



SOS



Blown Film Mill

Atlanta, Georgia

CX-2

Entire Line

01/01/2001

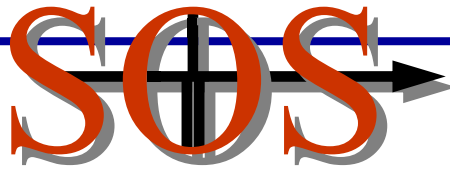
SOS# GA1234

800-638-8936

212 Trexler Lane
Rock Hill, SC 29732



STRAIGHTLINE OPTICAL SERVICE



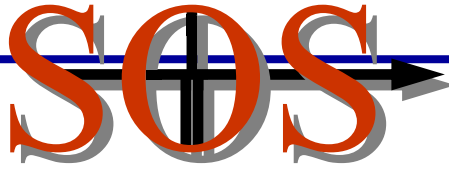
BLOWN FILM MILL

ATLANTA, GEORGIA

SOS#:	GA1234
SERVICE REQUESTED BY:	Steve Jackson
CONTACT PERSON:	Steve Jackson
MACHINE:	CX-2
SECTION:	Entire Line
DATE STARTED:	01/01/2001
DATE FINISHED:	01/01/2001
ESTIMATED TIME:	As Required
ACTUAL TIME:	As Needed
SOS TECHNICIANS:	Spencer Owens / Mike Bennett
MECHANICS PERFORMING WORK;	Mill

REASON FOR SERVICE:

SOS was instructed to inspect and correct all components of the CX-2 line.

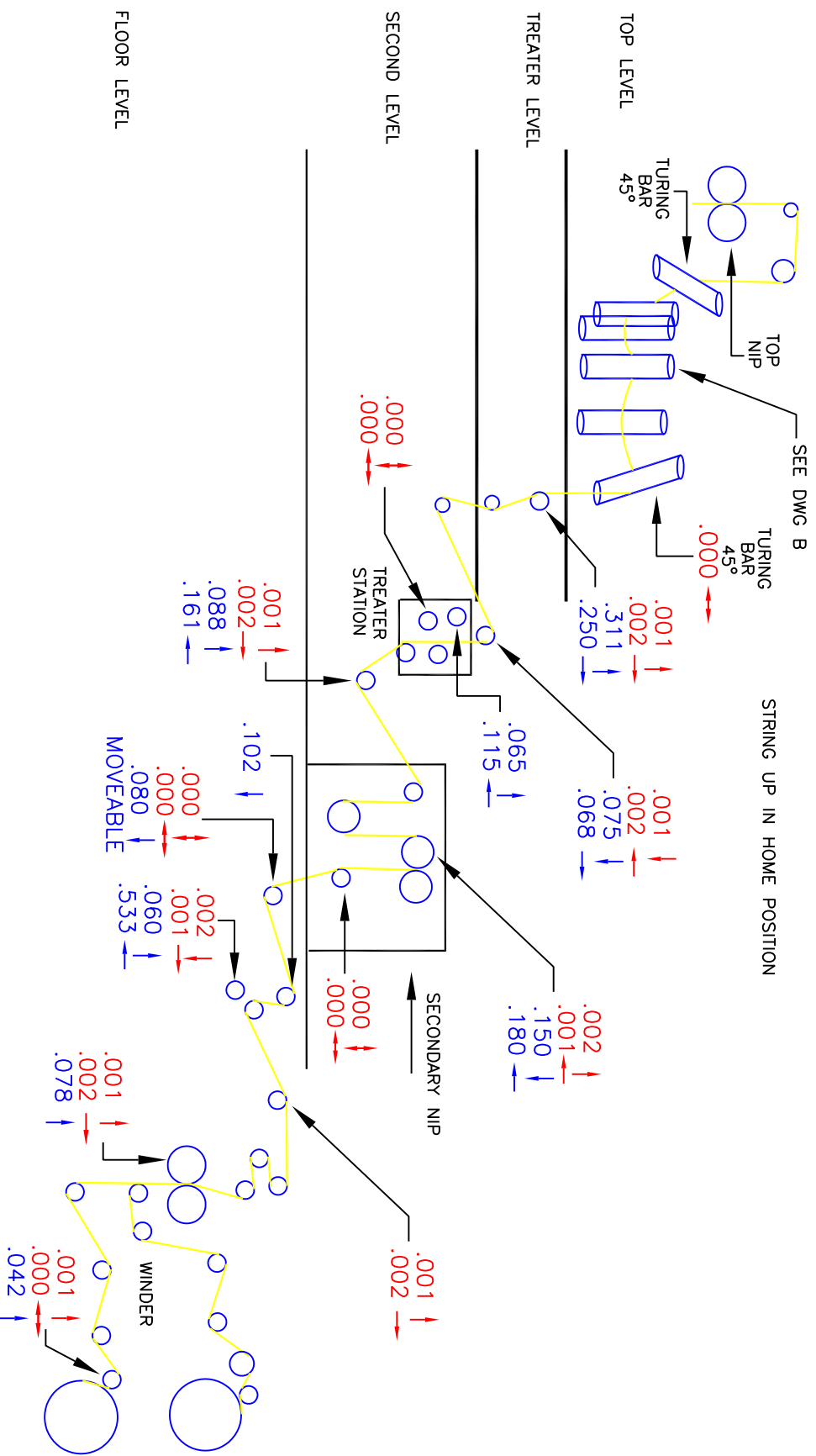


ALIGNMENT:

- ◆ SOS was contacted by Mr. Steve Johnson. Mr. Jackson requested that SOS inspect the entire CX-2 line. An inspection was also to be performed on the Treater Station and Nip Station. These were to be aligned with the true centerline of the machine. SOS established this centerline, and then produced an offset plugline which was used for all parallel inspections. The datum for level was gravity level. Tolerances to be held were +/- .003". The centerline established coincides with the centerline of the Primary Nip and the centerline of the Windup.
- ◆ SOS found the Secondary Nip off centerline by approximately 2 inches. SOS mechanics cut the welds holding the Secondary Nip in place and moved it to its correct position. All other components were inspected for centerline alignment and found to be in an acceptable position. Tolerance for this inspection was +/- .063" or 1/16".
- ◆ SOS inspected all components for level and parallel. Results of these inspections can be seen on drawing GA1234A.
- ◆ SOS inspected the rotating element of the Primary Nip. Only two of thirty jacking bolts were touching. This caused the table level to fluctuate greatly during rotation. This also caused the pulsating wrinkling coming out of the nip, as the nip would be level for a brief period during its rotation. See drawing GA1234B for the before and after results.

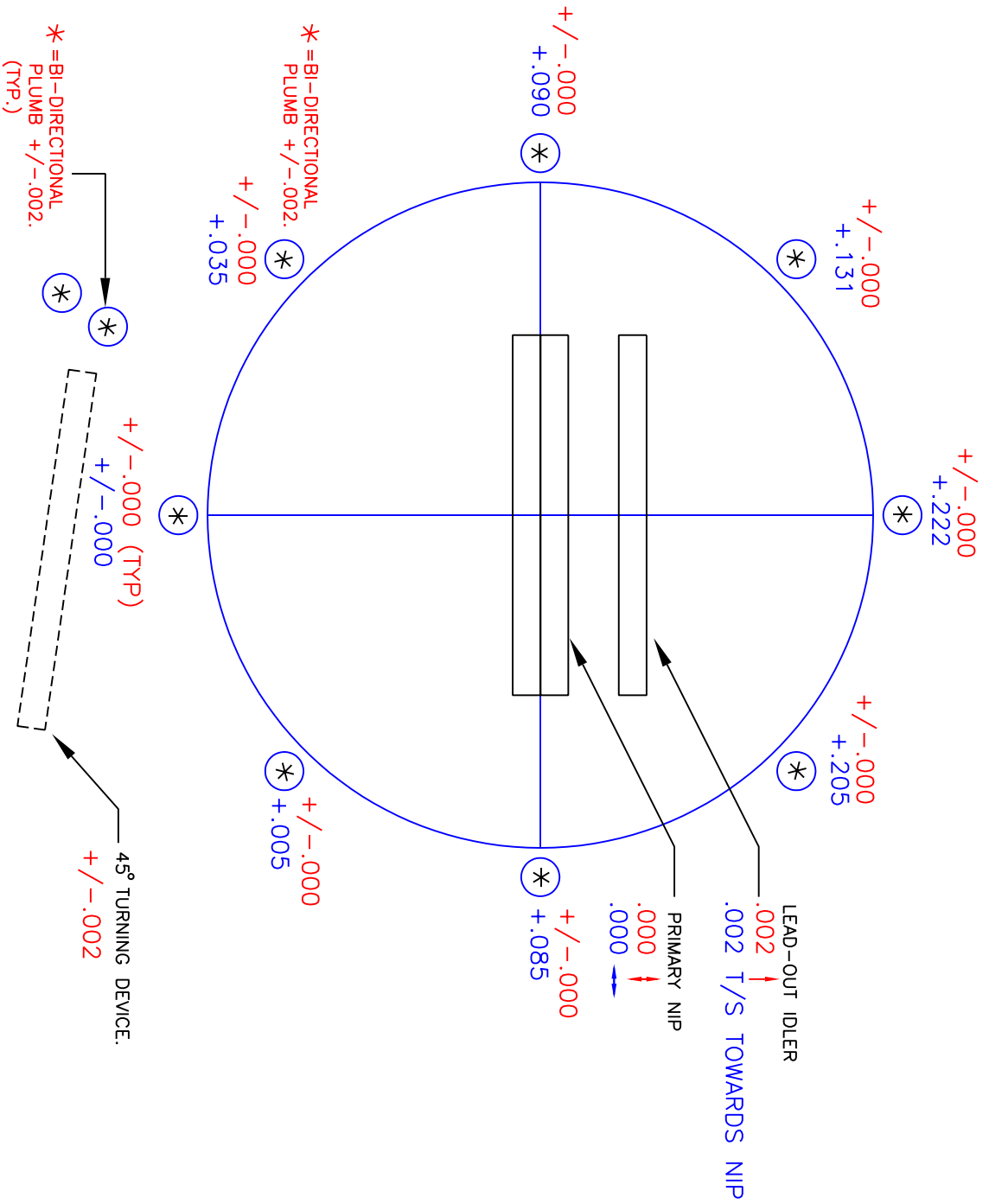
RECOMMENDATIONS:

SOS strongly recommends inspecting all film lines on an annual basis. This ensures that all components keep optimum alignment. This optimum alignment increases speed and quality and decreases unscheduled downtime.



- (1) NO SCALE INTENDED.
- (2) DATA INDICATES THE COMPONENT'S TENDING SIDE POSITION RELATIVE TO ITS DRIVE SIDE. THE DRIVE SIDE IS CONSIDERED THE "ZERO" REFERENCE (.000 +)
- (3) DATA IN BLUE INDICATES THE COMPONENT'S POSITION AS INSPECTED.
- (4) DATA IN RED INDICATES THE COMPONENT'S POSITION AFTER ADJUSTMENTS.

<h2 style="margin: 0;">STRAIGHTLINE OPTICAL SERVICE</h2>	
SOS FILE NO. <h3 style="margin: 0;">GA1234A</h3>	BLOWN FILM MILL ATLANTA, GEORGIA CX2 ENTIRE LINE
DATE: 1/01/2001 DRAWN BY: CCA	



- (1) NO SCALE INTENDED.
- (2) DATA INDICATES THE COMPONENT'S TENDING SIDE POSITION RELATIVE TO ITS DRIVE SIDE. THE DRIVE SIDE IS CONSIDERED THE "ZERO" REFERENCE (0.000 +)
- (3) DATA IN BLUE INDICATES THE COMPONENT'S POSITION AS INSPECTED.
- (4) DATA IN RED INDICATES THE COMPONENT'S POSITION AFTER ADJUSTMENTS.

STRAIGHTLINE OPTICAL SERVICE

SOS FILE NO.
GA1234B
 DATE: 01/01/2001
 DRAWN BY: CCA

BLOWN FILM MILL
 ATLANTA, GEORGIA
 CX-2
 TURRET PRIMARY NIP