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Repeaters

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Mr. E.H. Fors
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Dear Eric: Repeaters

Thank you for a copy of your letter to Myles on the above subject. As you say the question of twisting ovals to the correct inclination at the repeater entrance is only part of the problem. The back end lash is the other part.

The ideal would be a twister which gives the least possible restriction to the flow of the back end and also maintained the correct inclination into the repeater and this can be best accomplished by use of roller guides.

The roller twisters used at Tremorfa were positioned directly behind the delivery guide and setting of these rollers is most critical due to the long length of open trough leading into the repeater. Even small variations in stock temperature giving varying widths of ovals is sufficient to upset the twist.

The Tremorfa mill is reasonably fast but we had little trouble with "pigtailed" ends pulling off in the receiving guides because of the lack in restriction in the roller twister, instead we had the difficulty in correctly setting and maintaining the correct twist.

The Lancashire mill gave us the opposite effect, the mill is somewhat slower, the plug guides are easy to set and will maintain the correct twist until wear necessitates more twist, the occurrence of "pigtails" was much more frequent than at Tremorfa.

As you expressed to Myles, I agree that a method of twisting which has least drag on the oval and at the same time has good control of the twist is the ideal.

I think this condition could be best obtained by use of a roller guide directly behind the delivery guide, a series of cast iron plug guides spaced more open than the present plug guide set-up and allowing more latitude in the rifling, this followed by a second roller twist guide at the entrance to the repeater groove. The latter would ensure the maintenance of the correct inclination of oval.

Yours sincerely

Bill

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