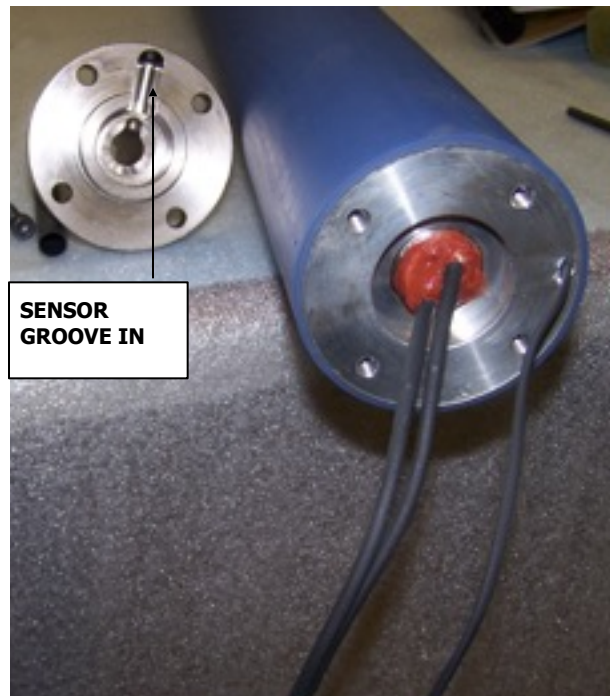
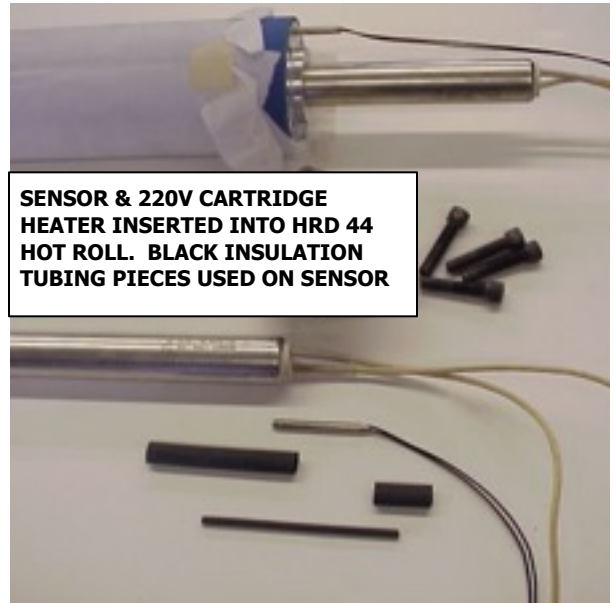


HOT ROLL DIGITAL 44

HOT ROLL ASSEMBLY

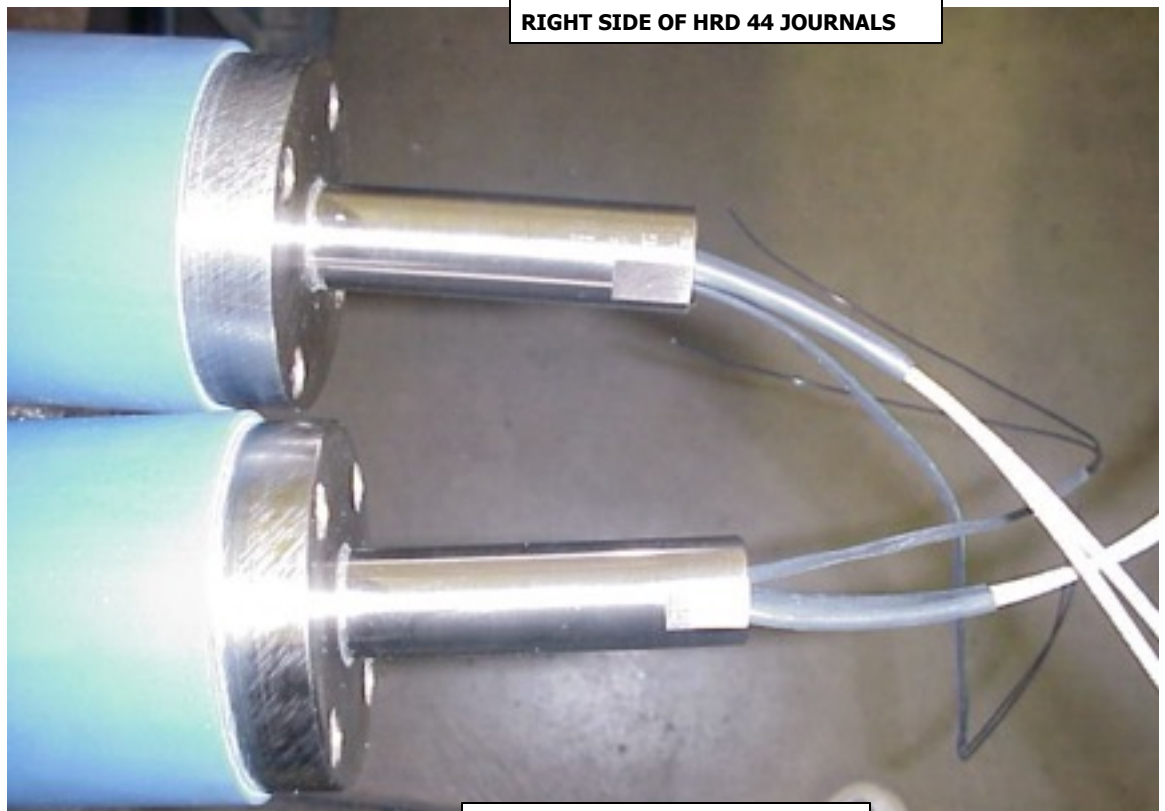
- 1) THE HRD 44 USES (2) IDENTICAL HOT ROLL ASSEMBLIES. THEY WILL LOCATE IN THE UPPER AND LOWER FRONT OF MACHINE. ASSEMBLE BOTH HOT ROLLS AS FOLLOWS.
- 2) LOOSEN (4) SOCKET HEAD CAPSCREWS HOLDING HOT ROLL SENSOR END HUB ONTO HOT ROLL BODY COMPLETE (EHR44 040.4) **FLOOR**. THIS HUB HAS THE OPEN BORE JOURNAL FOR WIRE EXIT.
- 3) CAREFULLY REMOVE JOURNAL FROM HOT ROLL BODY. USE PLASTIC MALLET IF NESSECARY.
- 4) INSERT 1.000" DIA. CARTRIDGE HEATER 220V (PRH180) **LOFT 1** INTO EACH HOT ROLL CORE. INSERT A SENSOR FOR TRAKSTAT (PRC212S) **LD03** INTO BOTH SENSOR APERTURES. WARNING: DO NOT FORCE THEM INTO THE BORE. IF NESSECARY, CLEAN BORE WITH BORE SWAB TOOL. STAKE SENSOR AND BOTH ENDS OF HEATERS.
- 5) CUT (3) 4" PIECES OF 3/16" BLACK INSULATION TUBING (PRI165) **CAB1** AND PLACE ONE ON EACH HEATER WIRE AND BOTH SENSOR WIRES. SHRINK TUBING. CUT 4" OF 3/8" BLACK INSULATION TUBING (PRI164) **CAB1**, COVER WIRE BUNDLE AND SHRINK TUBING.
- 6) ADD LOCTITE SILICONE SEALANT TO COVER ALL CERAMIC AREA OF HEAT CARTRIDGE, **CAB1** ESPECIALLY AROUND WIRES AND EDGE.
- 7) PLACE WIRE LEADS THROUGH JOURNAL BORE AND ALIGN GROOVE INSIDE JOURNAL FACE TO CORRESPOND WITH SENSOR LEADS.



ADD SEALANT OVER CERAMIC HEATER PARTS AND WIRE ENTRY INTO CERAMIC. SHRINK INSULATION ON HEATER/SENSOR WIRES. BUNDLE AND

**REATTACH JOURNAL ONTO CORE
USING 5/16-18 X 1 1/4 SHCS.
WARNING: DO NOT PINCH THE LEADS
BETWEEN JOURNAL AND BORE.**

- 8) **DO NOT TERMINATE LEADS. AFTER
HOT ROLLS ARE IN CHASSIS, THEY
CAN BE MEASURED TO 3 1/2" AND
TERMINATED, USING (2) FEMALE
FASTONS (PRT310) ON SENSOR WIRES
AND (2) FLAG FASTONS (PRT284) ON
HEATER WIRES. WARNING: GREAT
CARE MUST BE TAKEN WHEN
STRIPPING WIRES AND
TERMINATING. IF CUT TOO SHORT THE
HEATER\SENSOR WILL BE SCRAPPED.
MAKE ABSOLUTELY SURE THAT ALL
CRIMP CONNECTIONS ARE SECURE.**
- 9) **SLIDE A 1" PIECE OF 3/8" INSULATION
TUBING ONTO WIRES AND SHRINK AT
END OF JOURNAL FOR EXTRA
PROTECTION.**



RIGHT SIDE OF HRD 44 JOURNALS

**HRD 44 HOT ROLLS COMPLETED
WITH INSULATION TUBING ON**