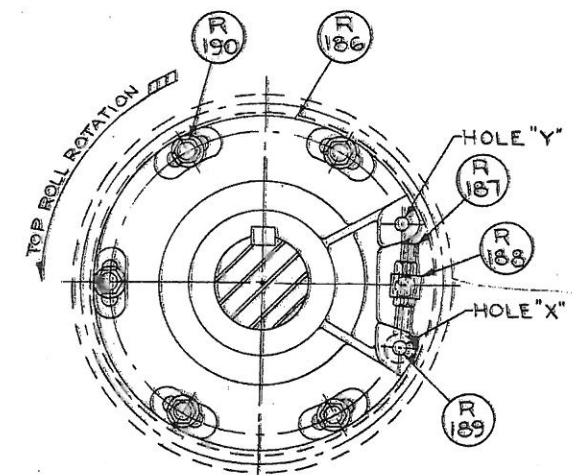


1/64 CLEARANCES

1/64 CLEARANCES

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



SECTION A-A

ASSEMBLY NOTE

ASSEMBLE WITH 1/4" SHIMS (1/8, 1/16, 1/32, (2) 1/64) AT POINTS "A" & "C" TO ESTABLISH 1/64 CLEARANCES. ASSEMBLE WITH 1/4" SHIMS ((2) 1/32) AT POINT "B". AS WEAR OCCURS, REMOVE THE REQUIRED AMOUNT OF SHIMS AT POINTS "A" & "C" TO MAINTAIN THE 1/64 CLEARANCES.

GROOVE ALIGNMENT (TOP ROLL, RIGHT OR LEFT)

ADD A MAXIMUM OF 1/8" OF SHIMS ((4) 1/32) AT POINT "B" TO SHIFT THE ROLL SHAFT TO THE RIGHT. REMOVE A MAXIMUM OF 1/8" OF SHIMS ((4) 1/32) AT POINT "B" TO SHIFT THE ROLL SHAFT TO THE LEFT. AFTER ADJUSTMENT ALWAYS CHECK FOR OUTBOARD BEARING SUPPORT CLEARANCES AT POINTS "D" & "E".

ROLL ROTATION

STANDARD ROLLS ARE FURNISHED WITH THE TOP ROLL SHAFT ROTATING IN THE DIRECTION SHOWN BY THE ARROW. FOR OPPOSITE ROLL ROTATION, SHIFT EYE BOLT R-187 AND EYE BOLT PIN R-189 FROM HOLE "X" TO HOLE "Y" IN SLEEVE R-186.

GROOVE ALIGNMENT (TOP ROLL, ROTATIONAL)

LOOSEN THE FIVE NUTS AT STUDS R-190. ALSO LOOSEN TWO NUTS ON EYEBOLT R-187. ADJUST THE APPROPRIATE NUT ON EYEBOLT R-187 TO ROTATE SLEEVE R-186 AND THE UPPER DIE GROOVES INTO ALIGNMENT. TIGHTEN THE OTHER NUT ON EYEBOLT R-187. TIGHTEN THE FIVE NUTS ON STUDS AND WASHERS R-190.

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| R-179 TOP ROLL SHAFT. | R-335 LOCKING WEDGES (R.H. & L.H.) |
| R-180 BOTTOM ROLL SHAFT. | R-382 DRIVING SPROCKET. |
| R-185 TOP ROLL SHAFT GEAR. | R-390 TOP ROLL SHAFT ADJ. CAP. |
| R-186 TOP ROLL ADJUSTING SLEEVE. | R-394 DRIVE SPROCKET CLAMP WASHER. |
| R-187 TOP ROLL ADJ. SLEEVE EYEBOLT. | R-416 BALANCE CYLINDER. |
| R-188 TOP ROLL ADJ. SLEEVE POPPET. | R-426 TOP ROLL SHAFT ADJ. CAP COVER. |
| R-189 TOP ROLL ADJ. SLEEVE EYEBOLT PIN. | R-427 BOTTOM ROLL SHAFT ADJ. CAP |
| R-190 TOP ROLL ADJ. SLEEVE STUDS & WASHERS. | R-428 THRUST RINGS. |
| R-191 BOTTOM ROLL SHAFT GEAR. | R-429 BEARING BLOCK GUIDE PLATES (L.H.) |
| R-199 DIE SLEEVES. | R-430 ROLL SHAFT BUSHINGS (R.H.) |
| R-264 BEARING BLOCK HOLDUP STUD (R.H.) | R-431 BEARING BLOCK GUIDE PLATES (R.H.) |
| R-265 ADJUSTING WEDGE (R.H.) | R-432 OIL SEALS. |
| R-266 BEARING BLOCK (R.H.) | R-433 OIL SEAL RETAINERS. |
| R-269 ADJUSTING WEDGE (L.H.) | |
| R-270 BEARING BLOCK (L.H.) | |
| R-271 TOP ROLL SHAFT BUSHING (L.H.) | |
| R-274 BOTTOM ROLL SHAFT BUSHING (L.H.) | |
| R-278 GEAR HOUSING. | |
| R-279 DIE KEYS. | |