

REV AUTHORED BY <i>BOB BATTIS</i>		DATE 07/28/12		DOC, ROLL FRICTION SETUP AND INSPECTION PROCEDURE				EFI/VUTEK INSPECTION PROCEDURE	
REV DRAFTED BY <i>BOB BATTIS</i>		DATE 07/27/12							
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REV. RELEASE DATE: 07/28/12							SIZE A	SHEET 1 OF 5	
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A	ECO 29004	07/27/12							

I. SCOPE

This procedure defines setup of equipment and the Inspection procedure to successfully complete Friction Tests on Media Transfer Rolls.

II. INTENT

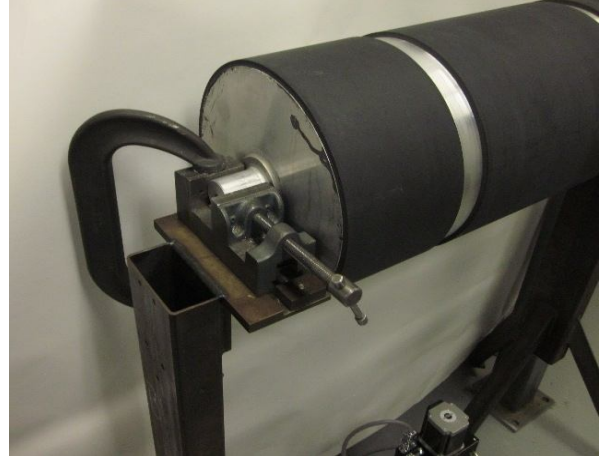
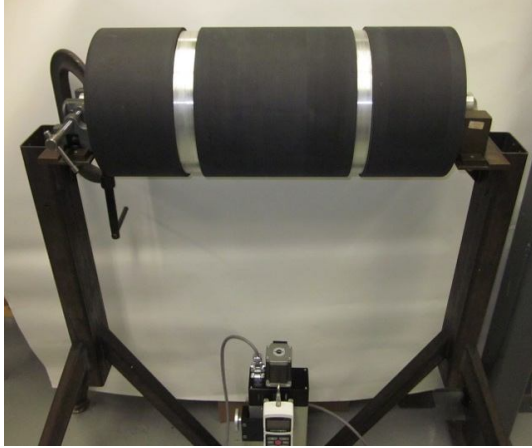
Ensure Inspection is to the highest accuracy and to a common standard.

III. EQUIPMENT

- A. Motorized Test Stand (50 Lb capacity) Mark-10, Model ESMH
- B. Digital Force Gauge (50 Lb capacity) Mark-10, Model M5-50
- C. Two Tensile Test Hooks – Mark-10, G1038
- D. Roll Conditioner – efi/Vutek 45084568
- E. Pull Media – efi-Vutek, Ultra Flex Normandy Pro, AS, Gloss, 13 oz
<http://www.ultraflex.com/PDFs/Normandy Pro.pdf>
Material size – 4" wide x 54" long
- F. Two ¼" diameter x 4" long steel rods (used to support Media width)
- G. One pound precision weight
- H. Roll Support Stands – The size and type is determined by size and weight of the Roll for Safety purposes.
- I. Vertical Stand – Fixture used to hold the Motorized Test Stand vertical.

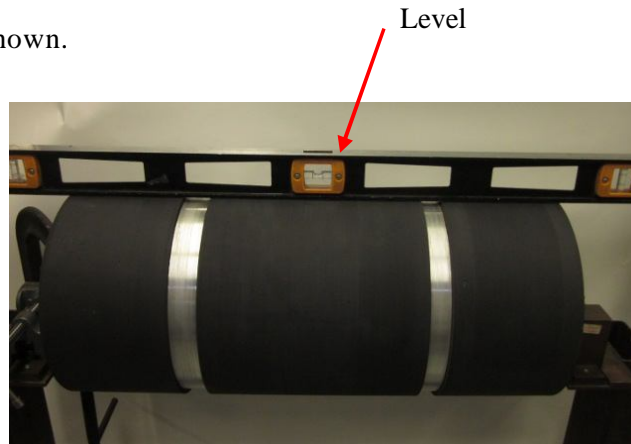
IV. ROLL SETUP

A. Setup roll stands with rigid mounts as required per Roll size to prevent the roll from rotating. **This setup is only for 3 meter rolls or smaller. Larger, heavier rolls require additional stability for the purpose of safety.**



B. Clean the entire EDPM covering of the roll prior to performing the friction test. Use Efi/Vutek roll conditioner, P/N 45084568. **Wait 30 minutes after cleaning process to perform Tests.**

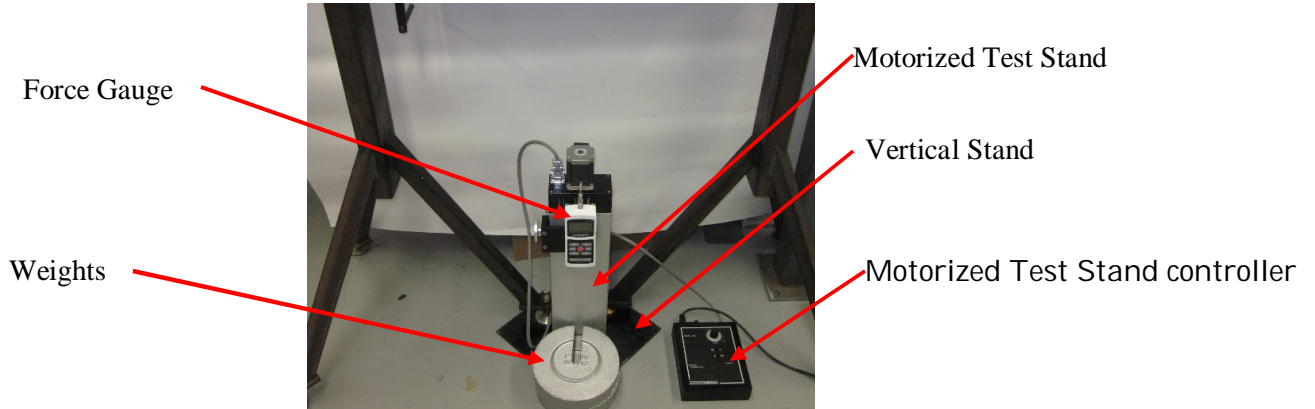
C. Level Roll as shown.



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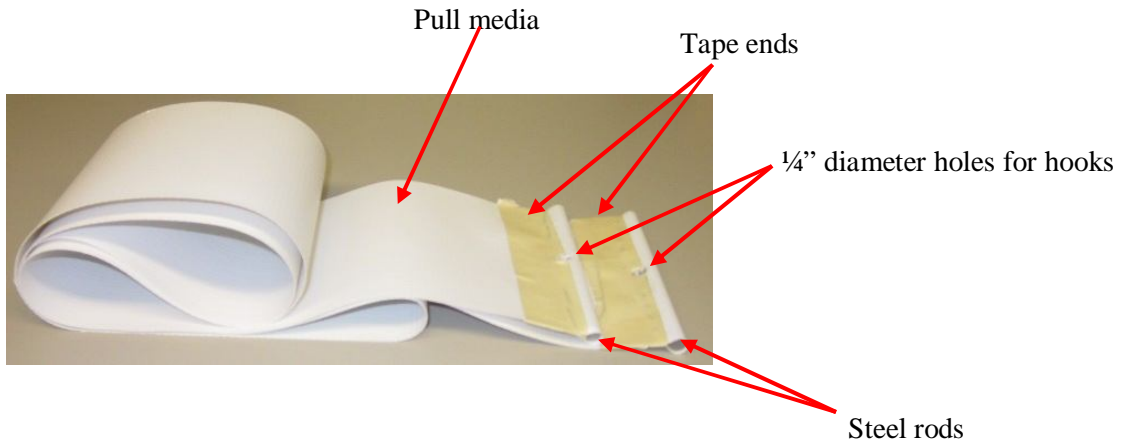
V. GAUGE AND TEST STAND SETUP.

- A. Attach Motorized Test Stand to vertical stand.
- B. Attach Force Gauge to Motorized Test Stand.
- C. Add (2) 20 Lb weights to vertical stand for stability.



VI. PULL MEDIA SETUP

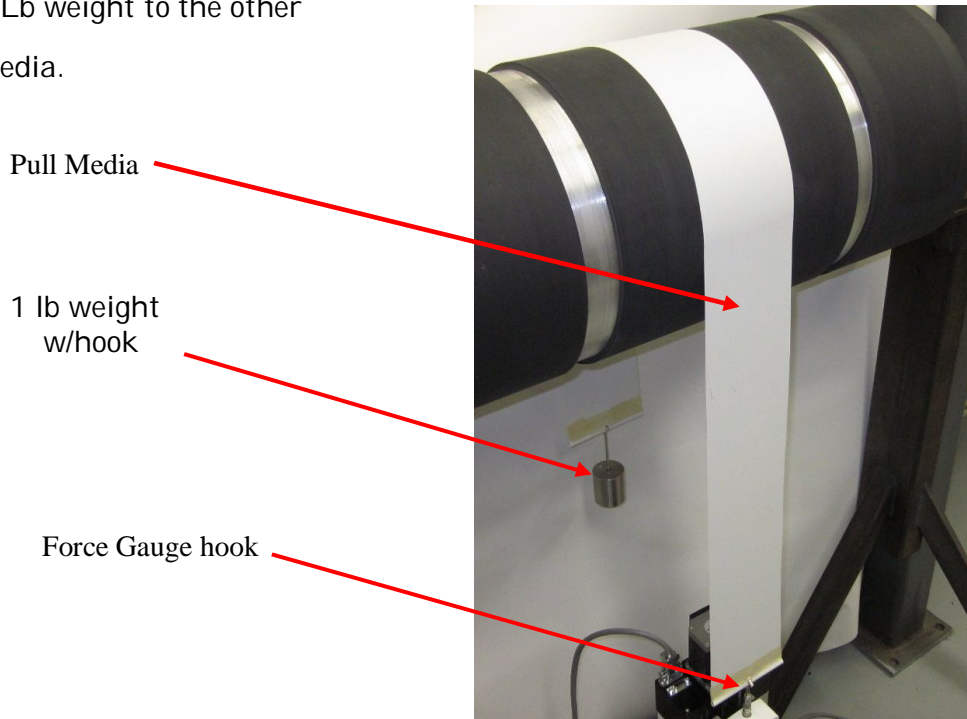
- A. Wrap ends of Pull Media around steel rods and tie off with tape as shown.
- B. Cut in a 1/4" diameter hole at each end as shown.



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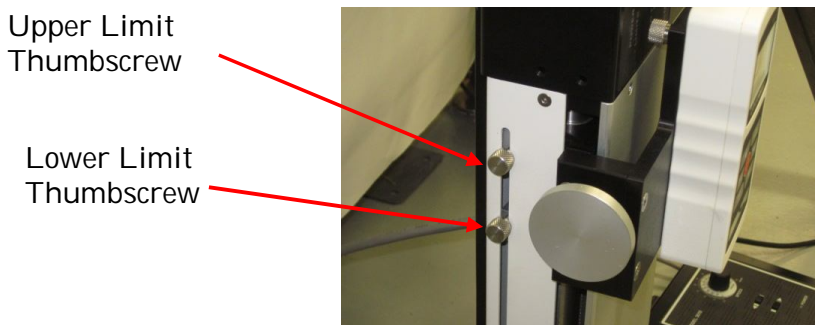
VII. ATTACH PULL MEDIA TO FORCE GAUGE AND 1LB WEIGHT

- A. Before attaching the Pull Media make sure the gauge is at the proper location of the roll to be measured. The location is specified on the Roll drawing.
- B. Using the hook on the Force Gauge, hook it over the steel rod and media in the ¼” dia. hole.
- C. Wrap Media over the roll. The media is to be vertical within +- 7 degrees of roll.
- D. **The coarse side of the media is to be in contact with the roll.**
- D. Attach the 1 Lb weight to the other end of the media.



VIII. SET MOTORIZED TEST STAND TRAVEL DISTANCE

- A. Set upper and lower limits for 3/32” travel using the thumbscrews.



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IX. TURN ON FORCE GAUGE

- A. Turn unit on.
- B. Press Mode key until you reach “Peak Tension”.

On/Off



Mode key



X. TAKING MEASUREMENTS

- A. To ensure the Gauge is pulling the media straight run the Motorized Test Stand up and down a few times at 20 IPM. This adjustment is on the Controller.
- B. With controller bring Gauge to the Upper Limit @ 20 – 30 IPM.
- C. Set Controller @ **.2 IPM**.
- D. Hit the down button on Controller until it hits Lower Limit. (An LED will light up on Test Stand when the Lower Limit has been engaged.)
- E. Record reading. In ALL cases a series of measurements should be taken and averaged.

NOTE: Measurement Locations and frequency of readings are determined by the Roll drawing.

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