

MarquipWardUnited

Corrugated & Sheeting Office
1300 N. Airport Rd.
Phillips, WI 54555-4527
(715) 339-2191

Finishing Office
10615 Beaverdam Rd.
Hunt Valley, MD 21030-2204
(410) 584-7700

visit our website: www.marquipwardunited.com

PC-Controlled Sheeter Seminar In-House Agenda – Contact: Mike Spanjer

- I. Registration, Introduction, Materials
- II. Operation and Components
 - A. Line layout and Machine nomenclature
 - B. Computers and Hardware
 - C. Computer Screen Operation, Order entry and Configurations
- III. Knife
 - A. Safety: Overview, ZES, IES, Control Lockout, Capacitors, Static Bars
 - B. Operator Controls: Screens, Manual Controls, Preventive Maintenance
 - C. Mechanicals: Draw Roll, Cylinders, Gear train, Blades and Tuning Overview
 - D. Electricals: Component Layouts, E-Stop Circuit Power Circuits, Cylinder Controller and Controls (Input/Output), Prints
 - E. Motors/Power Supplies/Drives
 - F. Resets, Indicators, Meggers, Inductance, Continuity Checks
- IV. Knife Outfeed
 - A. Mechanicals, Geometry, Diverters, Modulators, Changing Tape Belts
 - B. Pneumatics, Sensors
 - C. Review system controls, prints, Static Bar Tests
- V. Layboy/Piler
 - A. Safety Systems Overview, Belt Access, Safety Photoeye Protects, Lift Locks, Curtains, Preventive Maintenance
 - C. Operator Controls: Snubbers, Backstops, Lifts, Lift Setup
 - D. Lift Overview: Chain Systems, Hydraulics, Sensors, Pneumatics and Controls
 - E. Control Cabinets: Electrical Component Layout, Power Circuits
 - F. Drives/Motors
 - G. Controllers: Inputs/Outputs, Control Prints
 - H. Lift Feedback, Hydraulics, Drive Systems, Photoeye Protect
- VI. Splicers:
 - A. Safety Overview, Dancer Rolls, Heads, Threadup, Splice Cycle (SNRCBAR)
 - B. Pneumatic Print (Dancer Control)
 - C. Controller Input/Output and Tension Control Loop
 - D. Troubleshooting (Missed Splices)
 - E. Preventive Maintenance: Clamps, Dancer, Chain Tension/Head Alignment
- VII. Roll Stands:
 - A. Safety Overview
 - B. Hydraulics, Pneumatic and Electrical Control Prints
- VIII. Slitters: Tidland Manual Slitter and Marquip Automatic Slitter
- IX. Swing Arm Dancer or Web Tension Control Loop, Feedback, Sensors
- X. Web Aligner and Web Cleaners
- XI. Decurlers: Turret, Rotational, Plunge, Controls and Pneumatics
- XII. Final Review of Systems

Please discuss this with the Education and Training Department after reviewing this agenda. This has been written for all possible machines; some equipment may not apply for a particular class and will not be covered. Specific order presented for class may vary upon equipment represented by customer or plant.