



**BLACK BROS. CO.**

**Southeast Division**

1315 Baker Road, PO Box 4226  
High Point, NC 27263-4226  
Ph: 336-431-9145 Fax: 336-431-9275

FROM.....  
.....  
.....

**Do Not  
Drop**

To

**Black Bros. Southeast Service, Inc.**

1315 BAKER ROAD

HIGH POINT, NO. CAROLINA 27263

Make out Bills of Lading to read: "OLD, WORN OUT ROLLERS RETURNED"

Form-23203—1st. Bode Abbey Press

7-7721-2014

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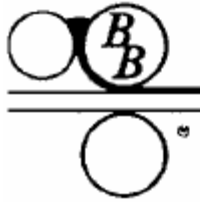
DIVISIONS

Sharing advances in coating  
And laminating technology

BLACK BROS. CO.  
CORPORATE HEADQUARTERS  
Mendota, Illinois

BLACK BROS. CO.  
SOUTHEAST DIVISION  
High Point, North Carolina

BLACK BROS.CO  
MIDWEST DIVISION  
Warsaw, Indiana



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### ROLL RECONDITIONING REQUIREMENTS

Company Name \_\_\_\_\_

P. O. Box \_\_\_\_\_

Street Address \_\_\_\_\_

City/State/Zip \_\_\_\_\_

Phone # \_\_\_\_\_ Fax # \_\_\_\_\_

Contact Person \_\_\_\_\_

Your Purchase Order # \_\_\_\_\_ Date \_\_\_\_\_

Number of Rolls \_\_\_\_\_

Grooved  
Or  
Ground Smooth

Type of Grooving \_\_\_\_\_

Machine Serial # \_\_\_\_\_

Type of Machine \_\_\_\_\_

Regrind and Regroove

Recover

New Roll on Exchange Basis

Other \_\_\_\_\_  
\_\_\_\_\_

1-13-98/RBK  
7-7924-2422

SD-327

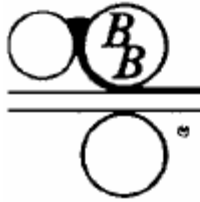
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## ROLL WEAR PREVENTION FOR COATING ROLLS

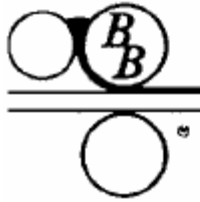
### Tips to Prevent Excessive Roll Wear:

**NOTE:** Always start with rolls that are in good condition.

- Avoid running coating and doctor roll together without coating material in reservoir. This will minimize roll and clutch wear (See clutch adjustment instructions in manual).
- Avoid having doctor roll clutch adjusted tighter than necessary and forcing rolls to skid when coating is not in reservoir (See clutch adjustment instructions in manual).
- Use only cleaning materials recommended by coating supplier that do not break down resilient covering on rolls.
- Always clean rolls thoroughly after production to avoid dried coating from damaging rolls on next production run (See cleaning instructions in manual).
- If rolls are not turning do not allow resilient roll(s) to be in contact with other roll(s) or with product for more than a few minutes. This will avoid creating a flat spot on resilient roll(s).
- Keep end seals adjusted correctly to prevent excess pressure on roll surfaces and on doctor roll clutch (See end seal adjustment instructions in manual).
- Always process product that is uniform thickness and clean, to avoid uneven roll wear.
- Roll wear will be minimized by maintaining bearing journals, chain, sprockets and by keeping bearings lubricated properly (See maintenance instructions in manual).

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## TIPS ON RUBBER ROLL CARE

1. Store rolls in the shipping container or on racks on the roll shafts, making sure the rubber surface is not in contact with containers or wall surface.
2. When storing rolls, rotate them periodically 180 degrees to eliminate any sagging of the rubber.
3. Store in a cool, dry place - not outside or in direct sunlight.
4. If rolls are to be stored for a long time, put oil on the bare metal parts.
5. Clean the rolls in the Spreader after every shift, making sure to get the ends of rolls, shafts, and end seals clean of all material.
6. For your convenience, send old worn out rolls to the nearest Black Bros. location after changing for reconditioning.

**Worn Rolls – Cost \$\$**

**Reconditioned Rolls – Save \$\$**

**HAVE YOUR ROLLS RECONDITIONED BY THE EXPERTS!**

7-7924-24051

07/26/02/JB

SD-341-1

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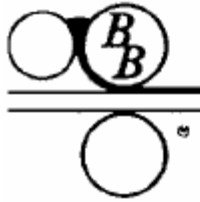
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## RESERVOIR END SEAL FITTING AND ADJUSTMENT

1. Rolls should first be centered in the machine with the bearing brackets tight against the slide bars. A straight edge should then be used on the end of the rolls to be sure that the doctor roll and coating roll ends are even. (Note: Parallel doctor roll with coating roll before making this adjustment.)
2. Be sure that the poly seal does not interfere with the fillet between the roll end flange and the roll shaft.
3. Check to be sure that the bottom edge of the tapered end of the poly seal is below the top of the doctor roll.
4. Check the end seal plates to be sure they are not sprung or bent.
5. Check the roll flanges; sometimes the outside diameter of the flanges may be more than the allowable .010" below the bottom of the roll grooves and a leak can develop in this area.
6. End seals must be fitted parallel to the roll ends.
7. Reservoir studs must be straight and tight.
8. Check the condition of the flanges on the ends of the rolls - if flanges are gouged or grooved, this can cause leaks.
9. The end seals should be adjusted so that it will not be necessary to pound them into place or pry them out.

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