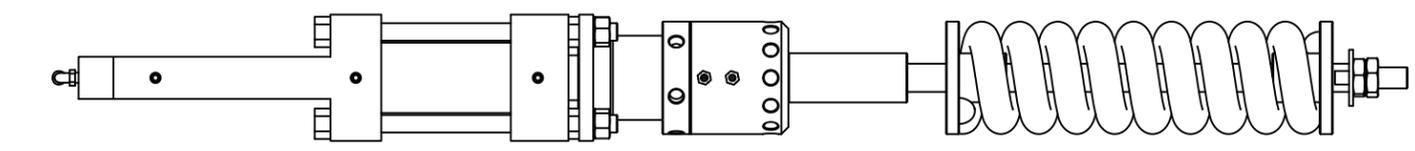
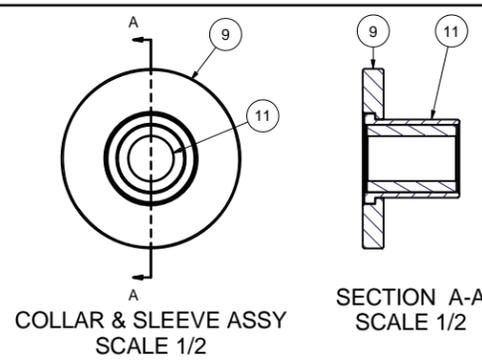


REVISION HISTORY				
REV	ECN	DESCRIPTION	DATE	APPROVED
A	K060147	RELEASE	11/10/2006	ajgager
B	K060147	CORRECT COMPONENTS AS BUILT: A0392	1/31/2007	ajgager
C	K070017	3/4-16 NUT WAS 3/4-20	1/31/2007	ajgager
D	K070194	K201-05456 WAS F80800002(2), K201-05369(1), K201-05370(1) & K201-05371(1)	12/21/2007	ajgager
E	K100263	ADD GREASE/ANTI-SEIZE LEADER	11/23/2010	dmjohnson



ECCENTRIC SHOWN IN ROLLS CLOSED POSITION. ADJUST ROLL GAP/ROLL ADJUSTING NUT: K201-05371 WITH ECCENTRIC IN CLOSED POSITION ONLY.

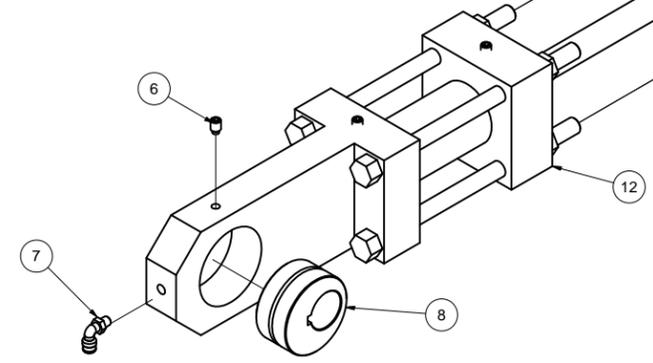
AIR BLEED

AIR BLEED

K201-05371: NUT, ROLL ADJUSTING, XHD 18/20"

K201-05369: NUT, JAM, ROLL ADJUSTING, XHD 18/20"

COMPLETELY COAT THREADS WITH FOOD GRADE GREASE OR FOOD GRADE ANTI-SEIZE BEFORE THREADING JAM NUT & NUT ONTO SCREW



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. TURN THE ROLL RELEASE ECCENTRIC: K200-00117 TO THE ROLL CLOSED POSITION USING THE MICRO HANDWHEELS.
3. CLOSE ROLLS USING THE HYDRAULIC PUMP. PLACE A FEELER GAUGE OF DESIRED CLEARANCE BETWEEN CLOSED ROLLS.
4. USE A SPANNER WRENCH OR 1/2" DIA. ROUND ROD TO LOOSEN; TURN CLOCKWISE (TOWARD FIXED ROLL); JAM NUT, ROLL ADJ (K201-05369) WHILE USING ANOTHER SPANNER WRENCH OR 1/2" DIA. ROD TO HOLD NUT, ROLL ADJUSTING (K201-05371) IN PLACE.
5. ADJUST NUT, ROLL ADJUSTING (K201-05371) ACCORDING TO FEELER GAUGE. INCREASING ROLL GAP: TURN NUT COUNTERCLOCKWISE (TOWARD PIVOT ROLL). DECREASING ROLL GAP: TURN NUT CLOCKWISE (TOWARD FIXED ROLL).
6. ONCE DESIRED GAP IS DETERMINED, SET THE NUT, ROLL ADJUSTING (K201-05371) 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 ADJUSTING (K201-05369) AGAINST NUT, ROLL ADJUSTING (K201-05371).

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 (66106500) FIRST.

1. DECREASING ROLL SPRING TENSION: LOOSEN (TURN COUNTERCLOCKWISE) INNER NUT, HEX JAM (66106500). LOCK IN PLACE WITH OUTER NUT, HEX JAM (66106500).
2. INCREASING ROLL SPRING TENSION: TIGHTEN (TURN CLOCKWISE) INNER NUT, HEX JAM (66106500). LOCK IN PLACE WITH OUTER NUT, HEX JAM (66106500). MAXIMUM SPRING COMPRESSION NOT TO EXCEED 1.00" [25.4 MM] FROM FREE LENGTH.

- NOTES:
1. DO NOT SCALE FROM DRAWING.
 2. TWO PIECES REQUIRED PER K000-00189: ROLLER MILL ASSY, DUAL DRIVE OF 18 X 12".

14	K201-05456	1	POSITIVE STOP PKG, HYDRAULIC XHD, 18/20"
13	K201-00273	1	SPRING, ROLL TENSION XHD, 18/20"
12	K201-00181	1	CYL, HYD 2.00 BORE X 3.00" STROKE, DL DRV 18 X 12
11	K200-07261	2	SLEEVE ASSY, HYD SPRING WASHER, XHD 220
10	K200-07260	1	SLEEVE ASSY, CYLINDER ROD SUPPORT, XHD 220
9	K200-00155	2	WASHER, POSITIVE ADJ HD & XHD 18/20"
8	K200-00117	1	ECCENTRIC, ROLL RLSE HD & XHD 12/18"
7	70012050	1	CPLG, ELBOW 90 1/8-27M NPT X 1/4" TBG
6	70010602	1	SCW, SET SKT HD NYLON TIP 3/8-16 X .50"
5	66546400	1	WASHER, LOCK, INT TOOTH TYPE A 3/4"
4	66545800	4	WASHER, LOCK, INT TOOTH TYPE A 5/8"
3	66406400	1	WASHER, FLAT TYPE A WIDE 3/4"
2	66106500	2	NUT, HEX JAM 3/4-16 PLT
1	66085900	4	NUT, HEX 5/8-18

This drawing is the property of the A.T. Ferrell Company, Inc. and must be returned immediately upon request. No part of this drawing may be reproduced, stored in a retrieval system or transmitted in any form or by any means, without prior written consent of the A.T. Ferrell Company, Inc.	E C F			
	NO MANUAL CHANGES			
DECIMAL: xxx ± .005 xx ± .030	ENGLISH: DIVISION OF A. T. FERRELL COMPANY	SCALE: 0.31:1	DRAWN BY: ajgager	APPROVED BY: DMJ
FRACTIONAL: ± 1/32	TITLE: ROLL TENSION ASSY, HYDRAULIC XHD OF 220 18"		DATE: 11/6/2006	SHEET: 1 of 1
ANGULAR: ± 1/2-	SIZE: D	PART NUMBER: K100-01001		

K100-01001