

**WORK INSTRUCTIONS FOR STOCK SLITTING**

SN	Instructions
1	Clean the machine and keep the surroundings clean.
2	Check the sharpness of slitting blades and replace them if required.
3	Get the slitting plan from Production Manager and collect the material to be slit.
4	Put the machine main switch "On" and mount the roller on shaft.
5	Inflate the shaft with compressed air and ensure locking of roll on shaft.
6	Mark the cutting position (as per requirement) on roll by using measuring scale.
7	Ensure that cutting blade is free from burr and no adhesive is stuck on sharp edge.
8	Start the motor and let roll start rotating.
9	Take the blade to the cutting position and press the blade against rotating roll. The pressure is applied till the blade cuts the paper core till end.
10	Repeat the same process for balance cut to get best recovery from stock
11	After Slitting, release the air from shaft and set the slit rolls free.
12	Remove the rolls from shaft and enter job details in logbook.

Prepared by: Production Engineer

Approved by: Production Manager