

ADJUSTMENT OF THE CONTROL ROLLER PRESSURE

See Diagram on page 18.

- 11.0 Lock the scale plate (6) with the tension lever (4).
- 11.1 Loosen the hexagonal socket screw (1).
- 11.2 Loosen the tension lever (4) and the screw (3).
- 11.3 Place the tension lever (4) and tension piece (5) aside.
- 11.4 Remove scale plate (6) and washer (2).
- 11.5 Loosen all four hexagonal socket screws (7) and remove the head plate (8).
- 11.6 Loosen the locking screw (10) in the counter nut (9) and unscrew with spanner wrench.
- 11.7 Loosen the locking screw (12) in the lower counter nut (13).
- 11.8 With the spanner wrench, turn the counter nut (13) slightly to the right on the control roll shaft (19) - the pressure between the control roll and the workpiece spindle should be increasing.

Important: If the counter nut (13) is turned too far to the right, the pressure will start to decrease. In that case turn counter nut (13) to the left. Now begin turning to the right again to find the highest pressure setting.
- 11.9 To test the pressure, the slots (11) of the control roller shaft must be parallel to the workpiece spindle.
- 11.10 If the pressure is satisfactory, begin assembly.
- 11.11 Tighten the locking screw (12) in the counter nut (13) so that counter nut (13) cannot move.
- 11.12 Turn the top counter nut (9) by hand onto the lower counter nut (13). Then back off the counter nut (9) one half turn. In this position tighten the counter nut (9) with the locking screw (10).
- 11.13 Screw the head plate (8) on using the four socket screws (7).

- 11.14 Mount the scale plate (6) using the washer (2) and tighten lightly with the screw (1).
- 11.15 Mount the tension piece (5) with tension lever (4) and secure with the screw (3).
- 11.16 Resetting the scale plate (6):
Tighten the stopper (15) on the workpiece spindle with the tension lever (14) at the permanent stop (20).
- 11.17 Turn the the scale ring (6) until the stopper (15) can be turned radially on the permanent stop (20) without seeing a light gap.
- 11.18 Loosen the socket screw (1) and turn the scale ring to the 90 degree position.
- 11.19 Maintain the scale ring (6) position with the tension piece (5) and tightly lock the socket screw (1).
- 11.20 The fine adjustment of the scale plate (6) is done by adjusting the vernier (17).
- 11.21 Loosen the two screws (18) and adjust the vernier (17). Make sure the vernier is not touching the scale ring (6).

DIAGRAM FOR CONTROL ROLLER AND SCALE ADJUSTMENT

