EDOLON® HEAT SHRINKABLE ROLL COVERS OF TEFŁON®

Installation Instructions
TYPE HST-2® / BIAXIAL STRESS (ONLY)

Before You Begin

Read All Instructions Thoroughly
Edlon, Inc. suggests a complete and periodic installation review between your mill personnel and our factory service technicians. Usually this can be done at no charge to you.

Check Roll Size
Edlon’s roll covers are custom-built to fit your roll. Sample strips of the expanded and recovered cover circumference are packaged with each cover. Use these samples to confirm (before unpacking the cover) that the packaged cover will fit the intended roll.

Equipment
1. Roll turner or lathe capable of 5-30 RPM.
2. Heat gun(s) with 500°F/750°F nozzle temperature.
4. Cleaning equipment and solvent.
5. A pipe 1’ longer than the roll face for use as the lifting apparatus. The pipe must fit the journal snugly and be capable of supporting the weight of the roll. Caution must be used to avoid concentrated loads on the roll shaft which can cause bending.
6. Tension disc. See reverse for fabrication instructions.

Shrinking the Cover
Position the heat guns approximately 1” from the cover and at a 90 degree angle to the roll axis. The roll must be rotating at all times when the heat guns are in use. Traverse the guns slowly and uniformly along the roll and in the direction of the unshrunk portion of the cover.

<table>
<thead>
<tr>
<th>Roll Diameter</th>
<th>Guns Suggested</th>
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<tbody>
<tr>
<td>1”-6”</td>
<td>2</td>
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<tr>
<td>7”-12”</td>
<td>3</td>
</tr>
<tr>
<td>13”-18”</td>
<td>4</td>
</tr>
<tr>
<td>19”-24”</td>
<td>5</td>
</tr>
<tr>
<td>25”-36”</td>
<td>6</td>
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</table>

The instructions provided are suggested installation techniques for Edlon, Inc. heat shrinkable roll covers. We believe this information to be the best available on the subject. Edlon makes no guarantee of result and assumes no obligation or liability in connection with this information.

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Edlon, Inc.® Heat Shrinkable Roll Covers of Teflon®

Installation Procedure

1. Sand/grind and clean with oil-free solvent.

2. Preheat metal rolls to 100°F-120°F in order to minimize heat loss during installation. Repeat step 1 as required - roll surface must be clean.

3. Slide lifting pipe onto journal. Clean and cover lifting pipe and roll ends to prevent dirt deposits on the sleeve interior.

4. Slide cover onto lifting pipe. Handle the cover by the inner packing tube to avoid creasing the cover.

5. Raise end of lifting pipe to support roll; remove journal support.

6. Slide cover onto roll; move journal support back into position; remove lifting pipe.

7. Slide a tension disc onto both journals. The cover will be clamped onto this disc.

8. Fabricate tension disc from plywood or metal. Cover all wood surfaces with tape to prevent wood chips/sawdust deposits on I.D. of cover.

9. Shrink cover onto disc. Caution - shrink only in the area and the necessary width to contact the tension disc.

10. Apply hose type clamps over cover onto the disc.

11. Shrink cover - starting in the center and with the roll rotating slowly, shrink to one end of the roll, return to the center and shrink to the opposite end.

12. Adhesive bonding - place needle under cover by carefully cutting a circumferential slit in the gap between the retaining disc and end of roll.

13. Mix adhesive and inject a large puddle under the cover.

14. Use half a wrap of new rope (clothesline) dragged lengthwise of the roll to spread adhesive. Repeat steps 12 and 13 as required moving adhesive from injection point to opposite roll end.

15. Tightly wrap glass tape on ends of roll. Do not remove tape or tension disc until adhesive is fully cured.

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