

Western Maintenance Conference

May 2 – 5, 2004

HO Break Out Minutes

Monday 5/3/04: Folder Break Out

- ⇒ Product not square on delivery?
 - Slavek – try band setting procedure
 - Murphy – Pin Timing check
 - When the lap is adjusted, then the pin timing should be adjusted too

- ⇒ There is a Pin Modification procedure for the Imperial 3:2 folders
 - Service Bulletin on Goss web site

- ⇒ Guide Roller settings very critical
 - Want to adjust the open edge side to position the section on the former
 - Closing the guide rollers at open edge pushes section towards the nose
 - Opening the guide rollers at open edge allows the section to move to the tail

- ⇒ Goss has a Flex Nose enhancement (air cylinder) that replaces the spring for better control of the first fold.

- ⇒ Anti-wrinkle rings reduce surface area of the paper to roller allowing no folds or creases in transferring sections. The rings are calculated in the OD of the roller.

- ⇒ Former set up for 57 degree formers
 - 10 inched from frame
 - 3.089 inch height from top of guide roller to flex nose insert scribe
 - 0.020 inch drop off from RTF

- ⇒ How often should you change the second fold roller springs?
 - This is difficult to tell, need to check and clean

- ⇒ Some users are switching from silicon applicators to corn starch applicators
 - Replaces water base silicon which is better for the folder, less rust
 - Oxydry is a name of a corn starch applicator

- ⇒ Dog-ears? This occurs when paper enters the 2nd fold rollers
 - If on the head of the book, maybe knife, cheek wood, or rubber
 - If on pin side, the Sovereign 160 page folder have a guide to help product travel over 2nd fold roller

- ⇒ Stripping Shoes
 - Larger products are stripped early, on the heel
 - Smaller products are stripped later, they stay in the pocket longer

- ⇒ 3/8" nips collars
 - Will get even wear, no step effect
 - Some users encountered problems when pulling balloon section

- ⇒ Goss Folder Enhancements
 - Flex nose air cylinder to replace spring
 - Air bags on 2nd fold rollers to replace springs
 - Cog Belt delivery, replaces stripping shoes

- ⇒ Spider gear sleeve replacement for oil leaks
 - Sleeve made of Titanium

- ⇒ Folder Down Guide Set Up
 - Folder on collect mark
 - 3/4" round bar in Fly pocket
 - Push guides to the bar

Monday 5/3/04: Parts and Service Break Out

- ⇒ Goss is now supplying catalog numbers, not part numbers, when performing audits
 - This has a negative impact on users as they cannot check their onsite inventories

- ⇒ Goss – Preferred Service Plan
 - Describes a discount when using this service

- ⇒ Parts Link – will it be able to accept credit cards?
 - Big cost for Goss to meet Federal Firewall Standard
 - An upgrade is planned within 2 years to do this

- ⇒ HO Unit Panel Membrane Replacements
 - Can Goss supply a replacement at an affordable cost?
 - User reports the overlay decal is not holding up

Monday 5/3/04: Unit Break Out

- ⇒ Cylinder Settings
 - User has circumferential registration problems telescoping from the near side of the unit to the far side. User has to shim plates in same position regularly to register

- Suggest Iron-Iron setting check. Some users have experienced this problem and found plate cylinders that have lost their pre-load to their cylinder bearings.
- ⇒ Ink Rails need to be re-pinned after 50” cut down if desired setting cannot be achieved.
- ⇒ Goss Digital Page Packs
- Very reliable and accurate
 - Reduces waste ink generated

Tuesday 5/4/04: RTP Break Out

- ⇒ Goss has an RTP upgrade for static belt reels
- ⇒ Using double thickness adhesive paster tape will cause more wraps to units
- ⇒ Static Belt Reels
- 50” cut down, have to move brush bracket if too far beyond the roll edge
 - Bracket are okay if using single brush
 - Brush spring tension needs to be re-calibrated for today’s lighter weight paper
 - Adjust transition tension voltage, verify ½ volt
 - Pilot Load Controllers cannot be rebuilt due to a hazardous material issue, have to buy new
- ⇒ Triple Trap, if entire paster pattern (32 inches) travels under 3 pipe rollers, then tension greatly increases which causes web breaks.
- ⇒ Straight Line Pastors are being made at an angle. A 3-inch difference from one side of the roll to the other should help paster percentage.
- ⇒ Baldor hydraulic motor is no longer available. Goss is working on a replacement system.

Tuesday 5/4/04: Quality Break Out

- ⇒ Registration Issues?
- Start a data collection process to determine identifying patterns
 - Use a Grid Print Test Form
 - Cleanliness – lock ups, pipe rollers
 - Dry Ice machines works well, can get messy
 - Verify plates, send plates to manufacturer to match Goss specs
 - Verify blankets are torque properly
- ⇒ Ink – Water – Plate Balance
- Keep fountain solution conductivity low if possible

⇒ Spray Bar Testers

- Technotrans has an excellent tester, very expensive though
 - Measure the liquid volume output of each nozzle, then calculate variance