

SERVICE INSTRUCTIONS

PAPER MACHINERY CORPORATION

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LID GROOVE STATION

No. 107.1

SET-UP INSTRUCTIONS PMC-1250

Before proceeding to the instructions below, the following **MUST** be true.

Using a Precision Ground Stock (flat edge) to depth micrometer down to the shoulder of the Bearing Shaft (where the Bearing sits against).

Then depth micrometer to the outer ring.

The distance of both should be within 0.001".

The outer ring may need to be ground, as stated in the drawing.

Items points must
be equal (flush)!

1. Bolt on new Curl Ring and Groove Tool.

There should be about 0.005 in gap between the Groove Tool and Curl Ring Nose.

2. With Station in full back position, check that the Groove Tool is running concentric. (#44 & 51 to center the Slide Bearing Shaft)

3. Back off the Cam Roller (18).

The Cam Roller pushes the Lid Groove Lever (40) that off-sets the Groove Tool (86).

4. Run Station 1.505 in forward.

This is 1st dwell position, where the station pauses/slows down for a moment.

5. Adjust Curl Ring so it just touches Die Rings.

6. Run Station full forward for the rest of the stroke.

7. Adjust Lid Groove Lever (40), inside, to feel it bottom-out (86). Make sure to not over load!

If Lid Groove Lever cuts thru, reduce the pressure.

