

Item No.	Designation	pcs.
1	Lifting body	1
2	Outer body	1
3	Back plate	1
4	Cover	1
5	Sector plate	3
6	Guide bushing	1
7	Thrust bearing	1
8	Key	1
9	Pin	6
11	Cotter pin	1
12	Spring	1
14	Screw	3
15	Screw	1
16	Screw	1
17	Thrust ring	1
18	Sensor ring	1
19	Retaining screw	3
22	Auxiliary cover	1
23	Centre screw	3

Figure 1

Part list

Safety instructions

When mounting or removing reeling heads, make sure your feet are not under them.

When assembling the reel to the reel bracket, check that the reeling heads are intact and the reel fits between the reeling heads.

Check that the reeling heads are inside the core. Do not use excessive force to press the reeling heads against the core, but rather leave a gap of 2 mm between the core end and thrust ring.

Do not put your hands between the reeling head and core when pushing the core or reel in place.

Do not put your hands between the reeling head and sensor ring when pushing the core or reel in place.

Do not put your feet under the reeling head when mounting or removing the reel.

Always follow the general safety instructions of the plant.

Mounting the KILL Reeling Head to the reeling station

1. Clean the guide and mounting surfaces before mounting the reeling head.
2. Mount the reeling head to the reeling station by fitting the back plate (item 3) of the reeling head to the mounting flange fitted to the reeling station shaft.
3. Lift the reeling head into the guide of the reeling station mounting flange and fix the mounting screws.

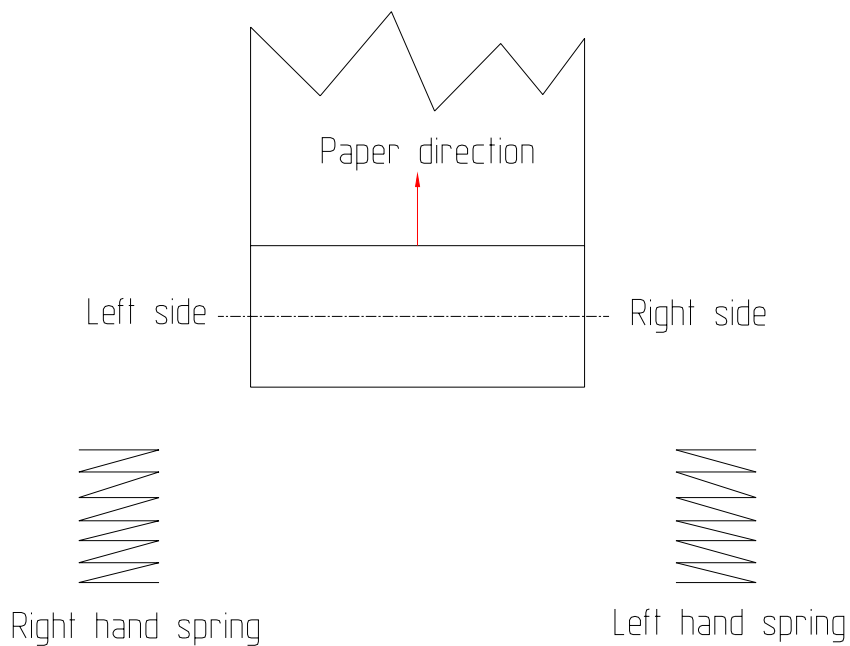
The tightening torques of the mounting screws are:

M12 135 Nm

M14 250 Nm

M16 330 Nm

4. Check that the reeling head is turning the right way. Make sure that you install a reeling head with a left hand spring into the reeling stand on the right, and a reeling head with a right hand spring into the reeling stand on the left (see figure below). After installing, check that the spring and paper turn into opposite directions.



Service and maintenance

Perform the following cleaning and maintenance operations after about three months of use.

1. Unscrew the mounting screws. Take the reeling head and its parts to the maintenance location.
2. Fit the reeling head for service in a vertical position under a hydraulic press, for example.
3. Remove the centre screw (item 23) and the auxiliary cover (item 22).
4. Load the ejector ring (item 17) by about 5-10 mm with a tool shown in the picture.



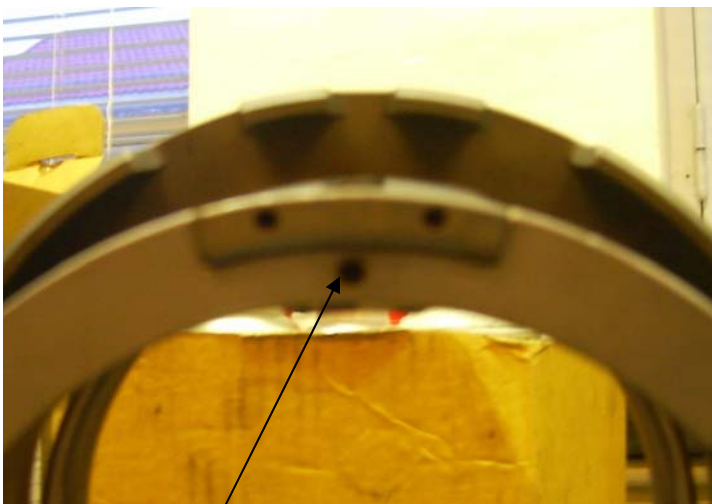
NOTE! Dismantling the reeling head without loading the ejector ring may cause danger to the person performing the service and others nearby.

5. Unscrew the mounting screws (item 14) of the cover (item 4) and lift the cover out of its place by wedging it carefully through the opening in the outer body.
6. Release the ejector ring (item 17) carefully, until all the spring force has been released.
7. Lift off the outer body (item 2) with the ejector ring (item 17) and sector plates (item 5) while supporting the pins (item 9).
8. Remove the spring (item 12).
9. Remove the pins (item 9) and lift off the guide bushing (item 6) and the thrust bearing (item 7).
10. Wash the parts and clean the air holes.

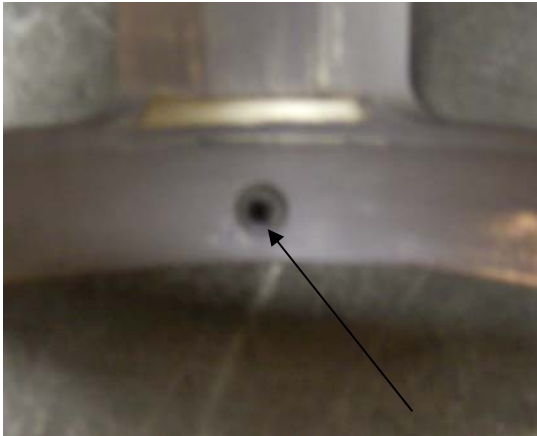
Replacing the ejector ring stopping plug



1. Unscrew the retaining screws of each plug. Since the retaining screws have been glued in at the factory, you may need to warm them up first.
2. Use a mandrel to remove the old plug.
3. Clean the plug holes of all glue and other dirt.
4. First install the bigger plug into the hole using a suitable tool. Make sure that the plug is positioned correctly, and tap it in its place.
5. Then tap the smaller plug into its place. Make sure that you do not tap the plug in too deep because this may prevent the outer cover from working.
6. Screw in the new retaining screws. Secure with a drop of glue.



Retaining screw



Check the plug distance from the surface

The assembly is mostly done in the reverse order.

1. Ensure that the sector plates (item 5) are aligned with the openings in the guide bushing (item 6).
2. Make sure that the spring (item 12) is in the correct position and that the reeling head spring is installed the right way (left hand spring in the right reeling stand and the right hand spring in the left reeling stand). There are guide pins (item 11) in the back plate (item 3) and in the ejector ring (item 17) for aligning the spring (item 12).
3. Reinstall the reeling head back to the reeling station according the instructions given earlier.

The following parts must be lubricated before assembly:

- Thrust bearing (item 7) and its counter surfaces
- Guide bushing (item 6) sliding surfaces
- Pin (item 9) rolling surfaces
- Sector plate (item 5) rolling surfaces
- Lifting body (item 1) rolling surfaces
- Outer body (item 2) sliding surfaces

It is recommended to use synthetic lubricants (grease) with the following properties:

- High corrosion resistance, adherence and lubricating capacity
- Heat resistance exceeding 230 °C
- High pressure and shock resistance

After servicing, check that the parts are moving without resistance.

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