



INSTRUCTIONS FOR ALIGNING GROOVES IN ROLL DIES AND
ADJUSTING FOR SIDE WEAR

AFTER ROLL DIES ARE ASSEMBLED ON ROLL SHAFTS, GROOVES ARE
ALIGNED BY ADJUSTING R 272 AT END OF TOP ROLL SHAFT.

HORIZONTAL ADJUSTMENT

UNLOCK JAM SCREW IN R 272 ADJUSTING SLEEVE. FROM ADJUSTING
SLEEVE SIDE, CLOCKWISE ROTATION OF R 272 MOVES ROLL DIES FROM RIGHT TO LEFT.
COUNTER CLOCKWISE ROTATION MOVES DIES FROM LEFT TO RIGHT. AFTER MAKING
ADJUSTMENT LOCK JAM SCREW IN R 272

ADJUSTMENT FOR WEAR

WHEN SIDE RUNNING CLEARANCE BECOMES EXCESSIVE, BOTTOM ROLL SHAFT
SHOULD BE ADJUSTED FIRST AS FOLLOWS.

REMOVE R 275 END CAP AND TAKE OUT ENOUGH SHIMS TO BRING TOTAL
SIDE CLEARANCE TO $\frac{1}{32}$. R 275 END CAP MUST BE REASSEMBLED TO ITS
ORIGINAL POSITION TO PRESERVE CORRECT TIMING.

UNLOCK JAM SCREW IN R 273 ADJUSTING THRUST COLLAR ON TOP ROLL SHAFT.
ADJUST R 273 TO A POSITION WHICH GIVES A TOTAL SIDE CLEARANCE OF $\frac{1}{32}$.
LOCK JAM SCREW IN R 273

WHEN ORDERING REPLACEMENTS, STATE
SERIAL NUMBER AND SIZE STAMPED ON
NAME PLATE OF MACHINE AND DESIGNATE
PART BY BOTH NAME AND NUMBER

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| R 179 | TOP ROLL SHAFT | R 266 | BEARING BLOCK (R.H.) |
| R 180 | BOTTOM ROLL SHAFT | R 267 | BEARING SHIELD RETAINER |
| R 181 | ROLL HOUSING FLANGED BUSH. (R.H.) | R 268 | BEARING BLOCK HOLDUP STUD (L.H.) |
| R 185 | TOP ROLL SHAFT GEAR | R 269 | ADJUSTING WEDGE (L.H.) |
| R 186 | TOP ROLL ADJUSTING SLEEVE | R 270 | BEARING BLOCK (L.H.) |
| R 187 | TOP ROLL ADJ. SLEEVE EYEBOLT | R 271 | TOP ROLL SHAFT BUSHING (L.H.) |
| R 188 | TOP ROLL ADJ. SLEEVE POPPET | R 272 | TOP ROLL SHAFT THRUST ADJ. SLEEVE |
| R 189 | TOP ROLL ADJ. SLEEVE EYEBOLT PIN | R 273 | TOP ROLL SHAFT ADJ. THRUST COLLAR |
| R 190 | TOP ROLL ADJ. SLEEVE STUD & WASHER | R 274 | BOTTOM ROLL SHAFT BUSHING |
| R 191 | BOTTOM ROLL SHAFT GEAR | R 275 | BOTTOM ROLL SHAFT END CAP & CAM STUD |
| R 192 | BOTTOM ROLL SHAFT SPACER COLLAR | R 276 | SHIMS-R.H. COMPLETE SET |
| R 193 | BOTTOM ROLL SHAFT THRUST RING | R 277 | SHIMS-L.H. COMPLETE SET |
| R 199 | DIE SLEEVE | R 278 | ROLL HOUSING |
| R 200 | DIE SLEEVE RET. PLATE | R 279 | DIE KEY |
| R 264 | BEARING BLOCK HOLDUP STUD (R.H.) | | |
| R 265 | ADJUSTING WEDGE (R.H.) | | |