



Item No.	Designation	pcs
1	Back plate	1
2	Cover	1
3	Outer body	1
4	Sector plate	3
5	Roller pin	6
6	Lifting body	1
7	Thrust bearing	1
8	Guide bushing	1
9	Ejector ring	1
10	Spring seat	1
11	Spring body	1
12	Spring cover	1
13	Key	1
14	Spring guide	1
15	Auxiliary cover	1
16	Coil spring	2
17	Cylindrical pin	1
18	Key	1
19	Allen screw	6
20	Allen screw	3
21	Allen screw	2
22	Allen screw	2
23	Centre screw	1

Fig. 1

Parts list

**Safety instructions:**

- Do not place your feet under the reeling head when mounting or removing reeling heads.*
- When assembling the reel to the reel bracket, ensure that the reeling heads are intact and the reel will fit between the reeling heads.*
- Check that the reeling heads are inside the core. However, do not press the reeling heads against the core using too much force, but rather leave a gap of 2 mm between the core end and thrust ring.*
- Do not place your hands between the reeling head and core when pushing the core or reel in place.*
- Do not place your hands between the reeling head and the ejector ring when pushing the core or reel in place.*
- Do not place your feet under the reeling head when mounting or removing the reel.*
- General safety regulations of the plant must always be observed.*

**Functional Description**

Before starting the reel-up operation the reeling head is pushed horizontally into the openings of the core ends. By the action of rotational moment, the reeling head clamps to the core end.

The clamping force depends on the tightness of the web and ends as the pull ceases. When the reel-up has been completed, the reeling heads are pulled out of the core.

To ensure good operational reliability the reeling heads must be kept in good condition by regular inspections and maintenance.

### Product Description

The KILL 150 reeling heads, with and without spring return, are mechanically expanding chucks. When the core or the reel is changed, the spring-return reeling head turns automatically to the middle position of the head to facilitate handling of the core.

The KILL reeling head is composed of parts described in Fig. 1. In this construction a guided pin and key assembly, by the action of rotational moment, pushes the sector plates (item 4) outwards against the wall the core opening, clamping the reeling head to the core. After the rotational movement has ceased, the springs (item 16) of the spring-return reeling head return the reeling head, together with the core, into the centre position and the sector plates (item 4) are pushed easily back into the outer body (item 3).

The reeling head is made of tampered high quality alloy steel and protected by black finishing.

### Mounting and Putting into Use

The reeling head is delivered from the manufacturer completely assembled and protected against corrosion.

Before using the reeling head the first time, the protective agents should be removed by wiping the surfaces with a clean cloth or a paper towel. If necessary, some solvent can be used.

The reeling head is pre-lubricated for the first use.

### Mounting the KILL Reeling Head to the Reeling Station

The reeling head is mounted to the reeling station by fitting the back plate (item 1) of the reeling head to the mounting flange fitted to the reeling station shaft. The guide and mounting surfaces must be cleaned before mounting the reeling head.

Align the mounting screw slots in the outer body (item 3) and in the thrust bearing (item 7) with the mounting screw holes in the back plate (item 1), and attach the mounting screws in such a way that the screw ends are flush with the rear surface of the back plate. In the spring-return reeling head, the outer body tends to remain in the centre position.

Lift the reeling head locating it into the guide in the reeling station mounting flange and install the mounting screws.

The mounting screws are not included in the standard delivery. The screws must be of grade 12.9.

The tightening torques of the rear plate mounting screws are:

M12	135 Nm
M14	250 Nm
M16	330 Nm

The outer body (item 3) and the sector plates (item 4) must turn without resistance when rotated back and forth by hand. In the spring-return reeling head, the springs tend to keep the outer body and the sector plates in the centre position. The reeling head is now ready for use.

### Cleaning During Operation

In connection with each core change, the reeling head should be cleaned by blowing air. Blow compressed air through the air hole in the cover (item 2) to remove e.g. fibre dust released from the core from inside the reeling head.

When air is blown into the head, the sector plates (item 4) are pushed outwards and the air comes out between the edges of the sector plates (item 4). After cleaning, the outer body (item 3) and the sector plates (item 4) must turn without resistance when they are rotated back and forth by hand. Repeat the blowing operation, if necessary. Note! Reeling heads with spring return.

## Maintenance

After approx. 3 months of use the following cleaning and maintenance operations shall be carried out.

Align the mounting screw slots in the thrust bearing and in the outer body.

Unscrew the mounting screws and bring the reeling head with its parts to the maintenance location.

Place the reeling head on a work bench in vertical position for maintenance.

First unscrew the cover (item 2) mounting screws (item 20) and lift the cover out of its place. If the cover will not detach, wedge carefully between the cover and the outer body. When the cover (item 2) is removed, also the spring-return mechanism is detached with it (in the reeling heads with spring return). Lift the ejector ring (item 9) out of its location. Lift off the outer body (item 3) with the sector plates (item 4) while supporting the pins (item 5).

Remove the pins (item 5) and lift off the guide bushing (item 8) and the thrust bearing (item 7).

Wash the parts and clean the air holes.

Inspect the lifting and bearing surfaces of the sector plates (item 4) and the lifting body (item 6). Check the condition of the pins (item 5). Inspect the bearing and guide surfaces of the guide bushing (item 8) and the outer body (item 3).

Check the bearing and guiding surfaces of the ejector ring (item 9).

The minimum thickness of the thrust bearing (item 7) = 2.5 mm.

If other parts are worn more than 0.2mm, such parts may have to be changed.

If any cracks are found in the parts, such parts must absolutely be changed.

The assembly is done primarily in reverse order.

Ensure that the sector plate (item 4) is aligned with the holes in the guide bushing (item 8) and in the spring-return types the "whisker" of the spring seat (item 10) is in line with the slot in the outer body (item 3) and in the lifting body (item 6).

Lubricate the following items

- Thrust bearing (item 7) and its counter surfaces
- Guide bushing (item 8) sliding surfaces
- Pin (item 5) rolling surfaces
- Sector plate (item 4) rolling surfaces
- Lifting body (item 6) rolling surfaces
- Outer body (item 3) 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 service, check that the parts are moving without resistance. The spring-return mechanism is serviced by the supplier.

### Malfunction

The reeling head cannot be inserted into the core

- Check that the head fits the core. The diameter of the outer body (item 3) must be at least 0.3 mm smaller than the inner diameter of the core opening.
- Remove possible damaged material from the edges of the core end.
- Check the operation of the reeling head. If the sector plates (item 4) do not move loosely and are not flush with the outer surface of the outer body, tap on the reeling head with a soft hammer and blow it clean. Repeat this procedure, if necessary.

The reeling head slips inside the core

- The core end is damaged. Change the core.
- The core is soft and gives in (one of the sector plates (item 4) is pressed into the core wall).
- Check the tightness of the web.
- Check that the head fits the core.
- The reeling head is dirty or worn. Check the operation of the reeling head and as necessary, carry out maintenance operations according to instructions.
- Poor grip. Replace the sector plates (item 4) with grooved plates. *NOTE! Grooved sector plates (item 4) are not included in the standard delivery*
- For soft, worn or slippery cores, so-called extended reeling heads are available.

The reeling head will not detach from the core

- A sector plate (item 4) has been pressed into the core wall (the core is soft). Check the condition of the cores before using them and check the tightness of the web.
- The reeling head is dirty or worn. Carry out maintenance operations according to instructions.

Abnormal noise from the reeling head

- Inspect the reeling head. Carry out maintenance operations according to instructions.

If you are unable to remedy a malfunction, please call Oy Klim-ko Ltd's service.

Contact information: