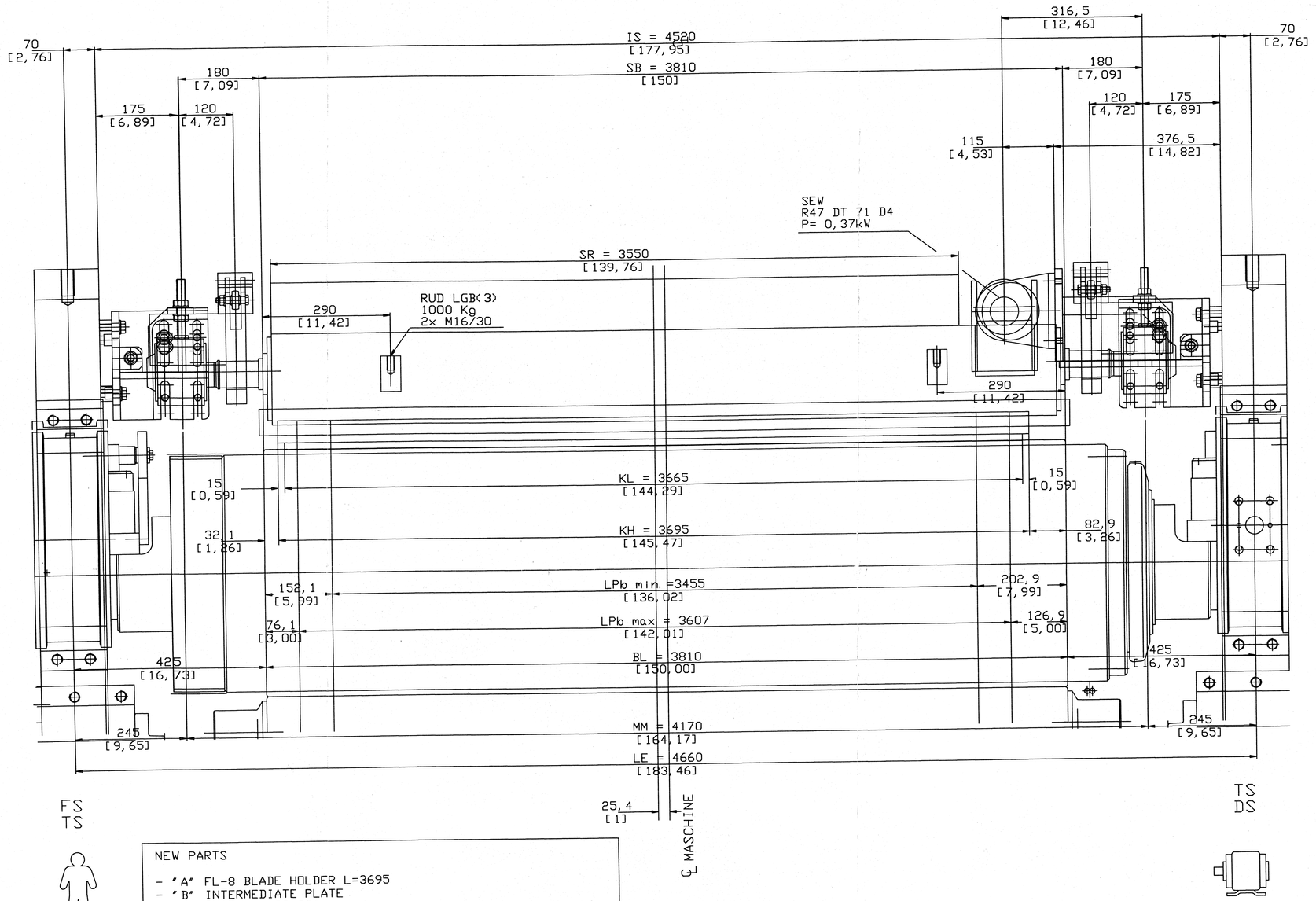
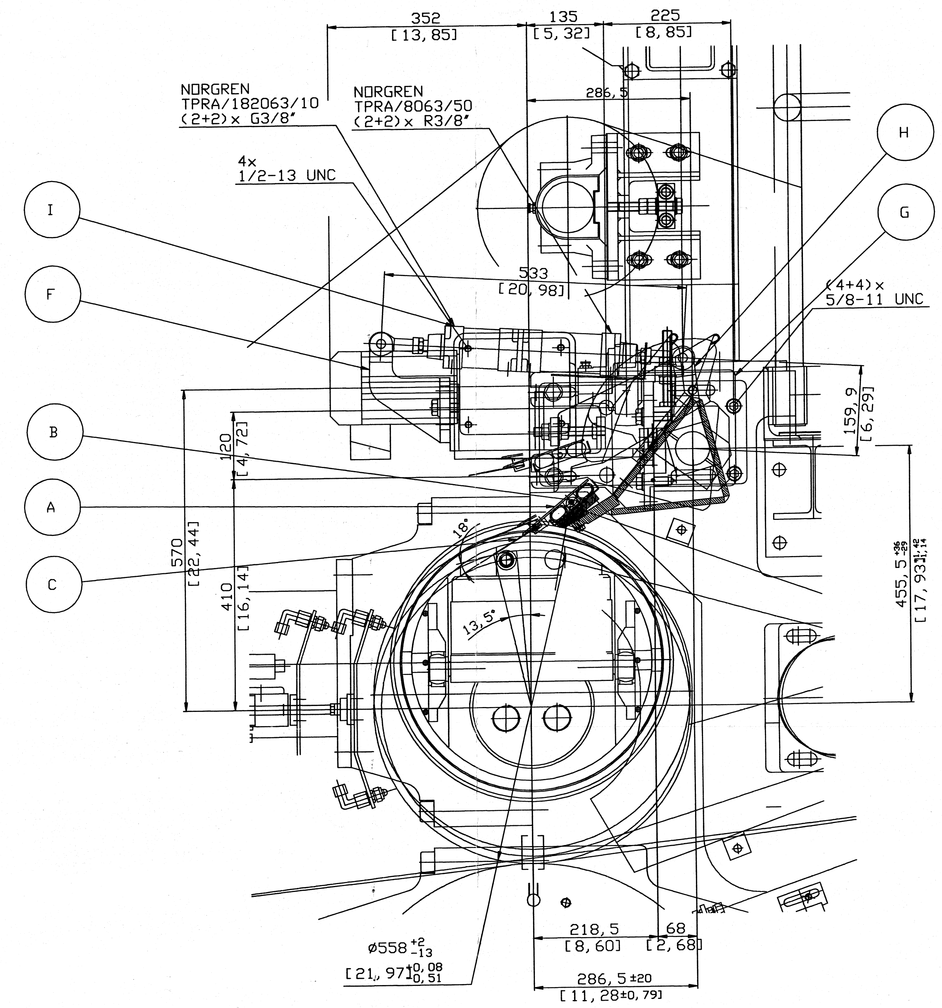
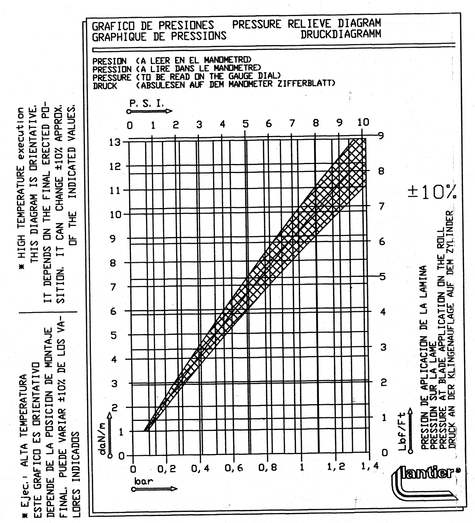
47724-C



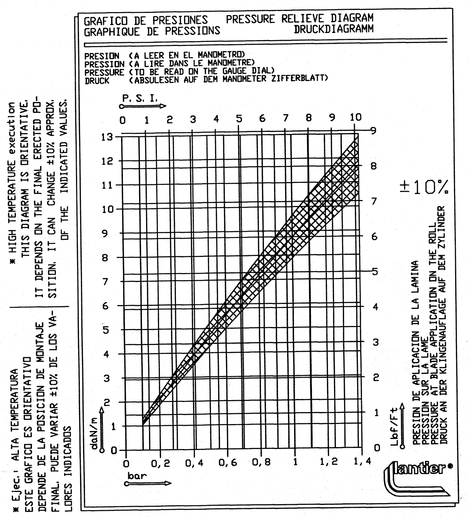


NEW PARTS

- "A" FL-8 BLADE HOLDER L=3695
- "B" INTERMEDIATE PLATE
- "C" BLADE 1x100x3665 mm
- "F" TENDER SIDE AND DRIVE SIDE CYLINDER SUPPORTS + PINS
- "G" TENDER SIDE AND DRIVE SIDE BRACKETS
- "H" TENDER SIDE AND DRIVE SIDE LEVERS + PINS
- "I" TENDER SIDE AND DRIVE SIDE PNEUMATIC CYLINDERS + UNION FLANGE + PIVOTING HEAD (NORGREN TPRA/182063/10)



100 mm WIDTH BLADE
LOAD DIAGRAM



100 mm WIDTH BLADE
LOAD DIAGRAM
ANGLE BETWEEN UPPER PLATE AND BASE 8,7°
(LIFTING POSITION)

BLADE ADJUSTMENT WITH NIP OPEN

IN THE PRESENT DRAWING THERE IS A TABLE WHERE IT IS INDICATED THE CORRECT ANGLE ACCORDING TO EACH S-ROLL DIAMETER.

AS SOON AS THE S-ROLL DIAMETER REACHES THE FOLLOWING RANGE, NEW ANGLE STENCIL SHOULD BE USED FOR THE NEW BLADE ADJUSTMENT.

FOR EXAMPLE, ONCE THE DOCTOR IS ADJUSTED DURING ERECTION, AFTER SOME PERIOD THE DIAMETER OF THE ROLL WILL BE MODIFIED (GRINDING), FOR EXAMPLE TO 557 mm, AT THAT POINT THE BLADE SHOULD BE ADJUSTED AGAIN USING THE ANGLE STENCIL OF 13°.

EINSTELLEN DER KLINGE BEI GEÖFFNETEM NIP

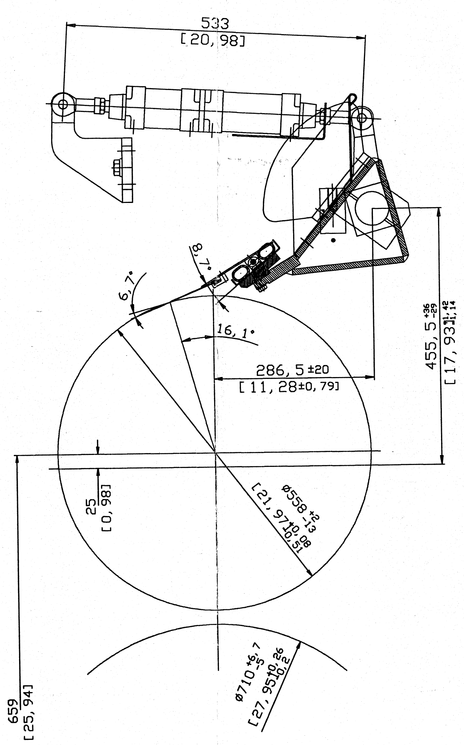
AUF DER SCHABERZEICHNUNG IST EINE TABELLE DARGESTELLT, AUF DER ZU ERKENNEN IST, BEI WELCHEM S-WALZENDURCHMESSER WELCHER WINKEL EINZUSTELLEN IST.

SOBALD DIE S-WALZE VOM DURCHMESSER HER DEN NÄCHST KLEINEREN BEREICH ERREICHT HAT, IST MIT DER NÄCHSTEN SCHABLONE DER KLINGENANLAGEWINKEL MITTELS VERSTELLUNG DES SCHABERBALKENS EINZUSTELLEN.

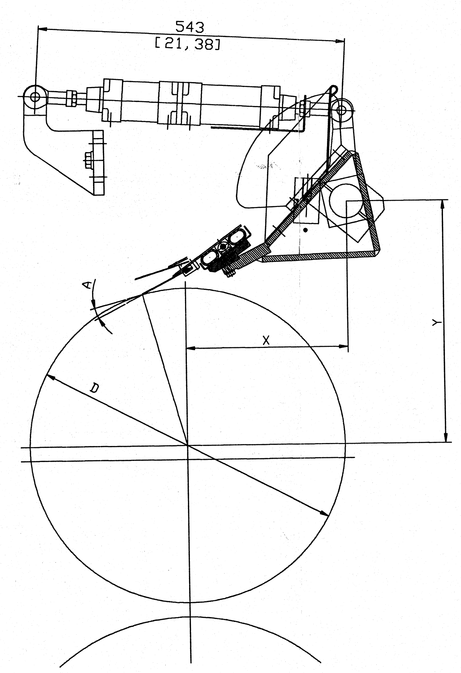
DAS HEISST Z. B. WENN NACH DER EINSTELLUNG BEIM UMBAU DIE WALZE DEN NÄCHSTEN DURCHMESSERBEREICH 557MM ERREICHT, IST DER SCHABERBALKEN SO ZU VERSTELLEN, DASS DER KLINGENANLAGEWINKEL NACH DEM EINSTELLEN 13° HAT.

S-ROLL DIAMETER D=	ASSEMBLY POSITION BLADE ANGLE A=	WORKING POSITION BLADE ANGLE	HORIZONTAL DISTANCE BETWEEN DOCTOR BEARING AND ROLL CENERLINE X=	VERTICAL DISTANCE BETWEEN DOCTOR BEARING AND ROLL CENERLINE (NIP OPEN) Y=	DETAIL DRAWING NUMBER
560-558 [22,05-21,97]	14,5°	18°+/-3°	297,5 [11,71]	434,5 [17,11]	16109-009-D
557-555 [21,93-21,85]	12,5°	18°+/-3°	288,6 [11,36]	430 [16,93]	16109-009-C
554-551 [21,81-21,69]	10,5°	18°+/-3°	279,9 [11,02]	425,3 [16,75]	16109-009-B
550-548 [21,65-21,57]	8,9°	18°+/-3°	273,2 [10,76]	421 [16,58]	16109-009-A

LIFTING POSITION
EXTRA CYLINDER BROUGHT IN
EXISTING CYLINDER BROUGHT IN
NIP OPEN



ASSEMBLY POSITION
EXTRA CYLINDER DRIVEN OUT
EXISTING CYLINDER BROUGHT IN
NIP OPEN



FS : FUEHRERSEITE TS : TRIEBSEITE
TS : TENDING SIDE DS : DRIVE SIDE

LE : LAGERMITTENENTFERNUNG
CENTER BEARING DISTANCE

IS : INNENABSTAND DER STAENDER
DISTANCE BETWEEN DOCTOR'S SEATING FACES

BL : BALLENLAENGE / FACE WIDTH

KL : KLINGE / BLADE

KH : KLINGENHALTER / BLADE HOLDER

SB : SCHABERBALKEN / DOCTOR BEAM

MM : SCHABERMITTENENTFERNUNG
DISTANCE BETWEEN DOCTOR BEARING CENTRES

SR : STAUBFANGRINNE / GUTTER

KUESTERS
Auftrags Nr. 240-81378

1x			
POSITION / POSITION	CANTIDAD / QUANTITY	EQUIPO / EQUIPMENT	EJECUCION / EXECUTION	MATERIAL / MATERIAL	NUMERO Nº / C. INV.
3/3/01	FECHA / DATE	NOMBRE / NAME	CLIENTE / CUSTOMER	KUESTERS / E. B. EDDY Kanada
Diseñado	15 11 03	M. ELCUAZ	PROYECTO / PROJECT	2x3-Walzen Kalander; Walze Nr. 6
Revisado	2 02 04	M. ELCUAZ	DENOMINACION / DESCRIPTION	SCHABER / CR. 55 FL-8 / DOCTOR
Aprobado	12 02 04	STIGO. U.	PESO ACABADO / FINISHED WEIGHT (Kg.)	ESCALAS / SCALES (D-S/M-D)	Nº	PLANO NUM. / DRAWING NUMBER	Rev.
			ca. 520	1/5 1/10	C A D	16109-006 1-2 Rev.

DIN AO 1189x841mm

lantier

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#10 PM No. 2 S. N. C. TOP ROLL DOCTOR CONVERSION | 47724-C