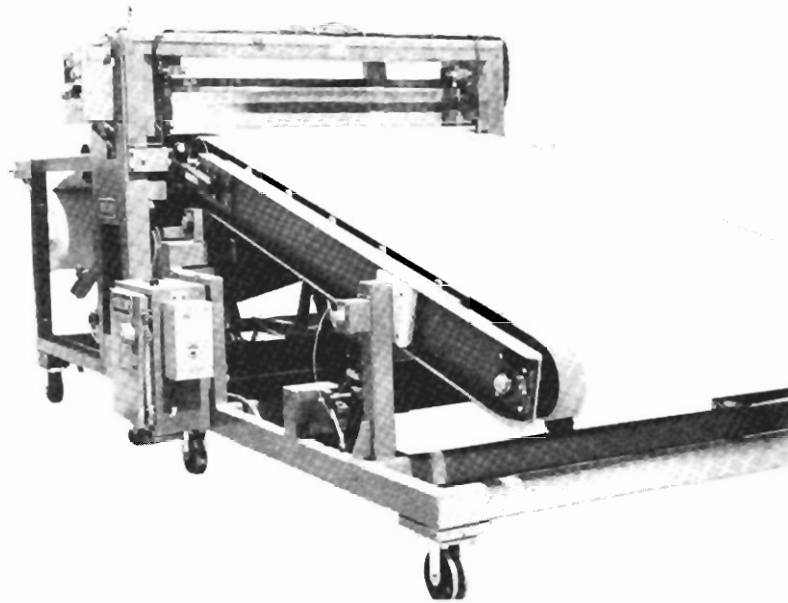


Flexible Sheet Length Slitter



(Shown with special corner notching punch system)

APPLICATION:

- Vulcan's Flexible Sheet Length Slitter has been designed for cutting flexible sheet as delivered by the draw roll stand from an on-line sheet manufacturing operation or as delivered by a powered let-off in an off-line operation.
- The cut-to-length slitting system consists of a set of servo motor powered nip rolls controlled by an ultrasonic dancer feeding the sheet extrudate through the cross-line traveling rolling slitter knife assembly onto a downstream conveyor traveling at a synchronized speed to the nip roll feed system. Upon sensing of the pre-programmed length by a digital encoder, the feed nip and the downstream conveyor are stopped and the rolling slitter knife traverses the sheet. Upon completion of the cut cycle, the downstream conveyor and the feed rolls are restarted ramping the sheet extrudate to above line speed to automatically return the amount of stored length in the dancer loop to the pre-cut value.

MODELS AVAILABLE:

Model No. (1)	Maximum Sheet Width (Ins.)	Maximum Sheet Gauge (Ins.) (2)	Maximum Cut Cycles/Minute (3)
SLS36	36	.100	11
SLS48	48	.100	9
SLS60	60	.100	8
SLS72	72	.100	7
SLS84	84	.100	6

- (1) Standard slitters do not include the powered let-off unit which is offered and priced as an option
- (2) The maximum sheet gauge will vary from these specifications according to the stiffness and toughness of the materials being cut.
- (3) The maximum cut cycles/minute will decrease from the values shown as the cut sheet length increases and the line speed decreases.

FRAME:

- Frame is constructed of structural tubing and plate
- V-grooved casters and combination hold-downs and height adjusters

DANCER:

- Three roll 6 inch diameter Ultrasonic Dancer assembly with tension adding capabilities
 - located between draw roll stand and feed-nip rolls in on-line configurations
 - located between let-off unit and feed-nip rolls on off-line configurations
- An ultrasonic sensor determines dancer roll position and adjusts the nip roll speed to maintain optimum storage of material in the loop
- Digital feed back system with touch pad entry for establishing length is included

NIP ROLLS:

- Nominal 10" diameter
 - Includes 1/2" thick layer of 45-55 durometer natural rubber covering
- Lower nip roll is servo-motor powered and controlled for precise cut-length tolerance
- Upper roll is equipped with 2 each air cylinders to actuate the nip and maintain a closed position during operation
 - Maximum operating nip force 25#/lineal inch of roll width
 - Maximum nip opening - 4 inches

KNIFE:

- The cross-line slitter unit is a rotary compression cutter mounted on lineal bearings which in turn travel on a structural member to reduce deflection. The lineal motion is produced by a rodless cylinder.
- Compression cutting by sharp rotary knife exerting radial cutting force against hardened metal bar surface located at a 42" height.

TAKE-OFF CONVEYOR:

- Standard conveyor center-line length is 60 inches (longer conveyor lengths available as option)
- Conveyor belt width is nominal sheet width plus 6 inches
- Conveyor pulley diameters - 8 inches
- Non-marking conveyor belt surface
- Upstream conveyor height - same as knife frame
- Downstream conveyor height - 42"
- Conveyor dimensions can be altered to suit customer requirements

LET-OFF UNITS: (Optional for Off-Line Units)

- Single Spindle Let-Off is powered with 2HP DC-SCR variable speed drive geared in for customers desired line-speed range
- Tilt-type safety chucks with 1-1/2" square slots for 2-15/16 diameter Let-Off Roll Shaft
- Expandable "Grabber" type air chucks for 6" cardboard cores
- Maximum roll weight - 3000 Lbs

OPTIONS:

1. Let-off units per outlined specifications
2. Longer than 60 inch take-off conveyor
3. Electrical other than 230V/3Ph/60Hz
4. Corner notching punches per customer radius

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