

INSTALLATION INSTRUCTIONS FOR EXPANDED FEP/PFA ROLL COVERS

PREPARATION

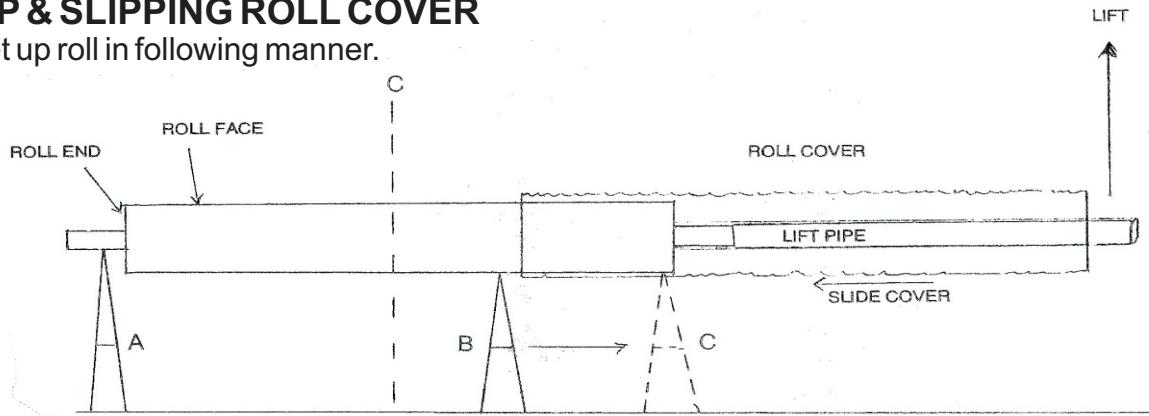
Surface of roll **MUST** be smooth, clean, and dry. Burrs, nicks, etc. (i.e. outward projecting imperfections) must be removed. Clean all oil, grease, and petrochemicals from roll surface with a non-petroleum solvent such as alcohol, chlorehene, acetone, etc. Blow off all dirt, lint, chips, etc. Tape roll ends and journals.

NOTE: METAL rolls (except chrome - which cannot be epoxy bonded) should be preheated to 120° - 130°F and wiped clean with solvent to remove machining oils. This may have to be done several times since **ALL** oils **MUST** be removed.

NOTE: Silicon rubber cannot be bonded. **ALL** others can.

SET UP & SLIPPING ROLL COVER

Set up roll in following manner.



Lift pipe should fit journal shaft fairly snuggly (.025" clearance) and be approximately 3/4 length of roll. Cover pipe with clean plastic or paper. Slide cover over pipe and up onto roll. Lift on pipe and remove stand "B". Slide cover all the way onto roll. Set roll down on well padded "C" stand (remove all slack from roll cover to prevent creases). Remove lift pipe. Heavy rolls with small journal shafts will require special rigging techniques.

PRE-SHRINK PRELIMINARIES

After setting roll (with cover) in lathe or roll stands, take open paper towel and wipe over roll face to **FEEL** for contamination under roll cover. If anything is detected, try blowing an air stream under the roll cover to blow out particles. Feel down again. Make sure **NO** contamination is present. obtain heat guns capable of producing 500° F- 750° F.

Shrinking

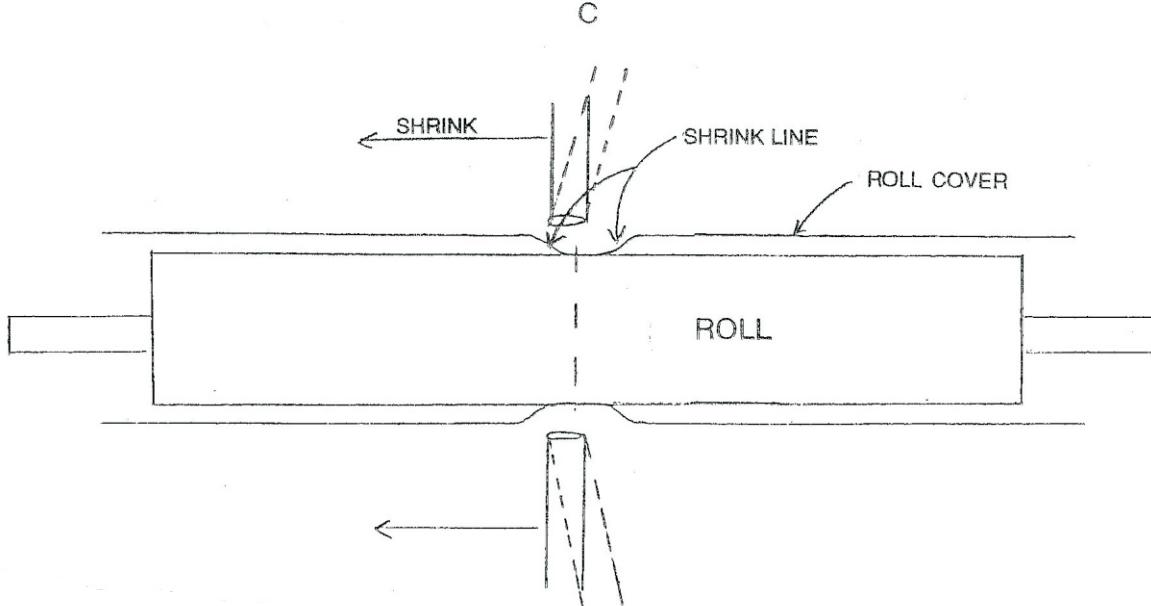
1) ROLL COVERS

Center cover over roll (i.e., equal amounts hanging over each end). Start in center using following guidelines.

1" Ø - 4" Ø	= 1 Heat Gun
4" Ø - 6" Ø	= 2 Heat Guns
6" Ø - 10" Ø	= 3 Heat Guns
10" Ø - 20" Ø	= 4 Heat Guns
20" Ø & Above	= 6 Heat Guns

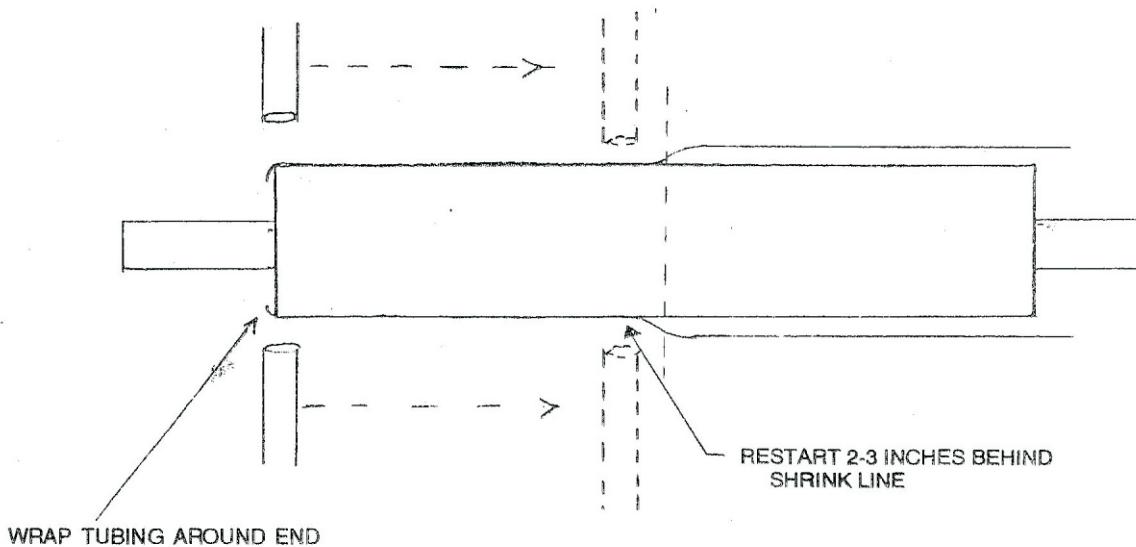
Rotate roll at 6-8 RPM. Bring heat guns to bear on tubing (all nozzles must be in straight line(plane) through roll) at 1-½ - 2" away from roll face. Wait until you obtain shrink line (i.e. a shrunk

portion of tubing then proceed right or left, keeping nozzles either $\frac{1}{2}$ way up shrink line or slightly behind shrink line. **DO NOT CROSS SHRINK LINE**. Nozzles should be positioned at 90° to roll or **SLIGHTLY AHEAD**.



Proceed **WITH** shrink line to roll end. Each roll cover will differ as to shrink speed. Shrink over end.

When "**RE-STARTING**" center, start 2-3" behind shrink line to allow all components to heat up. Proceed as above and finish roll.



NOTE: Never apply heat to a **NON-ROTATING** roll! If **WRINKLES** develop during shrinkage, they must be **REMOVED IMMEDIATELY**.

Stop shrinking, warm up area with one (1) heat gun (keep it moving) and **PUSH** wrinkle **AROUND** (not down) roll with a rubber squeegee ($\frac{1}{2}$ "neoprene 4"x4"). Restart roll cover 2-3" behind shrink line and proceed as above.