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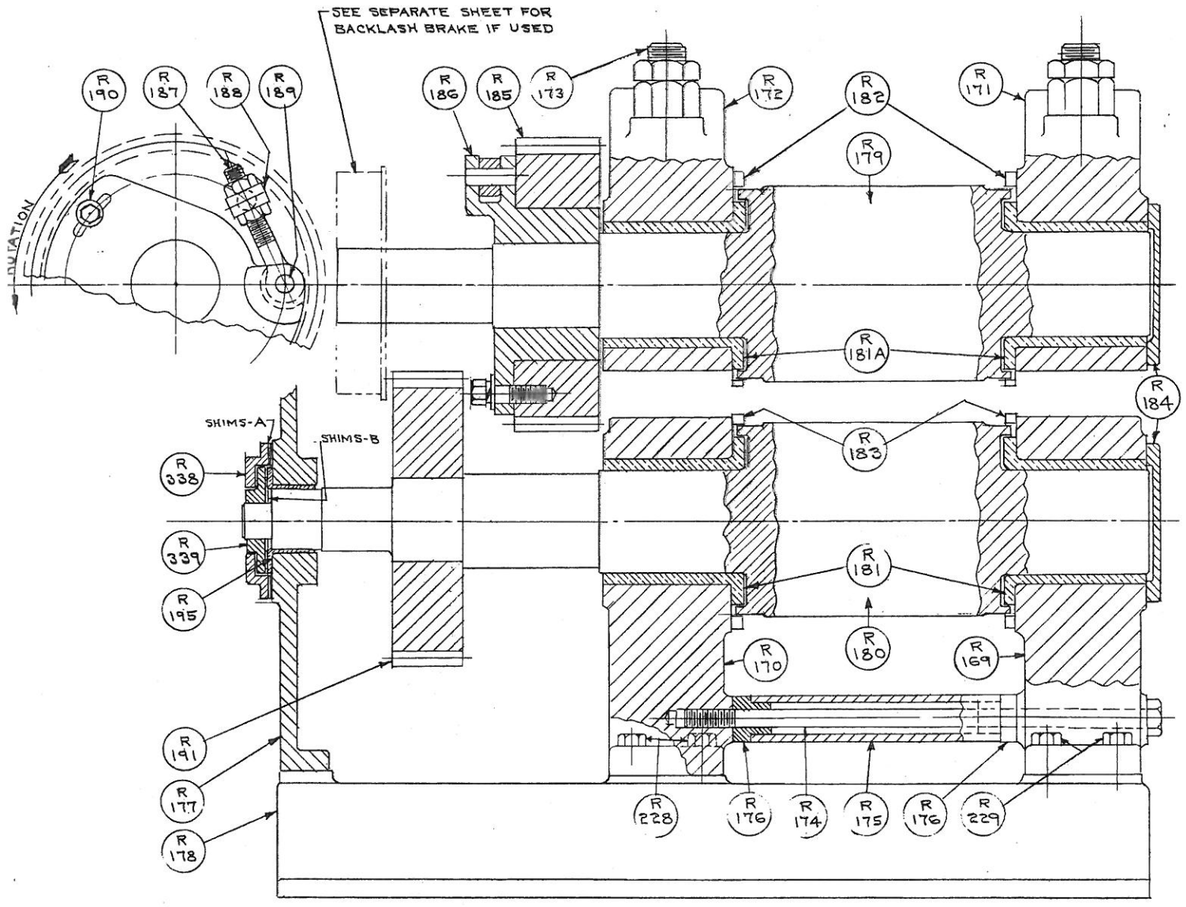
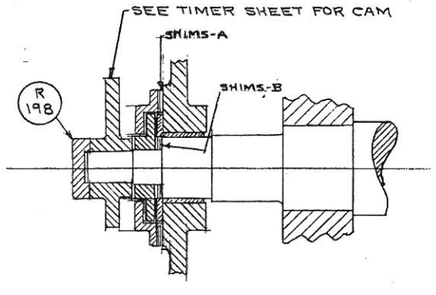
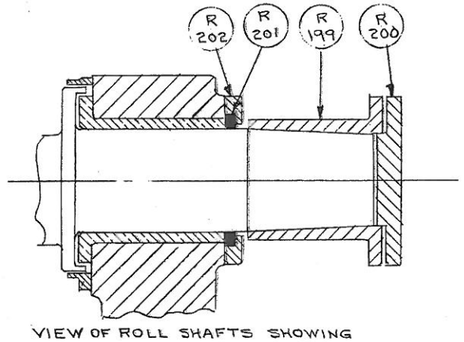
SHEET FR-2-D





VIEW OF BOTTOM ROLL SHAFT SHOWING EXTENSION FOR TIMER CAM FOR CLUTCH OPERATED ROLLS



VIEW OF ROLL SHAFTS SHOWING EXTENSION FOR OVERHUNG DIES

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ADJUSTMENT

TOP SHAFT MAY BE ADJUSTED VERTICALLY WITH NUTS ON STUDS R-173. BE CERTAIN TO TIGHTEN LOCK NUTS AFTER ADJUSTING.

TO TAKE UP WEAR IN FLANGES OF BUSHINGS, LOOSEN CAP SCREWS R-229 AND REMOVE TIE RODS R-174. MACHINE EQUAL AMOUNTS OFF END OF SPACER SLEEVES R-176 TO PROVIDE $\frac{1}{32}$ TOTAL SIDE CLEARANCE AT TOP ROLL SHAFT R-179. WHEN TIE RODS R-174 ARE REASSEMBLED, ROLL HOUSING R-169 WILL BE SHIFTED TO THE LEFT GIVING PROPER CLEARANCE

WHEN ALIGNING ROLL DIE GROOVES, FIRST CHECK LATERAL CLEARANCE AT BOTTOM ROLL SHAFT R-180. REMOVE SHIMS AT (A) TO LIMIT A MAXIMUM OF $\frac{1}{32}$ TOTAL END PLAY. ADD OR REMOVE SHIMS AT (B) TO ALIGN ROLL DIE GROOVES. ADDING SHIMS AT (B) SHIFTS BOTTOM ROLL SHAFT R-180 TO THE RIGHT.

R 169 ROLL HOUSING - R.H.
R 170 ROLL HOUSING - L.H.
R 171 TOP ROLL SHAFT BRG. - R.H.
R 172 TOP ROLL SHAFT BRG. - L.H.
R 173 TOP ROLL SHAFT BRG. STUDS
R 174 ROLL HOUSING TIE RODS
R 175 ROLL HOUSING SPACERS
R 176 ROLL HOUSING SPACER SLEEVES
R 177 GEAR HOUSING
R 178 BASE PLATE
R 179 TOP ROLL SHAFT
R 180 BOTTOM ROLL SHAFT
R 181 BOTT. ROLL SHAFT FLANGED BUSH.
R 181-A TOP ROLL SHAFT FLANGED BUSH.
R 182 TOP ROLL SHAFT BUSH. SHIELD RING
R 183 BOTT. ROLL SHAFT BUSH. SHIELD RING
R 184 ROLL SHAFT END COVER
R 185 TOP ROLL SHAFT GEAR

R 186 TOP ROLL ADJUSTING SLEEVE
R 187 TOP ROLL ADJ. SLEEVE EYE BOLT
R 188 TOP ROLL ADJ. SLEEVE POPPET
R 189 TOP ROLL ADJ. SLEEVE EYE BOLT PIN
R 190 TOP ROLL ADJ. SLEEVE SCREW & WASHER
R 191 BOTT. ROLL SHAFT GEAR
R 195 GEAR HOUSING BUSH.
R 198 BOTT. ROLL SHAFT END CAP
R 199 OVERHUNG DIE SLEEVE
R 200 OVERHUNG DIE SLEEVE RETAINER PLATE
R 201 ROLL SHAFT BEARING SHIELD
R 202 ROLL SHAFT BEARING SHIELD RETAINER
R 228 L.H. HSG. HOLD DOWN SCREWS (STD. CAP SCREW)
R 229 R.H. HSG. HOLD DOWN SCREWS (SPECIAL CAP SCREW)
R 338 BOTT. ROLL SHAFT END THRUST CAP
R 339 BOTT. ROLL SHAFT END THRUST COLLAR

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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