

Customer: Nr. ACU231044
SA UGEPA
Z.I. ROUTE DE THENNES
80110 MOREUIL
France

place of installation:
SA UGEPA
Z.I. ROUTE DE THENNES
80110 MOREUIL
France

purchaser:	Aurelien Baillet
purchase no.:	signed quotation ASQ901393
telephone:	
contact person:	
technician:	Pfeiffenberger, Andreas

comm. BST:	WA 21406 / ASO073259
comm. customer:	IG8
machine:	Emerson &Renwik 8units
service order:	ASR006214
Internal	0

BST equipment:	regi_star 20
<i>additions/ comments:</i>	

driven distance		plate	fellow passenger
	km	rent car	

day	date	travel time		break h	working time		break h	travel time		break h	comment	total	working time				travelling time						
		from	to		from	to		from	to				N	50	100	150	N	50	100	150			
Mon	18.10.2021	13:00	21:45	2,00								6,75					6,75						
Tue	19.10.2021	8:00	8:30		8:30	18:00	0,75	18:00	18:30			9,75	7,50	1,25			0,50	0,50					
Wed	20.10.2021	8:00	8:30		8:30	18:30	0,75	18:30	19:00			10,25	7,50	1,75			0,50	0,50					
Thu	21.10.2021	8:00	8:30		8:30	18:00	0,75					9,25	7,50	1,25			0,50						
Fri	22.10.2021																						
short report												Σ	36.00	22.50	4.25			Σ	8.25	1.00			

short report

The machine is a retrofit from used EMERSON&RENWICK parts. Mounted to a new 6 colour units (gravure/screen), next a register less additional gravure unit then additional screen unit RC7 prepared (both not ready installed and connected). Last unit is a embossing after 20m dryer hood. In this commissioning we test the gravure unit 1-6 together with embossing.

The system was installed and switched on. Check the signal from encoder and motor commands to machine. Encoder haven't a zero impulse at the moment. This will be realized from LENZE Technician Mr Werner Siemer until next intervention. Also for the embossing the encoder ratio is 37128/11875 (enc/cyl), after restart always a new gate position have to fin out without zero impulse.

The machine profaned interface was tested only with signal "web-run", "acc" and "start auto seq.", all other functionalities will later realized on machine side.

Web guide is running and controlled from RC8 in offset para with EKR "automatic" mode. RSH signal from RC9 embossing is supported RC8 with same gate position. Other mark selection for 8 must defined in preparation selected "mark reference". The embossing analogue terminal is 16bit +-10V, on machine side is at the moment 14bit only positive anlage input. This terminal will replace if part available.

We run test job with units 1-6 and units 1-4 with embossing in register. The register can controlled until 80m/min with constant speed. Over 80 m/min the mark print wasn't stable the error range increase.

Also after acceleration the print units need a while until come in register. The machine have double chillroller without motorized. Every motor command need a while until reaction on the print register

The register control is commissioning with basic function. Screen print isn't tested, unit 7 not commissioning and embossing machine anlogue input is limited by wrong input card. A additional visit is nessessary

If all units/parts are ready for commissioning and testing. Control speed tested: normal speed 1mm/s, second speed 3mm/s. TeamViewer ID 1056826890

☐ Material required as per attached list!

☐ work completed

☒ additional visit necessary

France 21.10.2021

signature technician

signature customer

Pfeiffenberger, Andreas

21.10.2021 17:25 Aurelien Baillet