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How Does Your Company Reduce Downtime?

The Quick-Set Bar
reduces downtime for
major business forms manufacturer

A White Paper
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Downtime is always a hot topic when discussing a printer's productivity. When a press is down, orders run late, customers become frustrated, and most important, money is lost. An area that is often overlooked is the downtime caused by making perforating rule and cutoff rule change over. EMT International introduced the patented Quick Set Bar in 1997 to help printer's reduce the amount of downtime required to make their necessary rule changes.

A perforating or cutoff bar is utilized to hold a flat blade (rule) in position on a rotating cylinder. The bar is installed in a slot(s) running the length of the cylinder. The perforating or cutoff rule is held in place by the bar. As the cylinder rotates, the rule strikes an opposing rotating anvil which creates the desired perforation or cutoff in the web. Traditionally, these bars, known as gib bars, were designed for the operator to set the height of the rule by turning bolts on the bar. Setting the rule height is required for each change over. This is a tedious process and a safety hazard. Operators have to contend with the edge of the rule and possibly inflict injury.

The EMT International Quick Set Bar is patented and designed for easy and safe rule changes. The bars are set to the required rule height at the initial installation of the bars. There is no need for adjustments of the bar for each rule change over. When installing the bar, shims are placed at the bottom of the slot (running the entire length of the slot) to help create the desired rule height. A urethane pad, sits on top of the shims, and also runs the length of slot. The bar is installed on top of this shim/urethane pad build up and held in place by safety clamps at each end. The urethane pad acts as a shock absorber that resets the rule to its original height after each strike of the anvil creating the extra benefit of extending rule life versus traditional gib bars. The rule rests on the steel lip of the bar for added durability and life span. An o-ring runs the length of the bar to press against the rule to prevent any side shaft.

To change rule on the EMT International Quick Set Bar, a compression tool resembling a pitch fork, fits into pre-drilled holes on top of the bar. The operator pulls the bar back utilizing the compression tool and the rule is easily removed and replaced. There is no need to reset the rule height when this change over occurs. These bars have been field proven for over 10 years.

A test done by a major business form manufacturer found that change out of rule using traditional bars took 1,240 hours of downtime over a year period. With the EMT International Quick Set Bar, downtime was reduced to 60 hours over the same year period. For more information on this study, please see the results below.

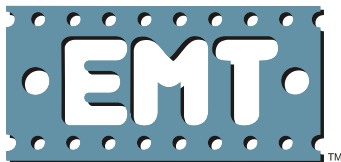
STUDY RESULTS	Press	# of Bars Required	Number of Make Readies Requiring Rule Change	Number of Rule Per Press	Number of Rule Changes Per Year
	A	10	492	2	984
	B	4	225	2	450
	C	4	234	2	468
	D	4	890	2	1,780
	E	4	489	4	1,956
	F	4	343	2	686
	G	2	847	2	1,694
	H	4	899	2	1,789
	I	2	67	2	134
	J	4	110	4	440
	K	6	60	4	240
	Total	48			10,630

7 Minutes Per Traditional Bar Rule Change VS. **20 Seconds Per EMT International Quick Change Bar**

10,630 Total Rule Change Out Per Year

Total Downtime Per Year for Traditional Bar Rule Change: 1,240 Hours
Total Downtime Per Year for EMT International Quick Change Bar: 60 Hours

It was concluded that the EMT International Quick Set Bar is a safe, effective method to reduce press downtime and increase productivity. The return of investment is quick and easy to document. Next time you are investigating reducing downtime on your printing presses, consider the downtime for perforating and cutoff rule changeovers. EMT International has a solution for you.



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