VKS TECH
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💥 WEB BREAK ACTION CARD

5-Minute Recovery Plan + 8 Hidden Causes Reference

Doc No: VKS/MET/AC/02
Issue: 01 **Rev:** 00
Print: A4 Landscape + Laminate
Location: Pin near each metalliser

🎯 5-STEP RECOVERY — DO IN THIS ORDER

1 CONTROLLED STOP & RECORD — 30 sec
Let auto-stop sequence finish. **DO NOT press E-Stop** — it is for emergencies only. Note time + break location on web.

2 OBSERVE BEFORE TOUCHING — 1 min
Photo the torn edge. Clean tear or jagged? Check both sides for wrinkles/burn marks.

3 8-POINT CAUSE SCAN — 2 min
Use the cause table on the right. Identify most likely from tear signature + tension display.

4 RE-THREAD & RESET — 1 min
Fresh leader, verify recipe matches current film, confirm alignment at each guide.

5 LOG IN F/16 — 30 sec
Cause code + downtime + wasted film + operator sign. No exceptions.

⚠ BEFORE YOU RE-START

Check: (1) Tension matches recipe for current micron • (2) All idlers rotating freely • (3) EPC sensor clean • (4) No visible edge damage on roll • (5) Anti-static bar powered

📝 F/16 CAUSE CODES — MEMORIZE

T Tension **E** Edge damage **A** Alignment **D** Dirty rollers **S** Speed change **St** Static
F Film defect **B** Boat splash **O** Other

🔑 TEAR SIGNATURE → CAUSE

Clean Horizontal	Diagonal + wrinkles	From one edge	Burnt / splatter	Random jagged
→ TENSION	→ ALIGNMENT	→ EDGE DAMAGE	→ BOAT SPLASH	→ DIRTY / FILM

🔍 8 HIDDEN CAUSES — RANKED BY FREQUENCY

#	Cause	Freq	Tear Signature
1	**Tension mismatch**	28%	*Clean horizontal tear*
2	**Edge damage on unwind**	18%	*Tear starts from one edge*
3	**Misalignment (tracking)**	14%	*Diagonal, wrinkles before*
4	**Dirty / worn rollers**	11%	*Random location, scratches*
5	**Sudden speed / tension jump**	9%	*Break just after parameter change*
6	**Static + web flutter**	7%	*Clean break, fluttering before*
7	**Film quality (supplier)**	6%	*Tear near visible defect/crease*
8	**Boat splash burn-through**	4%	*Burnt edge + aluminium splatter*
-	**Other (joints, shaft, core)**	3%	*Check joints first in F/16*

⚡ QUICK CHECK — 30-SEC TENSION TEST

- ✓ Watch tension display for 30 sec while running
- ✓ Jumping >±10% of setpoint? → **Dancer or sensor problem**
- ✓ Steadily climbing? → **Load cell drift, roller friction**
- ✓ Stable at setpoint? → Tension is not your root cause — check alignment / cleanliness

🛑 STOP CONDITIONS — PRODUCTION HALT

3+ breaks in one shift from same cause • Any boat splash tear (retire boat) • Recurring break on 2+ rolls from same batch (hold batch + raise NCR)