

## New Line Supports Thriving Window Film Business

Commonwealth Laminating & Coating, Inc. (CLC) is a rare exception in these recessionary times. Instead of experiencing losses, the company is showing double-digit gains for its SunTek® brand window films used in automotive and residential/commercial building applications.

CLC's success reflects a smart business model that employs superior processing technology, low overhead, and a nearly 10 percent (and growing) market share in the window film industry. Most notably, CLC has capitalized on overseas markets such as China, Eastern Europe, and Russia where the window film business is gaining

momentum. To support demand, the company recently installed a 72-inch (1,800mm) tandem coating and laminating line from Davis-Standard, LLC Converting Systems. This line, along with a similar line purchased in 2003, has positioned CLC for strong growth now and in the future.

"The window film business typically experiences single-digit growth," said Steve Phillips, President of CLC. "However, in some overseas markets such as China these products are really taking off. We've focused on technology



CLC's new line is equipped for multiple coating modes and quick changeovers.

investments that enable us to provide a far superior product at a price that is typically lower than our competition. This gives us considerable leverage. The new tandem coating and laminating line will further

strengthen our market position and allow us to take advantage of new opportunities."

The new line features two Series 4000 Cartridge Coaters equipped with multiple coating modes. The machine's modular

**Commonwealth** continued on page 3.

## NPE Purchase Sustains Growing Business

The home improvement products' business for Jifram Extrusions, Inc. has been so good that the company purchased a Davis-Standard Super Blue® extruder with DS-eTPC controls directly off the show floor at NPE. The new 3 1/2-inch (90mm) extruder, installed immediately after the show, is being used to manufacture a range of products including closet organizers, storage solutions and fence covers. Jifram appreciates the quick installation of the Super Blue as well as the efficiency of the DS-eTPC, which includes a 12.1-inch (300mm) color touch-screen with built-in PLC processor and multi-loop temperature control. The DS-eTPC is Davis-Standard's most recent discrete controller replacement.



A business that is all in the family. Pictured from left to right: James R. Fischer, Greg Fischer and Steven Fischer.

"The training time for the TPC controller was minimal and the extruder was up and running in no time at all," said Steven Fischer, President of Jifram Custom Extrusions. "The PLC decreased set up time and increased accuracy in setting the machine parameters on the TPC. We have

not accessed all of the features on the TPC, but as we become more familiar with this machine, we are certain it will offer us even more conveniences."

Jifram, based in Sheboygan Falls, Wisconsin, has been a Davis-Standard customer since the company opened its

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# D-S and Gneuss Collaborate on Innovative PET Sheet System

Davis-Standard, LLC and Gneuss, Inc., headquartered in Germany, recently joined forces to supply a unique non-dried PET sheet system that combines high outputs with cost-saving technology. The first of its kind in the U.S., this system merges Davis-Standard engineering and project management with a patented Multi Rotation System (MRS) from Gneuss. Processing rates of 2,000 pounds (900 kg) per hour for PET thermoformed sheet can be achieved while reducing overhead costs associated with similar non-vented extrusion processes.

## Background

The conventional method for processing PET, post consumer or industrial flake is via a single screw extruder. Using this method, moisture and volatiles must be removed first to avoid breakdown of the polymer chain during the melt phase of the process. This requires the feedstock to be crystallized so it can withstand elevated drying temperatures. The crystallizing, drying, and time involved is costly, requiring more energy, equipment and plant space for the finished product.

The technology offered by Davis-Standard and Gneuss streamlines this process. On the Davis-Standard system, a blender combines the PET, post consumer

or industrial flake with virgin pellet flake from each component's blender hopper in one step, eliminating the crystallizing and drying processes. Once blended, the resin is vacuum conveyed to the feed throat of the MRS extruder for processing.

## MRS Technology

The design of the MRS extruder is



Davis-Standard and Gneuss recently collaborated on a non-dried PET sheet system that combines high outputs with cost-saving technology. It is the first system of its kind in the U.S.

comparable to the vent section of a single or twin screw extruder where degassing of the melt stream occurs under precise vacuum control. However, the degassing section of the MRS is much larger, surpassing the surface exchange of a twin screw by 25 times and a single screw by

50 times. This makes it possible to remove moisture and volatiles in the melt stream even more efficiently. The degassing properties of the MRS are also effective when used with a moderate vacuum level, enabling processors to use less expensive and easier to maintain vacuum equipment. Other advantages include low shear stress

and thermal stress for melt, excellent pressure build-up (eliminating the need for a gear pump in some applications), low energy consumption and a compact design. The result is high quality sheet and a process that saves time and money. In addition, when processing post consumer

reclaim the degassing section provides excellent decontamination of the material. FDA approval for processing PET bottle flakes is pending.

## Davis-Standard Advantage

All extrusion technology for this system was supplied under the watchful eye of Davis-Standard. This included everything from the blender loader hopper, Gneuss's fully-automatic RSFgenius melt stream filter and in-line viscometer, to the die and the on-line X-ray gauging system (also in this *Keystone* issue), to the roll stand and winder. Key components included Davis-Standard's EPIC control system with closed loop capability; a roll stand with independent roll speed control; and a turret winder for 48-inch diameter rolls weighing over 5,000 pounds (2,200 kg). Davis-Standard engineered the system so that the finished sheet is fed directly into the secondary operation where it is thermoformed into translucent trays used for fresh food items such as strawberries and tomatoes.

For more information about Gneuss, visit [www.gneuss.com](http://www.gneuss.com). For more information about Davis-Standard sheet systems, contact Al Chrisbacher at [achrisbacher@davis-standard.com](mailto:achrisbacher@davis-standard.com).

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doors in 1981. After an initial Davis-Standard purchase, Jifram added extruders from other manufacturers, but realized the importance of purchasing from one primary manufacturer and went back to Davis-Standard. The company now owns eight Davis-Standard extruders and coextruders ranging in size from 2 to 3 1/2 inches (50 to 90mm).

"We appreciate that Davis-Standard supplies high quality, durable, American-made extruders," said Fischer. "They have an excellent reputation and very responsive customer service. We are a custom operation so we need machines that run a

variety of resins at rates ranging from 1 1/2 feet (0.45 meters) per minute all the way up to 150 feet (45 meters) per minute. Davis-Standard has also helped us with our coextrusion and triextrusion capabilities."

While the company's home improvement business is growing, Jifram's primary specialty is the point of purchase market. Jifram products are used in displays at major retail outlets throughout the United States. They also supply to OEM customers, two of which were Jifram's first and second accounts when the business first opened. Jifram does most of its business in the Midwestern part of the U.S.,

but has also shipped to Canada, Mexico and Taiwan.

According to Fischer, Jifram's greatest advantage is its people. Jifram is a family owned and operated business.

The company's founder James R. Fischer (Steven's father) is still active in the business. Employee turnover is minimal. The company's first hired employee is still there, working as Jifram's Quality Control Manager. Steven and his brother Greg learned the business early, both helping their father as teenagers and coming back to the business full-time after college.

"Being a family owned business

definitely impacts how we operate.

We are focused on customer service, ingenuity, competitive pricing and lead-time. We realize that we can no longer just extrude profiles, we must be a full service company," explained Fischer. "Davis-Standard has played an important role in supplying the equipment needed to support our evolving business model."

For more information about Jifram, visit [www.jifram.com](http://www.jifram.com). For more information about Davis-Standard's Super Blue extruder and DS-eTPC controllers, contact Wendell Whipple at [wwhipple@davis-standard.com](mailto:wwhipple@davis-standard.com).

# Improve Blown Film Quality Without Overspending

By Rick Keller, Vice President of Blown Film, Davis-Standard, LLC



Rick Keller

Improving blown film quality on existing machines can often be a daunting and confusing task. It is not uncommon to see successful companies approach this matter in a rather happenstance way, hoping for a miracle component such as an air ring or auto profile system to solve their quality and return goods problems. Unfortunately, these approaches often fail and users are forced to buy new machines as the only solution. Not that that's a bad thing! However, a better understanding of process variables and the factors impacting blown film quality go a long way in achieving goals in a thoughtful, logical and high value fashion and should be applied when specifying new components.

An absolute prerequisite for blown film quality is extrudate quality. If there is variation coming off of your screw tip, the die and air ring will not correct it no matter how fancy or advanced they may be. Measuring and understanding

the extrudate variation is a must for any extrusion operation, and one that many operations do not understand. It is vital that existing extruders have the proper instrumentation to measure melt temperature and extruder pressure in a manner that will optimize quality. This is often not the case. So how do we solve this problem?

The key is to have an extrusion process where the melt temperature and pressure are stable. Combining such stability with precision machined die lips and air ring parts will help you produce a fine, flat blown film. The individual component performance goals should meet the following criteria.

1. Extruder pressure variation: This should be less than 1 percent total variation; more than 1 percent variation in pressure yields 2.5 percent in MD thickness.
2. Extruder melt temperature variation

(time dependent): Design criteria should be under 2 degrees Fahrenheit; +/- 2 degrees may result in +/-1 percent in MD thickness.

3. Extruder melt temperature variation (position dependent): Design criteria to be under 5 degrees Fahrenheit. This is a more serious effect as cold material tends to flow in bottom of spiral and emerge as "port lines."
4. Airflow abnormalities in distribution: Variation should be less than 1 percent around circumference.

Should your measurements fall outside these parameters, a thorough investigation and improvements should be made. Most often, worn or inadequate screws are the culprit. A worn screw results in higher melt temperatures and higher melt temperature variations. We recommend replacing all screws and barrels as needed. The radial clearance between a screw flight and the barrel should be approximately 0.001

inch (0.0254mm) per every inch of the screw diameter. For example, a 3.5-inch (88.9mm) screw flight should be 3.492 inches (88.7mm) to fit into a 3.5000-inch (88.9mm) barrel. When the screw is worn more than 0.010 inches (.254mm) in diameter, you will start to see degradation in performance.

I hope this helps you maximize your equipment and components. If you are having difficulty improving your blown film process, please contact me at [keller@bc-egan.com](mailto:keller@bc-egan.com). One of our specialists will help you find a solution!

## Commonwealth continued from page 1.

design is one of its biggest advantages, making it possible to achieve changeovers by one operator in 10 minutes or less. The coaters are enclosed for safety and cleanliness, and off-line cleaning and system modification can be accomplished without contaminating the coating room. To further augment capabilities, Davis-Standard added a second cut-off system at the winder for transfers of thicker material films for window tinting. Automatic splicers on both unwinds and the rewind enable continuous operation at speeds up to 250 fpm (76 mpm).

"The new line has significantly improved the clarity of our films, which is especially important for windshield applications. Windshield films need to be as clear as the glass itself to avoid angular distortion," said Phillips. "This new machine is definitely

enabling us to produce the quality films our customers demand."

Similar to the system installed in 2003, the new line has an Integrator PRO supervisory control system; an advanced UV-curing unit; AC vector drives; network controllable web guides; two convective gas-fired dryers; and proprietary solar-reflective and p-s coating heads. Both Davis-Standard lines are used for supporting SunTek brand applications in the automotive, safety, architectural and solar control markets.

For more information about CLC, visit [www.suntekfilms.com](http://www.suntekfilms.com). For more information about Davis-Standard's coating and laminating capabilities, contact Christine Maxam at [maxamc@bc-egan.com](mailto:maxamc@bc-egan.com).

## Holiday Schedule

Davis-Standard and its affiliates will be observing the following holiday schedule in November and December.

### UNITED STATES

Thanksgiving	November 26-27
Christmas	December 24-25
New Year's Eve	December 31
New Year's Day	January 1

### CHINA

National Day	October 1-8
New Year's Day	January 1

### GERMANY

Christmas	December 24-25
New Year's Eve	December 31
New Year's Day	January 1

### UNITED KINGDOM

Christmas	December 25, 28
New Year's Eve	December 31
New Year's Day	January 1

We wish you a happy and healthy holiday season and prosperous 2010!



# New Hinge-Roll Feedsection Adds Value and Efficiency

Davis-Standard, LLC recently introduced a new hinge-roll feedsection for medical silicone processors and other elastomer processors requiring frequent compound changes or feedroll cleanings. The feedsection's straightforward design provides a combination of efficiency and simplified maintenance. The feedroll and interior of the feedsection is accessible by unfastening two swing bolts and lowering the attached swing-down cartridge by means of an electro-mechanical

cylinder. By removing four additional fasteners, the cartridge can be completely detached for feedroll and bearing replacement.

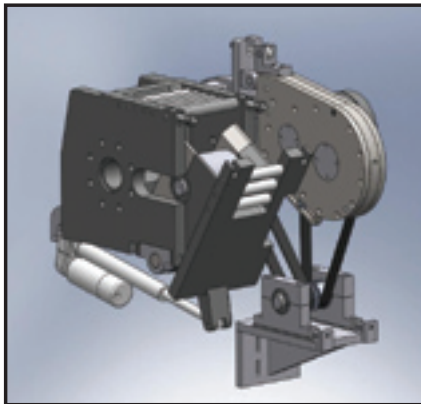
"This feedsection improves upon our existing Davis-Standard adjustable torque clutch design," said Joe Wnuk, Vice President of Davis-Standard's Elastomer Systems. "In addition to its simplicity, this design offers a uniform, consistent feed rate and adjusts automatically based on feed strip size. There is also no external

motor or feed drive required, providing cost savings."

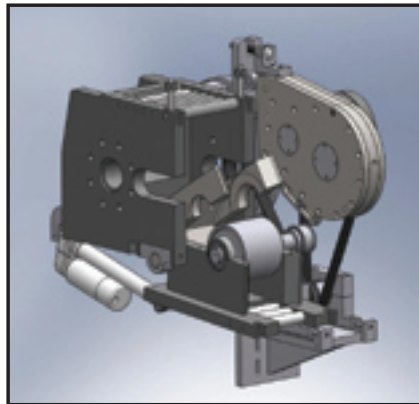
One of the greatest advantages is the feedsection's quick and easy maintenance. The belt drive eliminates lubrication requirements and the belts automatically loosen for feedroll removal. The feedroll and bearings can be removed without disassembly of additional components. For safety, the feedroll retainer swings away from the operator, positioning the roll in a more ergonomic lifting position for the

operator. This feedsection is available for retrofit to existing 3 1/2 inch (90mm) Davis-Standard extruders and other sizes as needed. It can be equipped with a through-hardened steel scraper or optional nylon scraper for silicone applications. Other options include a chrome-plated feedsection and feedroll, and water-cooled feedroll.

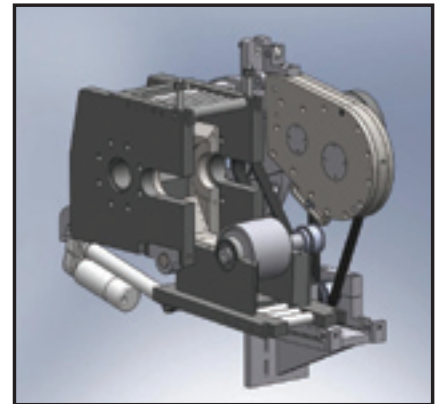
For more information, contact Joe Wnuk at [jwnuk@davis-standard.com](mailto:jwnuk@davis-standard.com).



Feed roll swinging down.



Intermediate position of feed roll retainer.



Full access for feed roll removal.

# Polyplex Endorses Davis-Standard's Quality and Service

Polyplex Corporation Limited, based in India, has found significant value in its relationship with Davis-Standard, LLC. In 2007, Polyplex installed a Davis-Standard extrusion coating line at its subsidiary in Thailand to support the company's thermal lamination PET and BOPP film business in Southeast Asia. The equipment has performed exceptionally well, allowing Polyplex to gain market share in the region and improve efficiency. Due to this successful implementation, Polyplex is currently working with Davis-Standard on a new line for CPP production.

"Davis-Standard's equipment has enabled us to produce quality product while reducing waste. We appreciate the vertical start-up, minimized sample approval time in market and wider range of production (1mil to 10mil). The line is operator friendly and we've received excellent technical support from Davis-Standard," said Senthil Kumar, Deputy General Manager

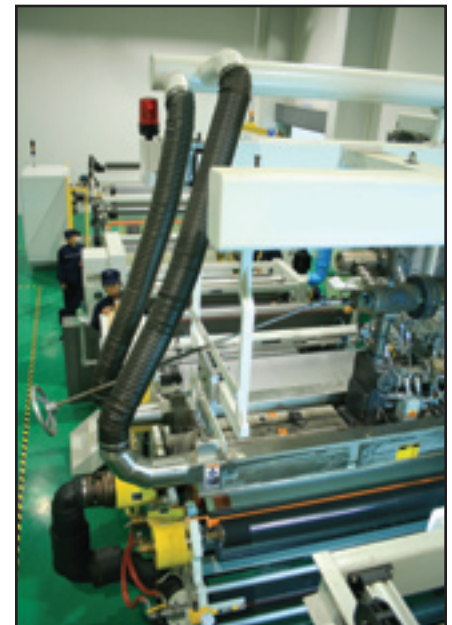
— Technology Cell of Polyplex. "They have also helped us improve our project schedule and timing as well as our response to inquiries. Davis-Standard is our technology supplier of choice as we look at our long-term business expansion and other multiple project requirements."

Polyplex's thermal lamination line in Thailand features three extruders with a three-layer feedblock, turret unwind with splicer, two-roll coater with arch dryer, extrusion laminator, Integrator PRO supervisory control system, and more. The line has a maximum web width of 2,000mm (79 inches) and machine line speed of 300 mpm (984 fpm). Davis-Standard also provided start-up assistance and commissioning. The line has played an important role in the company's film quality and expansion, which is essential for a respected industry leader like Polyplex. The company exports 75 percent of its total production to the United States,

Australia, Europe, Southeast Asia, Japan, Korea and others. Recently, Polyplex expanded into Turkey, making them the fifth largest producer of thin polyester films in the world.

Kumar added, "We are one of India's leading manufacturers and exporters of film for packaging, electrical and other industrial applications. To maintain our profitability, our operations worldwide need to be cost-effective without sacrificing quality. Davis-Standard shares in this philosophy and commitment."

For more information about Polyplex, visit [www.polyplex.com](http://www.polyplex.com). For more information about Polyplex (Thailand) Public Company Ltd., a subsidiary of

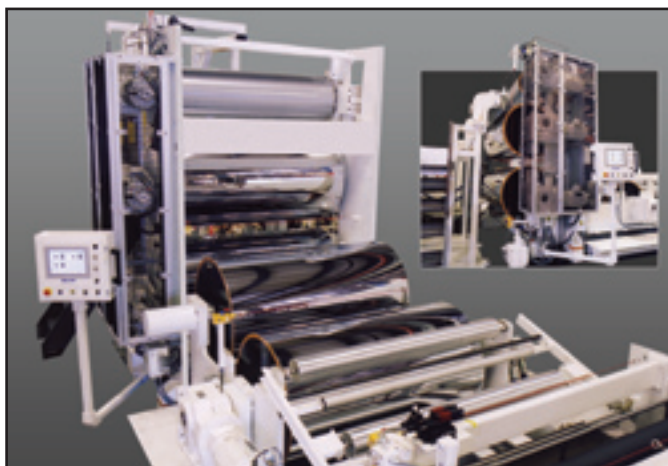


The new line has enabled Polyplex to support its thermal lamination PET and BOPP film business in Southeast Asia.

Polyplex Corporation Ltd., visit [www.polyplex.com/aboutus\\_plants.htm](http://www.polyplex.com/aboutus_plants.htm). For more information about Davis-Standard's product offerings and capabilities, contact Adnan Bdour at [bdoura@bc-egan.com](mailto:bdoura@bc-egan.com).

# XP Express® Supports Hundreds of Applications

The XP Express® roll stand system from Davis-Standard, LLC has proven its worth in applications and efficiency. Available in PS (packaging sheet) and CS (custom sheet) models, this roll stand is used worldwide for processes involving PP, APET and PS for products used in the beverage and prepared food distribution markets. It is also equipped for extrusion processes involving EVA, TPA and vinyl acetate copolymers for solar energy applications. In the area of barrier structures, the XP Express is effective at processing sheet with more than 100 layers using layer multipliers for microlayer composites. Following is a summary of sheet types as well as end use applications for both models.



The XP Express® is versatile and highly efficient, making it a popular choice among customers.

and features hands-free dynamic roll gap control through the full product range.

## CS Model

Like the PS model, this system is highly efficient with an ergonomic design, high processing rates and reduced carbon footprint. In addition, this model features a quick roll change design to accommodate custom embossed sheet.

Ancillary equipment for both roll stand models is integrated and designed based on individual application.

Equipment includes lamination; rolls,

baths and troughs for expanded cooling; post embossing, sheet conditioning on heavy gauge; dip tanks, roll coaters, and electrostatic for treating; web accumulators; slitting stations; thickness control; shear and stack; and single and multiple web winding.

For more information about the XP Express and Davis-Standard's sheet extrusion capabilities, contact Al Chrisbacher at [achrisbacher@davis-standard.com](mailto:achrisbacher@davis-standard.com).

## PS Model

This model is built for the packaging industry. It has a high capacity, highly efficient design with a reduced carbon footprint. It incorporates advanced technical features for direct extrusion, in-line thermoforming, or the production of roll stock for subsequent off-line thermoforming. The PS is capable of applications up to 8,000 pounds per hour

### PS MODEL

#### Sheet Type

Multi-layer, single barrier extruded sheet  
Multi-barrier layer, multi-layer extruded sheet  
Multi-layer, extrusion laminated barrier sheet  
EVOH, PVDC and Nylon barriers

#### End Use Application

##### Food packaging

- Retort process packaging
- Ambient stable shelf life packaging
- Microwave containers

##### Personal care products

- Vapor and moisture barrier, printability

##### Industrial

- Liquid containment

Mono or multi-layer, non-barrier sheet  
Polypropylene, APET, PLA, CPET,  
Polystyrene Crystal Styrene, Polyethylene,  
ABS

##### Containers

- Drinking cup
- Fruit and vegetable containers
- Bakery packaging
- Microwave containers
- Clam shell packaging
- Meat and poultry packaging

##### Appliances

- Refrigerator liners
- Spa tubs and baths

PE, PP

##### Agricultural and horticultural products

PET, PLA, PP, PE

##### Point of purchase

- Retail display packaging
- Graphic arts
- Prismatic

### CS MODEL

#### Sheet Type

Mono or multi-layer non-barrier sheet  
PP, PS, CPS, PE, FPVC, LDPE, Urethanes,  
ABS, PMA, PC

#### End Use Application

##### Custom finish sheet products

- Aftermarket automotive products
- Binder covers
- Chair mats
- Floor runners
- Lenticular sheet materials
- Light diffusers
- Medical
- Photovoltaic sheet
- Roofing walkway

## UPCOMING EVENTS

Davis-Standard, LLC will be participating at the following tradeshows and seminars.

OCTOBER

### CPP Expo

October 5-7, 2009  
Las Vegas, Nevada - USA  
Booth 5657

### Rubber Expo

October 13-15, 2009  
Pittsburgh, Pennsylvania - USA  
Booth 404

### The Basics of Plastics Extrusion

October 14-15, 2009  
Pawcatuck, Connecticut - USA

### Aimcal Fall Technical Conference

October 18-21, 2009  
Amelia Island, Florida - USA

### Saudiplast

October 18-21, 2009  
Riyadh, Saudi Arabia  
Booth #TBD

### AMI Stretch & Shrink Conference

October 26-27, 2009  
Atlanta, Georgia - USA

### Extrusion of Engineering Plastics

October 26-28, 2009  
Mystic Hilton Hotel  
Mystic, Connecticut - USA

NOVEMBER

### ICE Show

November 24-26, 2009  
Munich, Germany  
Booth #TBD

# Israeli Film Manufacturer Values Vendor Commitment

Poleg Plastic Industries located in Kibbutz Gevim near Ashkelon, Israel, appreciates Davis-Standard's equipment and personalized approach to business. A global film manufacturer, Poleg became a Davis-Standard customer 10 years ago with the purchase of an extruder. Prior to that, the company purchased two coextrusion lines from the Black Clawson Company, one in 1986 and one in 1991. Now that Davis-Standard, LLC offers the Black Clawson Converting Machinery brand, Poleg can rely on one source for most of its equipment needs. Last year, Poleg replaced a 20-year-old winder with a new

customized model. Most recently they purchased a 4 1/2-inch (114mm) extruder, installed in August.

"We like the personal relationship with our Davis-Standard sales representative. This has provided excellent access to technical support and all departments of the company," said Holland Shlomo, Plant Manager of Poleg. "The equipment is versatile and reliable, allowing us to process a range of resins including LD, HD, LLD, PP and so on."

Poleg's new extruder is engineered to increase output and improve melt quality. The modular winder/roll changer was

customized to Poleg's specifications and features two cutting mechanisms. These consist of a patented stationary knife on the turret and an adhesiveless knife on the roll changer. Poleg is able to use this versatile winder for three different types of film—embossed, stretch and protective. This is essential because they supply film to a diverse group of customers. The company's protective films are used in applications for roofing, greenhouses, noise reduction and absorption, road signs, new car protection, in stadiums, for sanitary applications and many others.

"We specialize in supplying films for

temporary surface protection," added Shlomo. "Our proprietary technology enables us to produce protective film without adhesives. We're able to complete the process in one step instead of two, making our products innovative and cost-effective while maintaining excellent quality."

Poleg is part of the Poli-Film group GmbH. For more information, visit [www.poli-film.de](http://www.poli-film.de). For more information about Davis-Standard's product offering in the Middle East, contact Adnan Bdour at [bdoura@bc-egan.com](mailto:bdoura@bc-egan.com).

# D-S Partners with Scantech Americas for X-Ray Technology

Collaborating with innovative vendors to supply specific components for complete systems is a priority for Davis-Standard, LLC. One such vendor, Scantech Americas, enabled Davis-Standard to integrate an X-ray transmission scanner for measuring sheet thickness on a proprietary PET system installed this past year. Scantech's gauging system is highly accurate in measuring plastics' thickness, enabling the customer to make a better, flatter, and more reproducible sheet in less time. The scanner on the PET line referenced is used in conjunction with Davis-Standard's EPIC control system, enabling the operator to make adjustments as needed. The result is a superior product with significant savings in terms of start-up time, reduced waste and material costs.

"Davis-Standard has done their share of due diligence in comparing our system to other vendors supplying Gamma and Beta gauges," said Rick Roth, Business Development Manager for Scantech Americas. "They have tested our X-ray technology for almost a year on as many applications as possible, and the results

have been better than expected. It is a pleasure working with a customer who is knowledgeable in so many applications and willing to spend considerable time testing new vendor technology."

In addition to Davis-Standard sheet applications, Scantech has been working with Davis-Standard's Converting Systems Group on cast film, laminated film, stretch film and non-woven applications. Scantech utilizes X-ray transmission to measure sheet or film thickness instead of Gamma Backscatter or Beta Ray technology. The online X-ray transmission is non-nuclear and provides accurate measurement for flat material production processes. Scantech's measurement systems provide gauging for thickness, weight, material composition, edge reading, web width, surface roughness, defect detection, moisture and more.

"As processing technology evolves, we are always looking to partner with companies that integrate forward-thinking solutions that improve customer



Scantech's X-ray transmission scanner is highly accurate for a better, flatter, and more reproducible sheet in less time.

products while saving them money," said Al Chrisbacher, Vice President of Davis-Standard Sheet Systems. "Scantech's technology assimilates well with our systems. We were very pleased with the results on the PET line and look forward to future projects."

Scantech, headquartered in France, has been manufacturing X-ray systems for 18 years. With success in Europe and Asia, the company most recently started manufacturing systems for North and South American customers. Scantech was the first company to introduce low

energy X-ray sensors for film applications, specifically bi-oriented films. The company manufactures a complete range of scanners as well as ergonomic software solutions. The company's automatic profile regulation is one of the fastest and most reliable in the business.

For more information about Scantech, visit [www.scantech.fr](http://www.scantech.fr). For more information about Davis-Standard's sheet systems, contact Al Chrisbacher at [achrisbacher@davis-standard.com](mailto:achrisbacher@davis-standard.com).



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

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