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Standardised Running In Procedure RZD Protected – NCN Protected

Phase	Spindle Speed	Traveller Change Duration ¹	Traveller Number	Notes
I	80% of final speed	1 hour	2 nr. heavier traveller	Rings cleaning ²
	80% of final speed	1 doff	2 nr. heavier traveller	
	80% of final speed	2 doffs	2 nr. heavier traveller	Traveller inspection ³
II	90% of final speed	1 doff	1 nr. heavier traveller	
	90% of final speed	2 doffs	1 nr. heavier traveller	
	90% of final speed	4 doffs	1 nr. heavier traveller	
	90% of final speed	8 doffs	1 nr. heavier traveller	Traveller inspection ³
III	Final Speed	1 doff	Normal traveller	
	Final Speed	2 doffs ⁴	Normal traveller	Traveller inspection ³
	Final Speed	4 doffs	Normal traveller	
	Final Speed	8 doffs	Normal traveller	Traveller inspection ³
	Final Speed	12 doffs	Normal traveller	
	Final Speed	16 doffs	Normal traveller	Traveller inspection ³
	Final Speed	24 doffs	Normal traveller	
	Final Speed	32 doffs	Normal traveller	Traveller inspection ³
	Final Speed	40 doffs ⁵	Normal traveller	Traveller inspection ³

IMPORTANT NOTES:

¹ The traveller change must be done with full cops (not with empty tubes!).

² Clean rings with a dry cotton cloth to remove dust accumulation.

³ If the % of burnt traveller is more than 5%, then the last traveller change duration is to be repeated till % of burnt traveller is less than 5.

⁴ From this step and after every traveller change (during normal production) the speed should be reduced at 80% of final speed for the first 30 minutes. This procedure will increase traveller life.

⁵ From this step, if the % of burnt traveller is less than 5%, traveller replacement cycle can be extended of 24 hours.