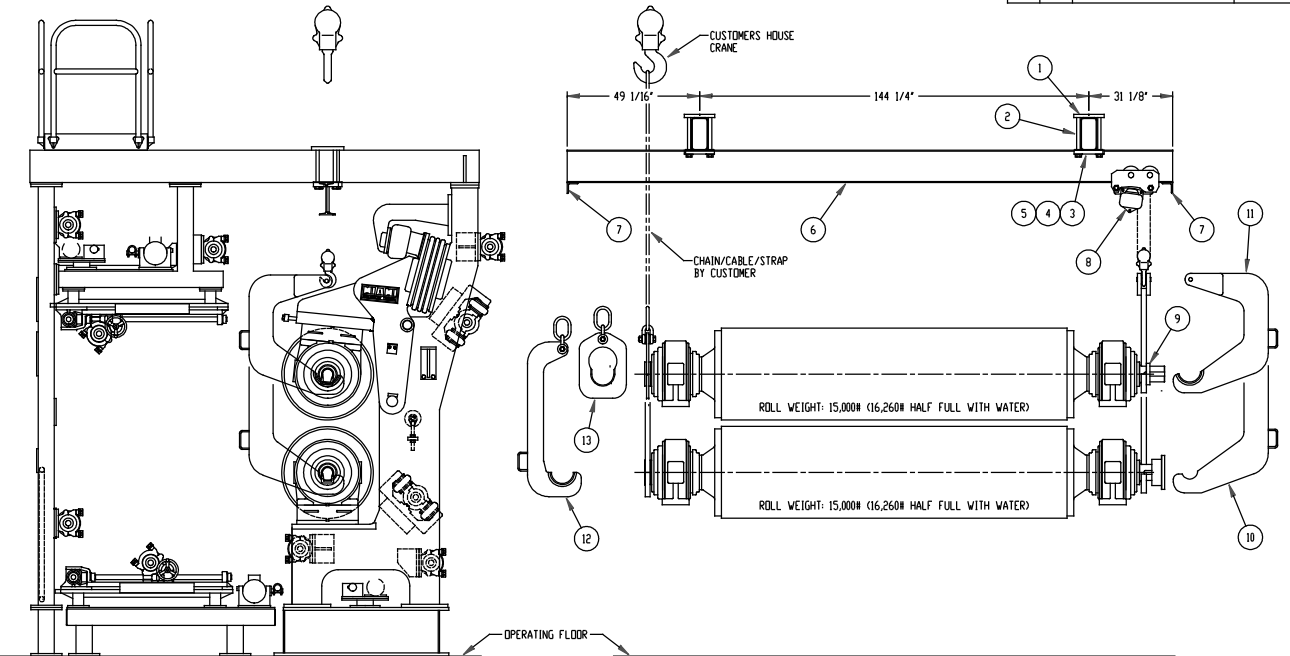
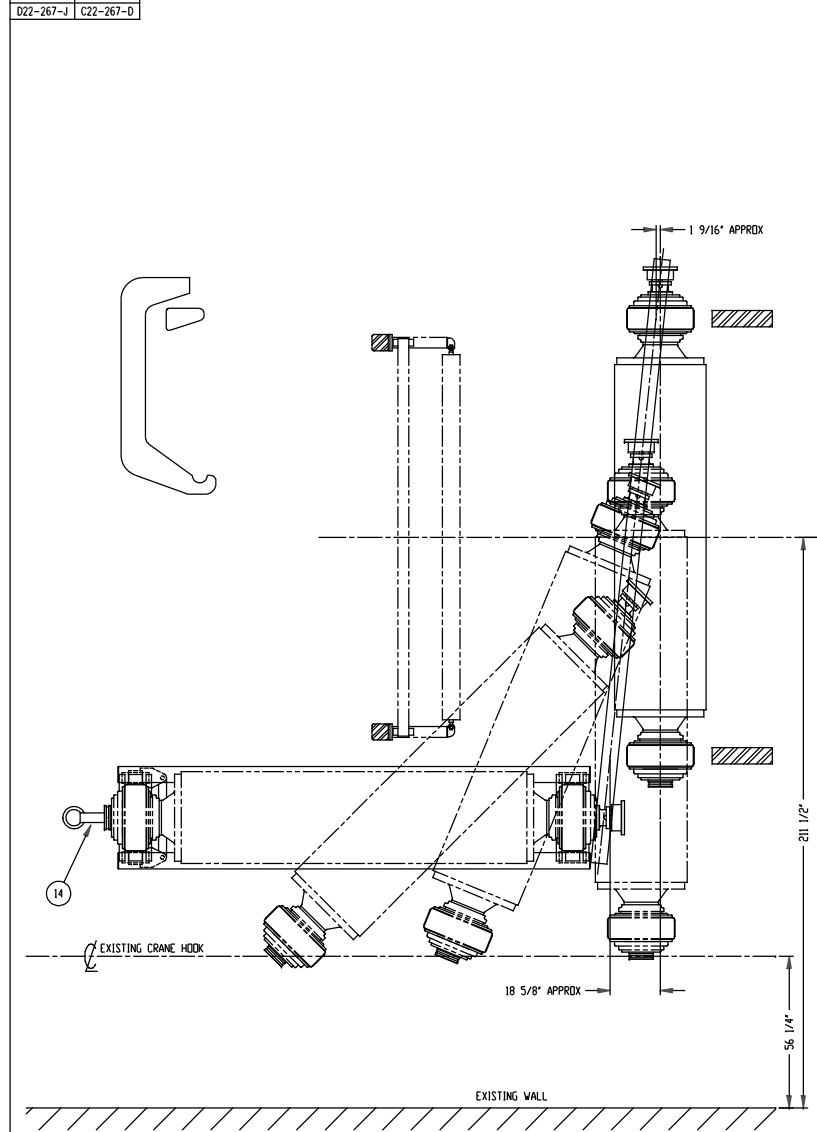
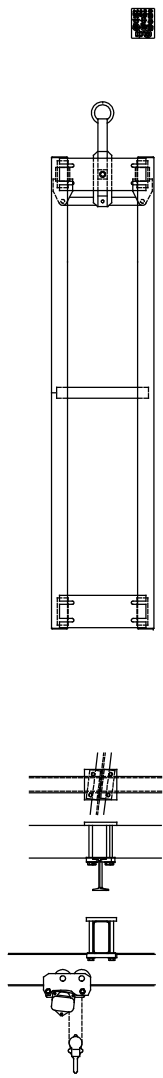


DWG. NO. D22-267-N
 ASSY. DWG. REF. DWG.
 D22-267-J C22-267-D



ROLL REMOVAL PROCEDURE

1. LOCK-OUT PRESS DRIVE.
2. LIFT TOP ROLL VIA AIR BAGS AND INSERT FRONT & REAR LOCK-UP PINS.
3. TURN OFF PRESS LOADING AIR SUPPLY WITH SAFETY LOCK-OUT VALVE AND PLACE NECESSARY LOCKS ON LOCK-OUT VALVE.
4. TOP ROLL - POSITION ROLL FOR 3/4\"/>
- 5. BOTTOM ROLL - UNCOUPLE DRIVE.
- 6. REMOVE FRONT SIDE FOOTWALK. (CAN BE STORED ON TOP BEAMS AS SHOWN)
- 7. REMOVE FRONT SIDE FOOTWALK MOUNTING BRACKET. (WET END)
- 8. REMOVE SAFETY RAIL.
- 9. REMOVE LEAD-IN PAPER ROLL AND FRONT SIDE MOUNTING BRACKET.
- 10. REMOVE FRONT & REAR NIP GUARDS.
- 11. REMOVE TOP & BOTTOM ROLL COOLING WATER PIPING.
- 12. REMOVE FELTS.
- 13. MOVE TOP FELT STRETCH ROLL TO THE EXTREME STRETCH POSITION.
- 14. TOP ROLL - SUPPORT REAR WITH TROLLEY HOIST (PART 8) AND TOP REAR LIFTING HOOK (PART 11).
 SUPPORT FRONT WITH HOUSE CRANE AND TOP FRONT LIFTING HOOK (PART 13).
NOTE: SECURE BEARING HOUSINGS TO STOP THEM FROM ROTATING. HOUSINGS ARE TOP HEAVY.
- 15. BOTTOM ROLL - SUPPORT REAR WITH TROLLEY HOIST (PART 8) AND BOTTOM REAR LIFTING HOOK (PART 11).
 SUPPORT FRONT WITH HOUSE CRANE AND BOTTOM FRONT LIFTING HOOK (PART 12).
- 16. REMOVE BEARING HOUSING MOUNTING BOLTS.
- 17. REMOVE FRONT SIDE PULL BLOCK.
- 18. MOVE ROLL INTO TENDING ISLE AS FAR AS THE HOUSE CRANE WILL ALLOW.
- 19. TRAVERSE HOUSE CRANE TOWARD WET END AND ROLL WILL MOVE FARTHER INTO TENDING ISLE.
- 20. POSITION ROLL CART UNDER ROLL AND SET ROLL ON CART.

QTY. 1 REQ'D. FOR F.O. #26183

PART	DWG. NO.	DESCRIPTION	QTY.
14	D22-267-C	ASSY OF ROLL CART	001 01
13	C21-001-11	LIFTING HOOK-TOP FRONT	001 01
12	C21-001-10	LIFTING HOOK-BOTTOM FRONT	001 01
11	C21-001-9	LIFTING HOOK-TOP REAR	001 01
10	C21-001-8	LIFTING HOOK-BOTTOM REAR	001 01
9	A21-001-8	LIFTING HOOK RETAINING RING	001 01
8	INGERSOLL-RAND LOW HEADROOM ARMY STYLE GEARED TYPE TROLLEY HOIST #THV50G10-8A		001 01
7	A22-206-44	ROLLOUT RAIL HOIST STOP	001 01
6	B22-267-32	ROLLOUT BEAM	001 01
5	A22-212-53	BEAM CLIP SHIMS	001 08
4	B22-212-48	ROLLOUT RAIL BEAM CLIP	001 01
3	A22-212-47	ROLLOUT RAIL SAFETY CLIP	001 01
2	A10-002-8	MOUNTING STUDS	001 01
1	A22-267-66	ROLLOUT RAIL MTG. PLATE	001 01

NO.	DATE	DESCRIPTION	BY	DATE	DWG. NO.

MIAMI MACHINE CORP.
 OVERPECK, OHIO 43055
 TITLE
**ASSY. of ROLL
 REMOVAL SYSTEM**
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MIAMI MACHINE CORP. 100 S. 10TH AVE. SUITE 100, CLEVELAND, OHIO 44115
 CHK. BY: SCALE: 1/2"=12" BY: DATE: 10/4/99 Dwg. NO. D22-267-N