

# GTW Developments Ltd.

## 601 Series splicers



GTW Developments Ltd., Unit 1, Pavilion Industrial Estate, Pontypool, UK, NP4 6NF

Tel. +44 1495 755661

Fax. +44 1495 752619

Web: [www.airbondsplicer.com](http://www.airbondsplicer.com)

Email: [enquiries@airbondsplicer.com](mailto:enquiries@airbondsplicer.com)

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## Model 601 - getting started

**Please read this section before you start operating the splicer. The rest of the manual deals with maintenance, and with details of products; these sections will not be needed immediately.**

Remove all packaging. For each splicer, you will have the appropriate splicing chamber – which will usually already be fitted. Depending on what you have ordered, you will have some or all of the following:

- Splicer
- Additional splicing chamber(s)
- Lanyard
- Optional hanger and screws
- Optional hanging clip

When the splicer is in use, the operator should loop the strap round his wrist to reduce the likelihood of the splicer being dropped.

It may be useful to have a fixed place to store the splicer temporarily when the operator has finished. If it has been supplied, bolt the hanging clip to a convenient spot on a machine. Fix the hanger to the back of the splicer, using the screws provided. (This operation will involve the removal and replacement of the blanking plate). The splicer can then be placed in the hanging clip when not in use. This reduces the likelihood of the splicer being dropped and damaged in service.

**Connect the splicer to an air line, minimum pressure 6 bar. (See Appendix 1 for compressed air Health and Safety issues)**

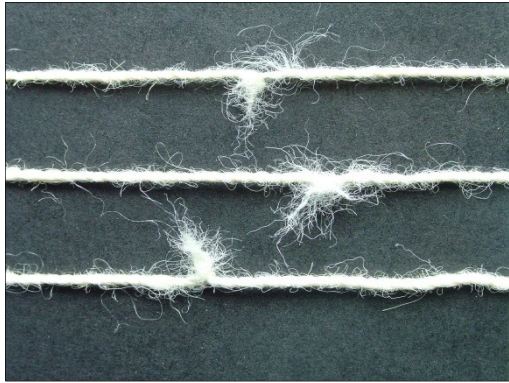
Under normal circumstances, the line pressure should be around 6 bar. The line should preferably be fitted with a pressure regulator so that adjustment may be made to suit local needs.

Hold the splicer with the trigger button facing the body, and press the trigger with the thumb.

- Look down into the splicer
- Press trigger part-way down - see the pad move until it hits the chamber
- Press trigger further - Listen for the air blast

## Forms of splice

The Model 601 splicer can only be used where both ends of the yarn are introduced from the same end of the chamber - the 'ends together' method. Such splices are quick and easy to make, but can only be used in non-critical applications. Most standard splicers are designed to make the neater, ends-opposed splices.

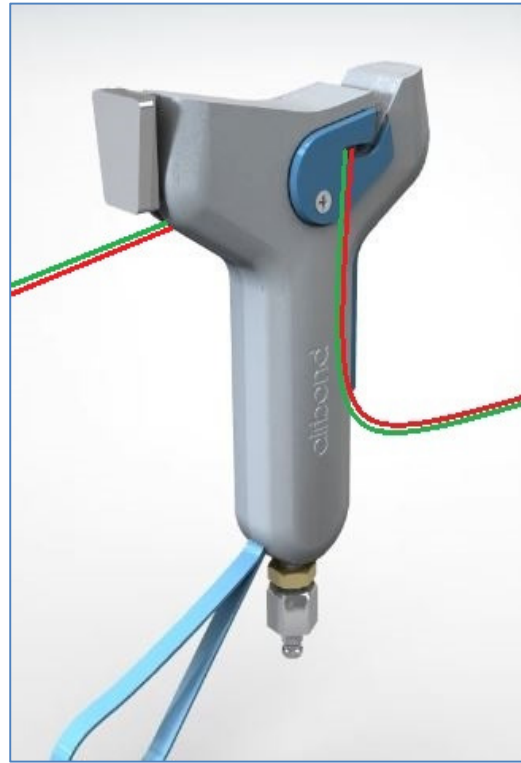


Ends-together and ends-opposed splices.

The ends-together splices on the left were made on a 601; those on the right on a conventional splicer.

## Splicer threading

### String-up instructions for right-handed operator

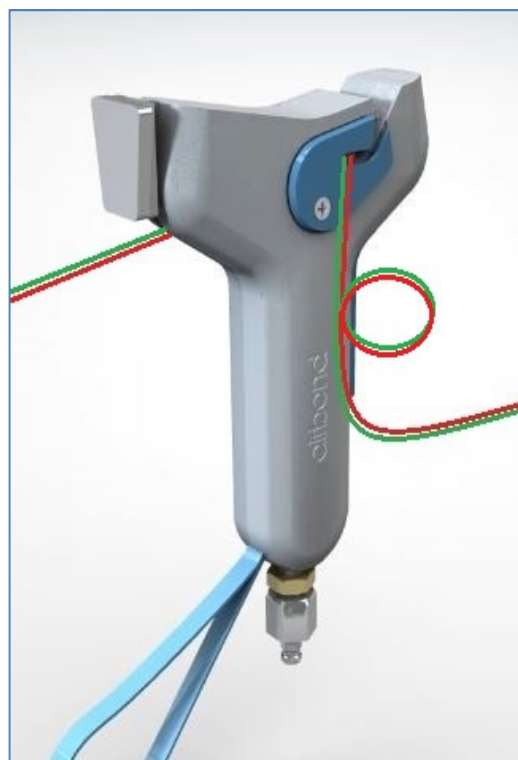


Hold the splicer in the right hand

Bring yarns up beside the splicer, on the right hand side.

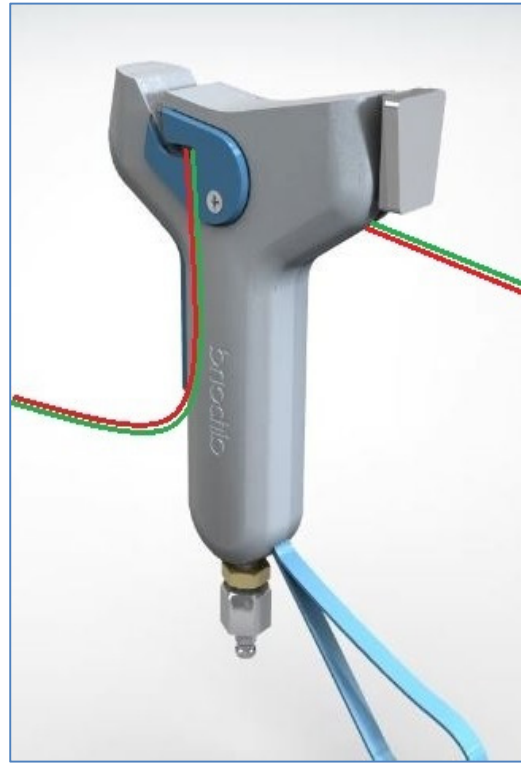
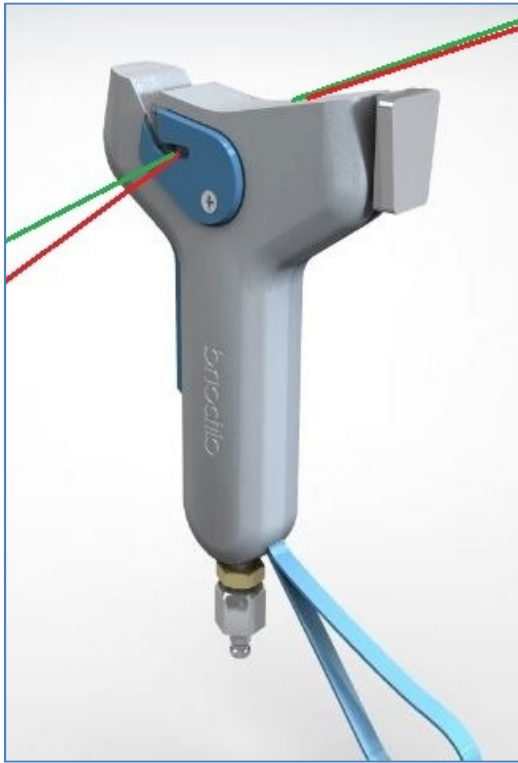
Place yarns together into splicer; restrain with fingers

Alternatively, restrain by looping round the index finger as shown below.



## String-up instructions for left-handed operator

**NOTE:** Before using in left-hand mode, ensure that the splicing chamber has been rotated, and the knife has been re-positioned correctly.

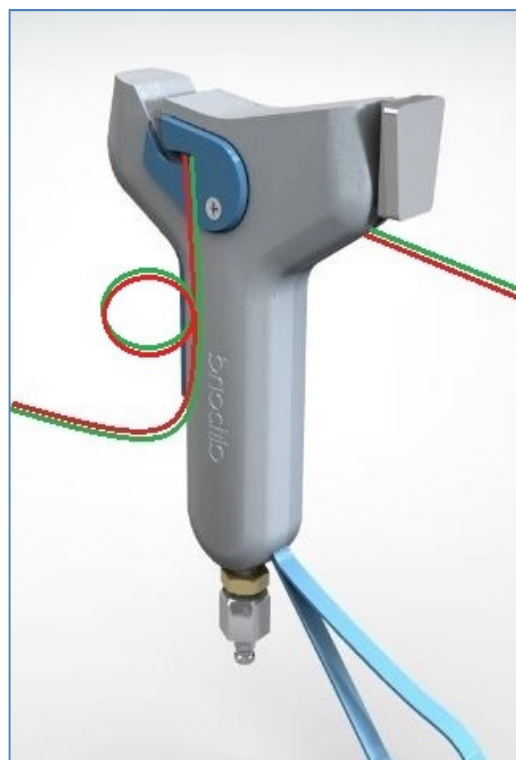


Hold the splicer in the left hand

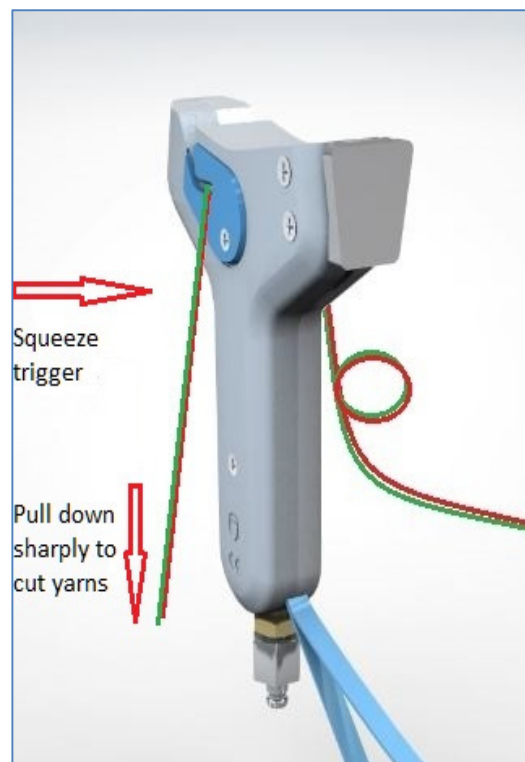
Bring yarns up beside the splicer, on the left hand side.

Place yarns together into splicer; restrain with fingers

Alternatively, restrain by looping round the index finger as shown below.



Once the yarns are in position, pressing the trigger starts the splicing action; the waste ends of yarn are cut off with the static blade as shown below.



## Optimising splicing performance - relative timing of blast and cut

Different yarns require different treatment during splicing. For example, 100% fine wool, being relatively fragile, requires a short blast, while tough yarns such as polypropylene can survive being exposed to a more violent blast.

Because, on the Model 600, blast and cut are completely independent, three splicing procedures are available to the user. All involve squeezing the trigger to close the chamber and initiate the blast, and all involve cutting; but the relative timing of blast and cut can be altered.

### Splice method 1- "Early cut"

1. Half press the trigger, so that the chamber pad closes, but not so far as to start the blast
2. Cut the yarn bundle by pulling down across the blade
3. Depress the trigger fully, so that the blast enters the chamber.
4. Keep the trigger depressed fully.
5. The splice should jump out of the chamber after less than a second

### **Splice method 2 – “Standard cut”**

1. Press the trigger all the way down, so that the pad closes, and the blast enters the chamber.
2. At the same time as pressing the trigger, cut the yarn bundle by pulling down across the blade
3. Keep the trigger depressed fully.
4. The splice should jump out of the chamber after less than a second

### **Splice method 3 – “Late cut”**

1. Press the trigger all the way down, so that the pad closes, and the blast enters the chamber.
2. Allow the blast to disturb the yarn for a short time; then cut the yarn bundle by pulling down across the blade.
3. Keep the trigger depressed fully.
4. The splice should jump out of the chamber after about one second



## Model 601 – general product information

The Model 601 Splicer is unique, in that the splicer body is held inside a rugged ABS outer shell. The shell is capable of standing up to heavy-handed use, but even if the shell is badly damaged by some accident, the splicer body will almost certainly remain undamaged within. The result is that the outer shell can be considered as an inexpensive consumable, while the inner splicer – the expensive part - should have an extremely long service life.

The new splicer body of the Model 601 is itself completely new. It has a novel, patented design, which is simple to operate and extremely simple to repair. The working part has no screws in its construction, and it can be dismantled and re-assembled in about five minutes, without any special tools.

The splicer has a number of components mounted inside an ABS casing, via which compressed air is conducted for the splicing action.

1. Trigger – the first pressing of the trigger causes the pad to move until it closes the splicing chamber
2. Pad - further pressure on the trigger pushes the pad firmly against the splicing chamber, causing the chamber to move back.
3. Valve – the splicing chamber and valve form a single sub-assembly, which means that movement of the splicing chamber moves the valve, allowing compressed air to pass into the chamber for splicing.
4. Splicing chamber – this has a profiled recess on the front face which, with the closed pad, forms a confined space in which the splice is made.
5. (Sometimes) A component called a restrictor plate may sometimes be attached to the splicing chamber, to extend its range of operation.
6. Guide plates - the plates provide a means of guiding the yarn across the splicing chamber and across a static knife..
7. Knife - the static knife on the exit side enables the yarn to be severed during splicing.

The Model 601 is simple, and easy to maintain. Moreover, its construction is such that it is extremely rugged, and requires very little attention in service. The splicer has completely new blast air technology, which is simple, revolutionary and patented. The splicer design allows the tool to make joints in a wide range of yarns without any change (high-twist, low-twist, heavy, fine, S-twist, Z-twist) - in general, there is no need to change chambers when changing yarns.

## Introduction

The company's long-established Models 101 and 105 have been proven over years of service to be the most flexible and durable products in their market sector. They are simple to operate, and easy to repair. They also have a quite unique flexibility of operation; a very wide range of yarns can be spliced on a single splicer configuration. Uniquely, the products can join S-twist and Z-twist yarns without changing the splicing chamber; indeed, they can splice S-twist to Z-twist.

The special characteristics of the 101 and 105 have made them the splicers of choice, particularly for carpet yarn spinners and weavers across the world.

Airbond set out in 2013 to take a fresh look at the 101 and 105, to see whether improvements could be made to the class-leading products. We have succeeded:

- The splicer has a completely new and simplified method of operation – patents are pending for this splicing principle.
- The splicing unit is not exposed at all to everyday wear-and-tear – the unit itself is completely enclosed within a stout ABS outer shell; an accident in service, which might have rendered existing splicers useless, now will merely entail the replacement of the inexpensive outer case.
- The splicing unit has been constructed without screws; when maintenance is needed, the unit can be dismantled merely by pressing out two pins; the whole thing can be dismantled and reassembled in about two minutes.
- The closure pad has been radically simplified; instead of the traditional pneumatic / mechanical actuation, the pad simply pivots on a lever arm, and adjusts automatically to fit the chamber.
- The new splicer is two-thirds of the weight of its predecessor.
- The new splicer is designed for right-handed or left-handed operation - the chamber can be reversed without using specialised tools.
- The trigger design has been made to be more operator-friendly.
- The splicer has improved balance, and feels easier to handle.

Quite simply, the 601 sets a new standard as an effective and user-friendly tool for making splices in carpet yarns.

**The Model 601 is currently available in four forms, the Model 601 H, the Model 601 HW, The Model 601 HF, and the Model 601 HFW. Two of these four forms – HF and HFW – are fitted with a flow-control device, for the user who may occasionally need to use lower air flows for splicing fragile yarns.**



## Model 601 H

This splicer is the simplest of the range. It has no hanging device, and no flow control valve.



## Model 601 HF

Some users may have a range of yarns, with some more fragile than others. Although this splicer has no hanger, it does have a flow control valve, permitting the user to reduce the violence of the air blast when necessary.



## Model 601 HW

Many users find it useful to “park” the splicer in a safe place when it is not in use. This is sound practice, because the splicer is unlikely to be damaged by being dropped, and it is not left lying on the floor, as a safety hazard. So this splicer is fitted with a wedge-shaped hanger. The splicer has no flow control valve.



## Model 601 HFW

This splicer is the most complete of the range. It has a hanging device, and a flow control valve.

# Maintenance

The new splicer unit is protected inside a rugged ABS outer case. Dismantling of the entire splicer therefore takes place in two stages:

1. The outer case
2. The splicer unit

## Splicer outer case dismantling



Place the splicer on a flat surface with the countersunk slotted screws facing upwards. This we define as the UPPER body shell. The other section is defined as the LOWER body shell.

Remove the slotted countersunk screw, Item 135.  
Remove the yarn guide plate, upper side, Item 1616.

Lift off the yarn guide plate. This exposes the entry side of the splicing chamber.



Reverse the splicer and remove the slotted countersunk screw, Item 135.

Remove the yarn guide plate, lower side, Item 1615.

Lift off the yarn guide plate. This exposes the other side of the splicing chamber.



Once the side-plate is removed, the knife, Item 909, is exposed. It is held in a recess in the body. It can simply be lifted out of the body recess.

Take special care when handling the knife to avoid personal injury. Care must be taken to ensure that the knife does not become lost when the guide plate is removed.

At the end of its service life, the knife should be discarded in a manner which will not cause injury to other people. Replacement blades are available from Airbond.



Place the splicer with its left side facing upward, allowing access to the three main slotted countersunk screws. Remove all three; removal of the top two allows the hanger (or the hanger blanking plate) to be removed.

Lift off the left-hand splicer moulding.





Removal of the upper body moulding reveals:

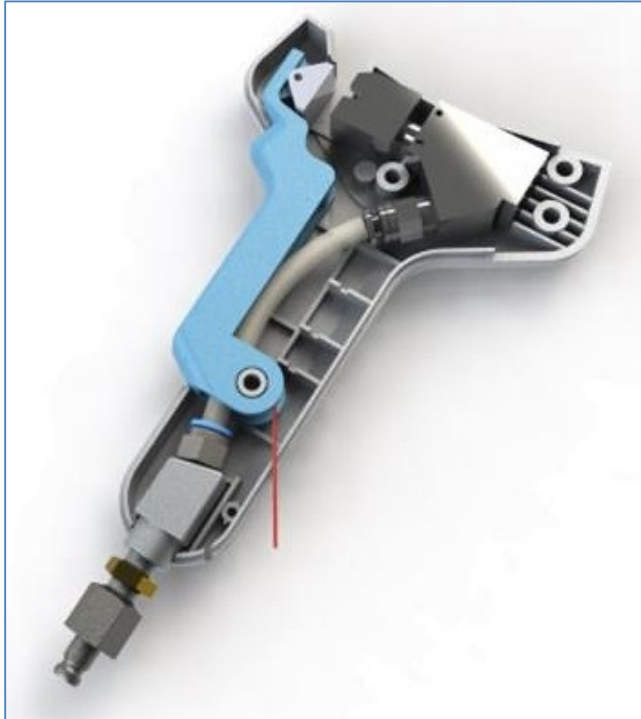
- the main splicer block, (here dark grey)
- the trigger / pad assembly (here blue)
- The lanyard (here blue)

Remove the lanyard securing pin, and lift the lanyard away



This action reveals the trigger return spring. TAKE CARE at this point; the trigger return spring may suddenly escape from its restraint location; sore fingers may result.

Trigger return spring



Release the trigger return spring with care

The trigger return spring is shown here (red) in its released position; in this state it poses no risk.



Ease the upper compression fitting, to release the air union and feed tube. Remove the air union and feed tube.



Lift away the trigger assembly, together with the chamber pad. Keep the assembly as one unit, unless you need to remove the chamber for maintenance or replacement.



Remove the splicing unit, leaving the lower splicer moulding empty.



If required, press out the pad retaining pin, and separate the trigger and closure pad.

## Splicer outer case reassembly



Lay the lower moulding on a flat surface with the thread inserts pointing upward.



The closure pad mounting pin is an interference fit in the splicer trigger lever. This arrangement retains the closure pad, while allowing the pad to be a loose fit, so that it can align itself to the face of the splicing chamber.

Press the pin through the assembly until it is located symmetrically.



Place the splicer unit into the recess in the moulding; ensure that it seated snugly at the base of the recess.



Assemble the trigger sub-assembly and the spring onto the moulding, using the lower boss as a pivot.

Do not tension the spring (shown red) into place at this stage.



Push the air feed tube into the air union sub-assembly.

Locate the air union sub-assembly into the base of the moulding, feeding the air feed tube up through the trigger.

Push the air feed tube into the main splicer unit.

Compress the trigger return spring, so that it locates in its securing slots in the moulding.



Push the lanyard pin into position in the moulding, and position the lanyard.



Locate the upper moulding, ensuring that the lanyard pin is in place.

Place the upper moulding into position.

Slide the hanger (or the hanger blanking plate) into position between the two mouldings.

Assemble the splicer body, using an M4 x 15 mm countersunk screw at the bottom, and two M4 x 25 mm countersunk screws at the top.



Position the blade in its recess, and replace the exit side-plate, using an M3 x 5 mm countersunk screw.

Repeat this action on the other side, to secure the yarn entry side plate.



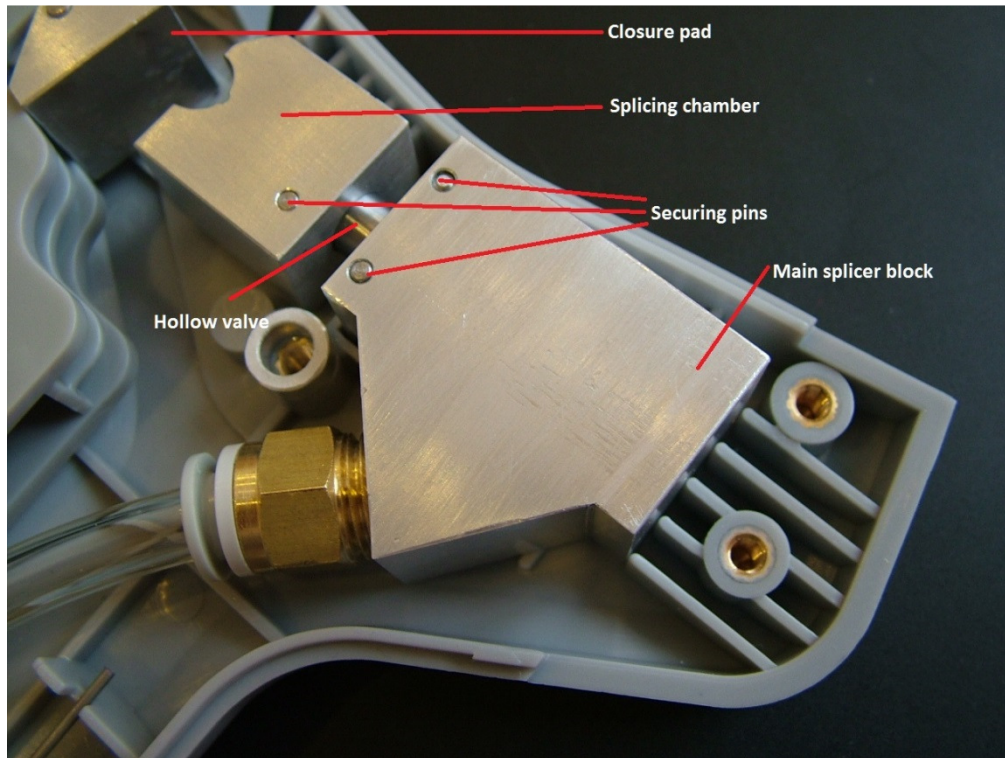


Replace the upper side-plate, using an M3 x 5 mm countersunk screw.

Repeat this action on the other side, to secure the other side plate.

## Splicing unit: Dismantling and reassembly

The splicing unit itself sits inside the outer moulding, so that it is not easily damaged in service. The entire splicing action is contained within the block shown in the photograph.

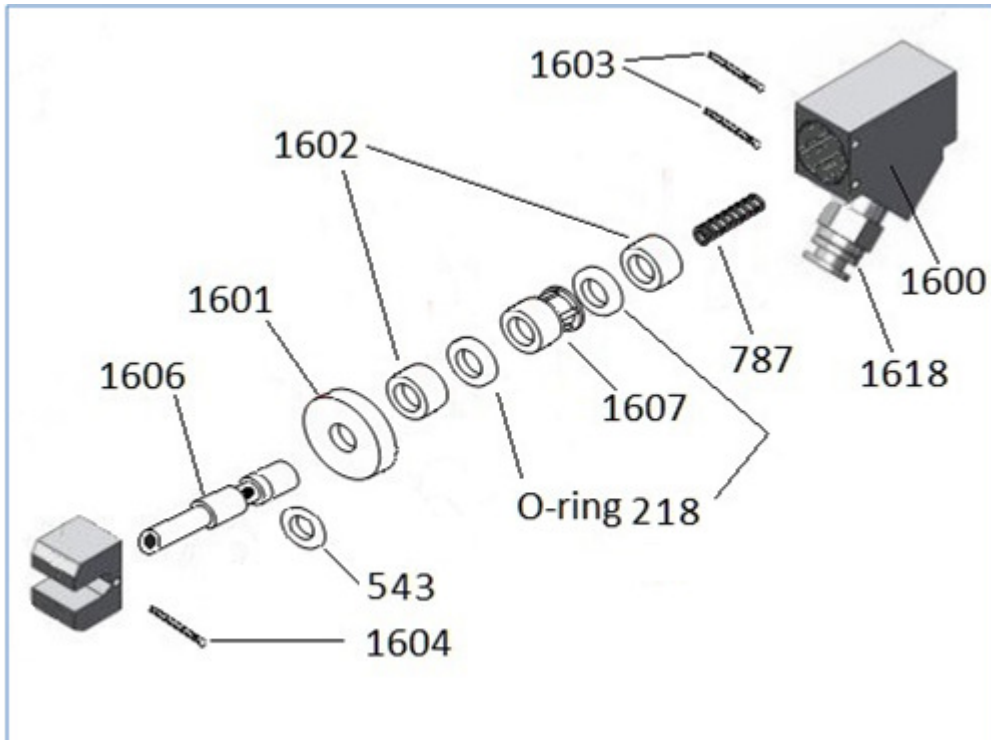


The closure pad is at the top left. The splicing chamber is secured to a valve which runs inside the main splicer block. The valve is hollow, such that air passing through the valve is directed into the chamber. When the chamber is in the resting position, the valve is closed, so that no air flows into the chamber.

Pressure on the trigger swings the pad forward. When the pad makes contact with the front face of the chamber, it aligns itself automatically, and applies a force to the chamber. When pressed by the pad, the splicing chamber slides back into the block, moving the air valve. After a short distance, the valve opens, allowing air into its hollow core, and thence into the chamber, causing the splicing action to start.

### NOTE:

- The pad is secured to the trigger with a simple pin.
- The splicing chamber is secured to the valve with a simple pin.
- The valve is held in the main block by two simple pins.
- So the whole assembly is held together by pins, which can be pushed out; there are no screws.
- A design feature of the splicer is that the valve is freely-mounted in the main splicer block; so the chamber can be rotated, to suit left- or right-handed operators



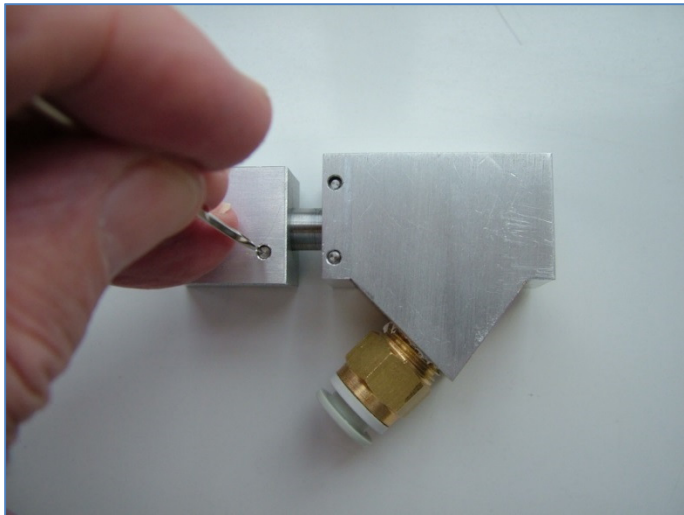
Components of the splicer unit.

From left to right:

- Splicing chamber (part number to be specified by customer)
- Chamber retaining pin 1604
- Valve 1606 (O-ring 543 placed on the valve)
- Retaining disc 1601
- Spacer 1602
- O-ring 218
- Shell 1607
- O-ring 218
- Spacer 1602
- Return spring 787



Lift the splicing unit out of the case, and detach the air feed tube, by compressing the quick-fit connector, and withdrawing the tube.



Remove the splicing chamber. With a small tool, press the chamber securing pin until it slides out. The chamber can then be removed from the valve.

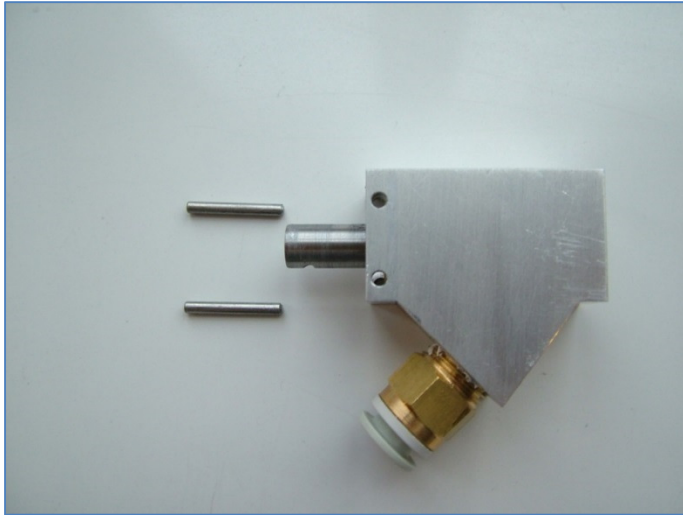


If you are simply replacing the splicing chamber, and not doing a full strip-down:

slide the replacement chamber onto the valve

position the chamber so that the hole for the securing pin is aligned with the small groove in the valve stem

replace the chamber securing pin



With the chamber removed, the compression washer can be seen; it is retained in place by two pins. Using the same small tool as before, press out the pins, so that they come free from the main splicer body.

With the two pins removed, removal of the inner components – the final dismantling of the splicer unit - can commence.



This photograph shows the splicer unit completely dismantled.

To reassemble:

- Locate the return spring in the end of the valve.
- Push the internal components, one-by-one into the splicer body, starting with the brass spacer which can be seen at the extreme right:
- Then assemble in the order shown above and below.

Note the small machined “flat” near to the end of the valve 1606; this locates retaining pin 1604, to keep the splicing chamber in place.

## Appendix 1                      Compressed air

Pneumatic splicers are operated by compressed air. Therefore the air supply must be appropriate. The following points are important:

1. Splicers generally operate at a pressure between 3 and 8 bar.
2. Pressure may vary according to application, but it must be as uniform as possible.
3. The air supply should be reasonably dry and clean, with the lowest possible flow resistance.
4. Because the time taken to make a splice is short, transient pressure drops associated with other demands in the mill may become important,
5. When the splicer is operated, line pressure at the splicer head normally drops by about 1 bar. If there are restrictions in the line, air will not be replenished, so that the pressure drop will be greater; weak splices may result.
6. Compressed air installations should therefore be designed to minimise pressure drop.
7. Never use narrow-bore supply tube; this introduces resistance.
8. When there is doubt about the quality of the air supply system, a pressure gauge should be fitted - temporarily - as near as possible to the splicer, so that static pressure and pressure drop can be monitored. This is particularly desirable in an installation which uses long lengths of coiled hose; losses in such hoses then to be significant.
9. Sometimes, static line pressure is known to be adequate, but there are demonstrable problems with transients. Then it may be useful to fit a few meters of wide-bore pipe or other form of plenum, close to the splicer. This will act as a reservoir, to minimise pressure drops while the splicer is in use.
10. Do not fit lubricators in the line very near to the splicer; an excess of oil on the yarn may weaken the splice.

## Compressed air and safety

All our splicers have been designed with safety in mind. The few moving parts have been enclosed or shielded to reduce the possibility of injury to the operator. In normal use, the only component which is in any way a source of hazard is the knife assembly. By design, however, the blades are difficult to reach, and are not dangerous in any normal circumstances. Knives represent a hazard only during removal and disposal. So, in normal use, the splicers present no risk.

However, the splicers do use compressed air, and that has the potential to cause injury.

1. Compressed air is dangerous: avoid any bodily contact with it.
2. Always follow the safety precautions recommended by the compressor manufacturer.
3. Always ensure that unions and connectors are fully tightened and sealed, and that there are no leaks.
4. Check the conditions of air supply lines on a regular basis. Always ensure that any flexible hoses are unblemished; if there are any cuts or abrasions to the outer surface of the hose, stop using the splicer and have the hose replaced by qualified personnel.
5. Do not look into the working parts of the splicer when it is being operated.

6. If a splicer malfunctions, do not use it until it has been repaired by qualified personnel.
7. For maintenance staff, additional advice is necessary. When cleaning or servicing is being carried out, access to the internal mechanism of the splicer is essential. Under these circumstances, maintenance engineers will be at greater risk than ordinary users. The engineer should adhere strictly to the following guidelines:
8. Before undertaking any service work, disconnect the splicer from the air supply.
9. During service work, exercise care while handling knives and springs.
10. Under normal circumstances, always refit safety covers before reconnecting the splicer to the air supply.
11. Under exceptional circumstances, it may be necessary - for test purposes - to reconnect the splicer to the air supply without its safety covers. While the splicer is being tested, wear protective gear and exercise due caution.

## Compressed air and noise

A splicer uses compressed air, which for a brief period - about 1 to 2 seconds - is vented to atmosphere while the splice is being made. Air at perhaps 7 bar pressure escapes through a small blast hole, creating intense turbulence in a small volume. Noise is inevitable.

Typical maximum noise levels vary from 80 db to 98 db, depending on the splicing chamber. Some chambers are quieter than others, simply because they have a smaller blast-hole, and allow less air to escape.

Our noisiest splicer, with the biggest blast hole in our range, generates a noise spectrum as shown in the table below:

Hz	63	125	250	500	1000	2000	4000	8000	16000
dB	47	52	57	63	74	89	92	93	95

In practice, splicers are barely noticeable in a textile mill. This is because the other mill machinery tends to be very noisy, and the sound of the splicer is lost in the general noise. Also, the blast only lasts for about one second.

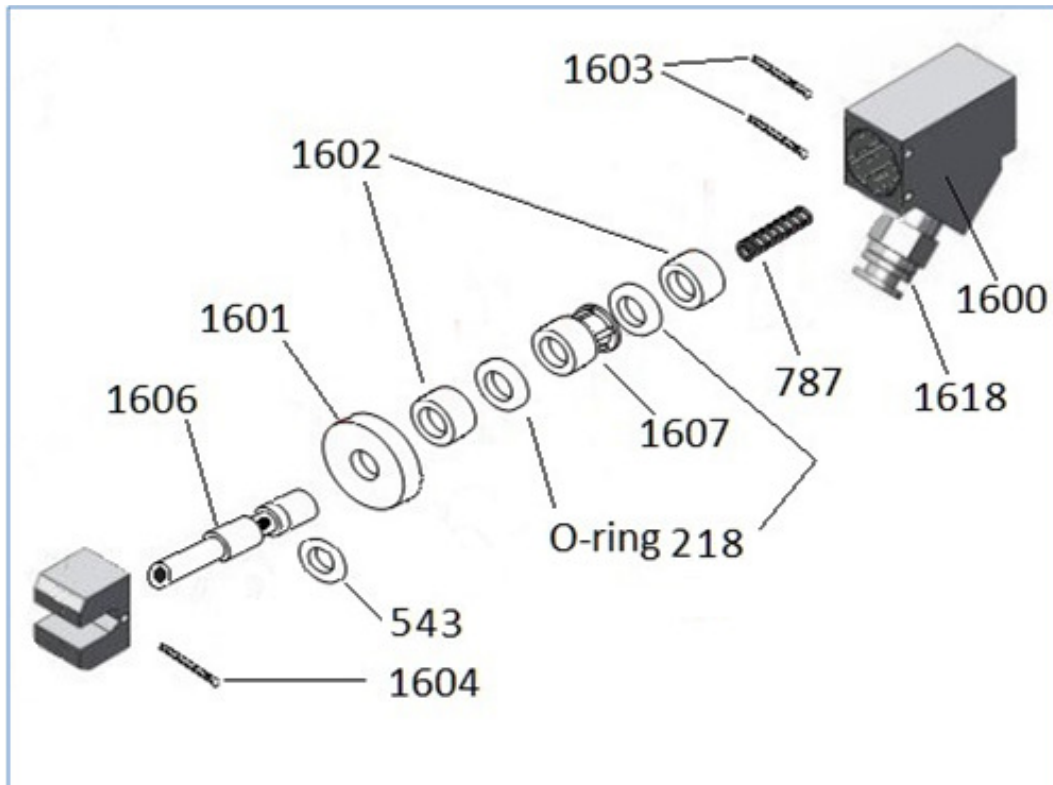
Nevertheless, in compliance with UK health and safety regulations, we recommend that ear defenders (to local standards equivalent to British Standard 6344 Part 1) be worn.







## Model 601 splicer - Parts; splicer unit



## Model 601 - Parts list

Description	Item No.	Part No.
Splicer holding clip	170	201-1199
'O' Ring BS 110	218	01-11-10
'O' Ring RM0070-15	543	02-07-15
Air valve return spring	787	10-136-018
Knife	909	10-106-114
Valve body	1600	10-100-127
Retaining disc	1601	10-133-120
Brass spacer	1602	10-133-121
Retaining pin	1603	10-137-157
Chamber pin	1604	10-137-158
Shutter pad pin	1605	10-137-159
Compression Valve	1606	10-113-127
Shell	1607	2200-54-05
Bottom connector	1608	10-156-600
Trigger return spring	1609	10-100-128
Pad	1610	10-113-129
Lanyard	1611	10-156-602
Outer case right (600 series)	1612	10-156-603
Outer case left (600 series)	1613	10-156-604
Trigger	1614	10-156-605
Yarn guide plate right	1615	10-105-154
Yarn guide plate left	1616	10-105-155
Air feed tube (125mm)	1617	10-156-606
Feed tube connector	1618	10-156-607
Hanging clip	1619	10-165-110
Hanging blanking plate	1620	10-165-111
601 Label	1629	10-156-608
M4 x 22 Socket countersunk head screw	1632	12-44-22
M4 x 12 Socket countersunk head screw	1633	12-44-12
M3 x 6 Socket countersunk head screw	1634	12-44-06
Splicing chamber	7000 Series	To be specified by customer
<b>Flow Control Parts</b>		
O-ring BS006	788	01-10-06
Bottom connector flow	1622	10-156-601
Flow restrictor valve	1623	10-113-128
Outer case right flow (600 series)	1637	10-156-612