<table>
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<th><strong>Title</strong></th>
<th>Reel stands and tension control.</th>
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<tr>
<td><strong>Author(s)</strong></td>
<td>Fuchs, Boris.</td>
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<td>Fuchs, B. (1994). Reel stands and tension control. In AMIC IFRA Workshop on Trends and Developments in Web Offset Technology, Bangkok, Sep 8-9, 1994. Singapore: Asian Media Information and Communication Centre.</td>
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<tr>
<td><strong>Date</strong></td>
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<tr>
<td><strong>URL</strong></td>
<td><a href="http://hdl.handle.net/10220/2495">http://hdl.handle.net/10220/2495</a></td>
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</tbody>
</table>
Reel Stands & Tension Control

By

Boris Fuchs
Reel Stands & Tension Control

Boris Fuchs, IFRA
Fig. 12.1-12.4: Automatic reel splicing sequence — with stationary belts

12.1
Position: Positioning the new reel when the expiring reel reaches a pre-determined diameter.

12.2
Pre-drive: The pre-drive arrangement speeding the new reel to the surface speed of the expiring reel.

12.3
Splice: Pasting to the new reel and severing the expiring web.

12.4
Transition Tension: Transition tension control ensures accurate and constant web tension by electronic means throughout the reel change cycle.

IFRA, Darmstadt
A look inside the DLC MEG reelstand: 1 = Four-quadrant motor; 2 = expanding chucks; 3 = two- or three-arm rotation shaft; 4 = pivoting splicing assembly; 5 = dancer assembly; 6 = emergency brakes.
Einziehvornrichtung
Webbing-up device

Zugwerk
Infeed unit

Drehrichtung der Rolle
turning direction of the reel

Drehrichtung der Arme
zum Kleben
turning direction of the arms when pasting

Beladung
loading

CD-Paster (in Klebestellung für große Rolle)
(in pasting position for big reels)
Einziehvorrichtung
Webbing - up device

Zugwerk
Infeed unit

AUROload für CD-Paster
Einziehvorrichtung

Webbing-up device
Einziehvorrichtung  Kettensystem
Webbing-up device  chain system
Einziehvorrichtung  Weiche
Webbing-up device  point
Einziehvorrichtung  Einhängesystem
Webbing-up device  hook-up system
FMC Can Supply Everything For Your Paper Handling Needs
Bahnspannungsmessung

messure of web tension

TECOSYS (Tension control system)
Vorspannwerk mit Pendelwalze
Débiteur avec rouleau pendulaire
Infeed unit with dancer roller

Zugwalze
Rouleau de traction
Driven roller

Gummirollen
Galets de caoutchouc
Trolleys

Pendelwalze
«Ist-Wert»
«valeur réelle»
du rouleau pendulaire
«actual value»
dancer roller
Vorspannwerk mit Mit Messwalze
Débiteur avec rouleau de mesuré
Infeed unit with measuring roller

Messwalze
Rouleau de mesure
Measuring roller

Zug-Sollwert
Valeur de consigne de traction
Nominal value-drive

Zugwalze
Rouleau de traction
Driven roller

Gummirollen
Galets de caoutchouc
Trolleys
Zugwalze mit Harmonic Drive
Rouleau de traction avec Harmonic Drive
Driven roller with Harmonic Drive

Zugwalze
Rouleau de traction
Driven roller

Rouleau de mesure
Measuring roller

Gummirollen
Galets de caoutchouc
Trolleys

Anzeige
Zug «Ist-Wert»
Affichage de la «valeur réelle»
de traction
Display tension «actual value»

Sollwert Voreilung
Valeur de consigne
de l'avance
Nominal value-advance

Längswelle
Arbre longitudinal
Main drive shaft

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Zugwalze als elektronische Welle

Rouleau de traction sous forme
der arbre électronique

Driven roller as electronical shaft

Zugwalze
Rouleau de traction
Driven roller

Messwalze
Rouleau de mesure
Measuring roller

Anzeige
Zug "Ist-Wert"
Affichage de la "valeur réelle" de traction
Display tension "actual value"

Gummirollen
Galets de caoutchouc
Trolleys

Sollwert Voreilung
Valeur de consigne du rouleau pendulaire
Nominal value-gain
WORK PROCEDURE

1. Roll transfer from a cart and surface paper cutting
2. Surface paper removal (Max. 10 sheets)
3. Scratch inspection
4. Auto-paster paper end forming (triangle cutting and adhesive double-coated tape pasting)
5. Red paper tape pasting
6. Cutter Side tape
7. Top end tape pasting and top end lab pasting
8. Tab and top end tape
9. Rolling
10. Work completion and loading the roll onto the cart

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Steering antenna card
Electronic rack

Steering antenna

Amplification

Steering motor

Magnetic field

Charging Steering assembly

Micro collector

Spacing

Batteries

Transceiver

Emergency indicator

Computer

Guidepath frequency

Light

Audible beeper

Bumper

Emergency stop button

Fuse compartment

Main switch

Release button

Hour meter

Battery indicator meter

Tape switch

Emergency disconnect

Release button

Safety bumper

Emergency stop button

Emergency light

Tape switch
4.1 Core properties for a reel up to 1.7 m in width

1. Inner diameter: 76.2 + 0.4 mm; −0.0 mm.
2. Outer diameter: maximum 107 mm (to enable fixed splicing).
3. Weight: <4 kg/m (to avoid heavy waste).
4. Moisture content: 6...9 percent.
5. Crush strength (compression strength): >2000 N/100 mm² (other strength properties also important, though less common in practice due to lack of standard measuring methods).
6. Elasticity modulus: >2700 N/mm². Not critical at normal web widths (1.6 m), but becomes critical at web widths of 2.5 m.
7. Linearity (warpage): ≤2 mm/m.
8. Out-of-roundness: maximum 0.5 mm.
9. Deformation on core: Acceptable on inner diameter to a certain extent without major fibre damage, not on outer diameter. The reel must be demountable and replaceable.
10. Before the reuse of a reel, core damage must be evaluated.

11. Information to be listed inside core: manufacturer, type of core, identification code.

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4.2. Chuck properties

**Expanding chucks**

1. Nominal diameter: preferable 75 mm.
2. Expansion movement: high, preferably 82 ... 85 mm in diameter.
3. Contact surface: 5000 mm$^2$, central drive; 2000 mm$^2$, belt drive.

**Conical chucks**

1. Contact surface: Long type of chucks recommended.
Expanding chuck of reel stand Goss CT-45 (T1).

Short conical chuck of Goss old type reel stand (T2).

Long conical chuck of reel stand MAN Flypaster 1150 (SK).

Expanding chuck of reel stand KBA RE 2 (KA).
Reports from every reel stand

Reports to production office

Scanning of barcode and inspection of damages

Connection for dumping data into PC

Reports to production office

Laser scanner for scanning reel stand reports

Around 30 different reports

Of Moidig To storage Toprossroom

Scanning of barcode and inspection of damages

Connection for dumping data into PC

Laser scanner for scanning reel stand reports

Around 30 different reports

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Relative stretch [%]

Test conditions blanket-satellite printing

<table>
<thead>
<tr>
<th>Test no.</th>
<th>Print speed copies/h</th>
<th>Web tension [dN/m]</th>
<th>Damping</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>infeed</td>
<td>delivery</td>
</tr>
<tr>
<td>S 4.3</td>
<td>50 000</td>
<td>34</td>
<td>16</td>
</tr>
<tr>
<td>S 4.2</td>
<td>50 000</td>
<td>34</td>
<td>16</td>
</tr>
<tr>
<td>S 4.1</td>
<td>50 000</td>
<td>14</td>
<td>14</td>
</tr>
<tr>
<td>S 3.3</td>
<td>50 000</td>
<td>14</td>
<td>14</td>
</tr>
<tr>
<td>S 3.2</td>
<td>50 000</td>
<td>14</td>
<td>14</td>
</tr>
<tr>
<td>S 3.1</td>
<td>50 000</td>
<td>86</td>
<td>36</td>
</tr>
<tr>
<td>S 2.3</td>
<td>50 000</td>
<td>84</td>
<td>36</td>
</tr>
<tr>
<td>S 2.2</td>
<td>50 000</td>
<td>80</td>
<td>36</td>
</tr>
<tr>
<td>S 2.1</td>
<td>50 000</td>
<td>14</td>
<td>16</td>
</tr>
<tr>
<td>S 1.2</td>
<td>50 000</td>
<td>36</td>
<td>18</td>
</tr>
<tr>
<td>S 1.1</td>
<td>50 000</td>
<td>36</td>
<td>18</td>
</tr>
</tbody>
</table>

For tests S 1.1.1 to S 3.3:
- DW 1: impression on, colour: magenta, damping as in table
- DW 2: impression off, with dummy plates, damping off
- DW 3: impression on, colour: black, damping normal
- DW 4: impression off, with dummy plates, damping off

For tests S 4.1 to S 4.3:
- DW 1: impression on, colour: magenta, damping as in table
- DW 2: impression on, cyan, damping normal
- DW 3: impression off, with dummy plates, damping off
- DW 4: impression off, with dummy plates, damping as in table

Damping:
- Normal: damping under production conditions
- N + 20%: 20% more damping agent than normal
- N + 50%: 50% more damping agent than normal

Printing speed: 50,000 copies/h correspond to a web speed of 7 m/sec.

Figure 9: Rel. stretching recorded during tests carried out with the satellite unit configuration of the «Abendzeitung» press.
Relative stretch [%]

Test conditions blanket-to-blanket printing

<table>
<thead>
<tr>
<th>Test no.</th>
<th>Print speed copies/h</th>
<th>Web tension [dN/m]</th>
<th>Damping</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>delivery</td>
<td>DW 1</td>
</tr>
<tr>
<td>G 4.3</td>
<td>50 000</td>
<td>34</td>
<td>normal</td>
</tr>
<tr>
<td>G 4.2</td>
<td>50 000</td>
<td>34</td>
<td>normal</td>
</tr>
<tr>
<td>G 4.1</td>
<td>50 000</td>
<td>36</td>
<td>normal</td>
</tr>
<tr>
<td>G 3.3</td>
<td>50 000</td>
<td>16</td>
<td>N + 50%</td>
</tr>
<tr>
<td>G 3.2</td>
<td>50 000</td>
<td>16</td>
<td>N + 20%</td>
</tr>
<tr>
<td>G 3.1</td>
<td>50 000</td>
<td>16</td>
<td>normal</td>
</tr>
<tr>
<td>G 2.3</td>
<td>50 000</td>
<td>78</td>
<td>N + 50%</td>
</tr>
<tr>
<td>G 2.2</td>
<td>50 000</td>
<td>82</td>
<td>N + 20%</td>
</tr>
<tr>
<td>G 2.1</td>
<td>50 000</td>
<td>82</td>
<td>normal</td>
</tr>
<tr>
<td>G 1.3</td>
<td>50 000</td>
<td>32</td>
<td>N + 50%</td>
</tr>
<tr>
<td>G 1.2</td>
<td>50 000</td>
<td>34</td>
<td>N + 20%</td>
</tr>
<tr>
<td>G 1.1</td>
<td>50 000</td>
<td>34</td>
<td>normal</td>
</tr>
</tbody>
</table>

DW 1: impression on, colour: magenta, damping as in table
DW 2: impression off, with dummy plates, damping as in table
DW 3: impression on, colour: black, damping normal
DW 4: impression off, with dummy plates, damping off

Damping: Normal: damping under production conditions
N+20%: 20% more damping agent than normal
N+50%: 50% more damping agent than normal
---: switched off

Printing speed: 50,000 copies/h correspond to a web speed of 7 m/sec.

Figure 10: Rel. stretching recorded during tests carried out with the blanket-to-blanket configuration of the «Abendzeitung» press.
1. At approx. 25°C and 55% relative humidity, the tensile strength must be greater than 200 daN/m.

2. The ratio between longitudinal and cross tensile limits must be greater than 1:2.5.

3. In the lower range of the longitudinal tension/stretch characteristic (up to app. 60 daN/m), the ratio between tensions ($\sigma_{dry}$ and $\sigma_{hum}$) must be less than 2:1 at 10% moisture content.

4. In the tension/stretch characteristic in cross direction, the difference between stretch when dry and with 10% water added ($\Delta l = q_{hum} - q_{dry}$) at 10 daN/m should not exceed 0.26%.

Source: E. Glöckner, KBA