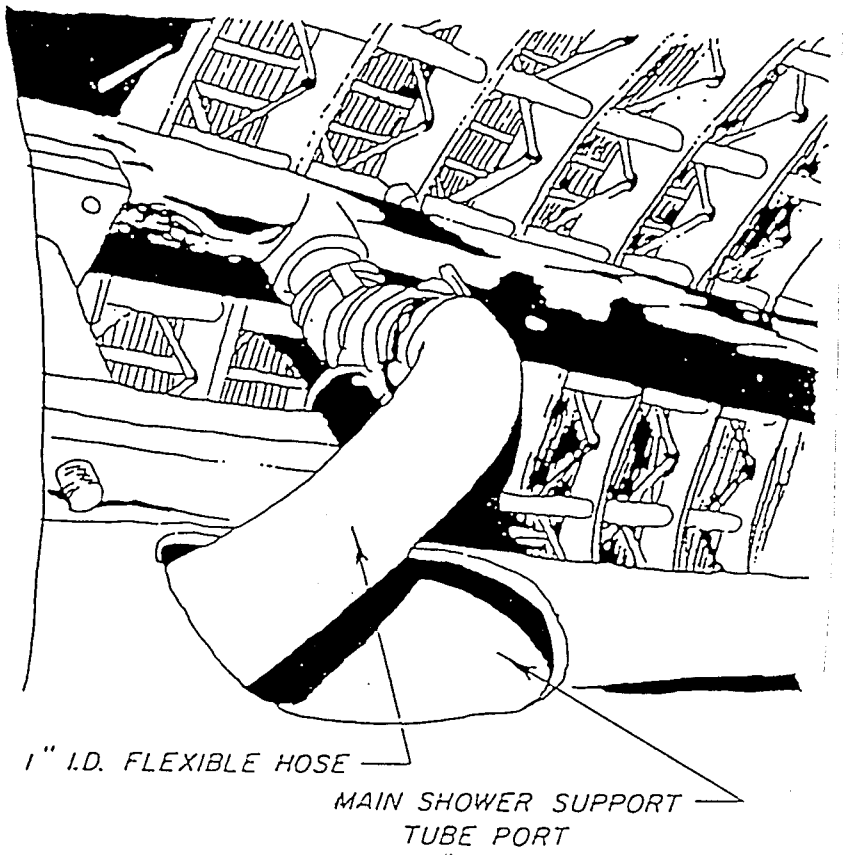
'C' ROLL

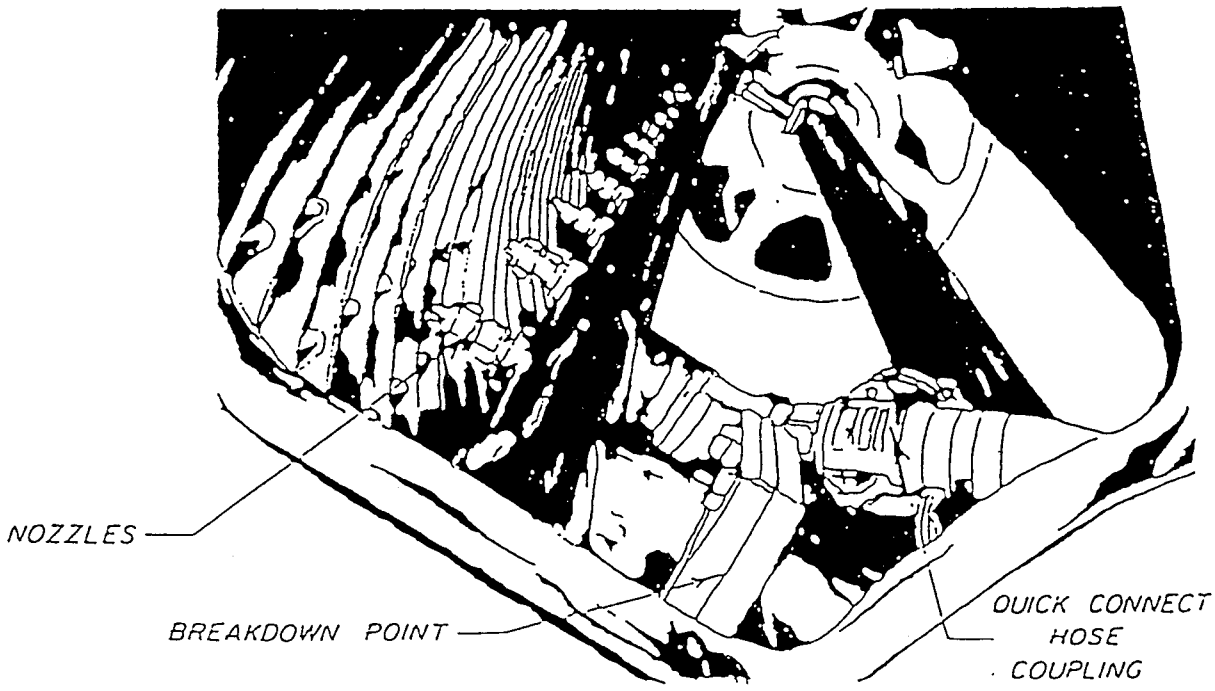
INTERNAL SHOWER



For cleaning purposes, the 'C' roll is equipped internally with a stationary fan-spray showering system having a pressure rating of 17.58 kg/cm^2 (250 PSI).

The water supply is provided by a 1" I.D. flexible hose which travels through the front side by way of the main shower support tube port and is fitted with 1" NPT quick connect hose and couplings on each end. This assembly of hose and couplings must have a rating of at least 17.58 kg/cm^2 (250 PSI).

The shower feed pipe and support assembly is of a breakdown design to facilitate removal and servicing of the fan-spray nozzles.

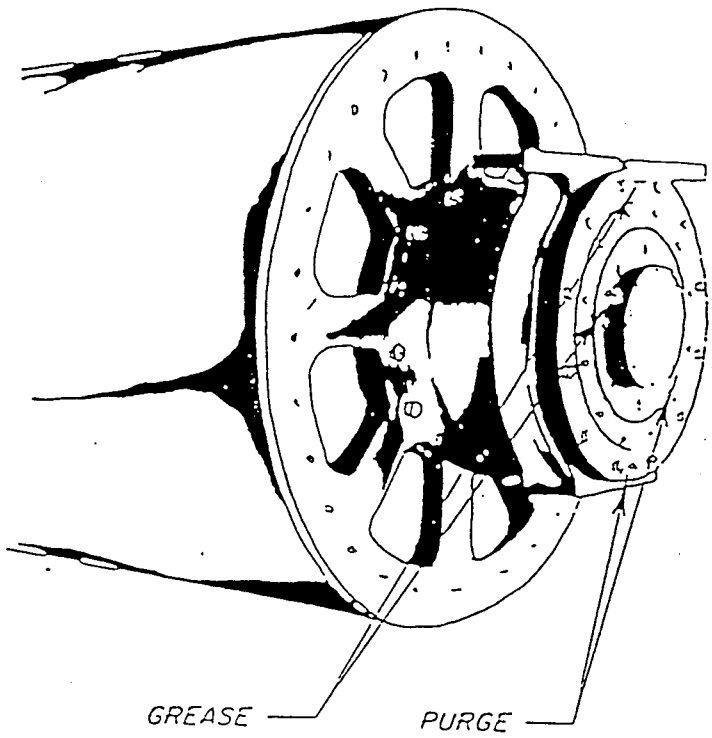


'C' ROLL

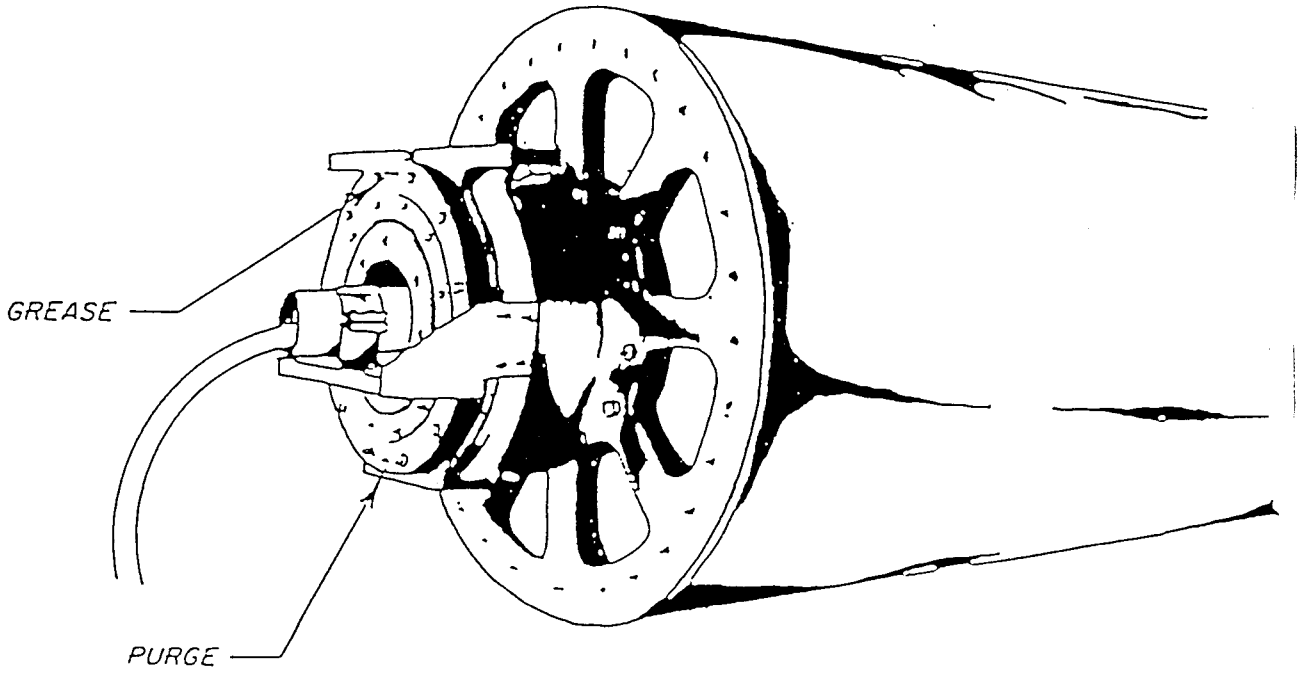
LUBRICATING

The 'C' roll is comprised of three bearings that have to be maintained. One external bearing is located at the tending side of the roll and one external bearing, along with one internal pilot bearing is on the drive end of the roll. The fittings for the internal pilot bearing rotate with the roll, thus special arrangements must be made to lubricate the bearing when the roll is stationary. Weekly lubrication using Mobil AW-2 or an equivalent, is recommended.

DRIVE SIDE



TENDING SIDE



'C' ROLL

FACE WIRE INSTALLATION
(Read instructions completely before proceeding)

If possible, the face wire should be installed by a qualified seamer. This service can be done in the mill, or if a spare roll is on hand, it can be shipped to a qualified service facility. If the situation dictates otherwise, a cantilever stand set-up, with tensioning rings and a pre-seamed sleeve, is required. The cantilever stand and tensioning ring set-up are depicted in Illustrations I and II.

The 'C' roll must first have a sturdy rear stand along with a cantilever stand designed for the weight and length of the roll. This arrangement allows the installation to be completed on bearings; avoiding any disassembly and minimizing any chance of damage to the roll.

Before proceeding with installing the sleeve, the old face wire must be removed by unsoldering the ends with a large soldering iron and splitting the old wire to remove it. The heads should then be prepared by removing the old solder that is left over and filling the heads with a coarse file to clean and create a rough surface for better bonding. The heads should then be tinned to better prepare the surface for soldering.

This preparation should be done before setting up on the cantilever stand to avoid any possible damage to the sleeve.

The first step is to install alignment rings to the heads. One tensioning ring is placed over the back stand, inboard side facing upwards, and the remaining tensioning ring is placed over the cantilever stand, properly oriented to facilitate tensioning. The pre-seamed sleeve must now be slipped over the cantilever stand, being careful not to crease or bend the wire. Any crease or bend in the sleeve may prove to be difficult or even impossible to remove entirely, ultimately affecting the final roll tolerance. Note that the sleeve is rapped on three (3) poles that should be utilized in stringing the sleeve on the stand. The roll can be bolted to the stands once complete preparations are made to the roll.

'C' ROLL

FACE WIRE INSTALLATION (Cont'd...)

Once the preparation is completed and the tensioning rings are in place, the sleeve can be slid over the roll and clamped between the tapered rings as in Illustration II. The wire can now be tensioned by alternately tightening the jack screws to a tension of 80 to 100 inch-lbs. Again alternating screws.

NOTE:
DO NOT CHASE THE READING ON THE TORQUE WRENCH ONCE ALL JACK SCREWS ACHIEVE 140 INCH-LBS. THE SCREWS ONLY NEED TO BE EVENED OUT BY FEEL. CONTINUING UNTIL ALL SCREWS CANNOT BE MOVED AT 140 INCH-LBS. WILL OVER-TENSION THE WIRE.

The wire is now tensioned and ready to be fixed to the ends. Cover the face wire with paper and mask the ends so 3/4" of head is all that is exposed. Solder the end down by first fluxing a section of the head and face wire with stainless steel soldering flux, then applying a high grade solder to the ends suitable for stainless to stainless bonding. Only flux an area long enough to be done within a five to ten minute time frame. This will prevent oxidation and promote a better bond. Continue soldering until one end is done and proceed to solder the other end.

NOTE:
ALL SOLDERING IS DONE WITH IRONS OR SOLDERING COPPERS - NOT WITH A TORCH!!!

'C' ROLL

FACE WIRE INSTALLATION (Cont'd...)

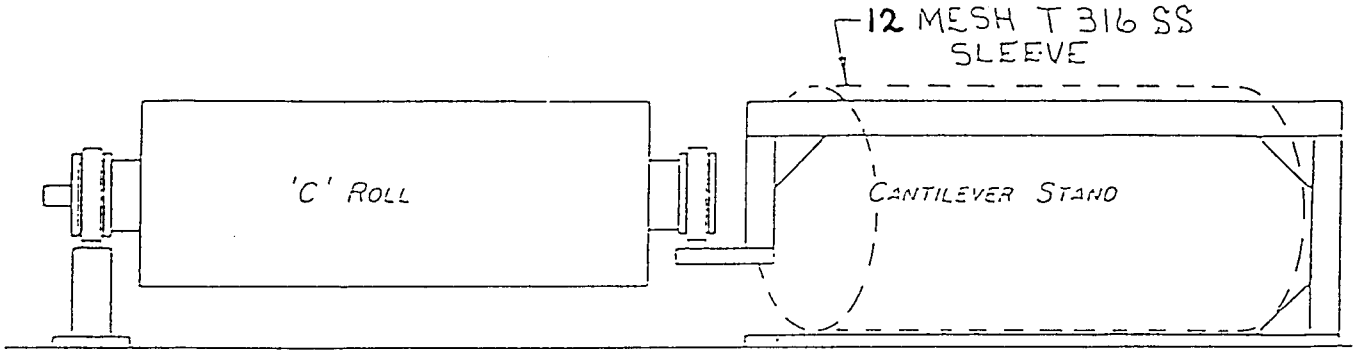


ILLUSTRATION I

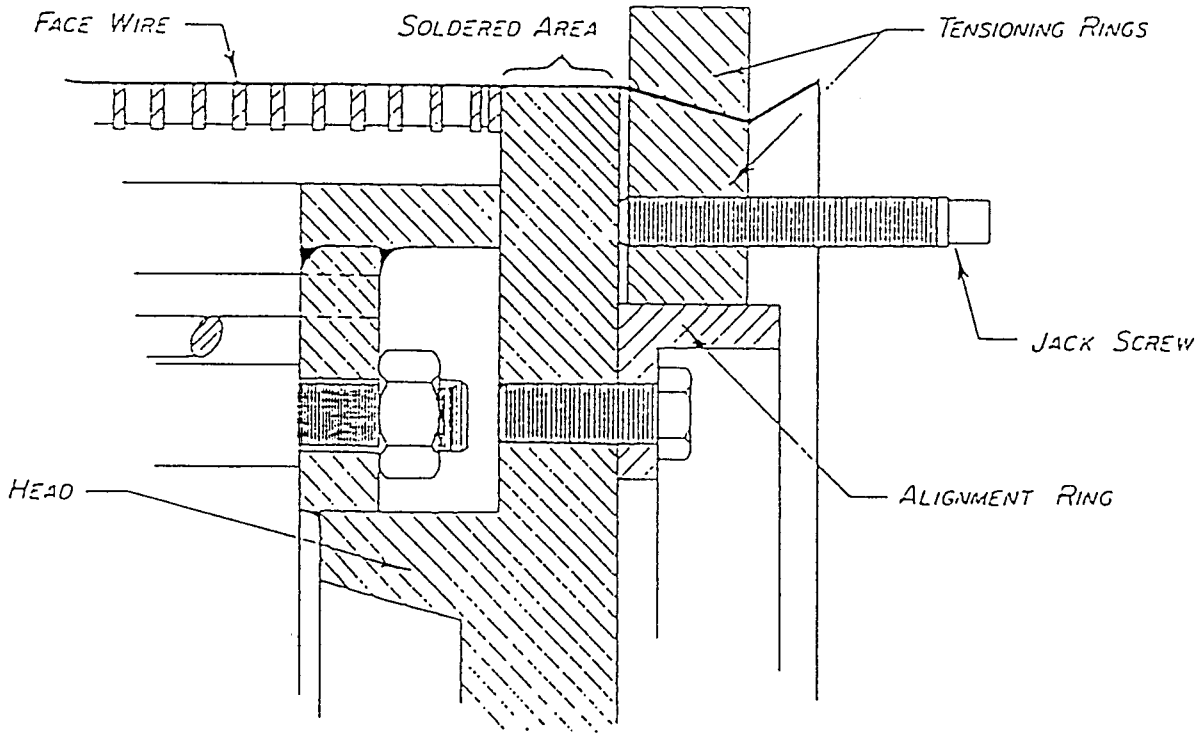


ILLUSTRATION II

'C' ROLL

FACE WIRE INSTALLATION (Cont'd...)

Once both ends have been soldered, cut the extra wire off by chiseling along the edge. (Illustration III). Be careful not to cut into the head. As you are chiseling the wires off, check for any "cold spots" that may have to be re-soldered. The area to be re-soldered would be noticeable by a crack along the cut off area. That area should be re-soldered before proceeding further. Once both ends are soldered and the excess material is removed, file any excess solder and smooth up the surface using a fine file. Remove the protective paper and thoroughly wash the ends to remove any remnant soldering flux. If the flux is not removed, the solder and wire will corrode. Remove the tension rings and alignment rings being careful not to hit the roll. Any excess solder or wire trimmings left in the bearing seals or loose in the roll could cause damage and must be removed. The tension rings should be cleaned and the jack screws oiled for future use. They have been in contact with a corrosion element and without proper care, future use may be compromised. The roll should now be ready to put back in service.

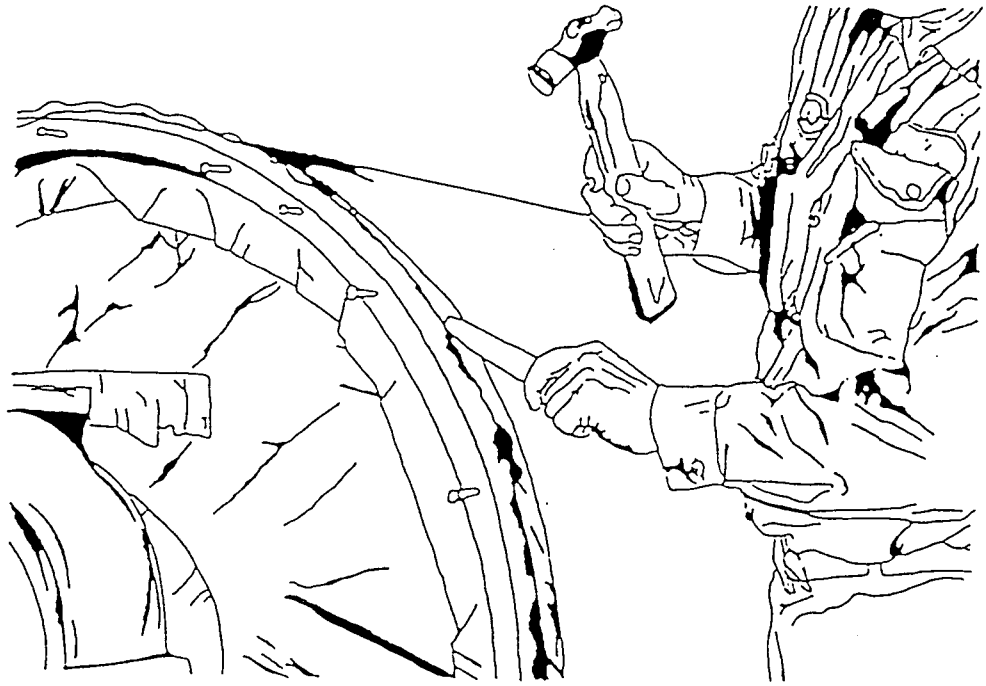


ILLUSTRATION III

S. O. 1117

EXTERNAL 'C' ROLL CLEANING SHOWER

The Top Flyte 'C' Former is equipped with a high pressure oscillating shower to clean the 'C' Roll. It is located between the wire blades on the main saveall.

The shower is a pipe in pipe design to allow for oscillation, removal for cleaning and for easier nozzle changing.

'C' ROLL GENERAL INFORMATION

ASSEMBLY	:	DRAWING NO. D7021441
ROLL SPECIFICATION	:	42" DIAMETER X 180" FACE
BEARING CENTERS	:	200"
BEARING DESIGN	:	SKF SPHERICAL ROLLER BEARINGS
MATERIAL OF CONSTRUCTION	:	T-316 STAINLESS STEEL
SHOWERING	:	STATIONARY FAN SPRAY FRESH WATER 34.2 GPM & 150 PSI
ROLL FACE WIRE	:	12" X 12" MESH T 316 STAINLESS STEEL .021" WIRE DIAMETER 45 DEG. SPIRAL SEAMED 42" DIAMETER X 180" LONG