Model 327

This table is available in a choice of three sizes for 36" (914 mm), 48" (1219 mm) or 60" (1524 mm) wide stock; specify maximum stock width when ordering. It employs a conveyor belt upon which cut panels of fabric are spliced. Included at the outlet end is a rubber-covered pinch-roller for stitching the splices.

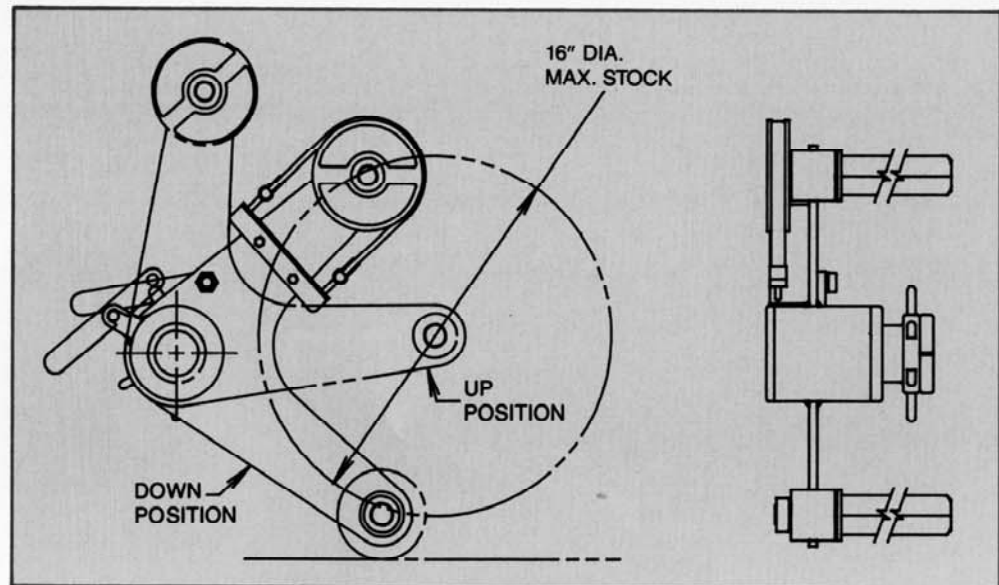
If the table is used to feed directly into the slitter, the table is driven by the slitter by use of an adjustable Vee-belt drive.

If the table is used to feed a festoon, it is provided with a 3 horsepower driven motor.

2. Wind-up Table for Windup of Slit Fabric or Gum, Model 387, see Figures 1 and 2

This table is available in a choice of three sizes for 36" (914 mm), 48" (1219 mm) or 60" (1524 mm) wide stock; specify maximum stock width when ordering. It employs a conveyor belt upon which slit fabric or gum is rolled up in individual liners at each wind-up station.

The number of wind-up stations and size of the table is determined by the user in consultation with



TYPICAL WINDUP STATION, FIGURE 2

RJS Corporation.

Each wind-up station receives a roll of cloth or plastic film liner, which is wound-up together with the slit material and prevents adjacent layers from sticking together.

The stations are of pivot-type design which may be latched in up position, and are laterally adjustable by screw to position them in alignment with the slit material delivered from the slitting machine.

The conveyor belt is aligned by use of an RJS Disciplin Belt Guide, and is driven from the slitter by use of an adjustable speed Vee-belt drive.

3. Servicer, Model 103, 2-Station, see Figure 3

This servicer is available in a choice of three sizes for 36" (914 mm), 48" (1219 mm) or 60" (1524 mm) wide stock; specify maximum stock width when ordering. Maximum full-roll stock diameter accepted by the machine is 16" (41 mm). It is intended to be used with fabric stock which has been cut, spliced and rolled up in a liner.

The payout of stock is dancer controlled, and the stock is fed directly into the slitter without need for the festoon, or make-up table.

The servicer may also be used with gum stock which has been rolled up in a liner.

4. Spreading and Guiding Unit, Model 326, see Figure 1

The table is offered in a choice of three sizes for 36" (914 mm), 48" (1219 mm) or 60" (1524 mm) wide stock; specify maximum stock width when ordering.

This accessory incorporates photoelectric sensors and guiding and spreading rollers to keep the stock central to the slitter and remove wrinkles.

5. Heavy Duty Stock Let-off, Model 318, see Figure 1

The let-off is available in a choice of three sizes for 36" (914 mm), 48" (1219 mm) or 60" (1524 mm) wide stock; specify maximum stock width when ordering. This accessory provides the means for letting-off rolls of stock up to 40" (1016 mm) diameter, and is driven by a direct current motor, dancer controlled.

6. Fabric Festoon, 30 ft. Storage Capacity

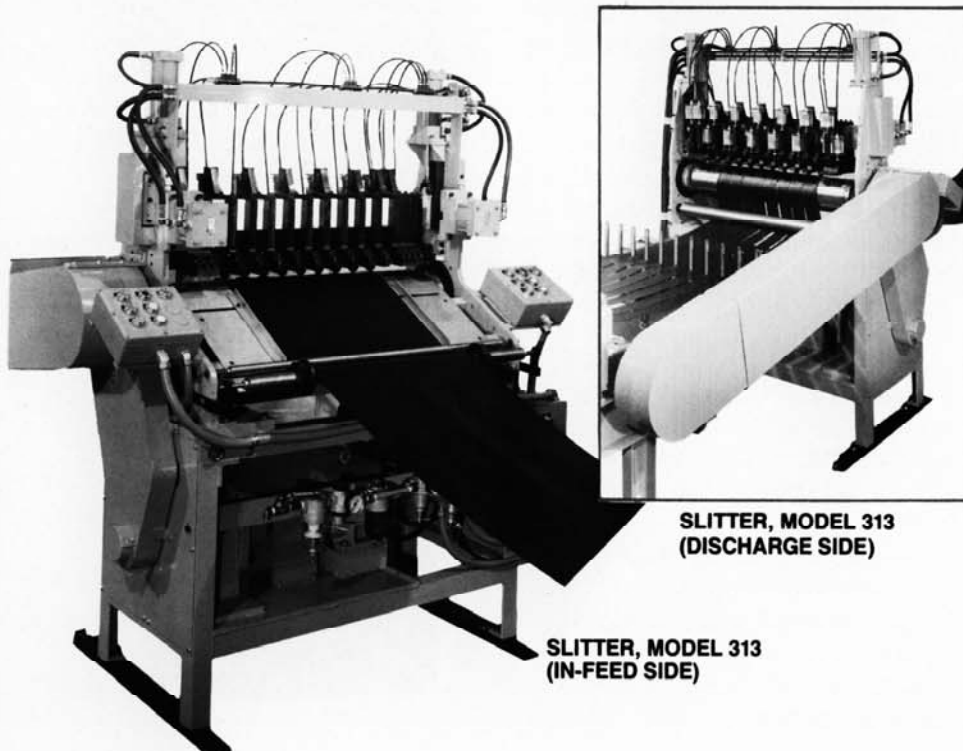
The festoon provides a constant supply of fabric to the slitter, when the system is used directly with a bias cutter.

The festoon is used in cooperation with the make-up table, which in turn is used for manually splicing the cut pieces of fabric from the bias cutter.

The festoon includes an inlet feed roller driven from the make-up table, and an outlet feed roller, driven from the slitter.

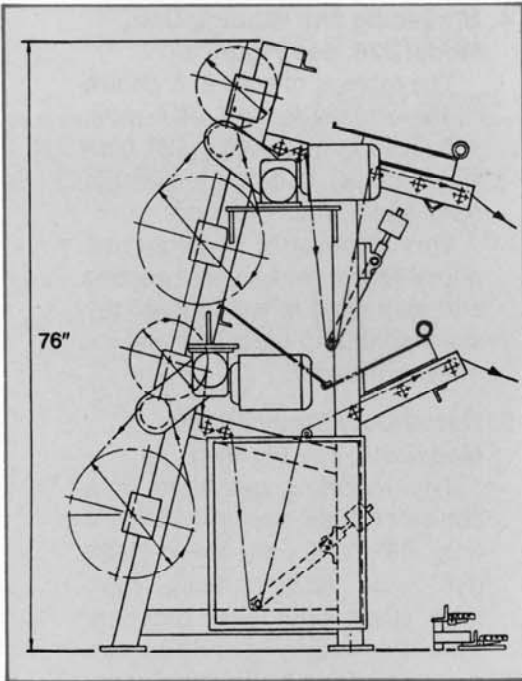
7. Fabric Festoon, 70 ft. Storage Capacity

Specifications otherwise same as the 30 ft. capacity festoon.



SLITTER, MODEL 313 (DISCHARGE SIDE)

SLITTER, MODEL 313 (IN-FEED SIDE)



MODEL 103 LET-OFF, FIGURE 3

PRICE QUOTATION ON ACCESSORIES

Only those accessories which have been indicated below will be quoted. The accessories are:

- Slitter, Model 313
- Make-up or Splicing Table, Model 327
- Wind-up Table, Model 387
- Servicer, 2 Station, Model 103
- Spreading and Guiding Unit, Model 326
- Heavy Duty Stock Let-off, Model 318
- Festoon, 30 ft. Storage Capacity
- Festoon, 70 ft. Storage Capacity

INSTALLATION

The installation depends upon the items purchased.

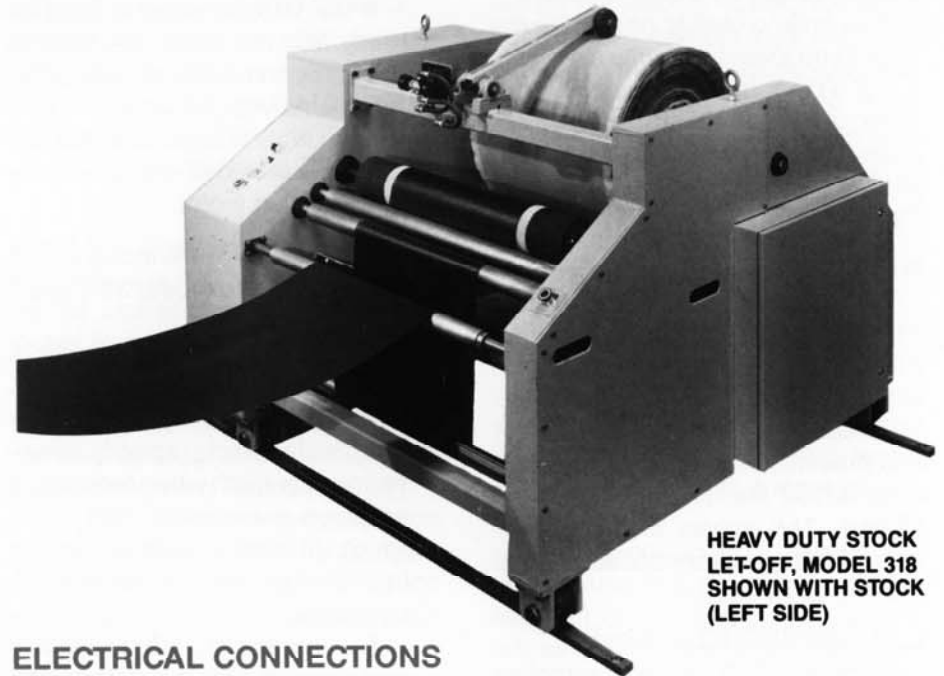
For a slitter line using a servicer or let-off and wind-up table, the installation will be similar to that seen in Figure 1.

The spacings shown on this drawing are approximate only, since final spacings among accessories are determined by the Vee-belt drive connecting the mechanical systems together, as well as the number of wind-up stations included in the wind-up table.

The slitter and accessories should be placed in their approximate position on the floor. The center line of stock flow on each accessory should be aligned with the center-line of the hardened anvil roller on the slitter. The Vee-belts should be installed on the pulleys, and the positions of the machines should be adjusted to make the Vee-belt tight. The machines should now be anchored to the floor. The slitter and make-up table are equipped with adjustable floor pads to permit final adjustment of the Vee-belt tightness after the machines are anchored in position.

The accessories which are driven from the slitter or from another accessory may require speed adjustment to synchronize the flow of stock through the system.

Adjustable sheave pulleys are provided on the driven accessory. While these have been adjusted at the factory to produce synchronism, final adjustment at the site may be required for good operation.



HEAVY DUTY STOCK LET-OFF, MODEL 318 SHOWN WITH STOCK (LEFT SIDE)

ELECTRICAL CONNECTIONS

Electrical connections are made at the circuit breaker/disconnect terminals.

Separate connections are required at the Model 313 Slitter and Model 103 or 318 Servicer, and at the Model 327 Make-up Table, if it is used to drive the festoon.

PNEUMATIC CONNECTIONS

Pneumatic connections are required at the Stock Let-off, Model 318, the Spreading and Guiding Unit, Model 326, and the Slitter, Model 313.



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MARCH 9, 1996

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