

Installation Instructions

REELEX Equipment

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Technician's Time

With the purchase or rental of any REELEX coiling machine, REELEX Packaging Solutions, Inc. provides a technician to power on, perform adjustments, test and train personnel.

NOTE: Technician's time used in commissioning REELEX coiling equipment is complimentary, including time spent powering, testing and training. However, the customer is responsible for travel expenses of the traveling technician.

Typical Commissioning Schedule:

Machine Type:	Single Spindle	Dual Spindle	Automated
# Technicians:	1 or 2	1 or 2	2
Day 1	Arrival, final installation, degreasing and power up	Arrival, final installation, degreasing and power up	Arrival, final installation, degreasing and power up
Day 2	Production personnel training	Line setup, integration and reset	Line setup, integration and reset
Day 3	Maintenance personnel training	Machine adjustment and testing	Machine adjustment and testing
Day 4	Testing and product configuration	Testing and product configuration	Testing and product configuration
Day 5	Answering questions, qualification	Answering questions, qualification	Production personnel training
Day 6			Production personnel training
Day 7			Maintenance personnel training
Day 8			Maintenance personnel training
Day 9			Answering questions, qualification and testing
Day 10			Departure

Customer Responsibilities

IMPORTANT: The following instructions are the responsibility of the customer. If additional time or an extra trip by REELEX personnel is required due to these items being incomplete, you will be responsible for all additional expenses, including technician's labor at current rates.

Installation Instructions

1. Shipping

Most REELEX equipment is sold ex-works (EXW) unless otherwise negotiated. When your equipment is completed, we will contact you regarding making shipping arrangements to pick up the equipment.

2. Prepare Power and Air Supplies

Prior to equipment arrival, please have the following air and power supplies available:

	Power Supply:	Air Supply:
Requirements:	230 v (+/- 10%), 3 phase, 40 amps, 50/60 Hz.	70 psi (5 bar) minimum Must be clean and dry
Fittings / Other:	Transformer is available for purchase upon request or may be purchased locally.	Typical Fittings: ½" NPT (or 15mm) D-1500 Fittings: ¾" NPT (20mm)

3. Unpack, Bolt to Floor and Prepare

Reference:

Line layout drawings can be found under the [manuals](#) section on www.REELEX.com/support

- I. When the equipment arrives, unpack and place the machine on the floor according to the line layout drawing. Please have all additional components (printer, sparker, etc.) ready for installation when setting up the REELEX line.

IMPORTANT: REELEX Technicians are not responsible for unpacking, moving or bolting equipment to the floor. Please have equipment unpacked, moved and ready to run prior to REELEX's arrival.

Payoff Requirements

Can I use a non-REELEX payoff with my REELEX machine?

Yes, however you will likely be unable to achieve maximum performance from your REELEX machine. If you plan to use a non-REELEX payoff with REELEX coiling machines, the payoff must:

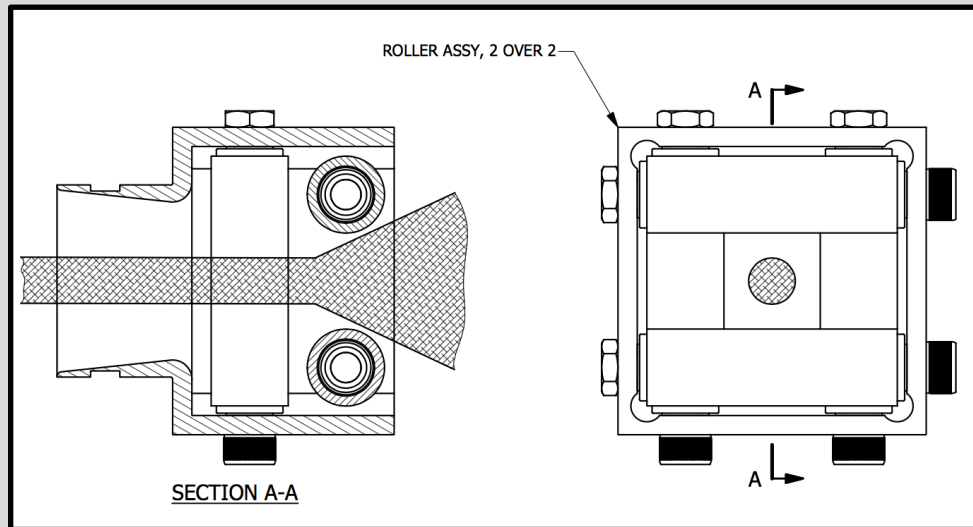
- Have a four-quadrant regenerative DC drive.
- Accept inputs from a 1K to 5K Ohm potentiometer signal from the [UDA](#).
- Be designed for rapid acceleration and deceleration from stop to full speed approximately 30 times per hour.
- Have adequate power to accelerate a full supply reel from stop to full speed in approximately 10 seconds.

Line Layout and Cable Path

Please pay particular attention to line alignment and spacing per the line layout. Ensure that the cable comes into contact as little as possible with components like guides, box rollers, etc. Not doing so could have electrical performance impacts on twisted-pair products.

Reference Drawing:

- [Drawing 99552](#) - Acceptable Wire Path



- II. Reassemble detached assemblies and ensure the machine is level:
 - A. Single-Spindle Machines - Place level on guarding frame
 - B. Dual-Spindle Machines - Place level on guarding frame
 - C. D-2000/D-2050 - Place level on boxing table rails (both directions). Also place level on spindle table rails.
- III. Bolt equipment to the floor, and run air and power to equipment. DO NOT TURN ON POWER. See line layout for locations.
- IV. Make sure all bare metal components have had protective coatings removed.
- V. REELEX supplies the complete line pre-wired with flexible conduit, please connect equipment using the conduits provided.

WARNING: Do not turn on power without REELEX personnel present. Applying power will void the warranty and could damage machine electronics.

4. Ensure All Line Components are Installed

Ensure all accessories (sparker, printer, etc.) are in place on the line according to manufacturers' instructions prior to REELEX's arrival. REELEX is not responsible for the installation or commissioning of non-REELEX equipment.

Technicians will assist with integrating accessory devices with REELEX machines, including landing cables, however cables must be provided and devices installed prior to REELEX's arrival.

IMPORTANT: REELEX personnel are only responsible for the startup and training of REELEX equipment. Additional components on the line should be installed by the respective manufacturer. If additional time is required to commission REELEX equipment due to missing or improperly installed accessories, technician time will be billed at standard rates.

5. Contact REELEX to Schedule Commissioning

When equipment is in place contact REELEX to schedule a technician visit.

6. Prepare for Technician's Arrival

Schedule the availability of at least one person to help the REELEX personnel with controller-to-machine wiring and other last-minute setup necessities.

During Commissioning

7. Make Cable Available

An adequate supply of cable, boxes and tubes should be made available for a “shakedown run”. The following amount of product is requested depending on machine type:

Single and Dual-Spindle Machines: REELEX recommends at least 100,000 feet of cable, 100 boxes and 100 tubes minimum.

Automated Machines: REELEX recommends at least 500,000 feet of cable, 500 boxes (1000 foot lengths) and 500 tubes. Please supply more if possible.

NOTE: Cable used during “shakedown” is typically sellable as long as all other customer equipment in the line is operational. Please make sure components such as sparkers or printers are up and running prior to running the line.

8. Provide Personnel for Training

All personnel related to REELEX machine production or maintenance should be available for training during commissioning. Please make sure technician’s time is used wisely.

If additional time is required due to key personnel not being present during commissioning, technician time will be billed at standard rates.

9. Equipment Sign Off

Once the equipment is deemed ready for production, the customer is responsible for signing off on the equipment and taking responsibility.

Confidentiality Statement

WARNING: This machine, manual and information contained herein is subject to the confidentiality clause of the REELEX License Agreement. In order to protect the intellectual property associated with the REELEX license, it is unlawful to copy, distribute or otherwise exploit the REELEX name, trademark, know-how and associated patents.

"All Know-How made available to LICENSEE by REELEX shall be kept confidential by LICENSEE who agrees not to disclose any such Know-how to third parties without the previous written consent of REELEX. Upon termination of this AGREEMENT and, upon sixty (60) days written notice by REELEX to LICENSEE, LICENSEE shall return to REELEX all Know-How reduced to documentation previously made available by REELEX to LICENSEE. LICENSEE shall not, after termination, disclose any Know-How to others or otherwise use, employ or exploit it."



This machine and packaging covered by U.S. and international patents issued and pending.

..... REELEX
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REELEX Contact Information

Email: Support@reelex.com

Phone: +1 845-878-7878

Website: www.REELEX.com

Technical Support and Service

REELEX Packaging Solutions Inc. is always committed to servicing the needs of our licensees. As a REELEX licensee, please remember that all assistance over the telephone or email is always free.

Support Team Email: support@reelex.com

Manuals: www.REELEX.com (find your machine and press the “manuals” button) or
www.REELEX.com/support

REELEX Warranty Statement

During the period of one year from the date of delivery of any Machine purchased or leased by LICENSEE pursuant to the LICENSE AGREEMENT, REELEX shall service such machine and repair or replace any machine part of the machine that becomes defective or faulty as a result of REELEX's fault, free of charge for parts and labor, unless such defect or fault shall be due to LICENSEE's negligence.

After the expiration of one year from the date of delivery of any REELEX Machine purchased or leased by LICENSEE pursuant to this AGREEMENT, REELEX shall continue to provide servicing of the machines as LICENSEE may request, but LICENSEE shall pay REELEX' servicing expenses for such machines, including labor and overhead, and shall pay for any required machine parts required to service such machines.

LICENSEE will permit REELEX, at REELEX's expense, to make service inspections of REELEX Machines at mutually convenient times, upon advance request by REELEX.

Equipment Manuals

NOTE: Comprehensive documentation is always available on our website:
www.REELEX.com/support

REELEX Service

All verbal or electronic advice, consultation or other assistance given over phone or email is always free of charge.

Issues with REELEX equipment should first be reviewed with REELEX technicians over phone or email before a service call is deemed necessary. Many issues can be resolved without a visit.

Service calls are billed per REELEX's service rates: www.REELEX.com/support.

Maintenance Performed by Licensee

Aside from mandrels and endforms, components used in REELEX machines are similar to components used in other common machinery in the wire and cable industry. As a part of the commissioning process of every REELEX machine, the REELEX commissioning technician will provide training to the Licensee's maintenance personnel for performing troubleshooting and routine maintenance.

REELEX machines have an extensive onboard troubleshooting system that can identify many common problems. In addition, service assistance from REELEX by phone or email is always available and always free.

Licensees are expected to employ mechanical and electrical maintenance personnel with adequate training and experience to work in a manufacturing facility. Specialized training is not required.

Once some minimal experience is acquired with REELEX machinery, most common problems can routinely be handled by Licensee's maintenance personnel. In the rare cases where a REELEX technician is needed, they can be dispatched with very little notice.

NOTE: Find manuals and other documentation for your machine at: www.reelex.com/support

Components/Issues that can be serviced by Maintenance Personnel:

- Wiring
- Motors
- Drives, including tuning procedure (Call REELEX for assistance if necessary)
- Connections
- Sensors
- Encoders
- Power supply
- Mechanical issues
- Springs, Bushings, Valves, etc.
- Lubrication and preventative maintenance
- Circuit Board Exchanges

Components/Issues that should be serviced by REELEX Personnel:

- Mandrel/Endform alignment, irregularities, unbalanced operation
- Traverse defects or improper movement
- Circuit board components
- Coil formation issues (no hole, inconsistent winding pattern)