

# SERVICE INSTRUCTIONS

## PAPER MACHINERY CORPORATION

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### PUSH INCURL

No. 108.1

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REF. #507-476 (CAM #406-389)  
PMC-1300

The following is instructions on how to set up the Push Incurl on the PMC-1300 model machine.

1. Center tooling (Lead Ring & Bevel Ring) to Mandrel.
2. USE CAUTION and rotate machine until station moves forward and Tool goes over Mandrel Nose Cone, locating over Mandrel. Lock in place using 4 Socket Head Bolts.
3. Rotate machine, in reverse, until Mandrels are between stations.
4. Install Plunger (tooling). Make sure there is 0.002" clearance between Plunger and Bevel Ring around all sides.
5. Install Stop Bracket (item 19 - #321-533). Make sure Rods are centered in Bores and located 1" from back end of Cover (cover is reference only).
6. Rotate Machine forward to First Dwell position (1.500").
7. Adjust Shock Absorber Nuts (item 12 - #34765-A) to obtain 0.030" gap between the Seam Clamp & Seam Clamp Relief (on tool).
8. Set Steel Stop Nuts (item 8 - #34767-A) to touch on Stop Bracket (item 19 - 321-533). Lock in place using 5/8" Jam Nuts (item 57).
9. Set Plunger using 3/4" Jam Nuts (item 58). Rotate Machine until Mandrels are in between stations. Set Plunger 1/8" back of Bevel Ring. Lock Jam Nuts.