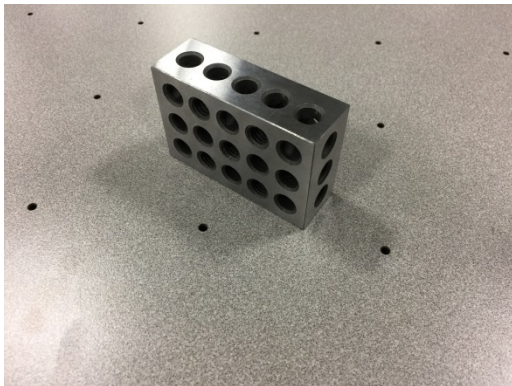


# PRESS ROLLER VERIFICATION

For the press to properly compress the IG unit it should be verified monthly that the pinch rollers are parallel to each other within .005

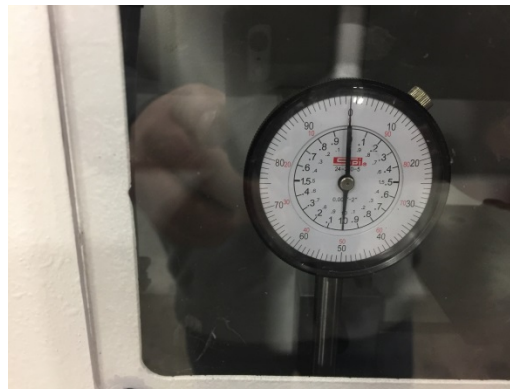
To perform this check you must have a block or bar of a known size



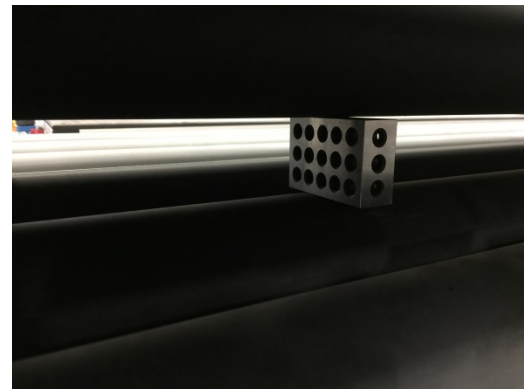
1. Using the hand wheel adjust the rollers together so that they contact each other (no gap should be viable on either end of roller)
2. Verify the reading on the indicator (both sides)
3. The readings side to side should be within .005



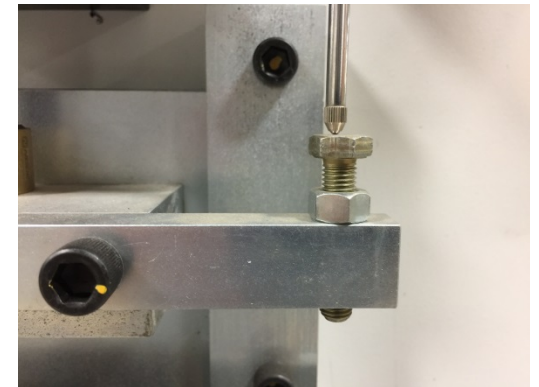
1. Using the hand wheel adjust the rollers to a size which you have identified from your block dimension (1.000 shown)
2. Insert your block between the pinch rollers on each side of the press
3. There should be a light friction fit between the rollers on each side
4. The indicator readings side to side should be within .005



1. Using the hand wheel adjust the rollers to another size which you have identified from your block dimension (2.000 shown)
2. Insert your block between the pinch rollers on each side of the press
3. There should be a light friction fit between the rollers on each side
4. The indicator readings side to side should be within .005



If the front and back indicators do not read the same and you have verified parallel of the rollers with your gage blocks, adjust the jamb bolt on which ever side is off to correct readings





If the front and back indicators are reading within .005 and there is a gap between your gage block and the roller on one side you can adjust that side by loosening the slave shaft coupler and adjusting each side independently from the other to correct gapping issue.

