K-120 Draw Stability

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Objective

Assess the effect of primary and secondary draw balance on continuity, diameter variation and break frequency.

Summary

Moderate primary draw followed by a smaller secondary correction produced the most stable runs. Aggressive second-stage draw increased local thinning and break frequency.

Interpretation

Draw stability was strongly coupled to incoming ribbon uniformity. The trial supported addition of improved feed and tension control in the later K-140 line.

Trial group	Primary draw	Secondary draw	Result
A	low	low	stable / low orientation
B	moderate	low	best continuity
C	moderate	moderate	acceptable
D	high	moderate	increased breaks

Conclusions

Finding

The K-120 data supported a staged draw approach with conservative second-stage correction. No universal draw ratio was established because ribbon condition remained a dominant variable.