

Service Reference Manual

INK FORM ROLLER PRESSURE

REQUIREMENT: To assure copy quality, form rollers must contact master or plate under proper pressure.

NOTE:

Form roller end play adjustment must be made before making this adjustment.

ADJUSTMENT:

1. Position the following:
 - Operation control lever to "Ink"
 - Form roller levers to "Off"
 - Aquamatic lockout to "Manual" (up)
 - Machines without Operation control lever: Turn night latch to "Operate"
 - Aquamatic night latch to "Operate"
 - Aquamatic control to "45"
2. Apply ink to ink fountain and adjust fountain screws for even distribution of ink. Ink the roller system.
3. After inking all rollers, turn off machine and attach a 4000 Series master to the master cylinder.
4. Turn handwheel until both form rollers are in a position where they can contact the master.
5. Adjust four locking nuts (1) on four adjusting screws (2) on both sides. With plates (3) flat against frame, draw locking nuts (1) up snug (not tight) to plates (3). Check that adjusting screws (2) can be rotated.
6. Re-adjust, if necessary.

CAUTION:

If plates (3) are not adjusted properly, adjusting screws (2) will bind and form roller levers will bind.

6. Turn four adjusting screws (2) to position form rollers to their maximum distance from the master cylinder. Tighten lock screws (4).
7. Gently turn two form roller levers to "On" and then to "Off".
8. Check ink bead lines on the master for the following widths, with a uniform measure within 1/64" across the length:
 - Upper form roller - 1/8" to 5/32"
 - Lower form roller - 5/32" to 3/16"
9. Loosen lock screws (4) as necessary and turn adjusting screws (2) in the direction shown in chart on the following page to INCREASE bead line.

NOTE:

When bead line is to be INCREASED (form roller moving toward master cylinder) the adjusting screws (2) must be turned in the direction listed on the chart. If not, the form rollers will be askew in the machine. It is possible to get a proper bead line dimension but it will run at an angle. Tighten screws (4).



10. Re-check adjustment page.

NOTE:

When the upper form roller is adjusted the aquamatic ductor roller must also be adjusted.

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NOTE:

Screws (2) with a milled slot  or milled flat  indicate high point of eccentric. Opposing eccentric screws (2) must be approximately in the same position on both sides of the machine to assure that the rollers are not skewed.

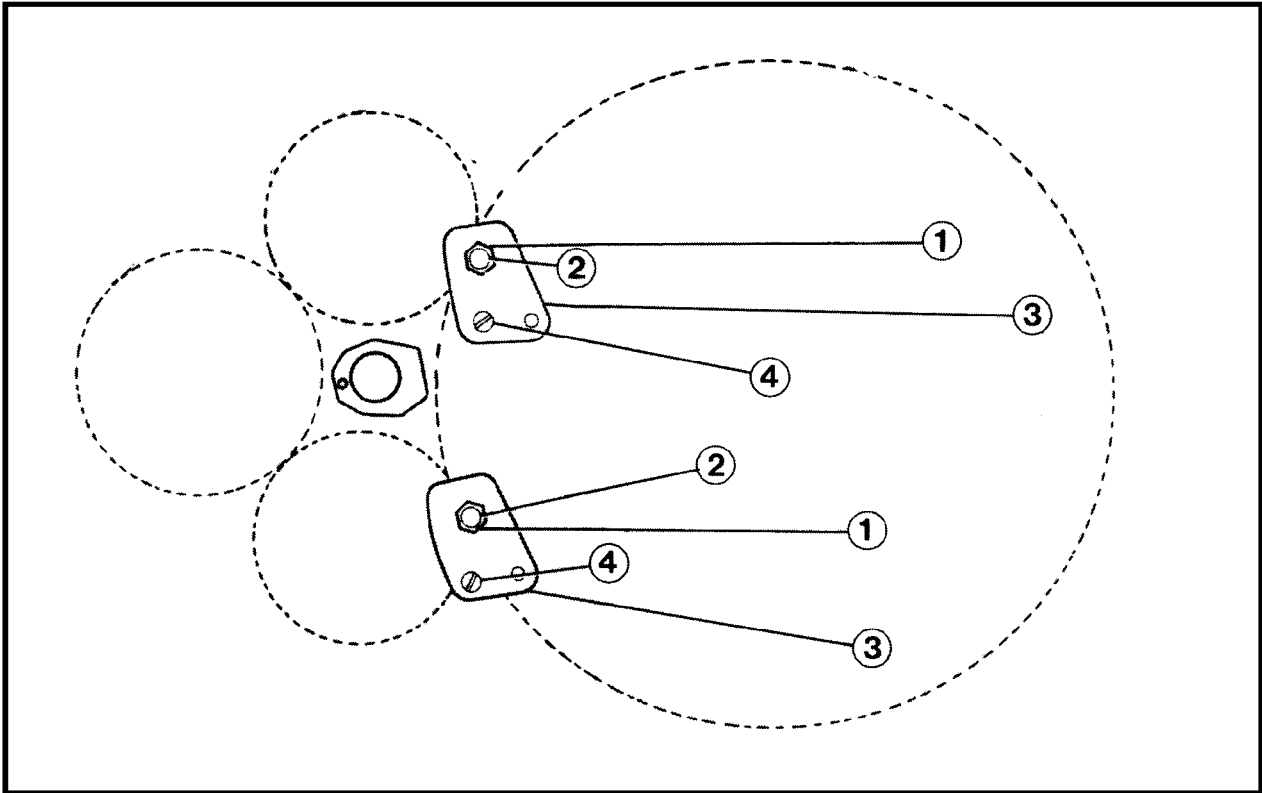


Figure 54 - Ink Form Roller Pressure Illustration

Turn the adjusting screws in the following direction to INCREASE the bead line to the correct dimension:

	NON-OPERATOR'S SIDE	OPERATOR'S SIDE
Upper Form Roller	Counterclockwise	Clockwise
Small Lower Form Roller	Counterclockwise	Clockwise
Large Lower Form Roller	Clockwise	Counterclockwise