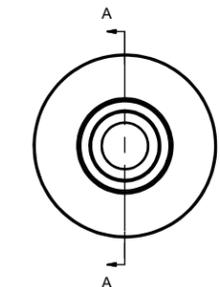
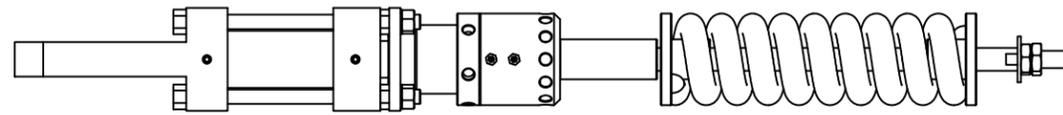
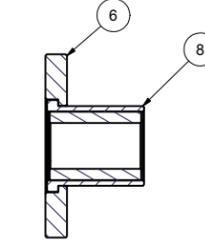


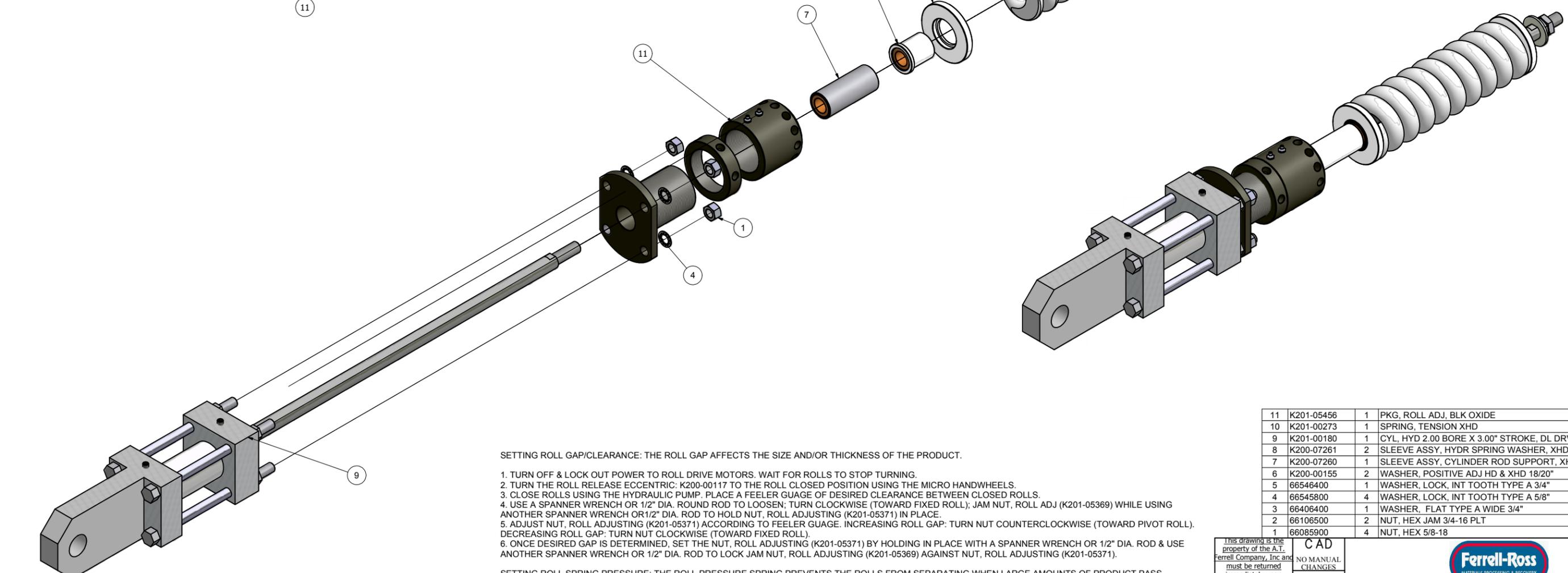
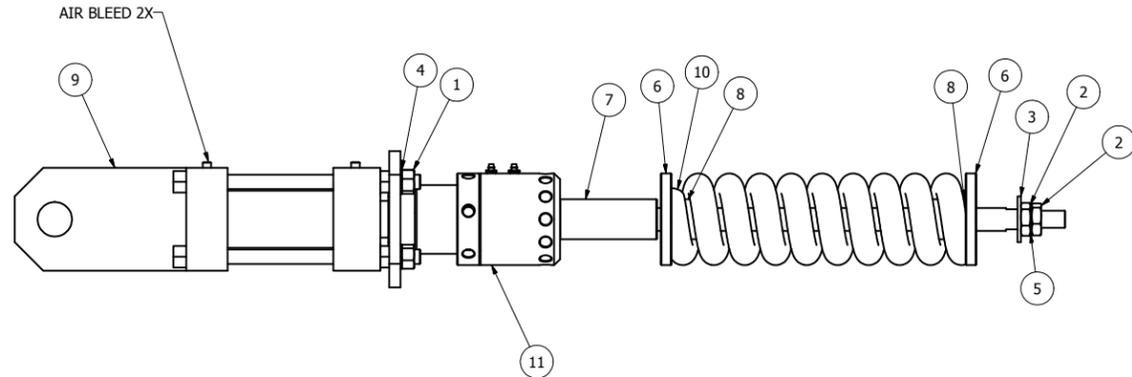
REVISION HISTORY				
REV	ECN	DESCRIPTION	DATE	APPROVED
A	K070029	RELEASED	2/23/2007	ALLENG
B	K070194	CREATE SUB ASSY K201-05456	12/31/2007	ALLENG



Collar & Sleeve Ass'y



SECTION A-A  
SCALE 1 : 2



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 (66108200) FIRST.

1. DECREASING ROLL SPRING TENSION: LOOSEN (TURN COUNTERCLOCKWISE) INNER NUT, HEX JAM (66108200). LOCK IN PLACE WITH OUTER NUT, HEX JAM (66108200).
2. INCREASING ROLL SPRING TENSION: TIGHTEN (TURN CLOCKWISE) INNER NUT, HEX JAM (66108200). LOCK IN PLACE WITH OUTER NUT, HEX JAM (66108200). 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".

11	K201-05456	1	PKG, ROLL ADJ, BLK OXIDE
10	K201-00273	1	SPRING, TENSION XHD
9	K201-00180	1	CYL, HYD 2.00 BORE X 3.00" STROKE, DL DRV 18 X 12
8	K200-07261	2	SLEEVE ASSY, HYDR SPRING WASHER, XHD 220
7	K200-07260	1	SLEEVE ASSY, CYLINDER ROD SUPPORT, XHD 220
6	K200-00155	2	WASHER, POSITIVE ADJ HD & XHD 18/20"
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

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	FINISH: NONE DECIMAL: .005 XX ± .030 FRACTIONAL: ± 1/32 ANGULAR: ± 1/2°	SCALE: 0.31:1 DRAWN BY: ajgager APPROVED BY: DMJ	DIVISION OF A. T. FERRELL COMPANY BLUFFTON, INDIANA - USA	DATE: 11/6/2006 SIZE: D PART NUMBER: K100-01186	SHEET: 1 of 1
	TITLE: ROLL TENSION ASSY, HYDRAULIC XHD OF 220 18"				
	DIVISION OF A. T. FERRELL COMPANY				