

KEYSTONE REVIEW

OCTOBER

NOVEMBER

DECEMBER

2006

Rexam Adds Five D-S Extruders to Union, Mo. Plant

Rexam, a world leader in consumer packaging solutions, recently installed five Davis-Standard Thematic® extruders at its plant in Union, Missouri. The extruders, ranging in size from 2 inches (50mm) to 130mm, included screen changers, melt pumps and control systems. Rexam, a Davis-Standard customer for 20 years, has purchased 15 Thematic extruders over the past four years to address increased production. The extruders are used for manufacturing multilayer sheet used in barrier containers for the shelf-stable food market. The Union plant is Rexam's only U.S. facility within the company to produce these types of containers and serve this market.

"I have worked with Davis-Standard on our last three line installations starting in 2002. The people are professional, the equipment is delivered in a timely fashion and start-up services are excellent," said Mark Borzillo, Production Engineering Manager at Rexam's Union, Mo. facility. "Our goal is to run as many quality parts as possible within a

24-hour period, seven days a week, year round. Our Davis-Standard equipment has performed very well under these conditions."

Borzillo especially appreciates the advanced control technology supplied with the extruders. This enables Rexam to maintain stable operating conditions and simplifies troubleshooting and maintenance procedures. It also provides flexibility in changeovers and improves



Mark Borzillo, Production Engineering Manager at Rexam, stands with one of the company's many Thematic® extruders.

changeover time. Rexam appreciates the consistency and quality of the extruded sheet which is then thermoformed into the finished

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New Model 1650 Dual Turret Winder for Wide Width Films

The Converting Systems Group of Davis-Standard, LLC recently introduced a new winder for wide width film converters – the Model 1650 dual turret winder. Based on designs for wide and heavy roll cast film applications, this winder is capable of winding film in widths up to 150 inches (3,810mm) using 3-inch (76mm) shafts. It is also capable of shaftless winding on cores 40 to 140 inches (1,016 to 3,556mm) wide; a unique capability for winders of this type. For added versatility, the Model 1650 is equipped to handle folded, gusseted tubing and in-line slit sheet on the same winder.

The Model 1650 has several design



The Model 1650 winder is capable of winding film in widths up to 150 inches (3,810mm).

advantages. The shaftless chucks can be moved from each side. Wiring is contained in a Catrac arrangement to protect the motor and control wiring while adjusting the width. Shaftless

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Converting Systems: +1 800-338-3660
Europe: +49 173-710-6407

D-S Davis-Standard®

Davis-Standard "GROWs" Manufacturing Efficiency

To further improve cycle times and customer value, Davis-Standard, LLC has initiated an active lean improvement program at its Pawcatuck facility. The initiative, officially named the GROW (Getting Rid of Waste) program, is streamlining processes and emphasizing teamwork across the board. In only one year since being reintroduced, GROW has promoted new strategies to strengthen the company's business plan by determining process improvements, setting goals, mapping out various processes, and implementing strategic and proven solutions. Several cross-functional teams are involved with GROW including the steering committee which oversees the entire program; value stream teams which review and make recommendations for processes; and Kaizen teams which develop the hands-on solutions that eliminate waste.

"The GROW initiative is a significant part of our effort to support Davis-Standard's motto of 'On Time, Every Time.' All employees contribute at some level and that is the primary reason this program has been so successful," explained Ernie Plasse, Davis-Standard's Executive Vice President. "Order and delivery timelines have been improved and wasteful activities are being eliminated. It's a never-

ending process. Kaizen projects are always underway to keep us focused on serving our customers with quality, competitively priced equipment."

The improvements are noticeable and many. Best of all, everyone at Davis-Standard's



Pawcatuck facility is made aware of the progress on a regular basis. Employees are constantly challenged to present new ideas on how to improve safety and quality, save money and eliminate waste. A few GROW program successes over the past year include:

- The spare parts department is on track to go from an 80 percent on-time delivery rate to 95 percent. Two new projects were initiated to improve customer notification systems for late deliveries and expediting emergency

breakdown parts.

- Screws (3 1/2 inch and under) have an on-time delivery rate of better than 90 percent. Improvements such as a color-coded system to identify screws, I.D. tabs to control inventory levels, and racks at strategic positions in the point-of-use process have helped make this possible.
- The time to move a drawing from engineering to manufacturing has been cut in half. Likewise the amount of steps in this process has also been cut in half.
- Currently, a new value stream event is underway to examine the systems test process. The goal is to reduce the scheduled test time by 50 percent. Ideas to meet this goal include pre-testing of electrical panels, timely ordering of supply components, improved communication with vendors, and more. A similar event will be completed for the screw ordering process.

"GROW is making us better, which helps us better support customers," said Jim Murphy, President of Davis-Standard, LLC Extrusion Systems. "Every lean project presents an opportunity to make us more efficient and effective. Customers are always welcome to visit our plant to see GROW in action."

Personnel News

Davis-Standard, LLC announces the following personnel news:

Frank-Uwe Schulz was recently appointed Managing Director of Davis-Standard GmbH in Erkrath, Germany. In his new role, Mr. Schulz will lead Davis-Standard's ER-WE-PA business, which supports converting and extrusion customers throughout Europe, the Middle East and Asia-Pacific.



Frank-Uwe Schulz

He comes to Davis-Standard from E.C.H. Will GmbH, a leading supplier of custom paper manufacturing and converting equipment, where he served as managing Director as well as Director of Sales, Customer Service and Marketing. Mr. Schulz brings more than 20 years experience and an excellent reputation to his new post.

James P. Vescio has been promoted to Vice President and Chief Information Officer, responsible for all information technology activities for the company.



James Vescio

Mr. Vescio has more than 30 years of industry experience, the majority of it spent managing information technologies

to support the reporting requirements of the company.

Robert Daboub has joined the company as Regional Sales Manager for the Extrusion System's Pipe and Profile Group. From his home office in Palatine, Illinois, he will be responsible for sales of extruders and extrusion systems for both the Profile and Elastomer Groups. His territory will include the states of Illinois, Iowa, Kansas, Minnesota, Missouri, Nebraska, North and South Dakota, and Wisconsin.



Robert Daboub

Robert Moeller has been named Technical Director, Extrusion. He will be responsible for managing all technical aspects for the extrusion coating and cast film products manufactured in North America. His responsibilities will also include driving new innovations into the product offering that meet customer and market needs.



Robert Moeller

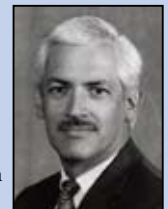
Frank Orsini has been named Director of Key Accounts and Marketing for Extrusion Coating. His responsibilities include the development and maintenance of key multi-national accounts on a global basis. He will



Frank Orsini

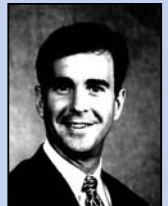
also direct the marketing effort related to extrusion coating to ensure that the Converting Systems Group understands and meets market needs.

Michael Perrigo has been named Technical Director, Blown Film. He will be responsible for driving new advances into the blown film product line ensuring that the Converting Systems Group continues to meet customer and market needs.



Michael Perrigo

Stephen Post has been named Director of Business Development for Asia. He will direct the sales and marketing efforts for the Converting Systems Group in Asia. His responsibilities will include identifying and implementing ways to enhance the company's presence in the region to better serve customers.



Stephen Post

James Shroyer has been promoted to the position of Product Manager, Elastomer. Mr. Shroyer will be responsible for sales and project management for the company's elastomer product line.



James Shroyer

XP Express™ Well-Received by Sheet and Film Processors

The pre-engineered XP Express™ roll stand system from Davis-Standard, LLC is gaining momentum in the sheet and packaging film markets. Davis-Standard has built and sold six XP Express systems over the past few months with dozens of inquiries in the works. The system, introduced in late 2005, is attractive to processors because of a competitive price, fast delivery and versatile design. The XP Express is equipped for the full range of sheet and packaging applications, including capabilities for lamination, solution coating, auxiliary cooling, slitting and trimming, embossing and protective film.

“The interest level is very high for this system because of its ease of access and operating features such as dynamic nip force (PL) control,” explained Al Chrisbacher, Business Area Manager for Davis-Standard’s sheet systems. “We’ve received very positive feedback from customers and anticipate that we’ll have several more of these systems in the field shortly.”

The XP Express is equipped with high

speed features for thin gauge applications and has the capacity for temperatures up to 800 degrees Fahrenheit. It can be configured in an upstack, downstack, offset top or offset bottom arrangement with roll cooling for three, four or five rolls. The design meets or exceeds all current safety requirements. Custom models are available for both custom sheet applications (“CS”) and packaging applications (“PS”). Optional equipment includes hot melt laminating unwinds, protective film let-offs, sheet stress relief systems, post embossing assemblies, web solution applicators, thickness measurement systems, edge trim and multi-



The XP Express™ can be configured in an upstack, downstack, offset top or offset bottom arrangement. Machine shown without guards to demonstrate features.

lane slitting devices, and auxiliary web cooling systems among others.

For more information about the XP Express, contact Al Chrisbacher at achrisbacher@davis-standard.com.

R&D Facility in Texas Bustling with Activity

Customer activity for both product trials and extrusion seminars has been on the rise at the Davis-Standard/Jorgenson Machinery laboratory in Houston, Texas. The lab, a partnership between Davis-Standard, LLC and Jorgenson Machinery Corporation, has seen a continual increase in lab utilization and inquiries since opening in 2005. Davis-Standard customers from across the U.S. and as far as the UK have come to run product trials in the areas of sheet, blown film, cast film, compounding and other processes. The lab is equipped with the full range of Davis-Standard Killion laboratory and small systems equipment as well as film gauges, tensile testers, melt indexers, gel counters, analytical systems, corona treaters and temperature control chillers.

According to Emery Jorgenson, Lab Manager and Owner of Jorgenson Machinery, Killion Laboratories is widely used for material and application development as well as proprietary trials. “Customers are pleased with the size of the lab, range of equipment and overall capabilities. They are able to do proof of concept testing that would otherwise cost them thousands of dollars more if they tried to do it in house,” explained Jorgenson. “We are increasing our number of trials each month and continue to receive an impressive number of inquiries. Recent trial activity includes a three-layer cast trial with EVOH, a multi-layer coating and paper laminating trial, and a three-layer blown film trial with PVOH. In some instances, customers ask us to run trials even if

they are not able to be there.”

Due to its proximity to the Houston airport, technical capabilities and set-up, the lab is also becoming a popular location for extrusion seminars focused on specific extrusion disciplines such as blown film and gel counting. The gel counting seminar in July was so popular that a second seminar was scheduled for September. This seminar focused on gel analysis using a gel counter for quality control testing of film on a cast or blown film station. Participants learned about the composition of gels, how they are created, and solutions for dealing with them.

Simon Dominey, Manager of Davis-Standard’s specialty systems, Killion and laboratory business groups, is pleased with the lab’s progress. “We have customers from across the country using or interested in using the lab. We have several inquiries from Europe and Japan, and have completed a trial for a UK company,” he said. “The lab is continuing to evolve as we upgrade and add new equipment and services. In the meantime, we are able to accommodate just about any process including tensile testing for film, off-line profiling to measure film thickness, gel analysis and several other specialized applications.”

For more information about the Houston-based lab and upcoming seminars, visit www.killionlab.com or contact Simon Dominey at Davis-Standard at 860-599-6342 or at sdominey@davis-standard.com. To schedule a trial, contact Emery Jorgenson at (713) 827-1455 or emery@killionlab.com.

Upcoming Tradeshows

Davis-Standard, LLC will be exhibiting at the following tradeshows during October and November. We look forward to seeing you. We will also be hosting a Basic Extrusion Seminar at our Pawcatuck, Conn. facility.

Rubber Mini Expo

Cincinnati, Ohio
October 10-12
Booth #523

Aimcal Fall Technical Conference

Reno, Nevada
October 22-25
Tabletop Booth

MASS Plastics

Worcester, Massachusetts
October 25-26
Booth #214

Basic Extrusion Seminar

Pawcatuck, Connecticut
October 24-25

CPP Expo

Chicago, Illinois
October 29-November 2
Booth #9505

IWCS

Providence, Rhode Island
November 12-15
Booth #312

Consultant's Corner



Challenges in Winding Flexible Packaging Film

By R. Duane Smith
Product Manager - Specialty Winding
Davis Standard, LLC

If all film webs were perfect, the ability to produce perfect rolls wouldn't be much of a challenge. Unfortunately, due to the natural variation in resins and additives and non-uniformities of the film formation processes, there is no such animal as a perfect film. The winding operation's challenge is to wind film webs with slight imperfections while ensuring these imperfections do not stand out in appearance and are not amplified during the winding process. The winder operator's challenge is to ensure the winding process does not produce additional variations in the product quality.

In defining quality, film product customers want rolls that are the right shape (round and proper width); the right size (right diameter or length); the right consistency (proper roll density, not too hard or soft); and have a good appearance (no blemishes or visual defects). Roll density or in-wound tension, is the most important factor in determining the difference between good quality and poor quality rolls of film products. Rolls that are wound too soft will go out of round while winding or will go out of round while being handled or stored. Yet, rolls that are wound too tightly can cause roll blocking (a defect where the sheet layers fuse or adhere together) and exaggerate web defects.

Roll density is developed in different ways

on different types of winders, but the basic principles of how to build roll hardness are the same. To remember these principles, remember that to consistently wind "dynamite" rolls you need TNT:

Tension - The winding web tension

Nip - The nip of the pressure roll or drum

Torque - From the center drive or torque drum

When winding elastic films, **web tension** is the dominant principle of winding to control roll hardness. The more tension pulled, the more stretch put on the web before winding, the harder the wound rolls will be. When winding inelastic films, **nip** is the dominant principle of winding to control roll hardness. The nip controls the roll hardness by removing the boundary layer of air following the web into the winding roll. The rolling nip also induces inwound tension into the roll. The harder the nip, the harder the winding roll. The challenge for winding flexible packaging film is to have sufficient nip to remove the air and wind hard straight rolls without winding too much inwound tension prevent causing roll blocking or deforming the web over the high caliper area.

Gap winding is ideal for films that are relatively narrow, can be wound at higher tensions, and are wound at speeds generally less than 250 mpm (800 fpm). This method permits a small amount of air to be wound into the roll to prevent deforming webs that have high caliper band areas. For successfully controlling roll hardness when gap winding, the lay-on roll must follow the winding roll's surface with a small and controlled gap. Roll density is controlled through torque, which is the web tension applied through the spindle drive. The drive torque produces a force which is transmitted through the web layers and tightens the inner wraps of film. This torque is used to produce the web tension on center winders. With these types of winders, tension and torque are the same winding principle. However, when the pressure roll is driven to control the web's tension, the torque induced through the center of the roll can be independently controlled to control the winding roll's hardness profile.

Three basic winding processes are used for winding film webs: center winding, surface winding and combination center/surface winding.

A **center winder** can gap wind where only tension is used to control the roll's hardness. It can also incorporate a lay-on or pressure roll so both tension and nip can be used to control the roll hardness. Advantages of center winding include the capability to wind softer, smaller diameter rolls; quick indexing and fast cycle times; capacity to wind films with high tack; dual direction

winding capabilities; and adhesiveless transfers. Disadvantages include limitation of maximum roll diameter due to the torque applied through the layers of film and a higher probability of generating scrap during roll changes.

Surface type film winders use a driven winding drum. The winding rolls are loaded against the drum and are surface wound. When surface winding elastic films, the web tension is the dominant winding principle. When surface winding inelastic materials, nip is the dominant winding principle. This process has the best utilization of space and horsepower; is best for winding large diameter rolls; minimizes waste during transfers; is generally less expensive and requires less equipment. Disadvantages include the fact that air can not be wound into the roll to minimize gauge bands and blocking problems. A drum type surface winder offers only single direction winding (unless on a turntable), and tape or glue on cores is normally required for automatic transfers.

A **center/surface winder** uses both center winding and surface winding processes. In this process, the web tension is controlled by the surface drive connected to the lay-on or pressure roll to optimize the slitting and web spreading processes. Ideally the web wraps the lay-on roll 180 degrees with the resultant tension vector 90 degrees to the nip. This provides maximum tension isolation between web and winding tension and a configuration where the web tension does not affect the nip loading. The primary advantage of center/surface winding is that the winding tension can be independently controlled from the web tension. This winder is also best for winding high slip films to larger diameters and for slitting and winding extensible films to larger diameters. It also has the capability to supply inwound tension without stretching the web over caliper bands. The disadvantage is the winding equipment is more expensive and more complex to operate.

In conclusion, winding good rolls of flexible packaging film is the challenge that every operator faces. Consistently winding good rolls depends on the consistency of bringing good film to the winding operation. A winder operator's job is not to camouflage poor quality flexible packaging film products into shippable rolls. His or her responsibility is to handle films with slight imperfections and to produce quality rolls that will run without problems on your customer's process and produce high quality products for their customers.

This is an abbreviated version of the paper presented at a recent ANTEC Conference. For a complete copy of this paper, go to www.bc-egan.com and look under the publications tab.

EPIC III™ Upgraded to Windows® XP

Davis-Standard, LLC recently upgraded the operating system for its EPIC III™ supervisory control to Windows® XP. This upgrade applies to all new EPIC III orders and is now the standard offering. Davis-Standard will continue to maintain the Windows 2000 platform to support existing customers with the FIX-32 EPIC systems. The company's MESA III system will continue to operate on Windows 2000. For more information contact John Clemens at jclemens@davis-standard.com.

CMR Service & Replacement Parts News

Davis-Standard's Converting Systems Group recently announced the future limitation of parts support for Egan CMR systems beyond 2009. Due to the evolution of technology over the past 20 years, it has become increasingly difficult to find sources for parts and software to support this system.

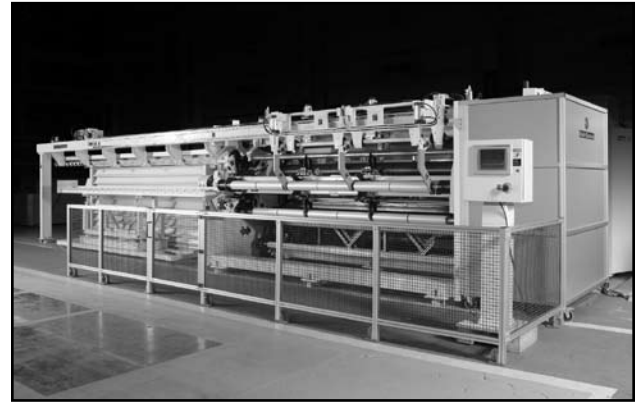
However, Davis-Standard will continue to support CMR customers by offering assistance contracts for both phone support and technical assistance. Beginning October 1, customers will have the option to purchase an assistance contract for an annual fee of \$1,895.00. These contracts will be plant site specific (cannot be transferred between locations), but will cover multiple CMR's at a given plant. Purchasing this contract gives the buyer unlimited access to technical assistance provided over the phone. Extensive trouble shooting will be chargeable as per established service rates. CMR owners who do not purchase this contract will be required to supply a purchase order for technical service and will be billed at the prevailing rates for all time and costs associated with the request.

If you are interested in pursuing a CMR support contract, please contact Tom McDonough at 908-722-6000, Ext. 2367. If you are interested in receiving a quotation to replace your CMR with the new Integrator Pro system, contact Tony Scott at 315-593-0457.

Converting Systems Group Hosts Open House to Promote Winder

An open house held by Davis-Standard's Converting Systems Group on June 14-15 successfully introduced the new Black Magic S4-2 CS 3000 Winder (BMW S4) for stretch wrap applications. The open house held in Oswego, New York and at Davis-Standard's facility in Fulton, New York, brought together several industry leaders. Presentations on high-speed stretch wrap, winding systems for stretch wrap, and blown stretch film production technology were given by Steve Post, Dan Hould and Rick Keller. Participants toured the Fulton laboratory and facility, which was followed by a winder demonstration and question and answer session.

The BMW S4 is a four-spindle surface/center winder ("S4") with two core shaft supports ("2CS"). It is engineered to improve efficiencies for hand wrap and stretch film production with an integrated automatic core and roll handling system and capabilities for producing six-up rolls on a 25-second cycle time, roll change to roll change. Based on



The open house demonstrated the high-speed capabilities of the new BMW S4 winder for hand wrap and stretch film production.

upstream capabilities and 80 percent line uptime, this winder can produce up to 2,700 roll sets per day. In addition, the BMW S4 can reduce the cost of offline equipment and labor with configurations that eliminate bleed trim and automation that can be customized to meet production requirements. It is equipped with a tape-less automatic roll transfer system, AC vector digital drive system and PLC Controls.

For more information about the new BMW S4 or the open house, contact Dan Hould with the Converting Systems Group at hould@bc-egan.com.

Davis-Standard, LLC Sees Jump in Reclaim Equipment Sales

Strong market conditions in the reprocessing sector have resulted in an increase of reclaim equipment sales for Davis-Standard, LLC over the past two years. The company has seen a rise in inquiries and North American sales for its single screw ram stuffer extruder and Scrapper® dual-diameter extruders as well as the Merritt Cascade System. According to Steve Kriger, Davis-Standard's Reclaim Product Manager, sales have been strong due to the high price of resin, environmental concerns and a strong product offering.

"The price of resin has been a key factor in companies wanting to reclaim more of the waste produced in generating their products. It is also a very positive trend from an environmental perspective. Most of our customers are buying machines to reclaim film, foam and injection molded scrap." He added, "With the addition of the Merritt brand to our product offering last summer, we have even more to offer customers in the way of extruders and complete systems for reprocessing post industrial and post consumer waste materials such as low and

high bulk density scrap, lightweight feedstocks, printed scrap and rolled scrap."

Davis-Standard can build reclaim extruders to process materials at rates from 50 to 10,000 pounds (23 to 4,545 kg) per hour. Equipment is available for upstream material preparation, storage and feeding, as well as downstream pellet collection. Feedscrews can be custom designed to accommodate a range of materials.

The addition of Merritt technology has expanded Davis-Standard's reclaim product line. The Merritt Cascade System provides a cost-effective venting solution for reclaiming materials and producing high quality pellets by removing moisture and ink levels from raw materials such as PE, Nylon, PET and PP. The Merritt Polycycle® System is an all-in-one system equipped with a ram feeder or wide mouth feed to reprocess waste from scrap to pellet.

For more information about Davis-Standard's reclaim solutions, contact Steve Kriger at skriger@davis-standard.com or Sandy Guthrie at sguthrie@merrittexttruder.com.

Hayes Industries Purchases Three More Merritt Extruders

Hayes Industries, Inc. of Sugar Land, Texas, recently purchased three Merritt extruders from Davis-Standard, LLC, including a 4-inch (100mm) machine at NPE in June. A specialty plastics/custom cabling manufacturer and post-tensioning industry OEM, Hayes Industries installed one of the extruders at its Texas plant and delivered the others to customers as part of complete systems packages. This purchase is typical for the company, which has purchased two to three Merritt extruders annually for more than 10 years. According to company President and Owner Norris Hayes, Merritt extruders have been an integral part of the company's diversified operation as an OEM and manufacturer of cables used in the oil, defense, petrochemical, communication, geophysical, marine, high temperature and fiber optics industries.

"The Merritt machines have held up extremely well for our in-house operation as well as for our customers who manufacture post-tensioning products. These machines are able to run the full range of thermoplastic materials for demanding applications at a maximum of 125 rpms, 100 percent of the time, 24 hours a day," explained Hayes. "They are straightforward, quality machines with excellent outputs. We've also been very pleased with Merritt's outstanding people and service. Their pricing is fair and delivery times are good."

The reliability and value of the machines has been important for Mr. Hayes as the company prides itself on manufacturing cables for harsh environments as well as short runs, tight lead times and unique product requirements. There is no minimum cable length requirement and Hayes Industries can deliver even complex cable assemblies in two to three weeks. They also manufacture and stock standard cables, which

Rexam *continued from page 1*

product. "We can always count on high quality sheet from our Davis-Standard extruders. This is important in supporting our commitment to quality, availability and service," added Borzillo.

Worldwide, Rexam serves the beverage, beauty, pharmaceuticals and food markets with around 100 manufacturing operations in more than 20 countries. The company is based in the UK. For more information about Rexam, visit www.rexam.com. For more information about Davis-Standard's sheet extrusion technology, contact Al Chrisbacher at achrisbacher@davis-standard.com.



Hayes Industries appreciates the reliability and value of Merritt extruders, purchasing two to three machines a year.

can be cut to any length, for blanket purchase orders. In addition to cables, the company extrudes tubing with capabilities for single or multiple components and high temperature plastics. In the area of post-tensioning, Hayes Industries has been a leader for more than 20 years, offering a broad range of products and services. Post-tensioning products are used to reinforce concrete, masonry and structures such as roads and bridges.

Hayes added, "I've been in the wire and cable business for nearly 40 years, so I've been exposed to both Davis-Standard and Merritt equipment for a long time. Both companies have a great reputation and products, so having them under one umbrella is beneficial to us. We look forward to continuing the relationship."

Hayes Industries supports customers throughout the U.S. and South America. For more information, visit www.hayesindustries.com. For more information about Merritt extruders, contact Sandy Guthrie at sguthrie@merrittextruder.com.

Model 1650 *continued from page 1*

operation can be used for gusseted and folded films which are wound into a narrow bundle for handling. Using the 150-inch shafts, the Model 1650 is capable of in-line slitting and winding of high quality sheeting. An auto transfer mechanism is used to transfer the web to the new core with either shafted or shaftless operation. Manual transfer is available on thick and folded films.

The Converting Systems Group is currently designing future winders to accommodate films up to 180-inches (4,572mm) wide. For more information about the Model 1650 or other winding technology, contact Rick Keller at rkeller@bc-egan.com.

D-S, LLC Holiday Schedule

Davis-Standard's manufacturing facilities will be observing the following holiday schedule in November and December. On behalf of Davis-Standard employees worldwide, we wish you a happy and healthy holiday season and prosperous 2007!

United States

November 24 & 25
December 22, 25 & 29

Germany

November 1
December 25 & 26

United Kingdom

December 25 & 26

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To update your Keystone subscription information with new addresses, contact names, e-mails, etc., please contact Wendy Smith at wsmith@davis-standard.com.

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