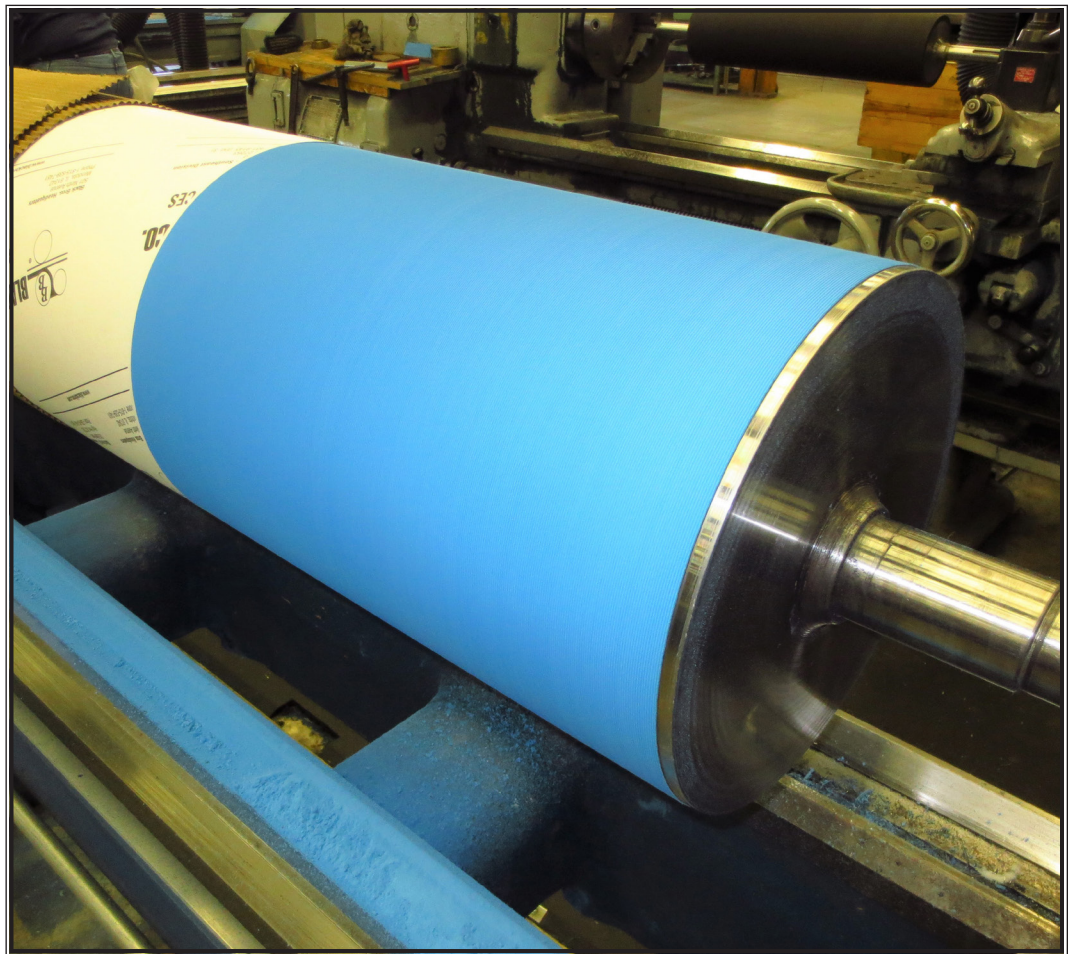


BLACK BROS. CO.

Roll Reconditioning

*We know your roll, because we built it.
Count on us to make it like new again.*



At Black Bros. Co. we manufacture the whole roll – steel core, to rubber covering, to roll finish specifications.

We will expertly recondition your roll to ensure proper coating weights and eliminate costly waste.

More Than A Tradition

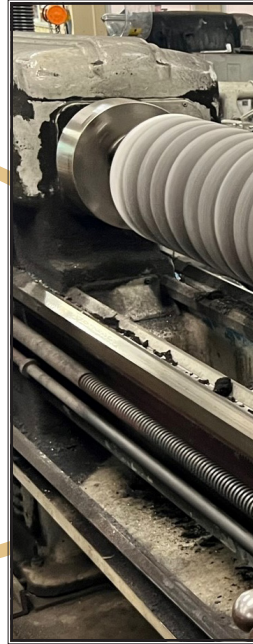
BLACK

Six Generations Strong

Roll wear prevention for coating rolls

- Always start with rolls that are in good condition.
- Avoid running coating and doctor rolls together without coating material in reservoir. This will minimize roll and clutch wear.
- Avoid having doctor roll clutch adjusted tighter than necessary and forcing rolls to skid when coating is not in reservoir.
- Use only cleaning materials recommended by your coating supplier that do not break down resilient covering on rolls.
- Always clean thoroughly after production to avoid dried coating from damaging rolls on next production run.
- If rolls are not turning, do not allow resilient roll(s) to be in contact with the other roll(s) or with product for more than a few minutes at a time. 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.
- Always run product that is clean and uniform thickness to avoid uneven roll wear.
- Roll wear will be minimized by maintaining bearing journals, chain, sprockets – and by keeping bearings lubricated properly.

It's as easy



For maximum roll performance, we urge you to return your rolls to us. Our technical staff will select (or can assist you in selecting) the best reconditioning process for your rolls.

How to care for your rolls

- Store rolls in the shipping container or securely on racks or in a cool, dry place. Avoid contact with containers or wall surface.
- When storing rolls, rotate them periodically 180 degrees to avoid flat spots.
- Store in a cool, dry place – not outside or in direct sunlight.
- If your rolls will be stored for a long time, put oil on the bearing surfaces.
- Thoroughly clean rolls in spreader after every shift, making sure to remove all coating material.
- For your convenience, send old worn out rolls to the nearest Black Bros. Co. location.

Call 815-539-7456 ext. 303 for all your roll needs!

as 1, 2, 3 ...



...r rolls to Black Bros. Co. periodically for reconditioning.
...proper roll covering materials, grooving specifications, etc.

Black Bros. rubber roll

...n the roll shaft, making sure the rubber surface is not in

...eliminate the possibility of sagging rubber.

t.

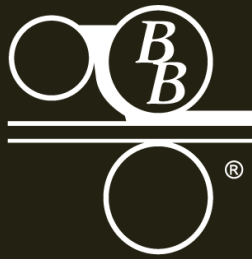
...re metal parts.

...g sure to get the end of rolls, shafts, and end seals clean of all

...st Black Bros. location after changing for reconditioning.

Reservoir end seal fitting, adjustment

- 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 the doctor roll and coating roll ends are even. (NOTE: Parallel doctor roll with coating roll before making this adjustment).
- Be sure that the poly seal does not interfere with the space between the roll end flange and the roll shaft.
- Check to be sure the bottom edge of the tapered end of the poly seal is below the top of the doctor roll.
- Check the end seal plates to be sure they are not sprung or bent.
- 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.
- End seals must be fitted parallel to the roll ends.
- Reservoir studs must be straight and tight.
- Check the condition of the flanges on the ends of the rolls. If flanges are gouged or grooved, this can cause leaks.
- The end seals should be adjusted so it will not be necessary to pound them into place or pry them out.



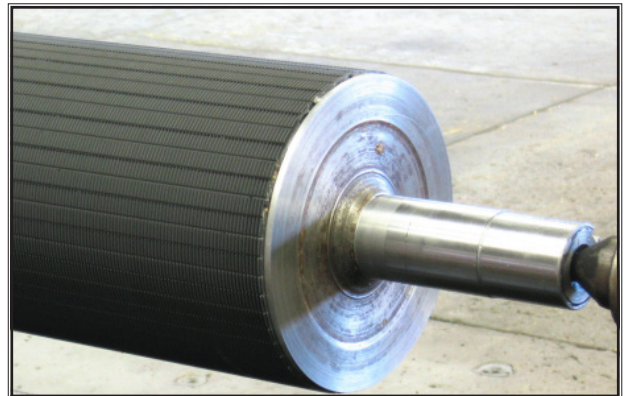
www.blackbros.com

Roll With Us!

	Black Bros.	Competition
Designed and manufactured core	Yes	No
Number of regrinds before recovery is needed	2+	0-1
Available service for entire machine	Yes	No
Non-stick coating available for core components	Yes	No
Ground to size bearing journals within machine specifications	Yes	No
Information, literature, return shipping tags, etc.	Yes	No
History of machine maintenance & roll reconditioning	Yes	No
24-step inspection on all incoming and outgoing rolls	Yes	No



Worn rolls cost \$\$\$



Reconditioned rolls save \$\$\$



Corporate Headquarters

501 9th Avenue (office)
799 5th Street (shipping)
Mendota, IL 61342-0410
Phone: (815) 539-7456 x303

CONTACT US

*for more information on our
Roll Reconditioning services
or world-class machinery!*

Southeast Division

1315 Baker Road
P.O. Box 4226
High Point, NC 27263
Phone: (336) 431-9145 x3