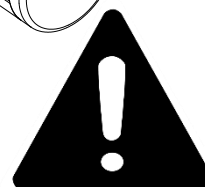
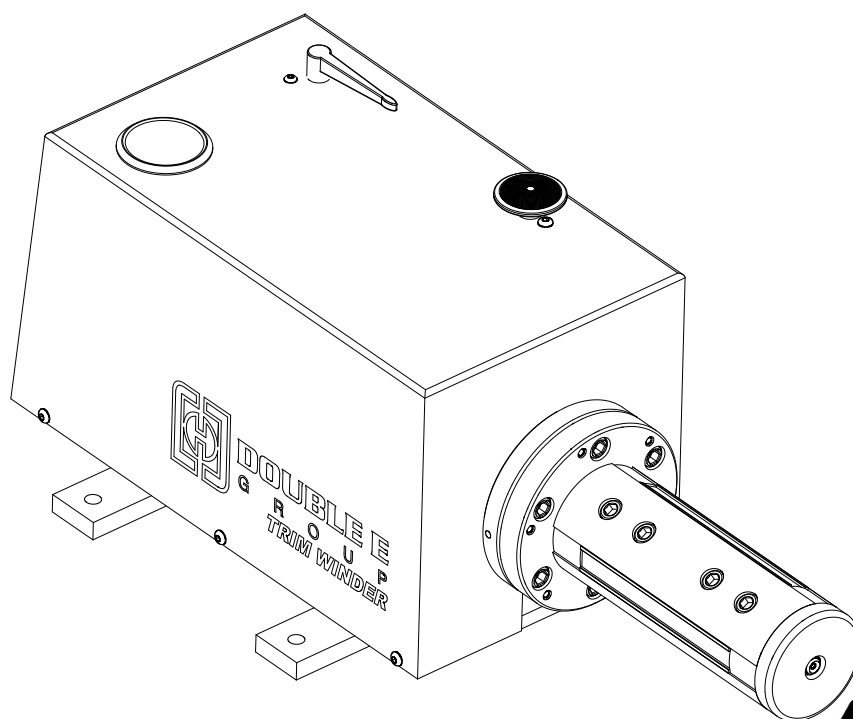


*USER'S GUIDE AND MAINTENANCE
MANUAL FOR DOUBLE E GROUP
PNEUMATIC TRIM WINDER*



ENG

USER'S GUIDE AND MAINTENANCE MANUAL FOR DOUBLE E GROUP PNEUMATIC TRIM WINDER

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A. INTRODUCTION

A.1 Introduction

We thank you for choosing Double E Group Pneumatic Trim Winder and are pleased to have you as a customer. We are confident that our product will provide you with years of satisfaction. For optimal performance, please use and maintain your Double E Group Pneumatic Trim Winder as outlined in this manual.

We recommend that you read this manual carefully and refer to it whenever a problem may arise. Our Technical Support department is also always available for advice and assistance. This manual describes the installation, operation, usage precautions, and detailed information about this product's accessories and options.

The product must be used according to the instructions. Keep this manual as a reference for the future.

Double E Group reserves the right, at any time, to make changes (without any obligation of revision), felt to be useful for the product improvement or for any constructive or commercial reason. Copying, buffering and transmission in any form (electronic, mechanical, by photocopying, translating or others) of this publication is forbidden without express Double E Group authorization.

Double E Group refuses any responsibility in case supplied equipment are set at work before the machine where they are going to be fitted has been declared to be in accordance with provision of the law 89/392 and its subsequent modifications.

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A.3 Important

- Do not use this product before having read and understood the whole content of this manual.
- Double E Group has done everything possible to make this manual complete and correct.
- Please transfer this manual to subsequent users if the product is lent or sold.
- Should this documentation or the warning labels applied on the device be lost or damaged, please request replacements from the supplying company.

A.4 Warranty

See general terms of sale. Our standard warranty is available on our website at www.ee-co.com.

B. SAFETY

B.1 Safety Instruction - Symbology

- For safe operation of the Double E Group Pneumatic Trim Winder, carefully read these safety instructions before use.
- Follow every WARNING and ATTENTION note, described in this section, as they are extremely important for safety.
- In this manual, warnings are indicated by the following signal word conventions.



Indicates a potentially dangerous situation that, if not avoided, is almost certain to cause serious injuries or death.



Indicates a potentially dangerous situation that, if not avoided, can cause moderate to serious injuries, or even death.



Indicates a potentially dangerous situation that, if not avoided, can cause minor to moderate injuries or damage to the equipment.



Highlights information needed to ensure the proper use of this device.

B.2 Safe Operation of Equipment



Double E Group designs and manufactures trim winders with maximum safety in mind. Please take careful note of the following rules for safe operation:

- Double E recommends always using the trim winder carefully without abusing it. Avoid strong collisions and/or accidental impacts with foreign bodies. These collisions can damage the trim winder's internal components.
- There is risk of injury or pinching from the rotation of this trim winder during winding as well as removing the trim material/core from the shaft. Keep sufficient distance during winding and do not touch any part of the shaft or optional side shields during rotation.
- Do not wear loose hair, clothing, or jewelry near rotating elements for risk of entanglement.
- Do not use the trim winder in working conditions different than stated in the specifications table or on any notes on the approval drawing.
- Do not exceed the operating loads of the trim winder as specified on the customer quotation and/or approval drawing. This voids the trim winder warranty and can be unsafe.
- Make sure all fasteners are in place and torqued to the appropriate specification before operation.
- Make sure the shaft is fully inflated before operation.
- All replacement parts on this trim winder should be original equipment supplied by the Double E Group.



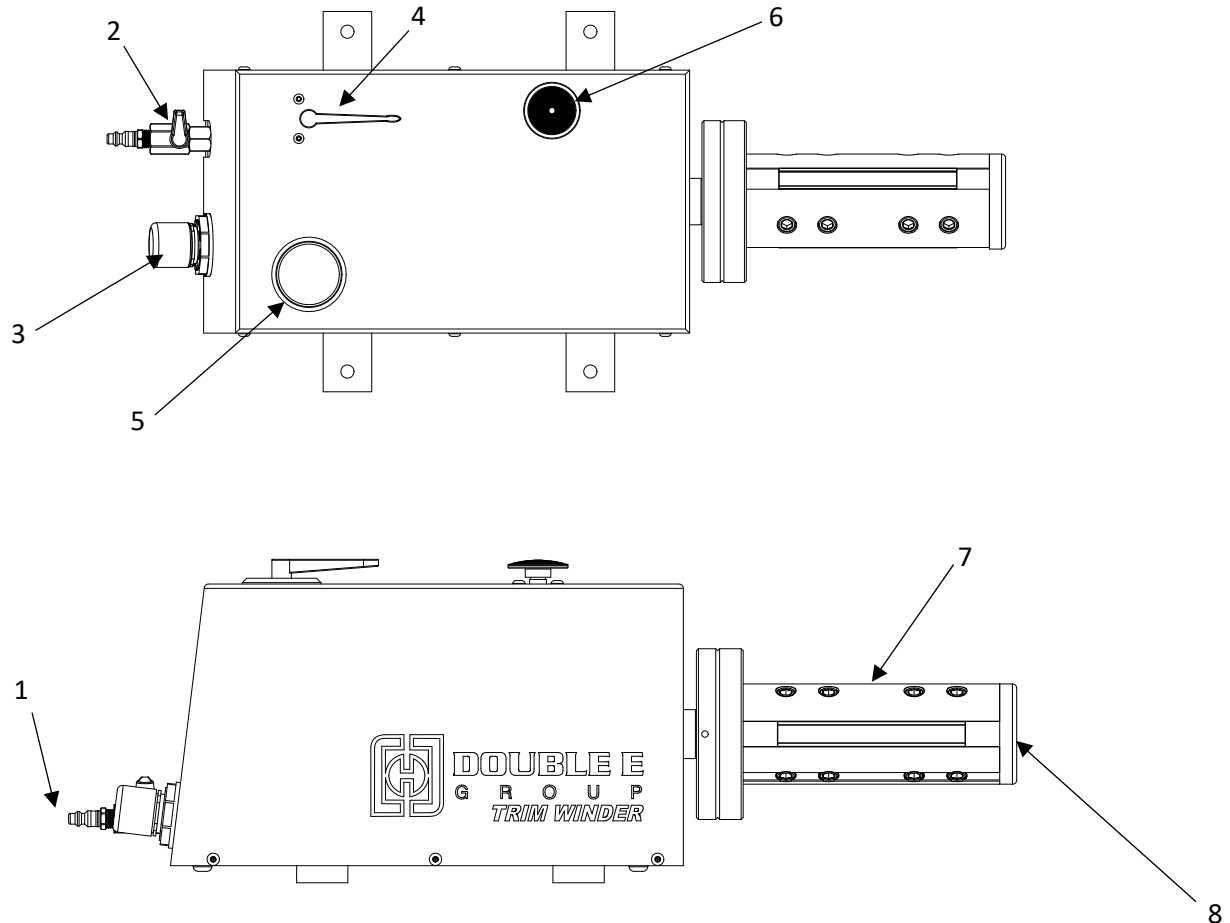
Visually inspect the bladder chuck prior to each use:

- Check the shaft body for any cracks or excessive wear.
- Check the gripping strip or leaf material for any cracks or excessive wear.
- Check that all pneumatic valves and fittings are tight and free of any leaks.
- Check that all fasteners are tightened to proper torque specification.

In the event that any of the above conditions are identified, do not put the bladder chuck in service and contact Double E Group Technical Support at 508-588-8099

C. TERMINOLOGY

C.1 Trim Winder Components



- | | |
|--|--|
| 1. Air Inlet (Universal Quick-Connect) | 6. Palm Button (For Reversing Direction) |
| 2. 90 degree ON/OFF valve | 7. Shaft |
| 3. Air Pressure Regulator | 8. Shaft Air Valve (shaft end) |
| 4. Speed Controller | |
| 5. Pressure Gauge (0-100psi) | |

Drawing is for reference only. Actual configuration may vary. Please refer to your approval drawing for an exact list of components included.

D. OPERATING INSTRUCTIONS

D.1 Shaft Inflation/Deflation

WARNING

Do not inflate or deflate the trim winder shaft while it is rotating.

To **inflate** the trim winder shaft, press the tip of the Double E Inflation Tool into the air valve. Squeeze the Inflation Gun while maintaining firm contact between the tip and the air valve for at least 30 seconds. This will ensure that the shaft is fully inflated prior to use. Refer to your specific assembly drawing for the correct air pressure for normal operation. In most cases, the trim winder shaft should be operated at a minimum of 80psi (5.5 bar) and should not exceed 100psi (7 bar).

Most Double E Trim Winders are equipped with a single air valve for the shaft. Refer to your assembly drawing for the exact location of inflation air valves.

To **deflate** the trim winder shaft, depress the air valve with the tip of the inflate/deflate tool for at least 30 seconds to allow all the air to fully exhaust from the shaft. Never use a finger to release air from the shaft.

NOTICE

Never try to remove cores from the trim winder shaft without fully deflating the bladder. This can cause serious damage to the core, gripping material, and body of the continuous lug shaft.

D.2 Controlling Rotational Speed and Torque

WARNING

Do not place loose clothing, jewelry, hair, or limbs on or around the shaft while adjusting the speed and torque of the trim winder.

To **adjust the torque** of the trim winder shaft, turn the regulator knob that is on the back of the trim winder housing next to the air input.

To **adjust the rotational speed** of the trim winder shaft, rotate the lever that is located on the top of the trim winder housing.

NOTICE

Most Double E Group Trim Winders are designed to run up to 600fpm with a maximum roll weight of 80lbs. Please refer to your approval drawing for exact operating limits and specifications. Never overload your trim winder. Failure to adhere to the stated limitations may result in severe damage to trim winder components.

E. PRODUCT SPECIFICATIONS

E.1 Technical Specifications



Do not exceed the operating parameters of the trim winder as specified on the assembly drawing. This voids trim winder warranty and can cause serious injury.

Please refer to the approval drawing for the operating parameters and limits of your trim winder.

F. MAINTENANCE

F.1 Routine Inspection

Perform routine inspection **weekly**. Routine inspection can usually be accomplished without disassembly or removal of the trim winder from the machine. The purpose of routine inspection is to ensure that the trim winder is functioning properly prior to being used in the machine. Inspect the shaft and its gripping elements to make sure that they are free of defects, nicks, cracks, or any foreign debris, such as a dust buildup, that may impair the proper functionality of the shaft. Ensure that all fasteners are tightened properly and are not missing. Ensure that the shaft is able to spin freely. Check that all knobs, controllers, and the regulator are properly functioning.

F.2 Annual Maintenance

Perform annual inspection/maintenance **yearly**. Ensure that all fasteners are tightened properly and that the side shields (if applicable) are installed per trim winder assembly drawing. Inspect all accessible pneumatic fittings to ensure that they are free of damage and leaks. Without an air connection Turn the shaft, ensuring that both ends remain concentric about the rotational axis, that there are no grinding sounds, and that the rotation is smooth.

F.3 Non-Routine Maintenance

If the product is used under normal conditions and inspected regularly, it is rare that any non-routine or extraordinary maintenance will be needed. In the event that it is necessary, it is recommended that you contact Double E Group Technical Support at 508-588-8099

F.4 Decommissioning

If the product is withdrawn or removed from service, it is necessary to make all at-risk components harmless through proper demolition. These operations must be carried out in accordance with the provisions existing in the nation or locale in which the product will be disposed.

F.5 Product Storage

All Double E trim winders should be carefully stored when not in use. To ensure maximum performance, Double E trim winders should be rested on padded surfaces to protect the metal components. Storage locations should be in cool, dry environments away from high levels of human or vehicle traffic.

G. REPLACEMENT OF COMPONENTS

G.1 Shaft Valve Replacement



Always fully deflate shaft prior to performing any maintenance on the trim winder. Trim winder should be secured to a work surface before performing any maintenance.

1. Unscrew old valve with a 7/16" (11mm) socket wrench.
2. Apply Loctite® 545 or equivalent pneumatic thread sealant to the threads of the new valve.
3. Screw in the new valve with a 7/16" (11mm) socket wrench.

H. TROUBLESHOOTING

H.1 Troubleshooting

Problem: Shaft Will Not Enter Core

Solution 1	Check core size. The inner diameter of the cores being used with the shaft should be slightly larger than the deflated shaft.
Solution 2	Check for core damage. If necessary, trim the core entrance with a knife to remove any damaged/deformed material.
Solution 3	Check Inflation. If the shaft does not fully deflate or deflation is difficult, replace air valve.

Problem: Shaft Slips in Core

Solution 1	Check inflation. Double E inflation tools are designed to measure the air pressure within the shaft. If the pressure achieved is less than 80psi/5.5bar, check air supply and inflation technique.
Solution 2	Check operational torque. Consult torque limitations.

Problem: Shaft Leaks

Solution 1	Replace valve and test.
Solution 2	Replace bladder and test.

Problem: Trim Material Tears in Operation

Solution 1	Check operational torque which may be excessive. Adjust torque if necessary.
Solution 2	Check that the web thickness is the same as that provided in the application details. Consult the Double E Group for alternatives.

Problem: Trim Material Loose or Bunching Up Before Trim Winder

Solution 1	Check rotational speed which may be too low. Adjust speed if necessary.
Solution 2	Check air supply
Solution 3	Check that the web specifications are the same as those provided in the application details. Consult the Double E Group for alternatives.

I. MANUFACTURER'S DECLARATION

Buyer shall afford Double E Group prompt and reasonable opportunity to inspect any goods as to which a claim is made and Double E Group shall have the right of final determination of the cause and existence of any defect under this warranty. No material may be returned to Double E Group without Double E Group's express prior permission in the form of a return authorization number.

Correction of non-conformities, in the manner and for the period provided above, shall constitute fulfillment of all liabilities of Double E Group to Buyer with respect for the goods, whether based on contract, negligence, strict tort, or otherwise.

J. RETURNS

Warranty and non-warranty returns are initiated through the issuance of a return material authorization (RMA) number from an authorized Double E Group sales or service/support representative. This can be obtained by calling Double E Group in West Bridgewater, MA at 508-588-8099.

The RMA number should be clearly evident on the shipping label and/or invoice and the package should be shipped freight prepaid. If questions arise or if additional information is required, please call the Inside Sales department at 508-588-8099

Product returns should be sent to the address below:

Double E Group, LLC
319 Manley Street
West Bridgewater, MA 02379
ATTN: RMA # _____

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