

SECTION III: TROUBLE SHOOTING

This chart will help you identify some slitting problems and solutions.

SYMPTOM	POSSIBLE CAUSE
Strip width out of tolerance	Incorrect setup Incorrect stripper ring practice Loose arbor nut Out of square condition on arbor Arbor deflection
Poor edge condition	Incorrect horizontal knife clearance Incorrect vertical clearance or overlap Separator disc practice Speed mismatch
Knives dull too quickly	Incorrect knife grinding practice Incorrect knife selection Speed mismatch Incorrect vertical/horizontal knife clearance
Knives chip	Too much vertical overlap Incorrect horizontal clearance Incorrect pass line Incorrect stripper ring practice Speed mismatch Incorrect knife grade selection
Marks on strip surface	Incorrect stripper ring practice Speed mismatch Incorrect tension stand practice Incorrect coolant practice Knife design
Camber in strips	Poor quality master coil Overarm & slitter alignment Inconsistent horizontal clearance
Wavy edges	Poor quality master coil Incorrect horizontal clearance Incorrect vertical clearance Incorrect stripper ring practice

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