

# SERVICE INSTRUCTIONS

## PAPER MACHINERY CORPORATION

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### PUSH INCURL

No. 109.1

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REF. #46100 (CAM #34994-D)  
PMC-1250

The following is instructions on how to set up the Push Incur on the PMC-1250 model machine.

1. Remove or back-off Stop Nuts (item 107, 34767-A) and 5/8 - 18 Jam Nuts (item 22).
2. Install Tooling (Lead Ring & Bevel Ring) on station leaving Mounting Screws loose.
3. USE CAUTION and rotate machine forward until station moves forward and the tool goes over the Mandrel Nose Cone. Lock in place using 4 Socket Head Bolts.  
NOTE: The Shock Absorber Nuts (item 111, 34765-A) may need to be backed off to center the tools.
4. Rotate machine, in reverse, until Mandrels are between stations.
5. Install Plunger (tooling), making sure there is a minimum of 0.002" clearance between the Plunger and Bevel Ring around all sides.
6. Rotate machine forward, moving the station forward 1.125" to the First Dwell Position.
7. Adjust Shock Absorber Nuts (item 111, 34765-A) to obtain 0.030" gap between the Seam Clamp and Seam Clamp Relief on Lead Ring Tool. Lock down the Shock Absorber and Jam Nut.
8. Adjust Stop Nuts (item 107, 34767-A) to touch the Stop Bracket (item 120, 46102-D) and lock in placing using 5/8 - 18 Jam Nuts (item 22).
9. Rotate machine, in reverse, until the Mandrel is between station.
10. Set Plunger (tooling) using 3/4 - 16 Jam Nuts (item 23) 1/8" back of Bevel Ring. Lock Jam Nuts.