

Spring 2003 – Vol. 7, Number 2

Newsletter

F.L. Smithe Machine Co. Inc.
899 Old Route 220 North, P.O. Box 36, Duncansville, PA 16635



“Counterfeit Parts - Buyer Beware”



Saving a few dollars on the purchase price may actually cost you a lot of money down the road. When a part doesn't fit or work correctly, it can cost thousands of dollars in downtime.

Furthermore, some counterfeit parts may actually damage your machinery, costing you more downtime and even more money in repair bills. Be careful with 3rd party parts that are not made to the Original Equipment specifications from F.L. Smithe Machine Co., Inc. Below is just one example which we have encountered in recent months.

One of our technicians recently performed several audits on RA machines for one of our customers. This technician discovered that the fountain rolls in the printers were missing the side rings (RA-20079). The lack of these rings will cause the printing units to leak badly. This oversight probably happened when the rolls were recovered or purchased from another vendor. The F.L. Smithe Service Department repaired this problem and installed these rings, and advised this particular customer to consider using F.L. Smithe Machine Co. for all of their parts so that situations like this can be prevented in the future.

CHAMPION SW Group Job Update

Our latest Champion SW machines are faster and more productive than ever. Our 2002 group of machines is rated at speeds of up to 1,500 envelopes per minute and we are proud to say that these SW's are running at these speeds. Furthermore, with our advanced engineering regarding tension control of the web in these machines, we are running double-window envelopes steady at speeds in excess of 1,000 envelopes per minute. F.L. Smithe has released a 2003 group job of Champion SW machines to manufacturing for availability in Q3-Q4 of 2003, so if you are interested please contact your Sales Representative immediately.

Picture of double window #C5 and #10 envelope that ran steady above 1,000 EPM in factory test



Champion SR

Our Latest Technology At Work

While the SR's that are out in the field continue to run very well and impress their owners, we have been hard at work making even more improvements. Our next generation of SR machines have several additional features that will increase productivity, decrease the experience levels needed to adjust and operate the machine, and provide for even more information via a network connection to your front office and our professionally trained service department.

- Servo Stack Press with exceptional print registration (Patent Pending)
- Automatic Color to Color Setup Register
- Fewer wear items
- Quick change
- Ergonomic design
- Steady production speeds up to 1250 per minute



Picture of 6 x 9 window envelope printed 4 over 1 and running steady at over 1,000 EPM

See us online at www.flsmithe.com

Just as with counterfeit parts suppliers, other service providers may appear to offer less expensive services or estimate less time to accomplish a project, but when they don't have the expertise levels that exist at F.L. Smithe Machine Co., it can end up costing you a lot of money in reduced productivity and profits.

1. One customer asked us to service three of their PHP cutting machines. One of their PHP's was rebuilt using F.L. Smithe's specification and the other two of their PHP's were rebuilt by the customer using their own specification. While it was quite simple and easy to service their F.L. Smithe PHP Rebuild, there was no documentation on the other rebuilt PHP machines. Furthermore, when F.L. Smithe tried to contact the persons who rebuilt these other two PHP machines, they were no longer associated with that particular company and there was no information or proper documentation left behind. Unfortunately this customer was literally left "high and dry." F.L. Smithe is now working with this customer to properly understand and document these other rebuilt PHP machines.



2. Another customer decided to use a less expensive service company to move and install a machine from overseas into their plant in the United States. Unfortunately for this customer, it ended up costing them a lot more money due to excessive downtime and the need to hire additional service providers to fix problems.

- The mechanic that removed the machine was not the same mechanic that installed the machine in the U.S.. The installer then blamed most of the problems on the mechanic who removed the machine.
- It took the less expensive service company several additional days beyond what was estimated to complete the work, and they left without testing the machine.
- The customer then had to hire an outside electrical contractor to fix electrical problems encountered immediately upon powering-up the machine.



F.L. Smithe Machine Co.'s Service Department uses the same technicians to install any equipment we are moving, we test all of our work before leaving and since we are the OEM of the machine, we understand all of the electrical requirements.

WHY DO BUSINESS WITH F.L. SMITHE?

F.L. Smithe Machine Co., Inc. has supported and has been dedicated to the envelope industry for the past 100 years, and we will continue to support you for many more years. When deciding whom to order your parts and service from, consider the following:

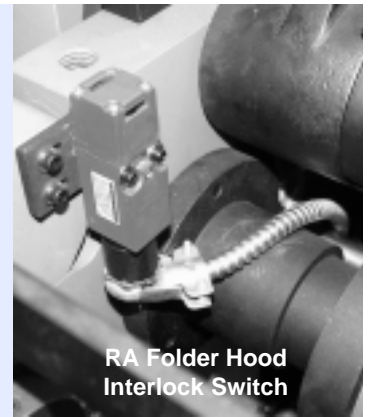
- ✓ **F.L. Smithe supports our parts and machinery.** With over 100 years of combined experience, our (3) Electrical Support Engineers and (1) Mechanical Support Engineer are dedicated to support your production needs. If you have a question, we have the answer.
- ✓ **F.L. Smithe is the "original" designer and manufacturer of the part.** F.L. Smithe makes a substantial investment in the research and development of our parts. As the Original Equipment Manufacturer, our replacement parts are made to the exact tolerances needed to operate your machines properly.
- ✓ **F.L. Smithe is proud to exceed a 90% stock fulfillment rate on over 40,000 parts.** We don't just make some parts; we make "all" the parts for our machines. If your machine is down, we will interrupt our production schedule to supply needed parts as soon as possible. Over 90% of parts are shipped within 8 business hours of order receipt.
- ✓ **F.L. Smithe continues to design, test and deliver quality machinery and parts in support of the envelope industry.** We design machine options which allow you to make more money with your existing machinery. We continue the development of new machinery which enables you to improve efficiency and profits.
- ✓ **We support you and the envelope industry. We need your support.**

Important
RA
SAFETY
Upgrades

RA Folder Interlock Switch

Additional protection is available for your RA operator with the installation of an interlock switch on the RA Folder Hood. This switch will shut down the machine if this hood is lifted while the machine is running. This interlock is standard on RA machines Serial No. 5481-up, except No. 5484.

To order, please specify **RA Special Order File #325** and **Instruction #69JA**.



RA Folder Hood Interlock Switch

RA Seal Fold Trap Adjustment Knob Extension

This safety feature is **highly recommended** by the F.L. Smithe Machine Co. for all envelope factories with RA Machines. This modification extends the seal flap trap height adjustment through the folder guard making it possible to adjust the seal fold trap height without lifting the guard. The height



RA Folder Hood Seal Flap Trap Adjustment Extension

adjustment extension is standard on all RA machines Serial No. 5481-up.

To order, please specify **RA Special Order File #319** and **Instruction #69IZ**.

RA HSP Gummer Remote Adjustment

The RA High Speed Patcher Remote Adjustment allows the operator easier access to the high speed patcher gummer phasing. The gummer phasing knob and bracket is relocated to a more accessible location over the primary patcher. A flex shaft connects the knob to the original gummer phase adjuster.

This installation is recommended when also installing the Patcher Safety Guard.

This adjustment is standard on RA machines 5481-up.

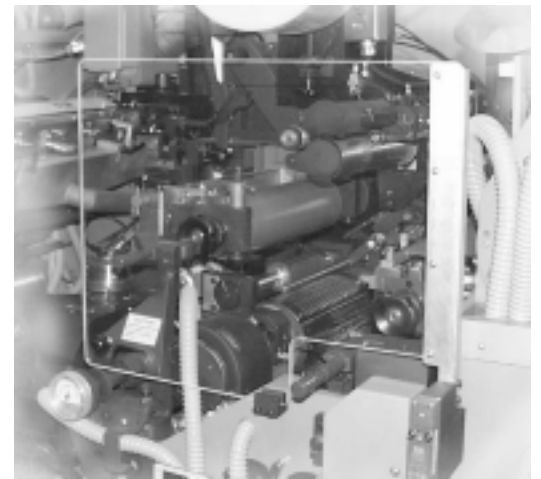


RA HSP Gummer Remote Adjustment

To order, please specify **RA Special Order File #326** and **Instruction #69JB**.

OPERATOR SAFETY Guard for the RA Patcher Units

The F.L. Smithe Machine Co. **highly recommends** that all envelope factories with either RA High Speed Patchers or Standard Patchers install this safety guard. This Plexiglas guard is mounted on the operator side of the RA machine and is designed to protect the operator or adjuster from inadvertent contact with the patcher transport mechanisms.



This guard is standard on all RA machines Serial No. 5481-up. To order it for RA machines Serial No. up to 5480, please specify **RA Special Order File #320** and **Instruction 69IW**.

**RA
Machine
Option
Highlights**

Make More Money With Your F.L. Smithe Machinery

RA Feed Skip Detector

If a blank is missed in the feeder, the patch that was intended for that blank will not appear on the collator. Jams cause down time and loss of productivity. A sensor is available to detect the missed blank and stop the machine while the operator is at the delivery table. This photo-sensor mounts to the tie bar directly over the first impression cylinder. The "RA" feeder skip detection system is an easy special order file to install. It takes approximately one hour and is a valuable update for your machine. To order, please specify **RA Special Order File #63** and **instruction #69 WW**. This is for machines prior to serial number 2248.



RA Side Scoring on Polyurethane

If you are still using the male/female side scoring system (before machine serial number 3438) you should

update your RA to the newer style urethane scoring unit. This system uses a urethane back up roll. This type of scoring is simple in design, easy to maintain and produces a consistently sharp score. In order to maintain paper control, a new entry guide jam detector with adjustable pressure rolls is also included. To upgrade to the improved side scoring, please order **RA SOF #168** and **Instruction #69 CS**.

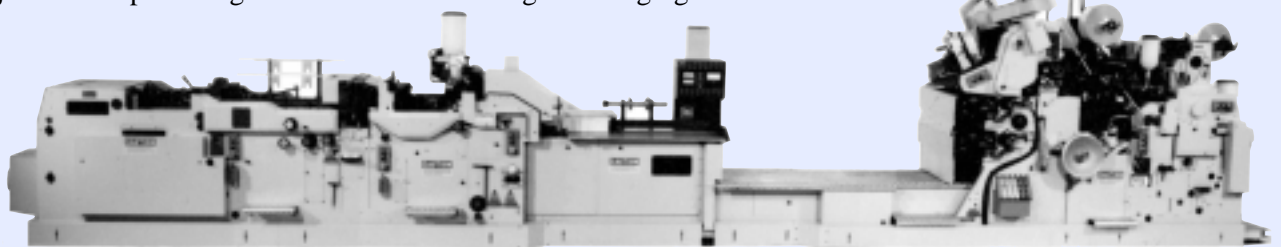
RA feed Stack Low Limit Sensor

The "RA" feed stack low limit sensor is an electric eye that reads the height of the blanks in the feeder and alerts the operator, by lamp at both the feeder and at the delivery table feeder box, when the stack is getting low. If the stack gets too low the sensor will automatically shut the machine down. This prevents a thick wad of blanks from being fed into the machine. Without this sensor there is a risk of damaging the main feed cylinder and /or the printers on the RA machine. If your RA machine was built before 1990 (before serial number 3397) this is a valuable Special Order File that should be installed. It takes about one day to install and it could save you countless hours of downtime. To order, specify **RA Special Order File #115** and **Instruction #69 JJJJ**.



RA Audit Program Provides Increased Productivity

F.L. Smithe Machine Co.'s RA audit program is a huge success! We have been helping many of our customers in the field increase production of their Champion RA machines through field auditing of the RA machine, by working with Adjusters and consulting with them on specific jobs. In most cases, we have been able to increase the productivity of some RA machines by 25% or more. We have also helped several customers to decrease change times as much as 50% by working with their Adjusters and providing some additional training on changing the machine.



HP SAFETY ENHANCEMENTS

HP Start Switch Guard

The F.L. Smithe Machine Co. is recommending this very important safety feature for the HP start button, located on the top and on the operator side of the ram.

This guard will prevent inadvertent contact with the switch and in turn unintentional activation of the press.

This guard is mounted with the existing screws in the switch. To order, please specify HP Start Switch Guard [HP-8211](#).



HP START SWITCH GUARD

HP Ram Safety

In 1974 F.L. Smithe Machine Co. developed an operator restraint system for the HP cutting presses to prevent injuries that may occur if the operator reaches under the cutting head while the machine is cycled. In the photo below you can see the safety system installed. A quick walk through your cutting department will let you know if you are up to date with this safety system. If you are not, you can order the files required for your specific HP machine from the list below.



HP RAM WITH SAFETY BED SCANNER & STEEL GUARDS

For HP machines Serial No. 267 through 1720 please specify [HP Special Order File #10](#) and [Instruction #36 TT](#) for the Ram Reverse System and Steel Guards.

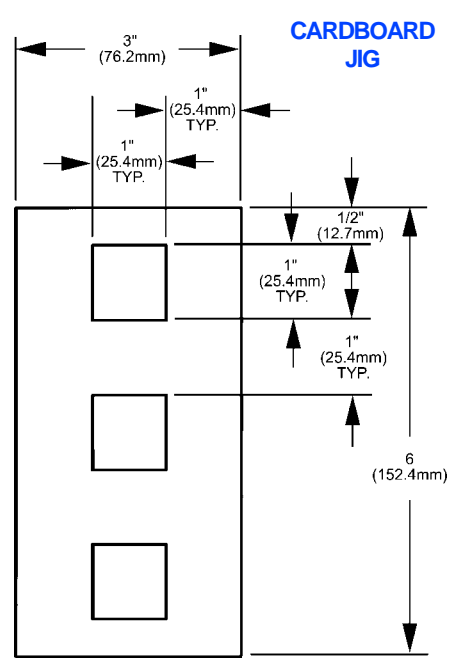
For HP machines Serial No. 2074 through 2568 please Specify [HP Special Order file #9](#) and [Instruction #36 RR](#) for the Ram Reverse System and Steel Guards.

For HP machines Serial No. 2641 through 2987 please Specify [HP Special Order File #8](#) and [Instruction #36 SS](#) for the Ram Reverse Solenoid Update and Steel Guards.

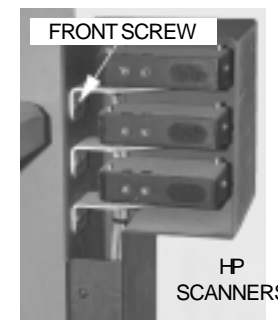
HP Cutting Table Height and Ram Reverse Safety Scanner Alignment

When the original wooden HP cutting table is replaced with an aftermarket table it **must** be 3-3/4" (95mm) thick or the safety system will not operate to factory specifications. This condition can put the machine operator in extreme danger.

In addition it is important to periodically check the alignment of the ram reverse scanner system. To check your HP safety scanner alignment, do the following: Use the drawing below to make a cardboard jig. Tape the jig over the ram safety reflector as shown in the photo. Without using a die or paper, turn on the power and cycle the HP machine to the cutting cycle and stop the machine. At this point cover the openings in the jig one at a time to check the alignment of the scanner beam. The red light on the three scanners should all be lit if properly aligned and each respective light should go out when the corresponding opening in the jig is covered. If any of the scanners have to be adjusted, simply loosen the front screw on each scanner and tilt the scanner until it is properly aligned.



TAPE CARDBOARD JIG OVER REFLECTOR



FRONT SCREW

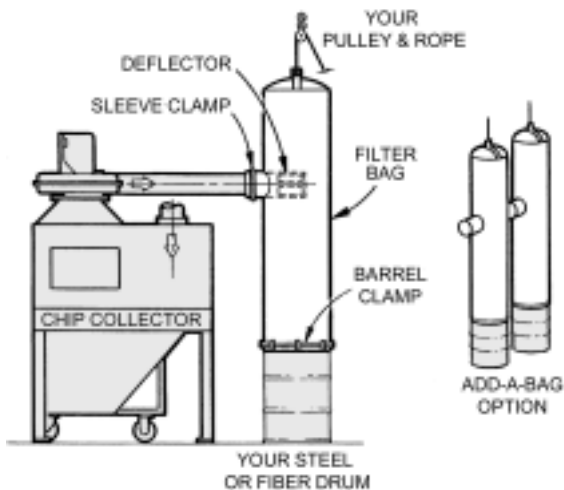
HP SCANNERS

Dealing With Paper Dust

The MOW, RO, SW and RA+WA chip collectors are being adapted with a dust control filtering system in many envelope factories. This system is inexpensive, simple to install, easy to maintain and produces excellent results. As shown in the sketch below, the 24" (610mm) diameter bag is suspended from the ceiling and is anchored at the bottom over a common 55 gallon steel or fiber drum. The inlet is located at the chip exhaust height. The bag should be as tall as possible for efficiency or an additional bag can be used for low ceilings.

One envelope plant reported that they are collecting two 55 gallon drums of compacted dust particles over the course of six months on each SW chip collector that they have this system connected to. This plant uses empty drums from their ink supply system.

To add this filtering system to your chip collector, please contact your [F.L. Smithe Sales Representative](#).



NOTICE TO USERS OF THIS SYSTEM

These dust control filtering systems must be cleaned periodically to maintain its efficiency. If the interior fibers are allowed to fill with paper dust, too much back pressure will reduce the chip removal capabilities of the chip exhauster. If the bag remains clogged after "shaking it out" we recommend commercial laundering. Having a spare bag on hand would be practical when this is done. This should be included in your routine maintenance program.

SW Patch Turnbar Maintenance

To help prevent scratching and undue tension on the film going into the SW patcher, the patch web turnbar's air supply must be set to deliver 3-10 lb. of air pressure. The air holes in the bars will self clean if the air flow is turned on and maintained. The unused holes must be taped off to maintain the proper air support to the web.



Step Platform Hand and Safety Rails

The addition of hand rails to your existing portable 4-step platforms is highly recommended by the F.L. Smithe Machine Co. These rails offer added safety to your adjusters when stepping up, standing on, or



stepping down from the platform. The rail kits are shipped as separate components and must be welded to your platform. Kits are available for "Tri-Arc" and "Cotterman" platforms.

To order, please specify **RO Special Order File #M91** for the "Tri-Arc" stand or **RO Special Order File #M92** for the "Cotterman" stand along with **RO Instruction #77CL**.



Serving the Envelope Industry since 1904

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