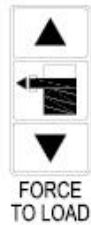


WRAPPING LIGHT OR UNSTABLE LOADS ON AN A-ARM MACHINE

Wrapping light loads can be an issue for stretch wrappers no matter if you start wrapping at the bottom of the load or the top. The A-Arm starts at the top and has some adjustments that may allow you to wrap light loads. Weight is not the only factor. Size of individual containers, slippery containers, stacking patterns, etc. can also add to the difficulty in wrapping light or unstable loads.

Here are some suggestions on how to calibrate the machine for light or unstable loads. The numbers shown refer to the section of the machine manual where this and more information can be found.

- 1) Force-to-load setting – reduce the force-to-load setting to 0 and slowly increase it to the desired result.



- 2) Delay the introduction of the Force-To-Load setting (tension) until a selected number of layers of film have been applied.

5:2:4:3:4.2 Delayed Film Force Revolutions Setting

The **DELAY FILM FORCE REVS.** setting is used to program the number of wrap revolutions that will be counted at the beginning of the wrap cycle before the keypad Force To Load setting is enabled.

- 3) Rotate the turntable at a very low speed for a selectable number of revolutions to stabilize the load before beginning normal wrapping speed.

5:2:4:3:3.7 Slow Start Revolutions Setting

The **SLOW START REVS.** setting is used to enter a value that will force the turntable to run using the Start Speed setting for the preset number of revolutions.

This feature can be beneficial when wrapping unstable products that will not sustain the full turntable speed before some layers of film have been applied to the load.

- 4) The film carriage normally stops at the top of the load before the turntable starts to rotate. You can program the machine to have the carriage travel lower so that there are more layers of product (more weight) and surface available to attach the film.

5:2:4:3:3.6 Carriage Height for Start of 1st Revolution Setting

The **1ST REV. START** setting is used to enter a value that will determine the height of the film carriage relative to the top of the load at which the first wrap revolution will be applied to the load. The value displayed is preceded by a minus sign to indicate that the value is below the top of the load.

Adjusting this parameter to a higher value will increase the angle of interference between the load and the film. This is beneficial when wrapping loads consisting of sacks, pails, drums, rolls, or other products that lack a defined corner that will catch the film at the start of the cycle.

Contact your Cousins Regional Manager if the above adjustments do not allow you to wrap the light loads.