Winding Stability

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Problem

At higher line speeds, small variation in incoming diameter and residual moisture produced traverse instability and uneven package build.

Trials

Winding tension was reduced in small increments while traverse geometry and reel edge formation were observed. The most stable packages were obtained below the upper K-140 speed range.

Result

No single winding condition removed the sensitivity. Improved dimensional regularity upstream remained the preferred corrective direction.

Observation	Effect
high winding tension	edge compression / local flattening
low winding tension	loose package layers
diameter excursions	traverse irregularity
moisture variation	changes in handling response

Archive condition

Recovery note

The original annex containing reel photographs and complete run identifiers was not recovered. This copy contains the surviving narrative and summary table.