



Date

"We Do It Right"

Your Company Name

Street Address

City, State Zip Code

Attn: Contact name

Re: Optical Alignment services on (Machine identification)

Right Alignment was asked to check the alignment of the #3 Laminator. We used the brass monuments in the aisle as our zero datum for machine centerline. We started the alignment process by checking the alignment of the rewind. No adjustments were needed on the rewind. We did notice the #1 core chuck is showing some wear. The two core chucks are level to each other but the roll is .025" low on the tending side indicating the wear in the chuck assembly.

On the laminator unit, the two unwind cores were .025"-.040" out of level similar to what was found the last time it was aligned in August, 2011. Shim was added to the frames to get the cores level. The lead-out roll under the floor was .050" out of level and adjusted accordingly. Several of the idler rolls under the floor between the laminator and the treater were .050"-.080" out of level. The mounting rail on the drive side was bowed down in the center. We were able to adjust the rail back level again.

Next, we checked the alignment of the treater through the unwind. The treater frame was .010" out of square. We adjusted the frame and then rechecked the rolls. The nip roll to the treater roll was "scissored" .025". The nip roll slides were adjusted to get the nip roll level. However, the roll may not hold its alignment due to the design. There was a "scissors" between these two rolls as our last visit as well. This misalignment will cause the web to pull uneven across the web as well as causing premature wear on the rubber roll. The outbound tension sensor roll was also .075" out of square.

The web guide infeed rolls were also twisted .070". We were able to align all of these rolls within .005" by shimming the frames at the floor. We were told you were having running issues

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Specializing In Industrial Alignment

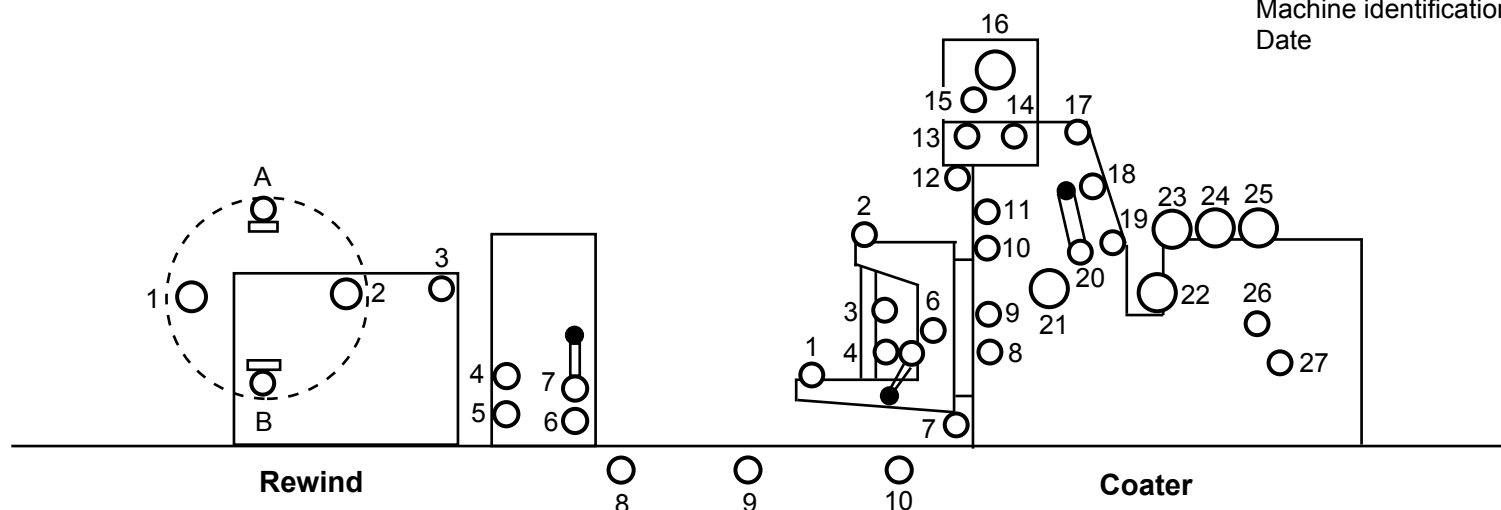
between the treater and the web guide area. The alignment issues found in these areas may have been the cause.

Lastly, the alignment of the unwind was checked. The alignment was satisfactory with the exception of the carry over rolls which were .020"-.025" out of square. These rolls were adjusted within .005".

Our alignment readings are on the following page. If you have any questions, feel free to contact us. Thank you for using our services.

Sincerely,

Jon Labs
Optical Alignment Specialist



REWIND

<u>ROLL #</u>	<u>LEVEL</u>	<u>SQUARE</u>
1	.000"	.012" R
2	.005" L	(----
3	.003" L	.000"
4	.000"	.000"
5	.005" H	.000"
6	.009" H	.000"
7	.005" H	.005" U
8	.002" L	.006" U
9	.005" H	.010" U
10	.000" (.050" H)	.010" U
A	.000"	.010" U
B	(----	.012" U

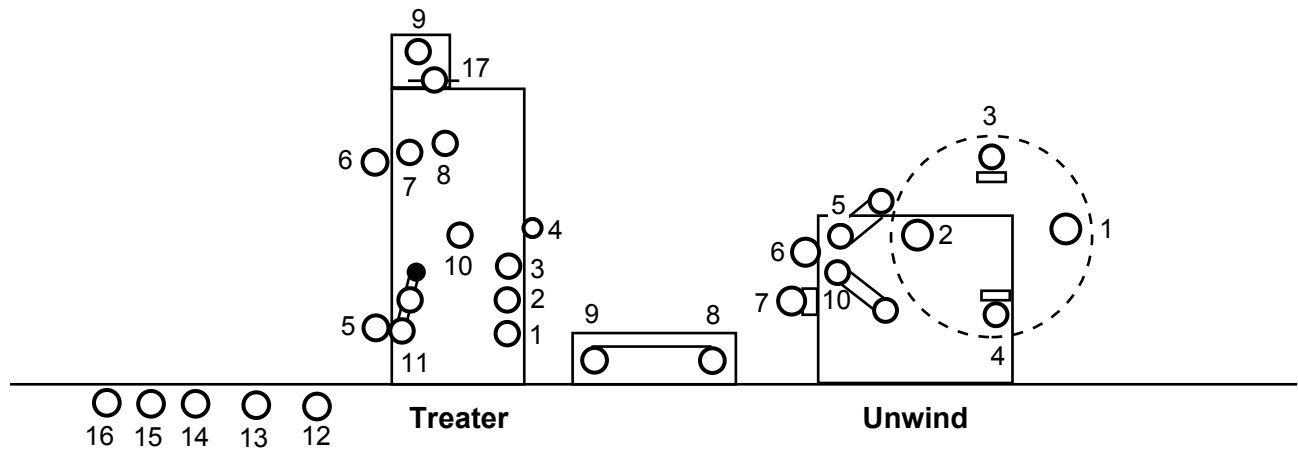
COATER

<u>ROLL #</u>	<u>LEVEL</u>	<u>SQUARE</u>
1	.005" H (.040" L)	.005" R
2	.005" H (.025" L)	.008" R
3	.000"	.005" R (.030" R)
4	.000"	.005" R
5	.003" H	(----
6	.003" H	.005" R
7	.000"	.007" R
8	.003" H	(----
9	.003" H	.005" R
10	.005" H	.006" R

COATER (cont'd)

<u>ROLL #</u>	<u>LEVEL</u>	<u>SQUARE</u>
11	.000"	.006" R
12	.002" H	.006" R
13	.000"	.000"
14	.003" L	(----
15	.005" L	(----
16	.007" L	.008" R
17	.003" H	.007" R
18	.002" H	.006" R
19	.005" H	.006" R
20	(----	.003" R
21	(----	(----
22	.002" H	.006" R
23	.002" H	.006" R
24	(----	(----
25	.005" H	NIP
26	.000"	.005" R
27	.000"	.006" R

KEY: L- Low to Tending Side
H - High to Tending Side
U - Tending Side Toward Unwind
R - Tending Side Toward Rewind
(**) - Before Alignment Reading



TREATER

UNWIND

<u>ROLL #</u>	<u>LEVEL</u>	<u>SQUARE</u>
1	.007" H	.002" R
2	(----	.002" R
3	.005" H	.002" R
4	.000"	.002" R
5	.002" L	.003" R
6	.005" H (.025" H)	.005" R (.015" U)
7	.005" L	.002" R (.075" U)
8	.005" H	.005" R (.003" U)
9	.000"	.005" R (.003" R)
10	.005" H	.002" R (.008" U)
11	.005" H	.000" (.010" U)
12	.000"	.002" R (.008" U)
13	.000" (.060" H)	.002" R (.008" U)
14	.000" (.080" H)	.002" R (.008" U)
15	.000" (.080" H)	.002" R (.008" U)
16	.000"	.002" R (.008" U)
17	.000" (.025" L)	NIP

<u>ROLL #</u>	<u>LEVEL</u>	<u>SQUARE</u>
1	.006" L	.005" U
2	.007" H	(----
3	.003" L	.003" U (.010" U)
4	(----	.000" (.025" U)
5	.004" H	.010" R
6	.005" L	.005" U
7	.005" H (.020" L)	.000"
8	.005" H (.025" H)	WEB
9	.005" L (.050" L)	GUIDE
10	.003" L	(----

KEY: L- Low to Tending Side
H - High to Tending Side
U - Tending Side Toward Unwind
R - Tending Side Toward Rewind
(***) - Before Alignment Reading