

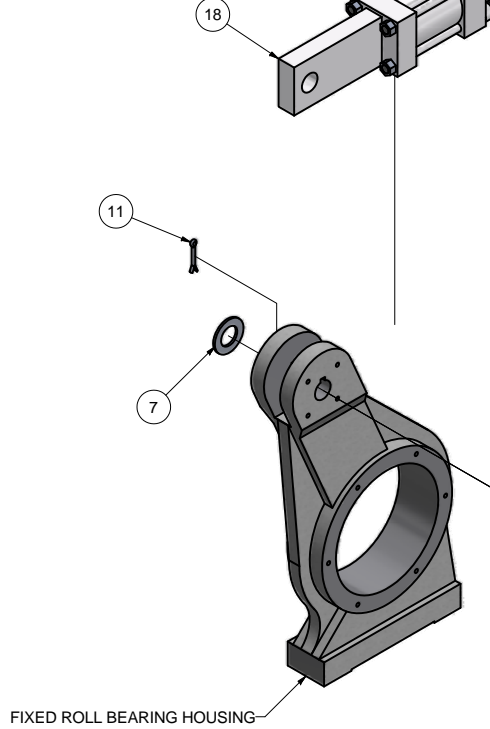
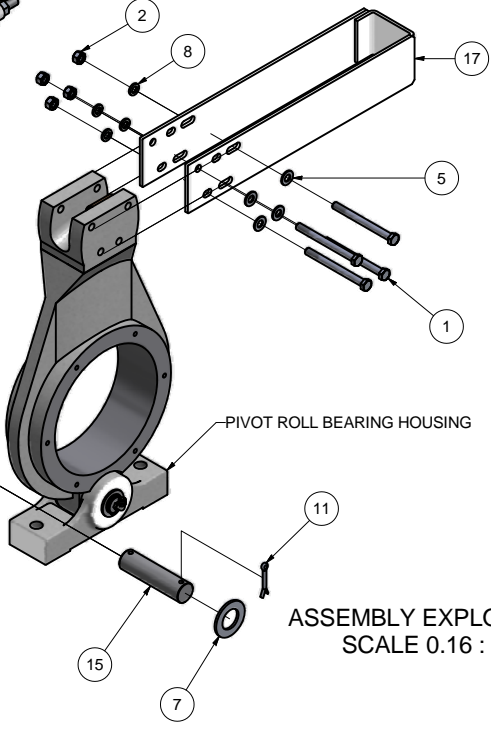
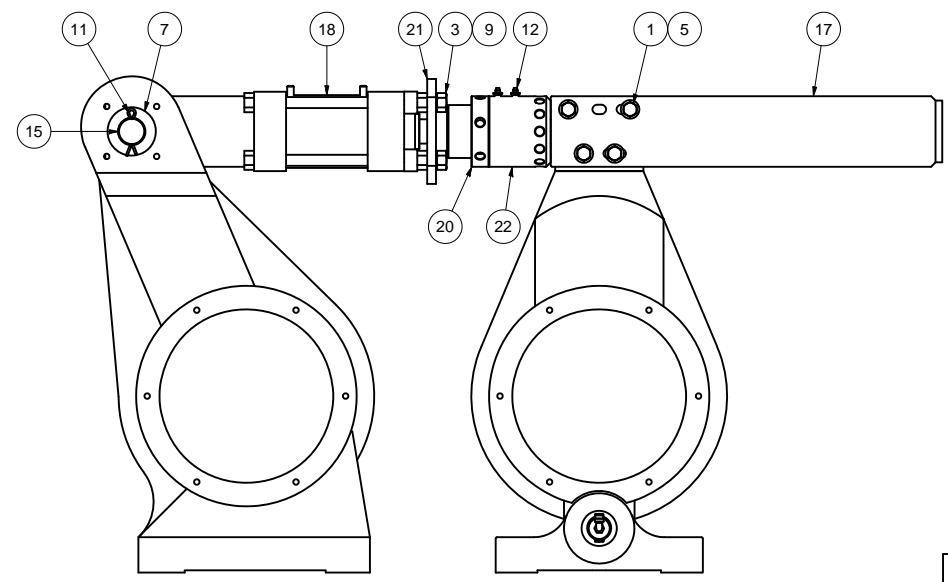
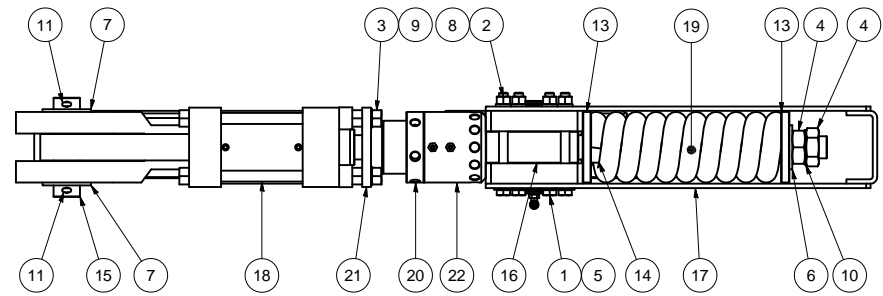
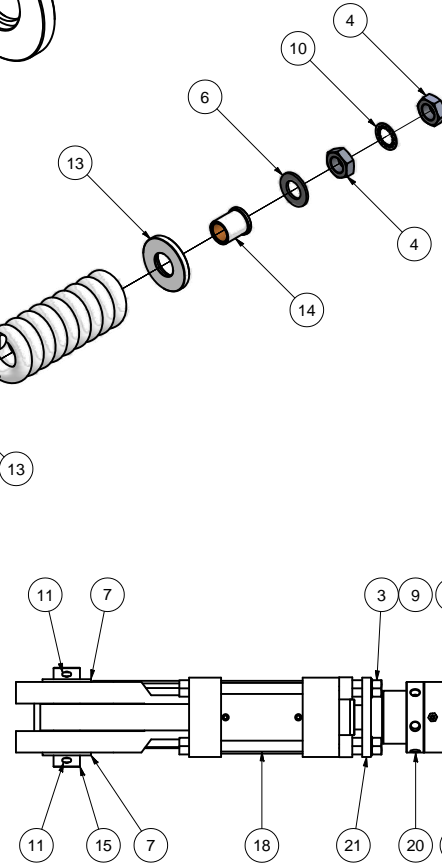
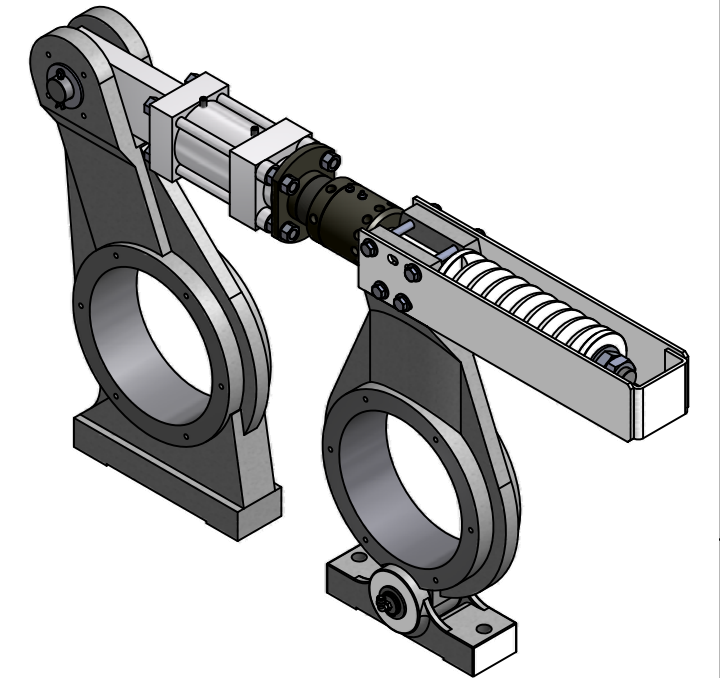
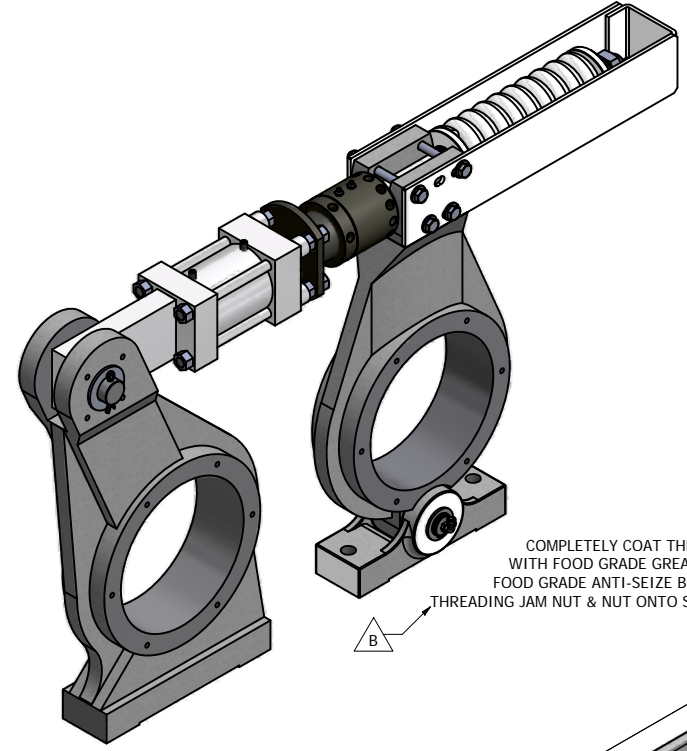
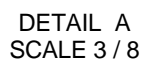
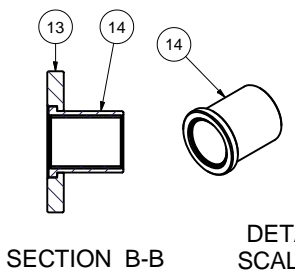
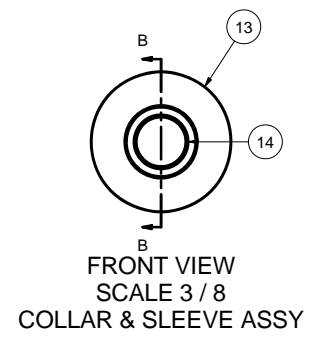
REVISION HISTORY				
REV	ECN	DESCRIPTION	DATE	APPROVED
A	K040061	RELEASE	2/5/2004	dmjohnson
B	K100263	ADD GREASE/ANTI-SEIZE LEADER	11/23/2010	dmjohnson

SETTING ROLL GAP/CLEARANCE: THE ROLL GAP AFFECTS THE SIZE AND/OR THICKNESS OF THE PRODUCT.

1. TURN OFF & LOCK OUT POWER TO ROLL DRIVE MOTORS. WAIT FOR ROLLS TO STOP TURNING.
2. CLOSE ROLLS USING THE HYDRAULIC PUMP. PLACE A FEELER GAUGE OF DESIRED CLEARANCE BETWEEN CLOSED ROLLS.
3. USE A SPANNER WRENCH OR 1/2" DIA. ROUND ROD TO LOOSEN; TURN CLOCKWISE (TOWARD FIXED ROLL); JAM NUT, ROLL ADJ (ITEM 20) WHILE USING ANOTHER SPANNER WRENCH OR 1/2" DIA. ROD TO HOLD NUT, ROLL ADJ (ITEM 22) IN PLACE.
4. ADJUST NUT, ROLL ADJ (ITEM 22) ACCORDING TO FEELER GAUGE. INCREASING ROLL GAP: TURN NUT COUNTERCLOCKWISE (TOWARD PIVOT ROLL). DECREASING ROLL GAP: TURN NUT CLOCKWISE (TOWARD FIXED ROLL).
5. ONCE DESIRED GAP IS DETERMINED, SET THE NUT, ROLL ADJ (ITEM 22) BY HOLDING IN PLACE WITH A SPANNER WRENCH OR 1/2" DIA. ROD & USE ANOTHER SPANNER WRENCH OR 1/2" DIA. ROD TO LOCK JAM NUT, ROLL ADJ (ITEM 20) AGAINST NUT, ROLL ADJ (ITEM 22).

SETTING ROLL SPRING PRESSURE: THE ROLL PRESSURE SPRING PREVENTS THE ROLLS FROM SEPARATING WHEN LARGE AMOUNTS OF PRODUCT PASS BETWEEN THE ROLLS. LOOSEN OUTER HEX JAM NUT (ITEM 4) FIRST.

1. DECREASING ROLL SPRING TENSION: LOOSEN (TURN COUNTERCLOCKWISE) INNER NUT, HEX JAM (ITEM 4). LOCK IN PLACE WITH OUTER NUT, HEX JAM (ITEM 4).
2. INCREASING ROLL SPRING TENSION: TIGHTEN (TURN CLOCKWISE) INNER NUT, HEX JAM (ITEM 4). LOCK IN PLACE WITH OUTER NUT, HEX JAM (ITEM 4). MAXIMUM SPRING COMPRESSION NOT TO EXCEED 1.00" [25.4 MM] FROM FREE LENGTH.



ITEM	PART NUMBER	QTY	DESCRIPTION
22	K201-05371	1	NUT, ROLL ADJUSTING, XHD 18/20"
21	K201-05370	1	SCREW, ROLL ADJ 3.00 X 4.63" XHD 18/20"
20	K201-05369	1	NUT, JAM, ROLL ADJUSTING, XHD 18/20"
19	K201-00273	1	SPRING, TENSION XHD 18/20"
18	K201-00184	1	CYLINDER, HYDR 3.25 X 3.00", 20" MILL
17	K200-00710	1	GUARD WLDMT, SPRING 18/20"
16	K200-00696	1	SLEEVE ASSY, CYL ROD SUPPORT XHD 228
15	K200-00680	1	PIN, CLEVIS, HYDR CYLINDER 18/20"
14	K200-00175	2	SLEEVE ASSY, HYDR SPRING WSHR, XHD 228
13	K200-00155	2	WASHER, POSITIVE ADJ HD & XHD 18/20"
12	F80800002	2	FITTING, GREASE STRAIGHT, 1/8" PTF
11	70002010	2	PIN, COTTER 1/4 X 2.00" ANSI B18.8.1
10	66548200	1	WASHER, LOCK, 1.25" INT TOOTH TYPE A
9	66545800	4	WASHER, LOCK, 5/8" INT TOOTH TYPE A
8	66445200	4	WASHER, LOCK 1/2"
7	66429000	2	WASHER, FLAT 1.50" NARROW TYPE B
6	66408200	1	WASHER, FLAT 1.25" TYPE A
5	66405200	4	WASHER, FLAT 1/2" TYPE A
4	66108200	2	NUT, HEX JAM 1.25-12
3	66085900	4	NUT, HEX 5/8-18 PLT
2	66085200	4	NUT, HEX 1/2-13
1	62585257	4	HHCS, 1/2-13 X 5.50"

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NO MANUAL CHANGES
EXCEPT AS NOTED

Division of A. T. Ferrell Company
Bluffton, Indiana - USA

Scale: 0.16:1
Drawn By: dmjohnson
Approved By: DMJ

DATE: 2/4/2005
SIZE: D
PART NUMBER: K100-02045
SHEET: 1 of 1

- NOTES:
1. DO NOT SCALE FROM DRAWING.
2. TWO PIECES REQUIRED PER K000-00186: ROLLER MILL ASSY, DUAL DRIVE 20 X 42".

K100-02045