

BST Eltromat France SARL Impasse de la Noisette - CE402 F-91374 Verrières le Buisson Tél.: +33 1 69 20 07 41 Email: bstfrance@bst.group Web: https://www.bst.elexis.group/	KOMORI for Gudang Garam ACU231001 Jérôme LEVIEL JL SEMAMPIR II/1 64121 KEDIRI Indonesia jerome.leviel@komori-chambon.fr
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Ticket number:	E2169
Customer order:	CDE CLIENT LS153146
Machine customer name:	KOMORI KEDIRI
AR:	
Tiket type:	INTERVENTION
Assign to:	NguJ -> jean-baptiste.nguyen@bst.group
Ticket date:	2024/07/24
Material:	REGISTER_R20
Type:	REGISTAR 20
SN:WA:	ASO065060 - WA0021084
Installation date of material:	2023/07/18
Teamviewer:	426 914 304
PC model:	
Original Application Version	3.9.002

8 day(s) of intervention calculation

2024 / 2024	Mon.09/09	Tue.10/09	Wed.11/09	Thu.12/09	Fri.13/09	Sat.14/09	Sun.15/09
Drive time		9	0.5	0.5	0.5	0.5	2
AM Start	07:30		08:52	08:00	08:00	08:00	
AM End			12:00	12:00	11:30	12:00	
PM Start			12:30	12:30	13:00	12:30	
PM End			20:00	19:00	19:30	20:30	
Drive time	9	2	0.5	0.5	0.5	0.5	9

2024 / 2024	Mon.16/09
Drive time	9
AM Start	
AM End	
PM Start	
PM End	22:00
Drive time	1.5

Start date of intervention	2024/09/09-07:30
End date of intervention	2024/09/16-22:00
Reason:	unstable R20 during splice.
Actions:	Komori's splice detector detecting splice, had too short signal for PLC cycle. Cycle time (10ms), cycle is too short to be visible by Komori PLC. After few run, closer circonference values are: Lenght standard: Feedback constant(1500->9000ms) Feedback gain (800->1200) Time constant lowpass: 6 Length event: FC: 7000ms FG: 800 TC Lowpass: 3 Lateral: FC: 2500 FG: 2500 TC Lowpass: 8 Offline config setting distance between unwinder splice to PU1: 35m (between each PU: 12m) After few splices we still have some waste more on lateral than on circonference. To improve circonference a D-portion had been set (consequence for D-portion value -> FG value must be lower). To improve lateral, we are now more reactif. Issue: splice sensor is just before PU1 Speed correction on lateral 250µm/s

	New settings: Length standard: FC: 9000ms FG: 600 TC Lowpass: 6 DeadB: 10 Hys: 20 D-port: 30 Length event: FC: 7000ms FG: 800 TC Lowpass: 3 DeadB:30 Hys.:20 Lateral: FC: 1500 FG: 900 TC Lowpass: 8 DeadB:20 Hys.:20 D-port: 50
Solution:	During and after splice, now behavior is better, reducing hardly the overshoot. Also on lateral behavior is more reactif. Waste during this period is reduced according acceptance value. The machine behavior with standard settings is also better. Full machine behavior after fine tuning is now agreed by KOMORI. (ipq center : checking waste indicator option, camera is well ejected defect printing)
Remarks:	
Ticket status:	open

Comment(s)

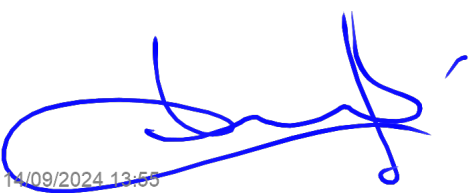
(If fields are not visible please open PDF file with Google chrome or Microsoft edge nagivator or update your navigator)

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Customer signature:

Name:

Date :


14/09/2024 13:55

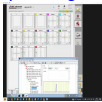
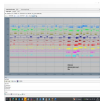
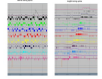
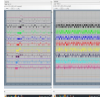
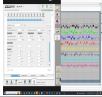
BST eltromat FRANCE signature:

Name:

Date :


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ATTACHED CALL'S FILE(S)

splice signal 	Teamviewer video for R20 behavior after splice signal 	Teamviewer video for R20 behavior after splice signal 	CDE CLIENT LS153146.pdf 	230m/min - 35m 
2024_09_14_07_42_35_splice-250m-min_side&length.png 	2024-09-13 11-01-31-233_250m-min-splice.mp4 	2024-09-14 08-20-01-142_splice250m-min.mp4 	2024-09-14 09-44-51-660_250m-min-splice.mp4 	2024-09-14_14-40_splice250m-min.png 
standard settings 	regi_star 20-20240914182914.zip 	2024_09_14_backup.zip 		

ACCEPTANCE CERTIFICATE / CERTIFICAT D'ACCEPTANCE

BST Eltromat France SARL Impasse de la Noisette - CE402 F-91374 Verrières le Buisson Tél.: +33 1 69 20 07 41 Email: bstfrance@bst.group Web: https://www.bst.elaxis.group/		KOMORI for Gudang Garam ACU231001 Jérôme LEVIEL JL SEMAMPIR II/1 64121 KEDIRI Indonesia jerome.leviel@komori-chambon.fr	
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Type:		REGISTAR 20	
SN:WA:		ASO065060 - WA0021084	
Installation date of material:		2023/07/18	

ACCEPTANCE CERTIFICATE: We confirm the acceptance of system REGISTER_R20 with serial number ASO065060 - WA0021084 installed the 2023/07/18 following parts list

CERTICAT D'ACCEPTATION: Nous confirmons l'acceptation du système REGISTER_R20 avec le numéro de série ASO065060 - WA0021084 installé le 2023/07/18 suivant la liste matériel de l'AR

Service instructions had been given by our engineer to following persons:
Les instructions de service ont été donné par notre ingénieur aux personnes suivantes:

Comment(s)

(If fields are not visible please open PDF file with Google chrome or Microsoft edge nagivator or update your navigator)

Customer signature:

Name: **Jerome LEVIEL**

Date : **14/09/2024**



14/09/2024 13:56

BST eltromat FRANCE signature:

Name: **JB NGUYEN**

Date : **14/09/2024**



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