

Western Maintenance Conference 2003

REDUCING WEB BREAKS

Seattle Times: The Seattle Times goal is to achieve 50 RPB. We used a shotgun approach to tracking web breaks prior to 3 years ago. We now have a partnership with Norpac and our in-house machinists and electricians to really track down and determine what is causing the breaks. We also have a web break tracking database and are very happy with the way we have it set up. We track anytime a web sheet is out. At that time the operators are to contact the electricians and machinists to come and determine cause of the breaks. We have made an effort to reduce breaks coded as unknown. After 750 per hour and we lose a sheet and send a point up we count. We also track and count sympathy breaks and have really tried to reduce them. We were in the low 20 RPB two years ago and now we are in the high 40's. We started checking and replacing spray bars which also helped reduce sympathy breaks.

Question: Were the spray bars not shutting off?

Seattle Times: Yes. The set point of the spray bar was not shutting off. They either were spraying too little or too much. There are many variables in the spray bars that can wear out. We in the Machine Shop built a spray bar tester stand where we could do a volume test. The set point dampener set off at 7. If water is still spraying we have a problem. If the sheets are not cleaning up we pull the spray bars and send them for testing. These spray bar tests reduced sympathy breaks by about 50%. Web breaks/sympathy breaks seem to be at start up and shut down mostly. We check the volume of water with the tester. It should be set at 42 lbs. of pressure.

Our paster percentage is up from 80% to about 98-100%. Paster carriage stops checked. The Machine Shop wants to make sure that the reel operator can't find fault with any of the machinery at the reel stand when checking web breaks. We have a very aggressive maintenance schedule to achieve this. We have a handout of the modifications made to Press 1 RTP1 available.

We maintain the slip rings and core brakes and changed our PM's to base them on what was happening in real time. We have also done all the adjustments to Goss specs. On the slip rings we used the Los Angeles Times specifications to check the RTP. We were using straight-line tape but the tolerances had to be zero and this didn't work well so we changed back to the old "W" paster pattern.

We are finding that 60% of the paster breaks are in the angle bar areas. There is a very low percentage of pasters. We started a subcommittee of our web break committee that meets weekly to try and analyze these breaks. Our regular web break committee meets monthly. Do other newspapers track web breaks? What are your percentages?

San Francisco: January/February we were at 51 RBP. We normally average around 31-32 RPB.

Denver: 46 RPB.

San Jose: We are at 39 RPB. We do have a new AGV system upgrade where we track the reels electronically. We no longer have reel reports. All the reporting is done at a workstation

with an HMI panel. There is a checklist on the panel that the operator must complete. They go through this panel to get to the screen for web breaks. Works really well. The only problem they have come across is when the lead on the press enters the web break on the HMI panel it can sometimes cause double entry. It is called an HMI panel or Trace computer.

Seattle Times: We now compare the reel report to the PIC report and they should match. We don't use the codes off of the press because we were getting too many unknowns. We are now also tracking location of breaks. At the slitter, angle bar, folder, etc. We use codes for where the break occurs. This has helped pinpoint trouble areas. We also work closely with our paper suppliers on problems with rolls/paper to help us reduce breaks. We give them copies of their company specific RPB reports. We also have a data acquisition system on Press 1 Unit 1 to help analyze breaks.

Goss: If we don't know the causes we can't fix the problems. That is why it is so important to eliminate the unknowns. Homeruns can be caused by an improper folder setup. Also slitter bar and angle bar setup can cause wrinkles in the press. Setting slitter and nips correctly is critical. If the folder has too much nip the paper will be weak on the edge and will snap.

Seattle Times: The press crew started cleaning the pipe rollers more often and this has helped tremendously. We clean them about once a week. That also reduces wrinkles. We also have our running crews do maintenance for about 30 minutes before make-ready. This includes checking and cleaning the pipe rollers.

Goss: They installed anti-wrap trolleys in Chicago. They adjusted them to 5/16" between the nut and spring.

San Jose: Anyone using 27.7 lb. stock? Had lots of trouble with it?

Sacramento: We were using 27.7lb. stock but had trouble with poor quality and see through. We went back to 30 lb.

Seattle Times: Wear on shafts of trolleys pulling wrinkles. The trolley wheel has sharp edges so they were wearing out. Want to steer it away from the edge of the sheet. Spring pressure only. Replaced or repaired damage. Anyone having trouble with angle bar slitters? Do you run with former slitters or angle bars?

San Jose: We use former bars unless we are running a tab. We found they were cutting on the RTF. Had more sympathy breaks when using them.

Goss: PM your RTF slitters as much as possible. The Colorliners cut on the RTF.

Sacramento: Do you use the same pattern? Have you tried others?

Seattle Times: We try to stick to the Goss paster pattern and have cards posted on the press as examples. But each operator is an artist! Nose tape was no different and had no advantages. Just expensive. Bridge tape – we use on angle bars. Have air pockets without it. It doesn't work well with straight line tape.

When straight in we don't use bridge tape. 1/2 rolls we do use bridge tape. 1/2 roll in the middle with 1 belt we use bridge tape at 40 lbs. of belt pressure. We have had great success in the last year doing this. We also don't let pasters sit over 8-10 hours. They must be remade at the start of each shift.

San Jose: Do you have a training program for this?

Seattle Times: No - no formal training. Most of our operators have been with us for many years.

San Jose: They make fresh pasters every night?

Seattle Times: Yes, fresh pasters - all runs. We were finding that the first paster was having the most breaks before we changed. We also use Baldwin web detectors. And we started tracking each operator's breaks and runnability. With our new management style we have monthly one-on-one's with the operators to discuss performance issues. We try to have core groups on the presses. With days off and schedule changes we end up with about 4 operators out of 8 on each press as part of a core group. Does anyone rotate the button (folder) person?

Goss: Most places have one person who runs the folder. Usually a lead. (Many papers stated this was the case)

Seattle Times: If anyone is interested in a copy of the maintenance schedule it will be available tomorrow morning. What is the most common areas of trouble?

Goss: The folder area. Setting the nips is the biggest problem. One of the most passed over areas. Moving the guide rollers while the press is running. Nip setting and trolley adjustments cause the most problems in folder setup. Guide rollers are misunderstood. Swing back and forth. They cause the most web breaks if not set correctly.

Sacramento: Management says back off the nips because they don't want to see them. Or pin holes. But when we back them off it makes it hard to run the product which causes web breaks. Running band adjustments is a great feature.

Seattle Times: The main point is to have the support people work closely with the operators on every break. All of our operators carry radios and are to call each and every time they have a web break.