



METRO USERS 2010

Web Break Reduction

Units & Superstructure

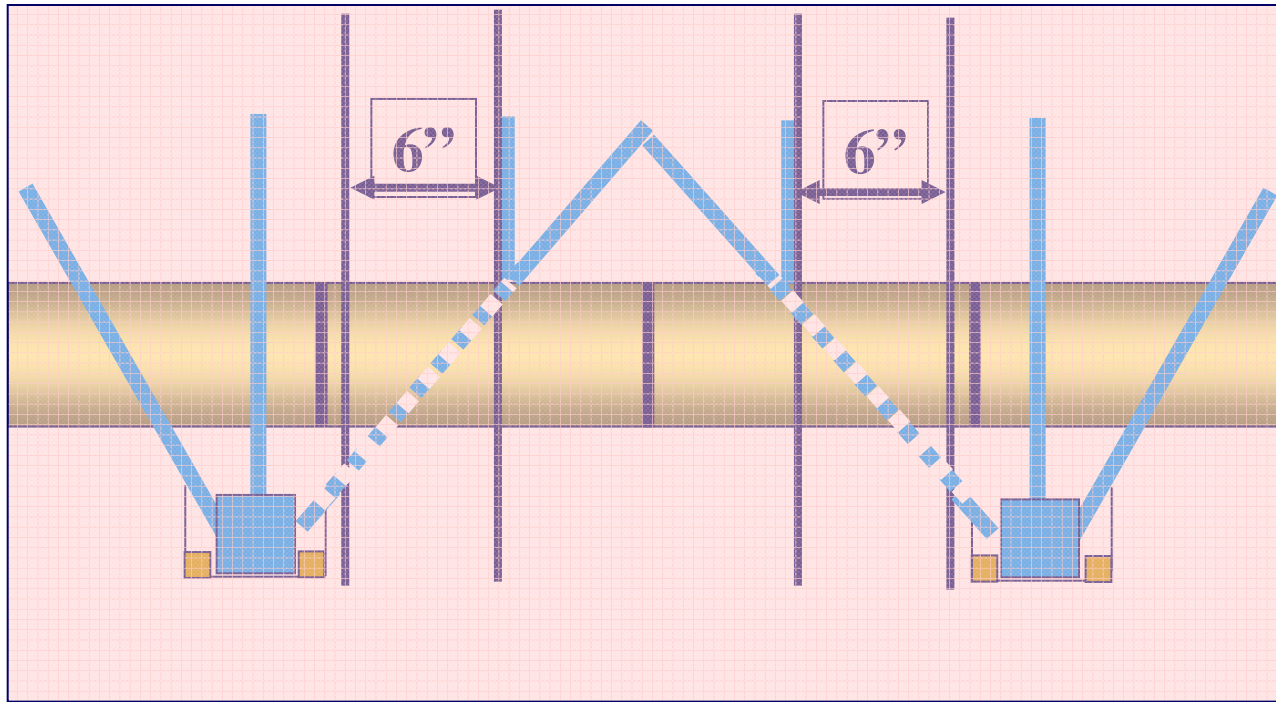


Pre / Post PWC Considerations

- **Reelstand set-up and paster patterns**
- **Print registration and ink/dampener control**
- **Roller front of bars and angle bar brackets**
- **Web control through tension and balance**



Paster Make-up Roller Front of Bars



Nose tabs do not pass under tab slitters at FRB

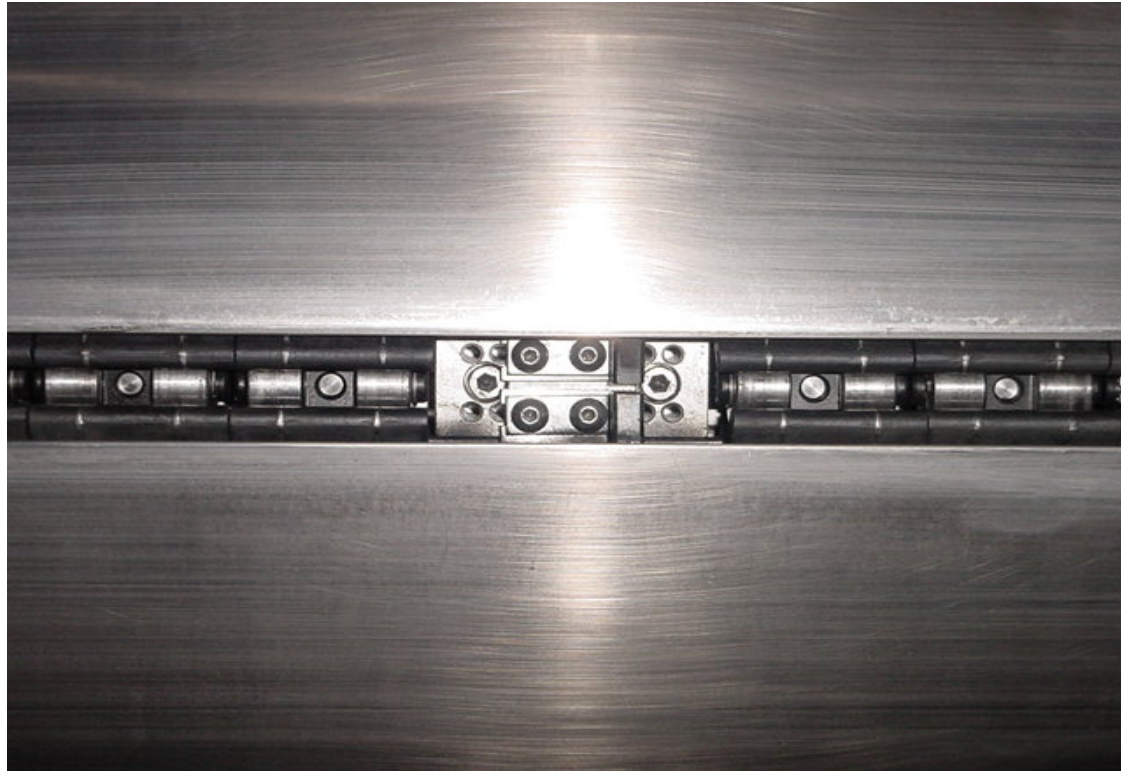


PWC & Unit Impact

- **Plate Lock Ups**
- **Register Pin Alignment**
- **Rubber Roller Widths**
- **Ink Rails**
- **Column Widths and Multi Web Width Software**



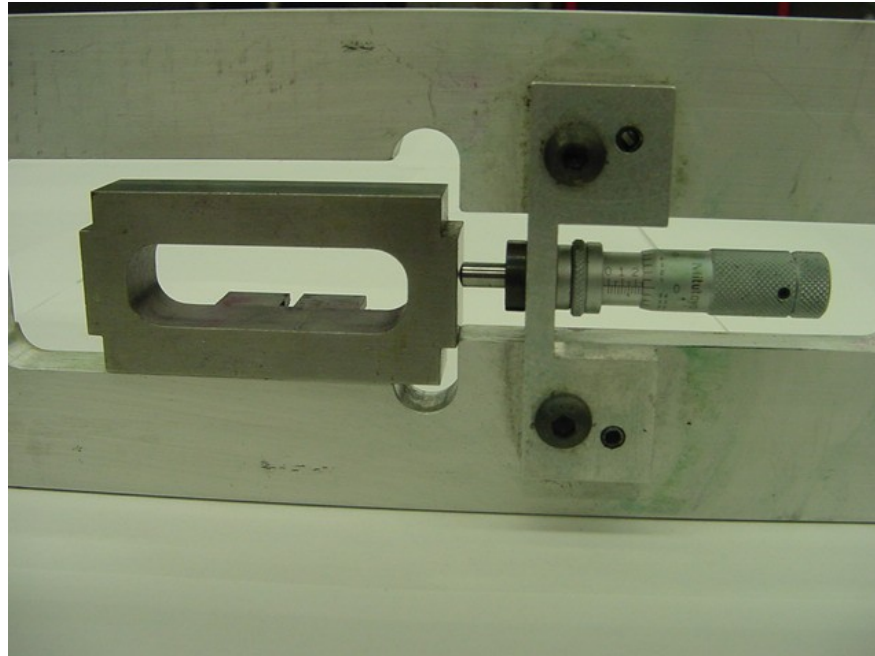
Lock-ups and Pin Registration



**Repositioned register pins.
Cylinder slots and lock-us cleaned for precise registration**



Register Pin Settings



**Micrometer style register pin gauge shown
Block can also be used with magnetic base and dial indicator**



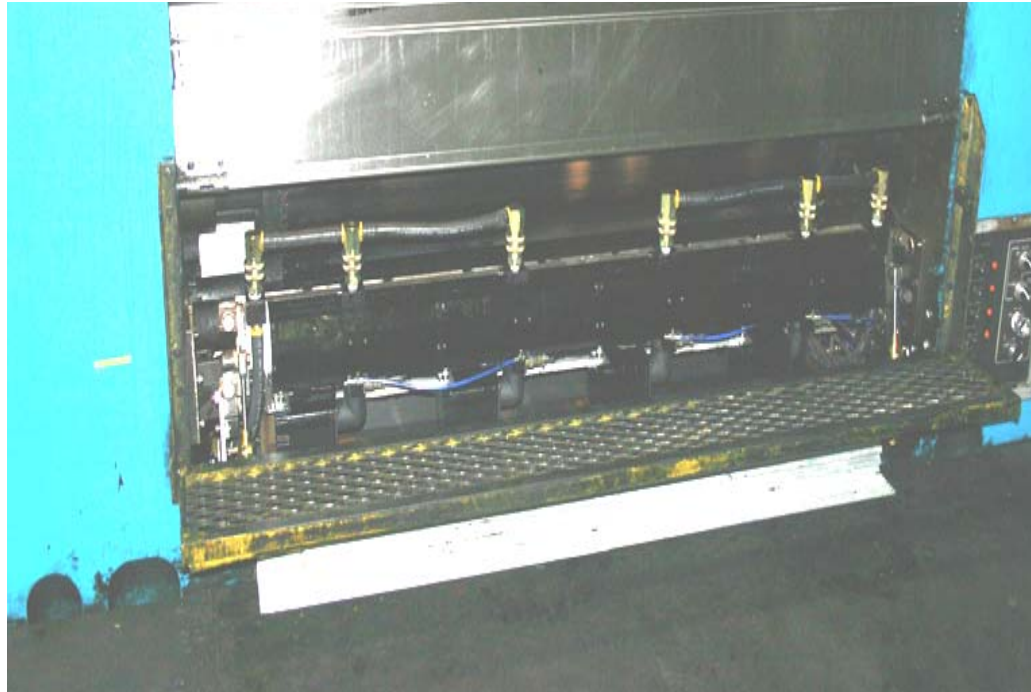
Lock-ups Pins and Blankets



Unit shown after completion of PWC with reduced width blankets installed



Correct ink Distribution



Dampening and inking must correspond with new web widths.



Roller Front of Bar Machining



**Slots and slot cleaners installed with repositioned slitters
Dust collectors are also addressed**



Angle Bar Bracketing

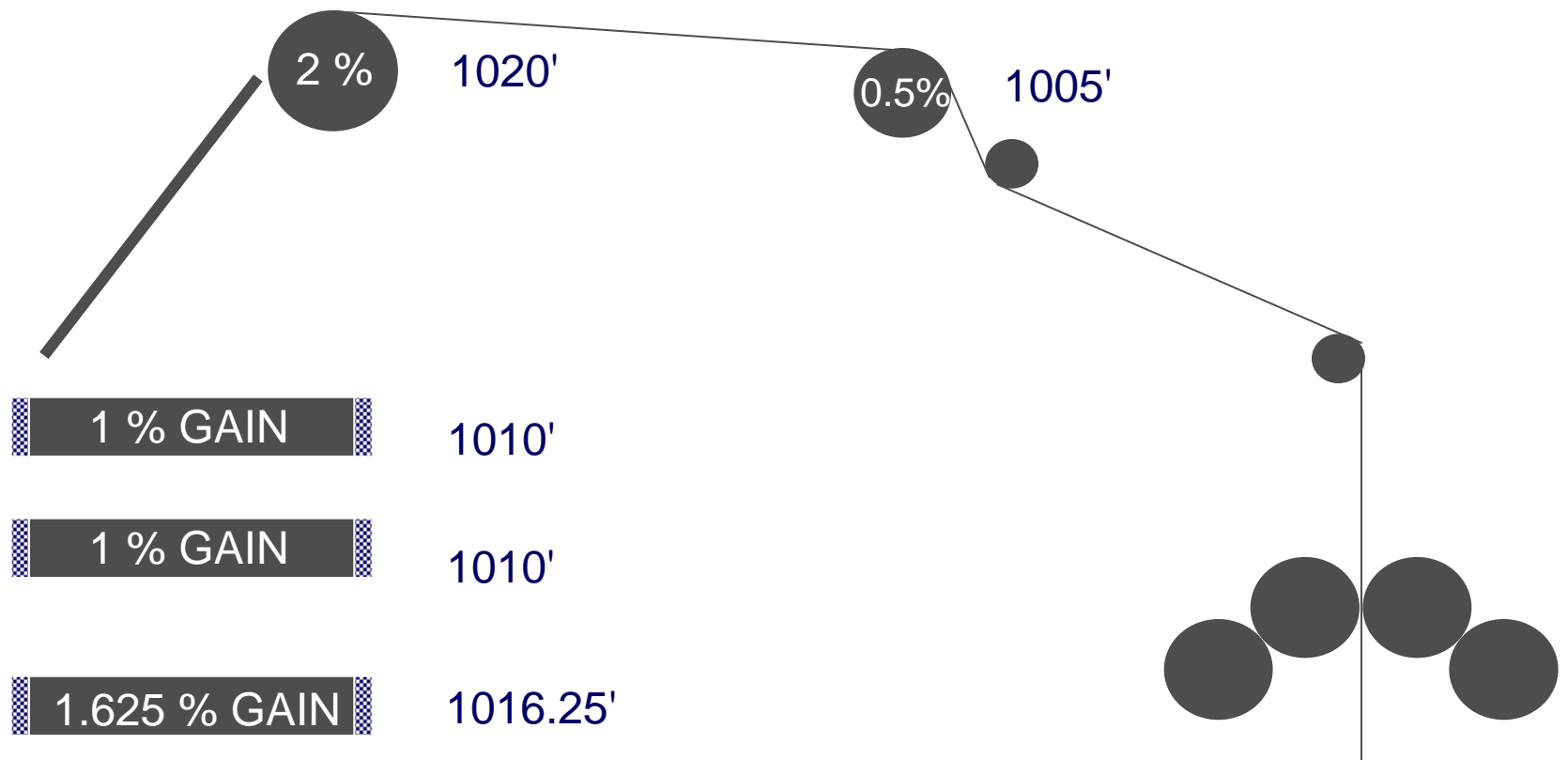


Drilling and dog pointing of shafts to correctly align barred webs



Tension Control

1,000' PER MINUTE
AT PRINT COUPLE





*Thank You
For
Your
Attention*