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## **Web-On-Air Operating Instructions**

Thank you for your purchase of this set of DMS Web-On-Air replacement air bars (*US Patent No. 6364247*) or complete turn bar unit. Please follow these instructions to achieve the best performance from your new air bars.

Carefully unpack and install the air bars or complete turn bar unit taking care not to damage the micro-porous air bar surfaces during handling. During installation, verify that your compressed air source is as clean and dry as possible. We recommend that your pressure regulator be as close as possible to the air bar in-feed points and that it includes a water filtration reservoir. It is also important to feed both air bars with the same length of air tubing from the regulator. DMS offers a high quality regulator with filtration as an option if required.

**After installation, set up your Air Bars in accordance with the attached sheet and operate the Web-On-Air bars as follows:**

- Always verify that air pressure is applied to the air bars before operation. ***Failure to apply air pressure to the bars can damage the air bar surface.***
- Clean air bars with air pressure applied ONLY! The micro-porous surface is impervious to most solvents. If cleaning is required, wipe with a soft cloth and solvent avoiding prolonged contact with the epoxy edges.

## **Air bar set up instructions.**

DMS, Inc. produce air bars using a quality-controlled process. The bars are thoroughly tested prior to shipping.

In actual use out in the field the bars are used in numerous presses under a variety of conditions.

There are several factors that are essential to the efficient running of DMS, Inc.'s air bars.

- A clean consistent air supply. Equal pressures should be supplied to the air bars when used in a turn bar configuration.
- The use of non-porous materials that allow for the formation of an air cushion between the bar and the web.
- Correct alignment of the bars to prevent edge loading.

We have compiled the following instructions as an aid to setting up our air bars.

1. Mount your air bar/s in your press
2. Place a pressure gauge in the opposite end/s to that of the air feed.
3. With your air pressure regulator in line connect your air feed to the air bar. When 2 bars are used in a turn bar configuration ensure that the air feed lines are of the same length following the "T" piece. Pressure regulators supplied by DMS, Inc. are limited to a 30psi maximum pressure.
4. All pressures described here relate to the pressure in the bar/s, not at the regulator. The pressure in the bar/s can be significantly different to that shown on the regulator due to the various lengths of tubing used for connection purposes and other factors.
5. Set the air pressure so the reading on the air bar / s is approximately 12 p.s.i.
6. Web your press with a narrow web and using a Sharpie pen place a mark 1/8" away from each edge of the web with the press running.
7. Run the press and while keeping a close eye on the Sharpie pen marks gradually lower the air pressure in the air bars. The purpose of this is to determine the point at which the air cushion between the air bar and the web collapses. When this occurs the web will skew to one side. Note the pressure at which this occurs and raise the pressure in the bar/s by 2 p.s.i. This will be your running pressure.