

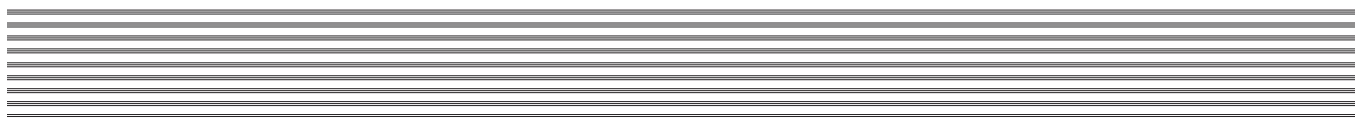


ASG – Mounting Instruction

Doffer Resharpening Device 60"

Edition: October 2021 / pg

Superior Performance



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Mounting Instruction ASG

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Translation from the original
instruction manual / german.



Premium Swiss Quality



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EC Declaration of incorporation

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Rapperswil,

Graf + Cie AG declare that the product:

Bezeichnung: Doffer Resharpener Device

Typ: ASG

Serial-No.: -----

Machine -No.: -----

fulfils the following relevant provisions:

2006/42/EC (EC Machinery Directive)
including their modifications

Reference to the harmonised standards:

EN 60204-1 Safety of machines – Electrical equipment of machines,
Part 1: General requirements

Responsible for the documentation: Quality Manager
Graf + Cie AG, Bildastrasse 6, 8640 Rapperswil, Switzerland

Graf + Cie AG

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1. Safety

1. Safety

1.1 Symbols in the document

Example of a note on safety

<div> <div>Gefahr</div> <div>  <p>Bei eingeschaltetem Hauptschalter könnte die Maschine jederzeit in Bewegung gesetzt werden Verletzungen an Händen können die Folgen sein.</p> </div> <div>  <p>Der Hauptschalter ist unbedingt aus zu schalten</p> </div> </div>	<p>It is absolutely essential to observe the safety precautions. Safety precautions are classified and highlighted by signal words. The example shows a safety precaution indicated by the signal word "Danger".</p> <p>DANGER Maximum danger level. This is used in the case of risks where there are very far-reaching consequences, with fatal injuries, irreversible or incurable injuries and very serious but curable injuries "DANGER" is only used when damage is highly likely to occur due to improper behavior</p> <p>WARNING Second highest level of danger used for risks where there are far-reaching consequences, the same as at maximum danger level. Unlike maximum level, "WARNING" is used where the probability of damage occurring in the case of improper behavior is only slight.</p> <p>CAUTION Moderate level of danger is used in the case of risks where the consequences are less serious, completely curable injuries to only slight injuries with short absence from work. Also used for damage to property with far-reaching consequences.</p> <p>IMPORTANT Low level of danger is used when there is a risk of slight damage to property.</p>
---	--

1 Signal word

"Danger", "Warning", "Caution", "Important" classify the safety precautions.

2 Risk

Description of the risk situation The potential consequences of the damage are also described.

The description of the risk involved is emphasised by a symbol.

3 Directions for avoiding danger

Description of what needs to be done or avoided in order to prevent accidents and damage occurring. The direction for avoiding danger can be emphasised by a command or prohibition symbol.

Danger symbols



General hazard area



Risk of injury



Risk of injury due to part of the body being pulled in



Risk of injury due to being pulled in



Hazardous voltage



Electric shock from capacitor



Risk of stumbling

Prevention symbols



Use eye protection



Wear protective footwear



No admittance



Shut down power before working on the installation



Switch off via the main switch and secure switch with a padlock



Press EMERGENCY STOP button



Do not touch



Wear safety gloves



No admittance to unauthorized personnel

Symbols in the Document



The page indicated refers to the currently selected chapter.



More information on this subject can be found on the page indicated



Incorrect application, not permissible



Correct application, OK



Outcome. For example, after an operation step

1.2 Legal stipulations

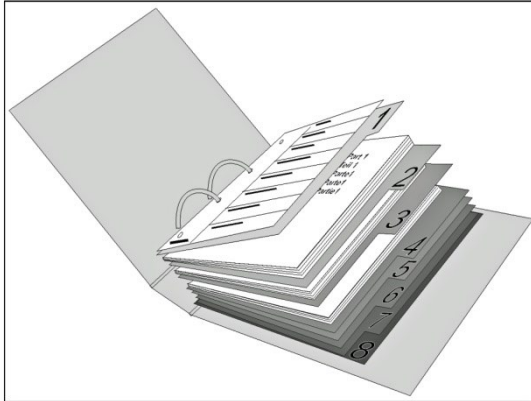
1.2.1 Liability

Graf has issued this mounting instruction to the best of its knowledge and belief. Graf cannot accept any liability for possible editorial deficiencies and errors within this mounting instruction. Graf reserves the right to implement changes at any time in the mounting instruction or on the device described therein without prior advice. No part of this mounting instruction may be reproduced, transferred, altered or translated in any way without the prior written consent of Graf + Cie AG Rapperswil. The attaching of foreign parts may effect the characteristics of the device and its safety. Graf cannot accept any responsibility for any damage caused by such parts. The German edition is relevant for the contents of this mounting instruction.

1.3 General notes on safety

1.3.1 Safety precautions

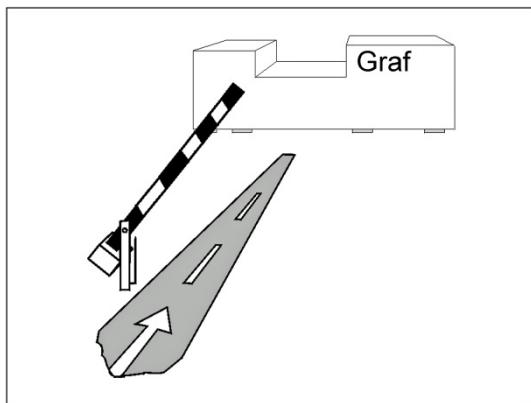
Availability of the operating instructions



All sets of instructions, especially documents relating to safety, must be kept in a place where the staff can consult them freely.

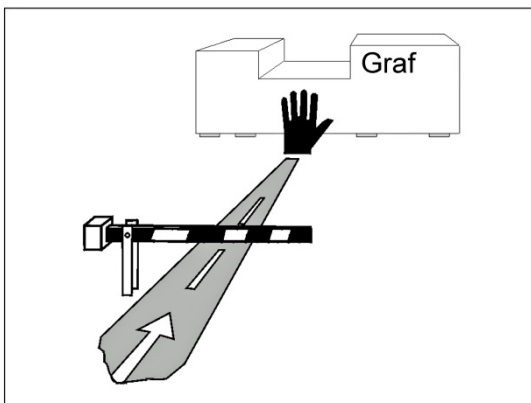
Only those who have access to correct information can work safely and efficiently.

Access available only for trained and authorized persons.



Appropriate measures are to be taken to ensure that only authorized or trained personnel have access to the machinery.

No admittance to unauthorized persons



Appropriate structural and organizational measures must be taken to ensure that untrained persons have no access to the machinery.

Regional safety regulations

Local safety regulations and laws in force in the individual countries must be observed.

Obligatory notification

Should an accident occur on a machine or should it become clear that operating a machine constitutes a potential danger, Graf + Cie AG, CH-8640 Rapperswil, must be informed immediately in writing.

Graf + Cie AG declines all liability for any damage that may occur due to failure to observe this regulation.

Work on electric components

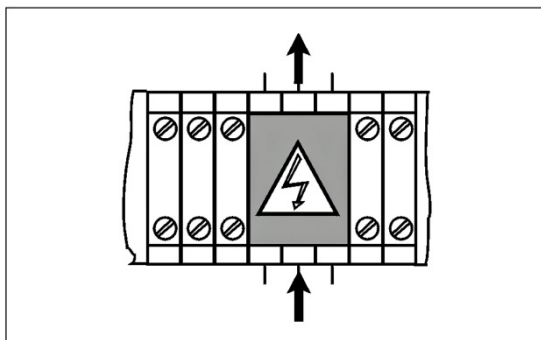
With the machine shut down, turn off the main switch and secure with a padlock.

Only qualified electricians may work and carry out checks in the electric and electronic areas.

For operational checks and troubleshooting in test operating mode, it may be necessary to work with live voltage on certain units. This kind of work demands particular care and attention, with instruments and tools in perfect working order.

In order to guarantee correct operating process the sensors must not be actuated during normal running.

External voltage

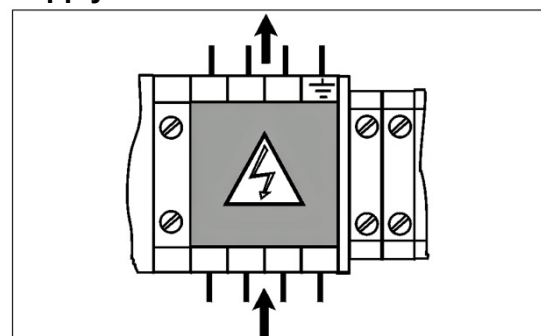


Certain circuits may still be carrying live voltage even when the main or safety switch is off.

These circuits are marked at the terminals according to the diagram.

Particular care and attention is required in this area.

Supply line



The supply line to the main switch is live even when the main switch is off.

The terminals of the supply line are marked according to the diagram.

Particular care and attention is required in this area.

Covers that are tightly screwed down

Covers that are tightly screwed down, as well as inspection windows and piping, must not be removed unless operating conditions on the machine are safe.

Operating conditions on the machine are not safe unless the following requirements are met. The main switch or safety switch must be turned off and secured with a padlock. In addition, no components must be moving.

The covers must be put back in place before the machine is put back into operation again.

Maintenance work

Observe the maintenance regulations of the machine concerned.

During maintenance work, turn off the main or safety switch and secure with a padlock.

This prevents the machine being inadvertently switched on by a third person.

Auxiliary agents and tools

Auxiliary agents such as ladders, hoisting devices etc. must be in perfect condition.

Tools and other auxiliary agents must not be deposited on machines that are running.

Falling objects may cause accidents or damage.

Whenever chemicals such as solvents are used, the instructions of the manufacturer concerned must be observed.

If work is carried out in which the danger of eye injury is not fully excluded, protective goggles must be worn.

This applies particularly to cleaning jobs involving compressed air.

Oil or grease residue on the floor is to be removed immediately.

Practical clothing

For operating reasons, it is not possible to secure all rotating or moving parts of a machine for the purpose of preventing accidents. The risk of accidents in such areas can be considerably reduced by wearing appropriate clothing.

Do not wear loose clothing (wide open sleeves, scarves, ties etc.)

Long hair must be specially protected. Always wear a cap.

Always wear protective goggles for grinding work.

Do not wear rings on your fingers or wristwatches.

Do not carry tools in open breast pockets. These objects might drop out or fall into the machine.

Work on buildings and installations in the vicinity of the machine

If it is necessary to carry out such work, the machine must be shut down. This applies particularly if it is necessary to work above the machine.

Do not climb onto the machine or use it as "scaffolding".

Alterations to machines and appliances

The machines are constructed in accordance with the state of the art.

The machines are tested and approved only in their original versions.

Installing parts made by other manufacturers may alter the characteristics of a machine and impair its operating reliability. Graf + Cie AG declines all liability for any damage of this nature.

Disposal

In the event that the machine is to be permanently put out of operation, the statutory rules in the relevant country, concerning reutilization, recycling and waste disposal, must be observed.

Any oil, grease or batteries in the machine must be disposed of in a proper manner.

Think safe.

For reasons related to operability, productivity etc. it is not possible to eliminate completely all sources of danger.

Particularly in such cases, the overestimating of one's own abilities or presumptuous thinking along the lines of: "Nothing can happen to me"?, are the greatest sources of risk.

Daily routine jobs also demand constant attention.

Thinking safe reduces the risk of injury and is therefore never a waste of time.

Fireproofing textile machines

Type of danger

Localized fires may result from various textile processes due to the ignition of fibres, fly or fibre dust, especially where cotton comes into contact with heated bearings, sparks from metallic impurities and electric sparks.

Such fires on our textile machines may cause slight damage to property or the environment and there is a low probability of personal injury by burning or inhalation of toxic smoke.

Accordingly, manually operated fire extinguishers must be provided in the spinning mill suitable for combatting fires of the following categories:

Fire classification A:

Solid materials, mainly of an organic nature, which would normally burn when exposed to glowing heat, such as textiles (fibers, fly or fiber dust), compound materials containing rubber.

Fire classification B:

Liquid or liquefying materials, such as oil, grease, paint, resin, wax, plastic.

Suitable extinguishing agents must be supplied according to this division into fire classifications.

These may be, for example:

water, with or without additives, for reducing the surface tension for instance.

foam

powder

quenching gases e.g. carbon dioxide, nitrogen, argon and mixtures

The use of powder extinguishers of this fire classification is also permitted to extinguish fires on low-voltage equipment. To reduce subsequent damage due to soiling, however, we strongly recommend the use of quenching gases.

Number, size and distribution of extinguishing agents must be determined in conjunction with the regional offices responsible for fire safety.

Furthermore, the personnel must be instructed in the use of the fire extinguishing equipment, escape routes, etc., in accordance with local regulations.

Every operator of textile machinery must actively support fire-protection and firefighting in his/her company.

1.4 Machine identification

Manufacturer

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Postfach
CH-8640 Rapperswil

Tel. +41-(0)55-221-7111
Fax +41-(0)55-221-7233

1.4.1 Name plate

The information in these Operating Instructions refers to the Doffer Resharpener Device ASG with the following nameplate:

Graf + Cie AG Bildaustrasse 6, 8640 Rapperswil Switzerland			
Type:	Year:		
Serial-No.:	Machine-No.:		
Current:	A	Pre-Fuse:	A
Voltage:	V/AC	Hz	

- Machine type
- Year of make
- Serial number
- Machine number
- Current (Ampere)
- Pre-Fuse (Ampere)
- Voltage (Volt/Alternating current)
- Hertz

The above details have to be indicated on possible enquiries for spare parts.

1.5 Machine description

1.5.1 Doffer Resharpener Device ASG



Graf + Cie AG manufactures a service device for the activating of metallic card clothings, the ASG.

It is the aim of this mounting instruction to inform you as the operator of the proper use and safe application of the device.

1.5.2 Intended application

The ASG (Doffer Resharpener Device) is an appliance to carry out service work on Rieter C60, C70, C72, C75 and C80 cards.

The device allows you to safely activate and sharpen doffer wires.

The ASG is suitable for the activating and sharpening of all standard types of doffer wire.

1.6 Technical data

ASG

Technical data		
Length	1610mm	
Weight	4.7 kg	

1.7 Commissioning

Machines manufactured by Graf + Cie AG must always be assembled and commissioned by Graf's own staff.

Should the assembly of new or existing plant be carried out by a third party, however, Graf + Cie AG declines all liability.

1.8 Decommissioning

Put the machine into a safe state.

Disconnect the power supply.

Protect the machine from misuse.

Secure the machine in such a way that when it is idle there is no risk of injury to any person.

The machine-specific regulations with regard to decommissioning must be observed.

The machine must be suitably protected against soiling and corrosion.

These regulations, and particularly the safety regulations, must be adhered to most exactly.

1.9 Putting back into operation

All elements affecting safety must be tested to ensure that they are in perfect operating condition.

The machine-specific regulations with regard to re-commissioning must be observed. These regulations, and particularly the safety regulations, must be adhered to most exactly.

1.10 Disposal

The environmentally friendly disposal of equipment, electronic components, recyclable materials and other components of the resharpener device is governed by national and regional laws. For detailed information on the correct disposal please contact the local authorities responsible.

2. General Information

2. General Information

The ASG (Doffer Resharpener Device) is an appliance to carry out service work on Rieter C60, C70, C72, C75 and C80 cards.

The device allows you to safely activate and resharpen doffer wires.

The ASG is suitable for the activating and resharpening of all standard types of doffer wire.

3. Scope of delivery / Installation

3. Scope of delivery / Installation

3.1 Scope of delivery

3.1.1 Basic equipment ASG



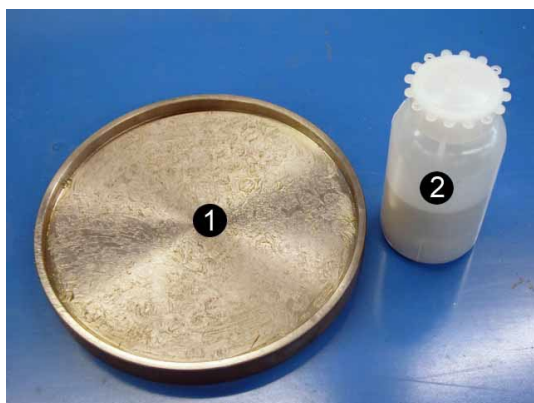
3.2 Accessories



- Adjusting wrench bearing play
Art.-No 25159950



- Socket spanner
Art.-No. 25163006



- Regenerating plate (1)
Art.-No. 00604580
- Silicon powder in plastic bottle (2)
Art.-No. 81V223104

4. Card C60 / C70 / C72 / C75

4. Card C60 / C70 / C72 / C75

4.1 Preparation of the card C60 / C70 / C72 / C75

Caution!

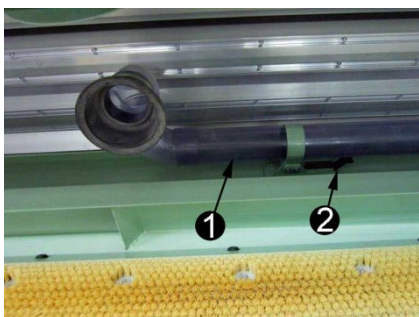


There is a danger of the card being put into operation at any time as long as the main switch is turned on with possible injuries to hands.

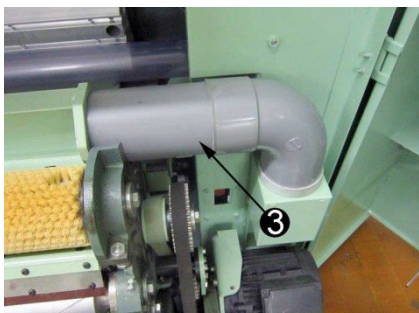


- It is imperative for main switch to be turned off.

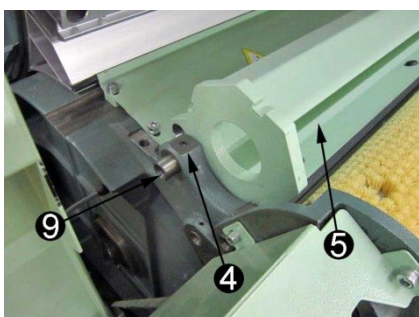
The ASG must be installed with card at a standstill only. The safety regulations of Rieter, as manufacturer of the card, with respect to securing / shut-down of the card for service and maintenance work must be adhered to and closely followed.



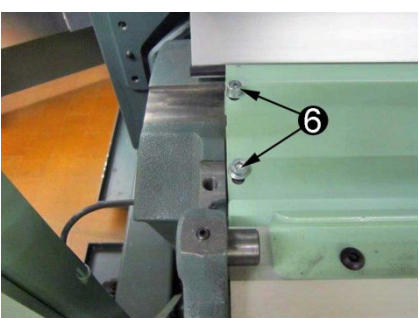
- Remove suction tube (1) by lifting of lever (2).



- No screws need to be loosened since the suction tube (3) is attached by a plug-in connection.



- Use Allen-key to loosen headless screws left and right (4); slide out fixing bolt (9) laterally.
- Remove cast iron suction tube (5).



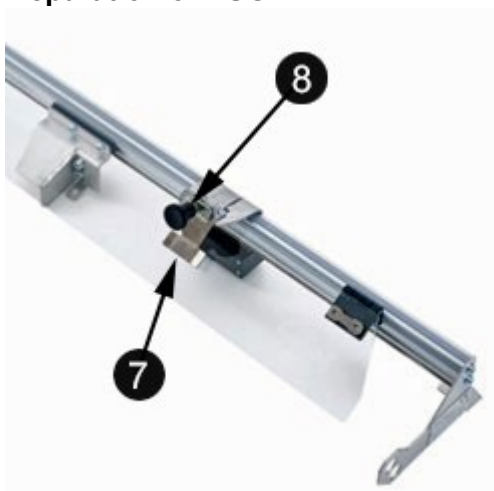
- Loosen attachment screws left and right (6) of doffer cover plate.
- Remove cover plate.

Attention!!

- Screws (6) with washers are required to attach the ASG.

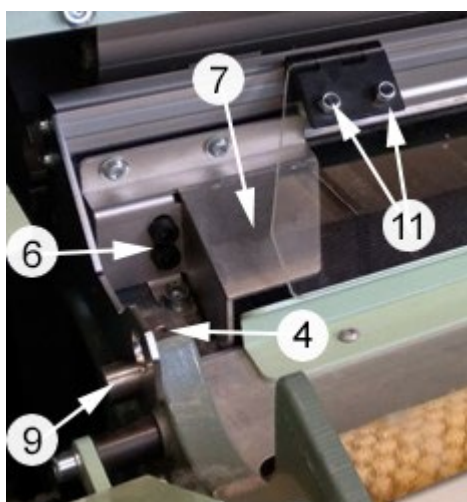
4.2. Attachment of the Doffer Resharpener Device ASG to the card

4.2.1 Preparation of ASG



- Slide attachment supports (7) left and right on to the left- and right-hand side of the device.
- Retract grinding stone by means of the locking pin (8) (to prevent damage to the grinding stone during installation of device).

4.2.2 Positioning and attachment of ASG



- Position ASG on frame of doffer and secure with fixing bolt (9).
- Fasten the two headless screws (4) left and right.
- Use socket spanner supplied to attach the supports left and right (7) with screws (6) of the doffer cover plates.
- Adjust height as required by loosening screws (11) and refastening screws (11) following adjustment.
- Refasten the two screws left and right (6).

4.3. Activating of clothings

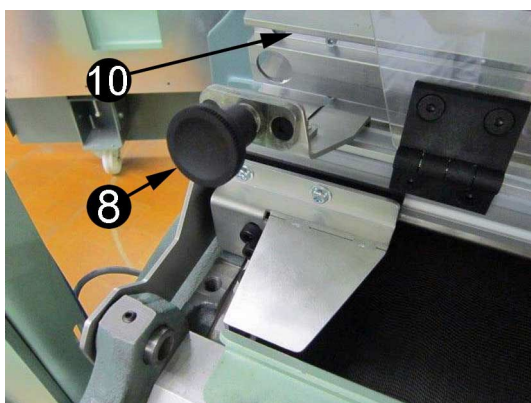
4.3.1 Starting-up of the ASG device

The speed of the doffer of the C60/C70/C72/C75 cards needs to be set at the operating panel; point 81.2: Maintenance / Grinding of doffer wire.



- Start-up doffer in service mode with 300 – 400 m/min delivery speed (depending on type of card), wait for rpm to be reached.

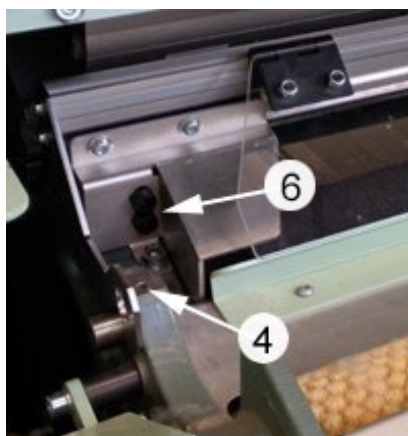
Danger!



- Make sure that protective cover (10) covers the doffer.
- Position grinding stone on doffer wire by turning the locking pin (8).
- Use locking pin to pull grinding stone evenly across width of doffer wire (~2 m/min).
- For the activating of newly installed doffer wire 4 to 6 passages with the grinding stone are required.
- Upon completion of the passages, lift off grinding stone by pulling and turning the locking pin by 90°.
- Stop doffer in service mode.
- Use digital or manual microscope to check activating of doffer wire.
- Repeat process if required.

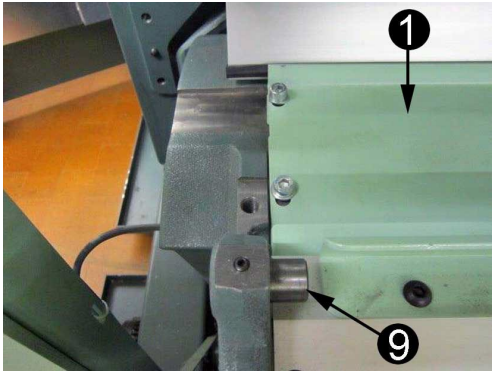
4.4. Restoring card to normal working condition

4.4.1 Loosening and removal of the ASG

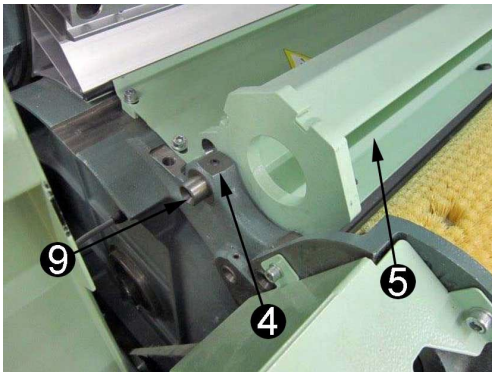


- Loosen fastening screws (6) with socket spanner from the card.
- Loosen headless screws (4) of the fixing bolt.
- Laterally move fixing bolt.
- Remove ASG from the card and store in transport box.

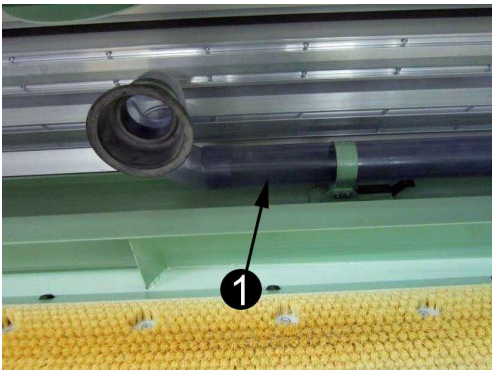
4.4.2 Reattach card components to card



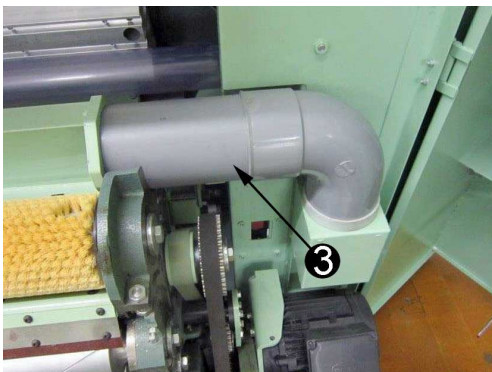
- Insert cover plate (1) and attach with respective screws.
- Attach the cast iron suction tube (5) and insert positioning bolt (9).



- Fasten headless screws (4) of the positioning bolts (9).



- Reinstall suction tube (1).



- Insert synthetic tube (3).

IMPORTANT!

- Set card to automatic mode at the operating panel according to the Rieter instructions following the resharpening process.

5. Card C80

5. Card 80C

5.1 Preparation of the card C80

Caution!

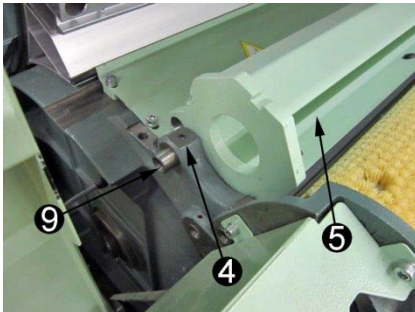


There is a danger of the card being put into operation at any time as long as the main switch is turned on with possible injuries to hands.

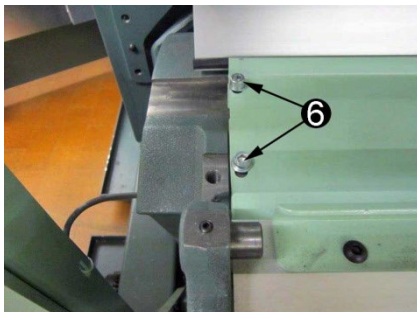


- It is imperative for main switch to be turned off.

The ASG must be installed with card at a standstill only. The safety regulations of Rieter, as manufacturer of the card, with respect to securing / shut-down of the card for service and maintenance work must be adhered to and closely followed.



- Use Allen-key to loosen headless screws left and right (4); slide out fixing bolt (9) laterally.
- Remove cast iron suction tube (5).



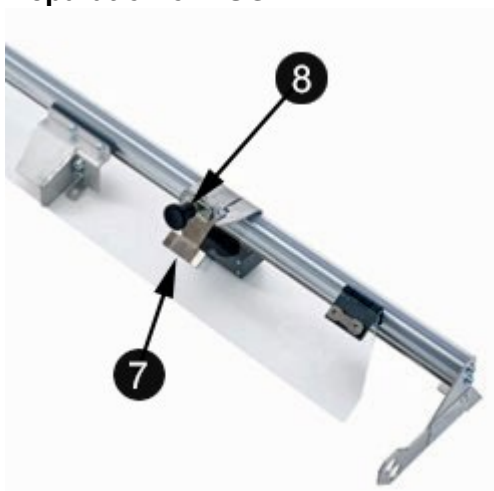
- Loosen attachment screws left and right (6) of doffer cover plate.
- Remove cover plate.

Attention!!

- Screws (6) with washers are required to attach the ASG.

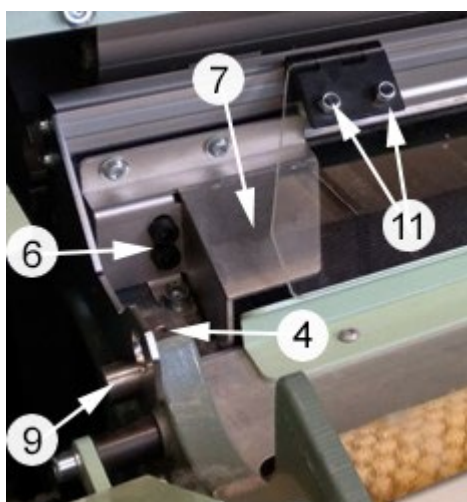
5.2. Attachment of the Doffer Resharpener Device ASG to the card

5.2.1 Preparation of ASG



- Slide attachment supports (7) left and right on to the left- and right-hand side of the device.
- Retract grinding stone by means of the locking pin (8) (to prevent damage to the grinding stone during installation of device).

5.2.2 Positioning and attachment of ASG

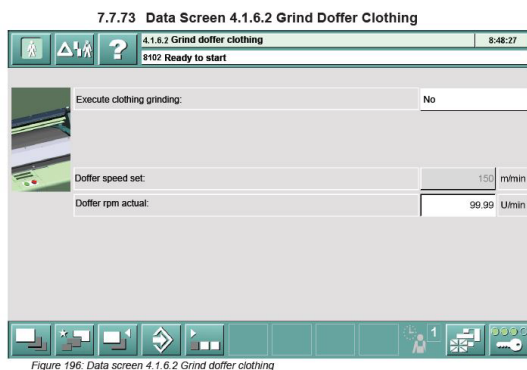


- Position ASG on frame of doffer and secure with fixing bolt (9).
- Fasten the two headless screws (4) left and right.
- Use socket spanner supplied to attach the supports left and right (7) with screws (6) of the doffer cover plates.
- Adjust height as required by loosening screws (11) and refastening screws (11) following adjustment.
- Refasten the two screws left and right (6).

5.3. Activating of clothings

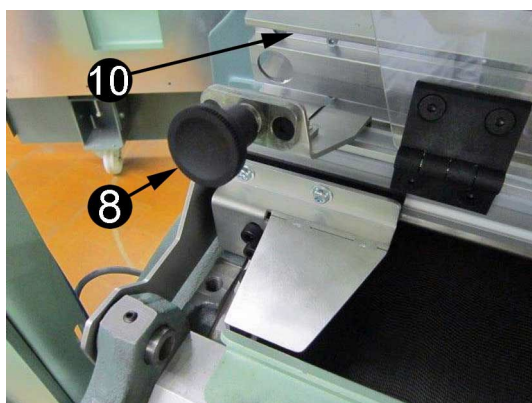
5.3.1 Starting-up of the ASG device

The speed of the doffer of the C80 cards needs to be set at the operating panel; point 4.1.6.2: Maintenance / Grinding of doffer wire.



- Start-up doffer in service mode with 300 – 400 m/min delivery speed (depending on type of card), wait for rpm to be reached.

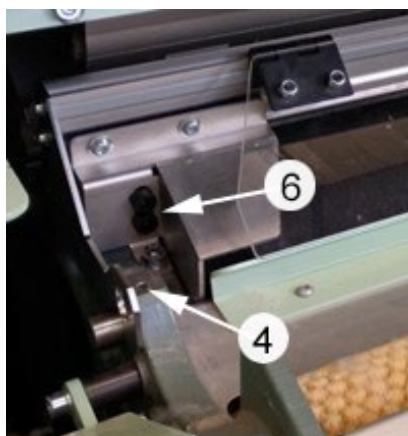
Danger!



- Make sure that protective cover (10) covers the doffer.
- Position grinding stone on doffer wire by turning the locking pin (8).
- Use locking pin to pull grinding stone evenly across width of doffer wire (~2 m/min).
- For the activating of newly installed doffer wire 4 to 6 passages with the grinding stone are required.
- Upon completion of the passages, lift off grinding stone by pulling and turning the locking pin by 90°.
- Stop doffer in service mode.
- Use digital or manual microscope to check activating of doffer wire.
- Repeat process if required.

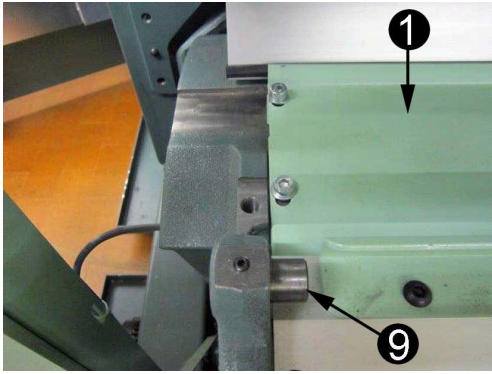
5.4. Restoring card to normal working condition

5.4.1 Loosening and removal of the ASG

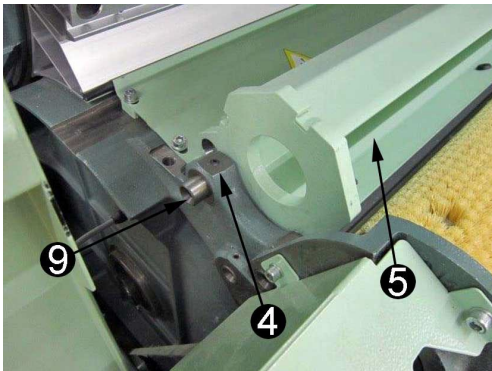


- Loosen fastening screws (6) with socket spanner from the card.
- Loosen headless screws (4) of the fixing bolt.
- Laterally move fixing bolt.
- Remove ASG from the card and store in transport box.

5.4.2 Reattach card components to card



- Insert cover plate (1) and attach with respective screws.
- Attach the cast iron suction tube (5) and insert positioning bolt (9).



- Fasten headless screws (4) of the positioning bolts (9).

IMPORTANT!

- Set card to automatic mode at the operating panel according to the Rieter instructions following the resharpening process.

6. Service and Maintenance

6. Service and Maintenance

The ASG should be cleaned regularly. In case of excessive play of the guide slide, same can be adjusted with the spanner supplied.

Important!

It is imperative that the grinding head is kept clean at all times to ensure proper performance of the stone. If the edge of the grinding stone is lightly pressed, it has to slightly retract into the guide rail. If not => cleaning is required!

If the grinding stone is clogged with dirt and impurities it needs to be cleaned, preferably using benzine.

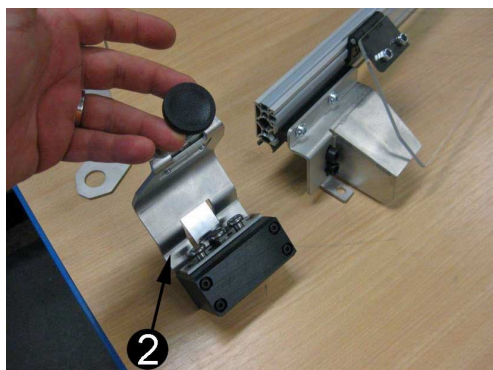
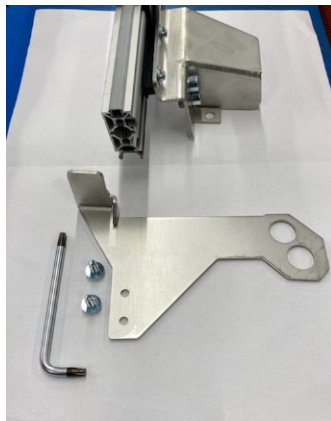
Once doffers of 5 – 7 cards have been resharpened the stone should be checked and regenerated if required (see point 6.2).

Worn grinding stones need to be replaced.

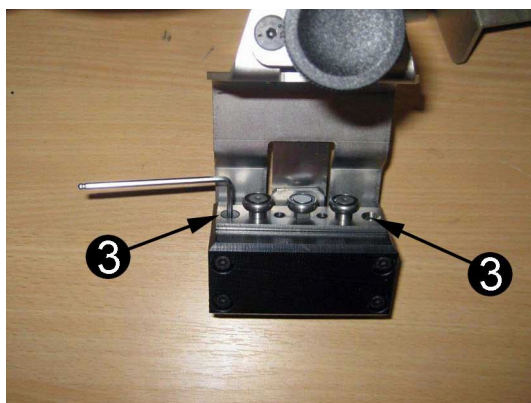
6.1 Resetting of guide slide



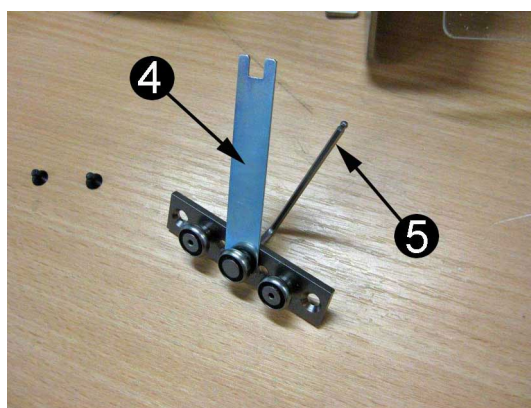
- Remove side cover on left-hand side by loosening the two screws (1).



- Move out grinding head (2).

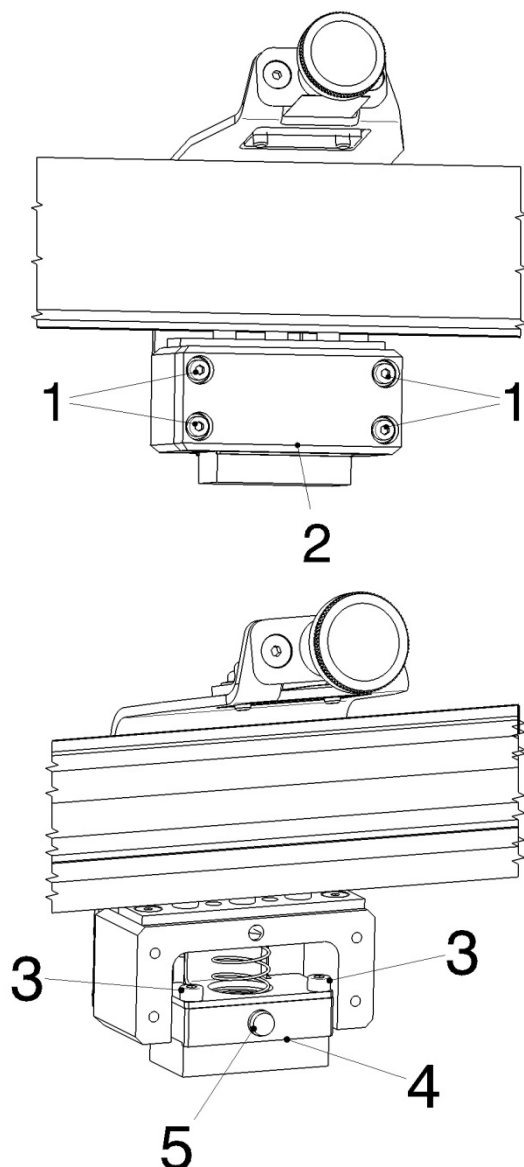


- Loosen both screws (3) left and right and remove guide slide.



- Insert the special adjusting wrench supplied (4) as illustrated at the center guide roller and turn Allen key (5) at the eccentric to achieve the play desired in the guide.
- Test play in C-guide.

6.2 Replacement of grinding stone



- Procedure dismantling:
- Remove screws and washers (1).
- Remove cover plate (2).

- Remove screws (3).
- Remove grinding stone (4) and replace.

Procedure assembly:

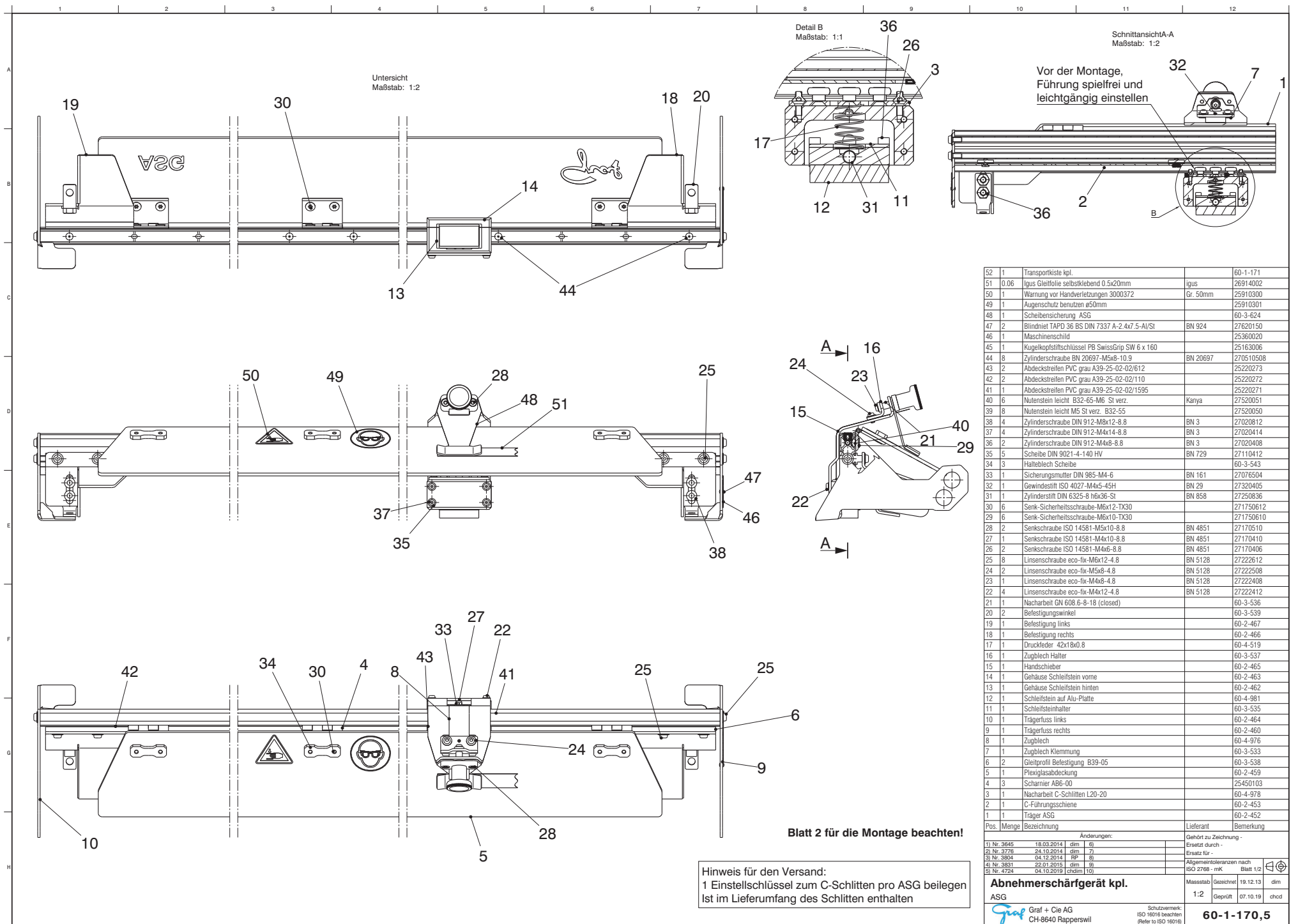
- Position straight pin (5) through the spring steel sheet into the guide rail.
- Fasten screws (3).
- Fit cover plate (2) and position straight pin (5) into the guide rail.
- Fasten screws with washers (1).

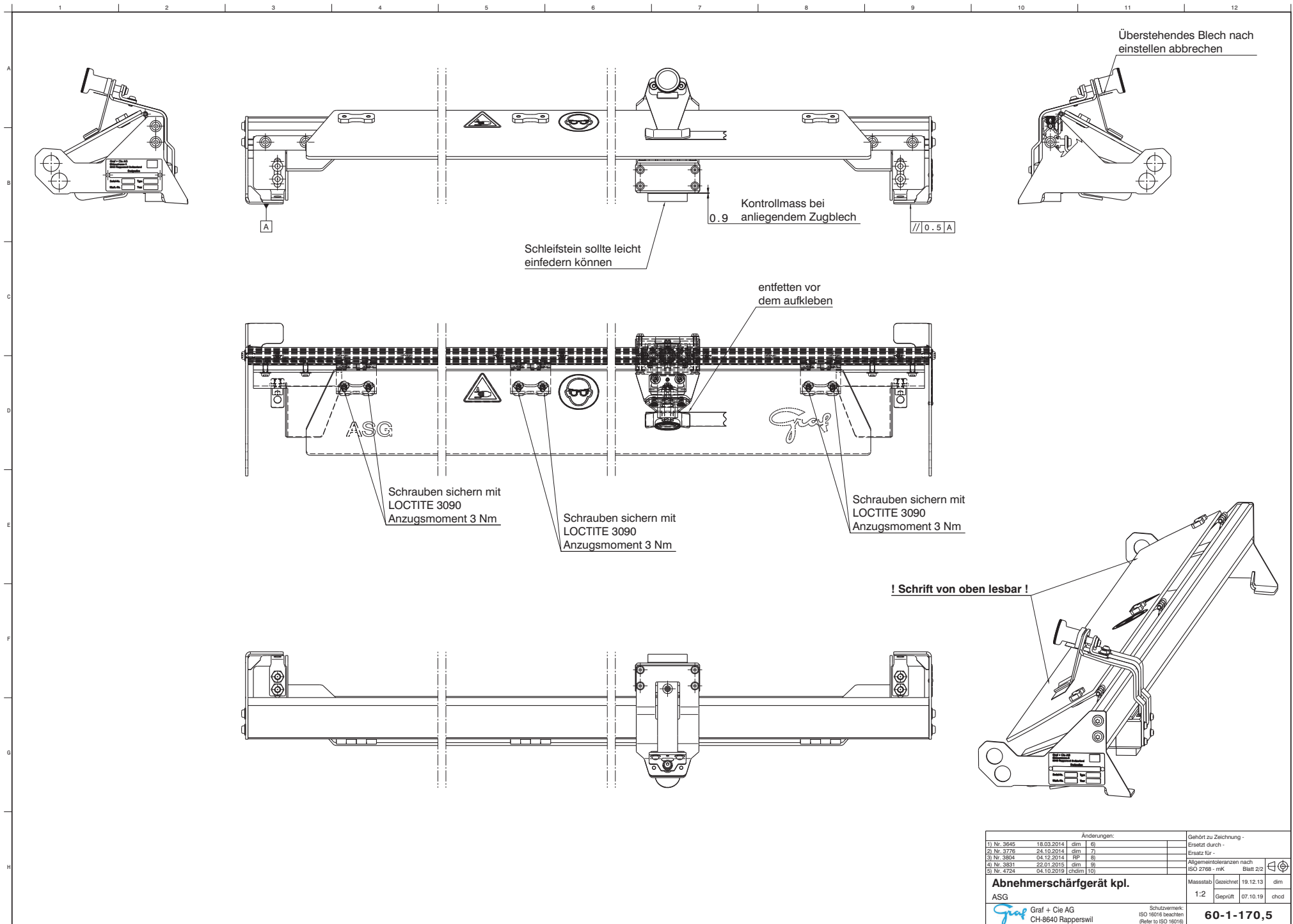
6.3 Regenerating of the grinding stone



- Dismantle grinding stone according to point 6.2.
- Distribute silicon powder in the regenerating plate (approx. 1 mm).
- Apply moderate pressure and move grinding stone in the shape of an 8.
- Check evenness of stone.
- Repeat this procedure until the grinding stone is clean and even.
- Apply compressed air to clean the grinding stone.
- Re-install grinding stone according to point 6.2.

7. Attachment





Änderungen:				Gehört zu Zeichnung -	
1) Nr. 3695	18.03.2014	dim	g)	Ersetzt durch -	
2) Nr. 3776	24.10.2014	dim	7)	Ersetzt für -	
3) Nr. 3804	04.12.2014	RP	8)	Allgemeintoleranzen nach	
4) Nr. 3831	22.01.2015	dim	9)	ISO 2768 - mK	
5) Nr. 4724	04.10.2019	chdim	10)	ISO 2768 - mK	
Abnehmerschärfergerät kpl.				Massstab	Gezeichnet 19.12.13 dim
ASG				1:2	Geprüft 07.10.19 chod
Graf + Cie AG				Schutzvermerk:	
CH-8640 Rapperswil				ISO 15019 beschriften (Refer to ISO 15019)	
				60-1-170,5	

Spare and wear parts ASG

Pos.	Qty	Item description	Item No.	Qty per machine
Abnehmerschärfgerät siehe Zeichnung 60-1-170				
Doffer resharpening device see drawing 60-1-170				
9	1	Trägerfuss rechts Mounting plate right	00602460	1
10	1	Trägerfuss links Mounting plate left	00602464	1
12	1	Schleifstein auf Aluminium-Platte Grinding stone on alu plate	00604981	1
17	1	Druckfeder Pressure spring	00604519	1

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For more addresses see homepage!