



VIEW OF ROLL SHAFTS SHOWING
EXTENSION FOR OVERHUNG DIES

ADJUSTMENTS

A VERTICAL (TOP ROLL SHAFT)

TOP ROLL SHAFT, R179, MAY BE ADJUSTED VERTICALLY BY MEANS OF NUTS ON STUDS, R173. BE CERTAIN TO TIGHTEN LOCK NUTS AFTER ADJUSTING.

B ROLL GROOVE ALIGNMENT (ROTATIONAL ~ TOP ROLL SHAFT)

LOOSEN THE NUTS AT STUDS, R190, AND THE TWO NUTS ON EYEBOLT R187. ADJUSTING THE APPROPRIATE NUT ON EYEBOLT, R187, TO ROTATE SLEEVE, R186, AND THE TOP ROLL DIE RADially TO LINE UP WITH BOTTOM ROLL DIE AT PICK UP POINT. TIGHTEN THE OTHER NUT ON EYEBOLT, R187. TIGHTEN THE NUTS ON STUDS, R190.

C ROLL GROOVE ALIGNMENT (LATERAL ~ BOTTOM ROLL SHAFT)

REMOVE THE NUT LOCKS, R454. LOOSEN ONE NUT, R452 OR R453, AND TIGHTEN THE OTHER NUT TO MOVE THE BOTTOM ROLL SHAFT LATERALLY. AFTER BOTTOM ROLL SHAFT IS POSITIONED, ADJUST INNER AND OUTER NUTS, R452 & R453, TO PROVIDE $1/64$ IN CLEARANCE AT "A" AND "B". INSTALL NUT LOCKS, R454.

D ROLL ROTATION (CHANGE DIRECTION)

STANDARD ROLLS ARE FURNISHED WITH THE TOP ROLL SHAFT ROTATING IN THE DIRECTION SHOWN BY THE ARROW. FOR ROTATION IN THE OPPOSITE DIRECTION, SHIFT EYEBOLT, R187, AND EYEBOLT PIN, R189, FROM HOLE "X" TO HOLE "Y" IN SLEEVE, R186.

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 ROD
R 175 ROLL HOUSING SPACER
R 176 ROLL HOUSING SPACER SLEEVE
R 177 GEAR HOUSING
R 178 BASE PLATE
R 179 TOP ROLL SHAFT
R 180 BOTTOM ROLL SHAFT
R 181 ROLL HOUSING FLANGED BUSHING
R 182 TOP ROLL SHAFT BRG. SHIELD RING
R 183 BOTTOM ROLL SHAFT BRG. SHIELD RING
R 184 ROLL SHAFT END COVER
R 185 TOP ROLL SHAFT GEAR
R 186 TOP ROLL ADJUSTING SLEEVE
R 187 TOP ROLL ADJUSTING SLEEVE EYE BOLT
R 188 TOP ROLL ADJUSTING SLEEVE POPPET
R 189 TOP ROLL ADJUSTING SLEEVE EYE BOLT PIN
R 190 TOP ROLL ADJUSTING SLEEVE STUD & WASHER

R-191 BOTTOM ROLL SHAFT GEAR
R-193 BOTTOM ROLL SHAFT THRUST COLLAR
R-195 GEAR HOUSING BUSHING
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-382 TIMING SPROCKET
R-394 DRIVING SPROCKET CLAMP WASHER
R-452 NUT (OUTER)
R-453 NUT (INNER)
R-454 NUT LOCK

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