


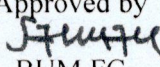
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Document type
Work Instructions

Title
Work Instructions for setting of rotary embossing Unit

1. Purpose:

To ensure that the setting of rotary embossing die shall be carried out under controlled conditions.

Prepared by  Hassan	Approved by  BUM FC	PAGE 1(1)	REV 4	DATE 01.07.2024	DOC NO. WILEMANIC/CL/4.9/02
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2. Scope:

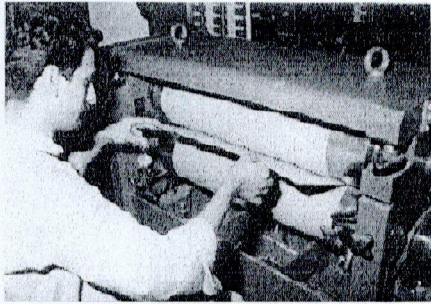
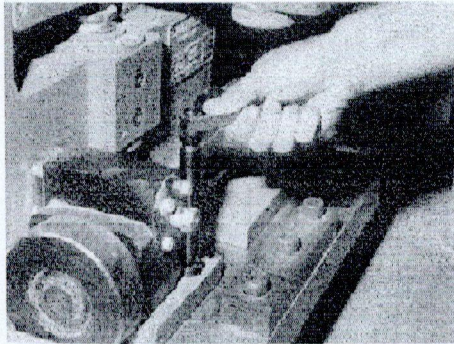
These instructions are applicable to setting of rotary embossing die.

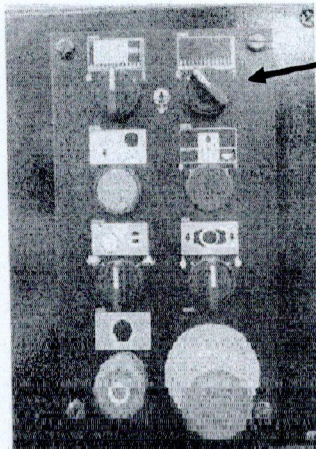
3. Overall responsibility:

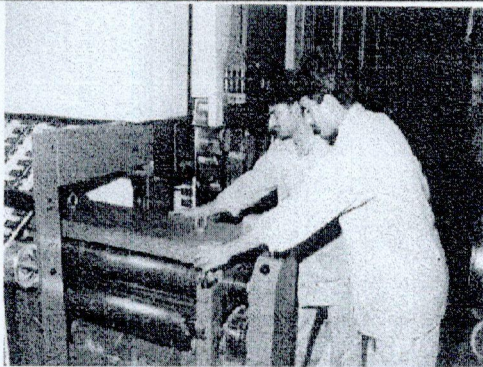
Overall responsibility lies with the production manager carton line.

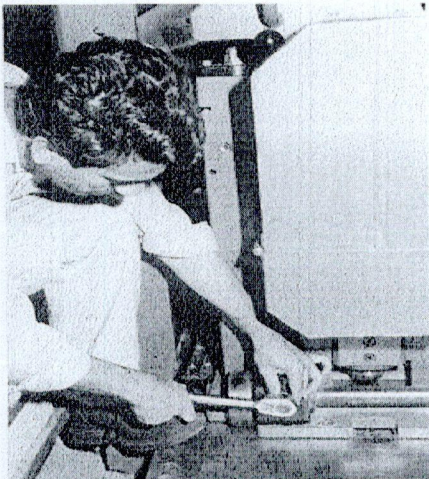
4. Instructions:

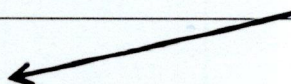
Sr. #	Activity	Responsibility
4.1	Remove the protective paper from the embossing rollers	Operator

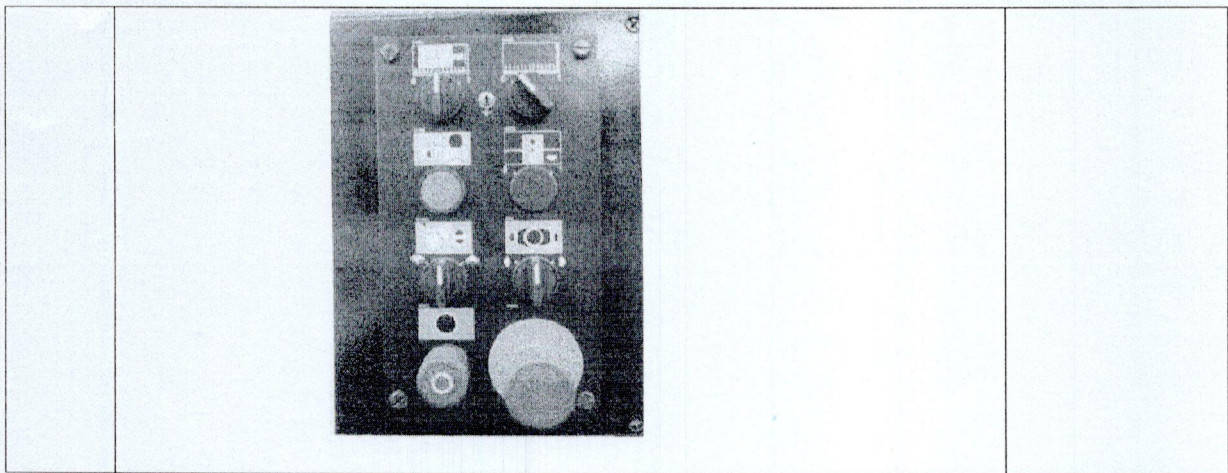
		
4.2	Unlock the embossing unit from the base. 	

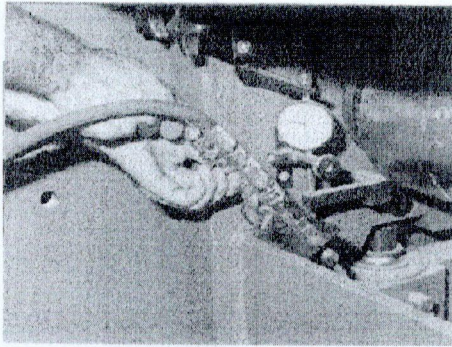
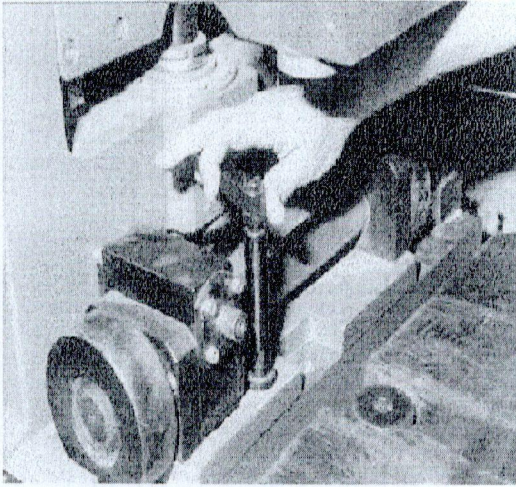
Sr. #	Activity	Responsibility
4.3	Turn selector S46G to position "1" to turn on the air supply.  S46G	Operator
	printing units at 12'o clock.	
4.5	Push the embossing unit into the machine.	Operator

		
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Sr. #	Activity	Responsibility
4.6	Free the wheel of the embossing unit by moving the screw. 	Operator
4.7	Push further the embossing unit till it reaches to its position.	
4.8	Turn selector S46G to "0" position to stop the air pressure. S46G	

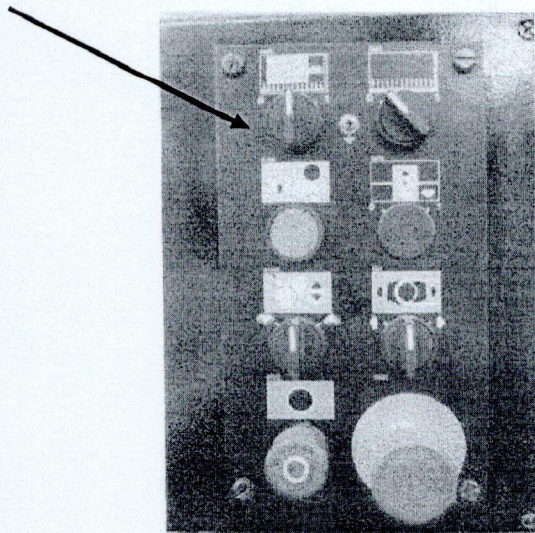




Sr. #	Activity	Responsibility
4.9	Plug-in the hydraulic pipes. 	Operator
4.10	Lock the embossing unit. 	

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Sr. #	Activity	Responsibility
4.11	Thread the web into the embossing unit.	Operator
4.12	The embossing rollers can be lifted or lower with the help of selector S20G the cutter- creaser panel.	Operator.
4.13	To remove the embossing unit, o the same in the reverse order. Use selector S40G on the embossing unit panel to push the unit out of the machine.	Operator



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