

PrintConcept Grafische Maschinen GmbH Doyle Web Cleaning / one- and both-sided

Installation guide / Maintenance

1. Adjustment and setting of the manifold(s)
2. Adjustment and setting of the brushes
3. Maintenance of the brushes. → **Important and to be followed**

Requirement for this description are pre-installed manifolds

1. Adjustment and setting of the manifold(s)

- 1.1 Both manifolds are pre-installed at the side frames of the machine with slightly tightened screws / brackets. Therefore the adjustments described as follows can be made. Afterwards **tighten the screws !!**



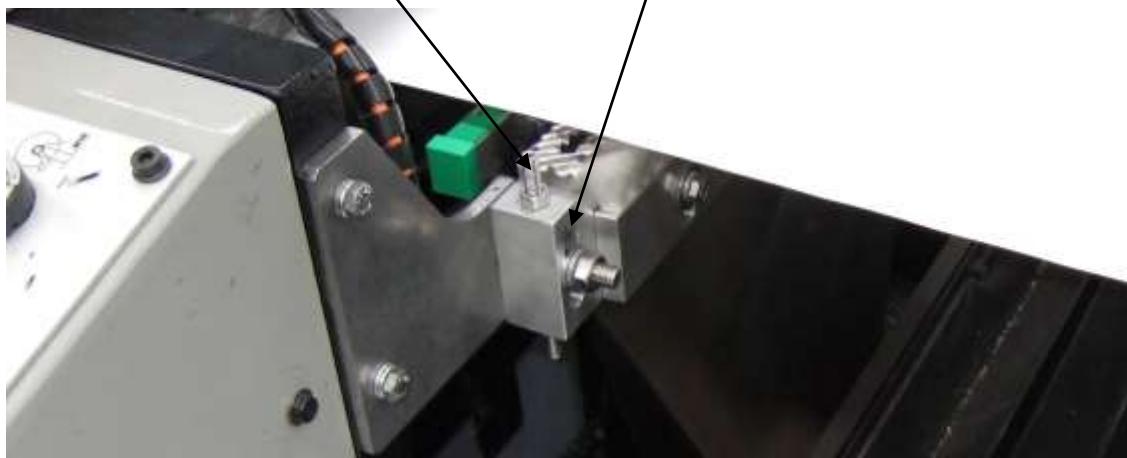
- 1.2 The maximum web tension has to be given for the adjustment of the manifolds to the web.

- a. The manifold / the faceplate has to be in a 90 ° setting angle to the web. The bracket has a long slot to correct this angle. **If the setting angle is not correct, the inlet and outlet brushes are wearing off differently.**



- b. The manifold has to be parallel to the web. If this is not the case, the brushes are wearing off differently from side A to side B and it is not guaranteed the brushes fulfill their tightening function (vacuum).

The A and B side are adjusted through the long slots. The fine adjustment is done through the set screws with a socket head wrench. The set screws in combination with the screw nut serve also as screw locking.



- c. The manifolds have to be adjusted to the web that the ends of the brushes touch the web.

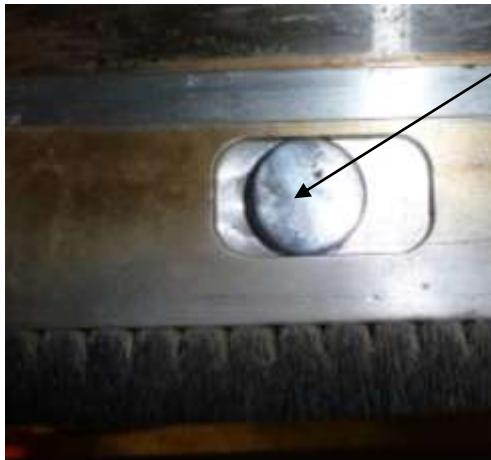


2. Adjustment of the brushes

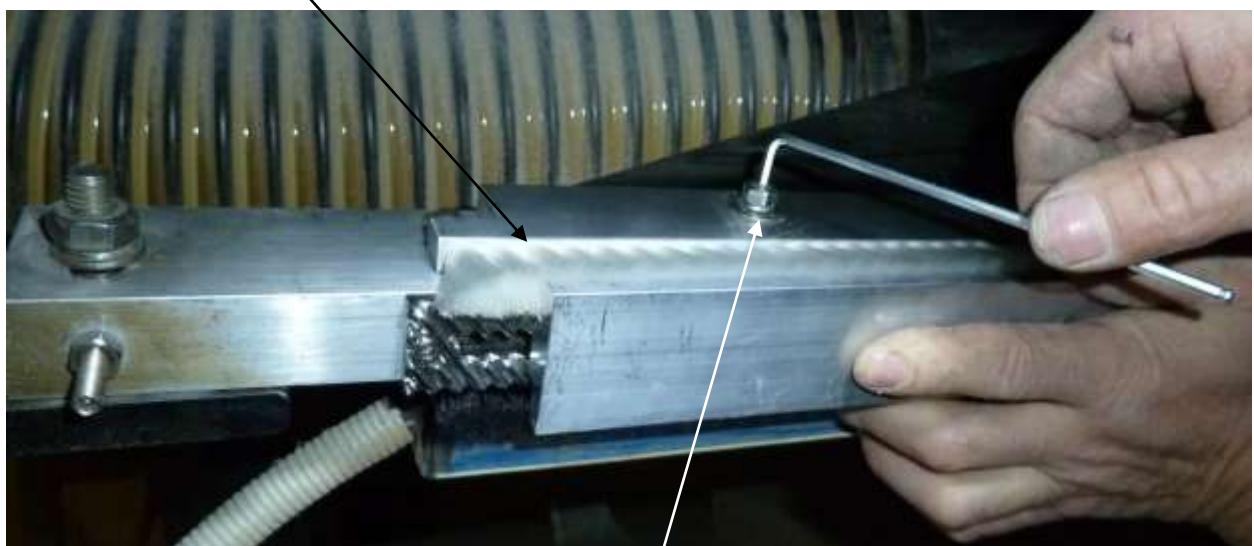
- a. Use the delivered template for brush adjustment to adjust the brushes (T-piece approx. 55 cm long). The inlet brushes are black, the outlet brushes white. For special applications both are white.



- b. The inaccessible brush row respectively screws (ionisation affects the handling) have to be served via the eccentric screw with an socket wrench.



- c. Lay the template on the faceplate and push the accessible brushes against the template.



Push the inaccessible brushes against the template through the movement of the eccentric screw with the socket wrench.

One set of brushes (length of the manifold for example 2500 mm) exists of 4 inlet brushes and 4 outlet brushes. Please adjust successively all pairs of brushes.

3. Maintenance and brush adjustment → **Important and to be followed!!!!**

- Adjust all inlet brushes and outlet brushes **equally-parallel** (three times possible). If this is not followed, the web will not touch along the whole working width and the brushes cannot tighten the vacuum. The consequence will be a loss of vacuum and efficiency of the system.
- Check all brushes regularly if they are above the faceplate. We recommend to do this visual check once per week.
If the brushes are not adjusted respectively changed, the web will run on the faceplate which will grind down gradually. The consequence will be that the necessary air curls cannot be produced in order to catapult the dust particles.



The **wear of the brushes**, this means the time until the next adjustment is necessary, depends on:

- Materials and surfaces used
 - Web speeds
 - and amount of shifts
 - Setting/intensity of the vacuum through the valve at the inlet of the exhauster. Depending on material (grammage), pollution degree and web width, a reduced vacuum may be sufficient.
- If it is no longer possible to readjust the brushes, it is necessary to change them with another set of brushes. (Please consider delivery times since the refill is done by the manufacturer). The worn out brushes can be returned to PrintConcept and will be refilled with original brushes by the manufacturer. The ionization has to be removed when the brushes are changed. Please see chapter 2.0.
- If the brushes are not changed or adjusted, the faceplate will wear off.**

Spare part numbers can be found in the manual and should be stated in your order.

Remark:

- All time data and intervals are recommendations based on findings of the past.
- Each installation is different in view of
 - materials
 - web widths
 - web speeds
 - number of shifts
- Each customer should adapt the necessary steps and frequency of maintenance intervals to the given parameters.

Kohlberg May 2020