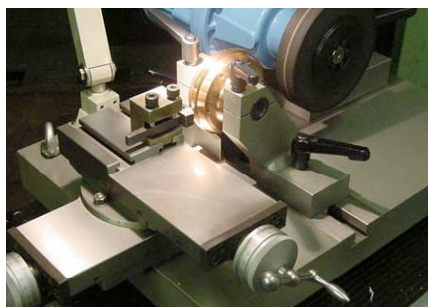


7.6.2. The Redressing of the Roller Heads and the Correction of the Pendulum Head

For improved maintenance:

Employ a roller-dressing and returning device for the redressing and post-redressing of the roller heads (see also CM 91).



To ensure that the maintenance of the electrode wheel heads is carried out exactly and efficiently manner, we urgently recommend the procurement of a so-called welding roller redressing unit, type CM 91.

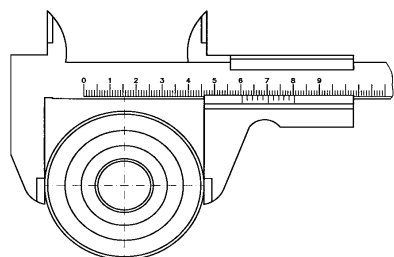


NOTE:

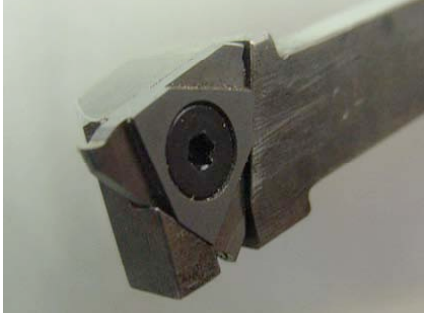
A correctly performed wire groove is an elementary requirement for the quality of the welding! If you do not possess such a dressing unit, return the roller heads to Can Man for remachining.

The following table specifies the minimum diameters of the various seam-welding wheels.

Seam-welding wheel type	∅ New	∅ Minimum
PR/QR 42	42 mm	40.5 mm
PR/QR 49	49 mm	47.5 mm
PR/QR 62	62 mm	60.5 mm
PR/QR 90	90 mm	88.5 mm
SS 120 Welding disc	120 mm	115 mm



Measurement is made over the outermost roller diameter.



Original Can Man redressing tool. It was designed specifically for the exact redressing of the wire profile in the electrode wheel heads.

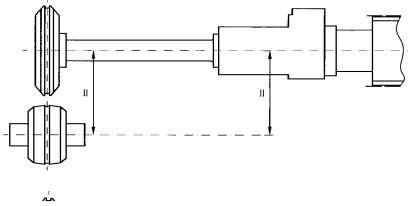


NOTE:
For this reason, always use the original Can Man redressing tool (supplied with every machine) or make sure that the redressing profile and the profiled wire perfectly matches!

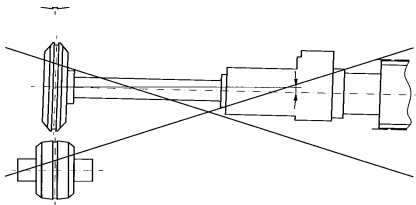


NOTE:
The quality of the grooves in the electrode wheel heads is essential for the welding process.

If the pendulum roller head is no longer true, it is only necessary to make one correction.



The illustrations speak for themselves.



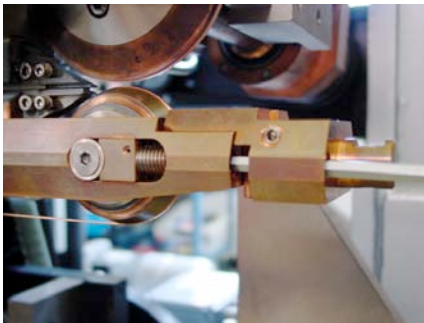
INCORRECT!



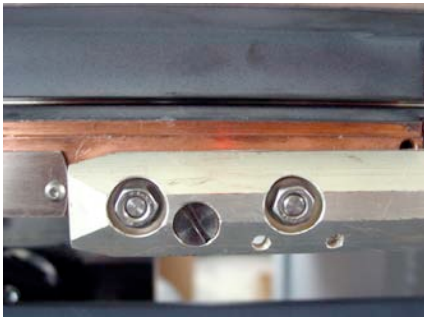
A complete set of gauges is supplied to enable the important settings of the welding geometry to be made in a proper manner.



NOTE:
Before you start with following task, switch off the cooling unit.



The lower welding roll need to be replaced by the "dummy roll", for this, undo the two screws that clamp the roller head axis.



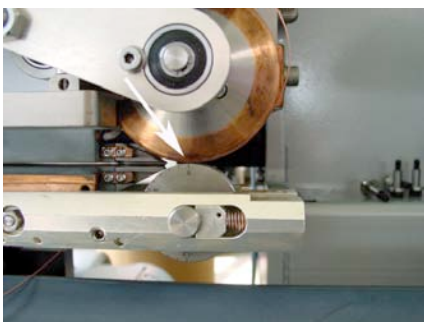
Undo the two M6 nuts only from the front side, not from the backside, in order to keep the position.



Take the outside welding roll holder off, be aware that some cooling water will come out from the cooling circuit of the lower welding roll.

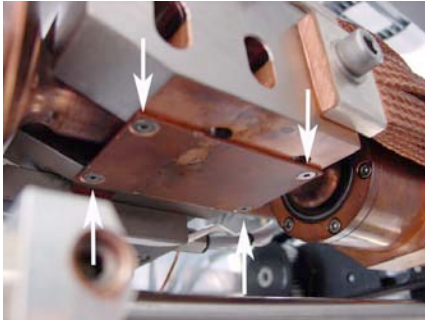


Mount the "dummy roll" together with the shaft into the welding roll holder.

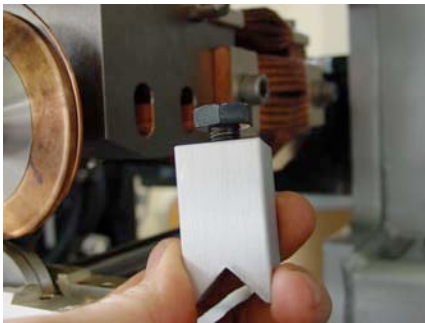


Turn the roll position "0", according to the picture.

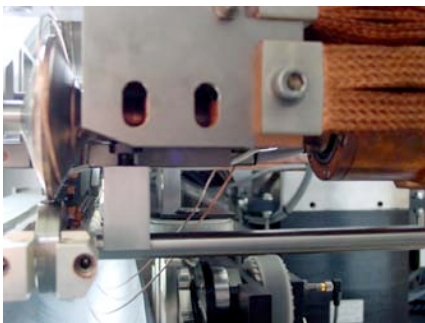
NOTE:
If you have recessed the welding roll make the corresponding correction. And take the wire out of the upper welding roll.



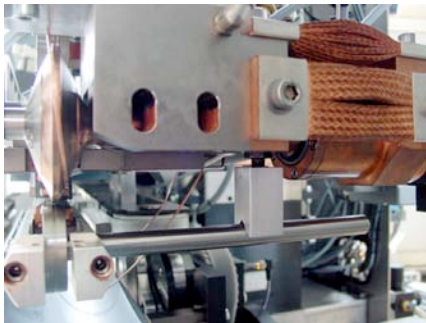
Undo the four M4 screws and take the current bridge off.



Use the supplied height gauge and place it between the mounted bar and pendulum axis.



The precision-ground head serves as a counter measuring point for the axis of the pendulum roller head.



The measurement result from left and right side must be the same.
Tolerance $\pm 0,05$ mm.



To make the necessary adjustments you need to loosen the two M10 screws of the fixture.



Then use the M10 screw underneath to make the necessary adjustments.



NOTE:
See Setting the lower welding roll, Chap. 5.5.6