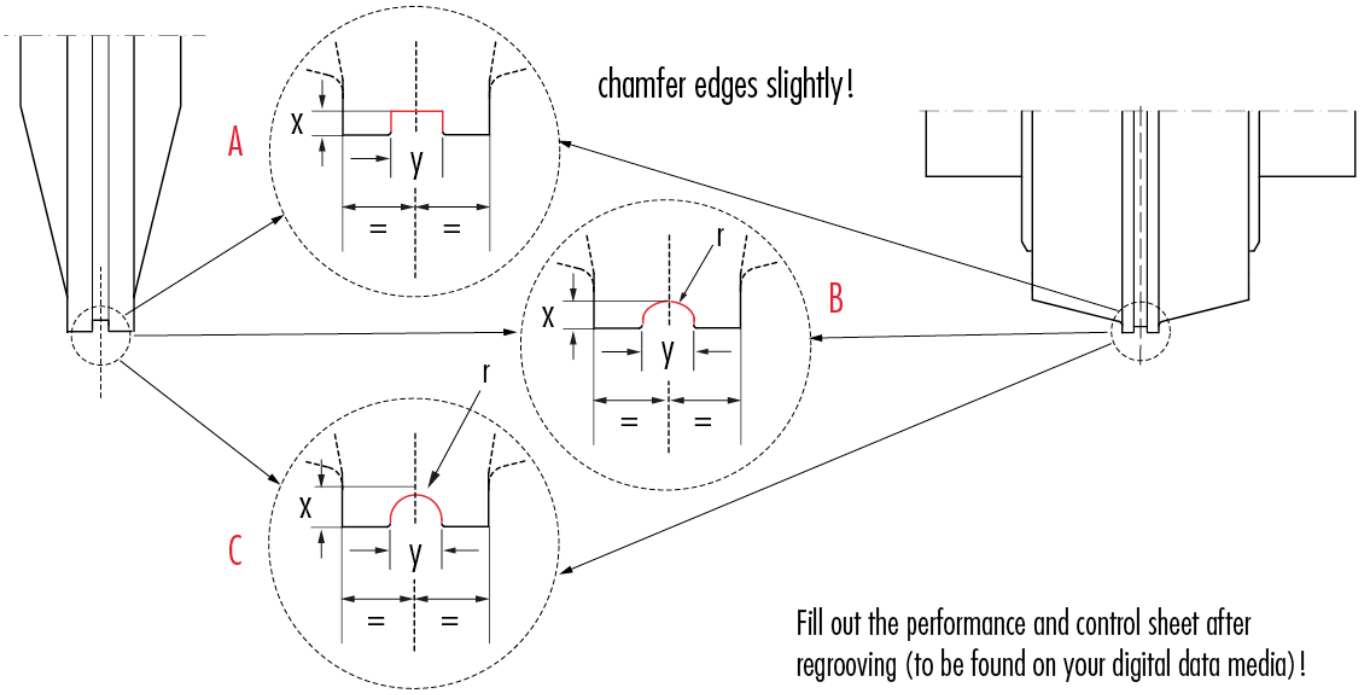
Regrooving Weld Rolls



Attention:

Fill some of the emulsion into the cooling bores before re-grooving (especially when using a regrooving machine such as CM 91 or similar)! Wet contacts inside the roll will reduce wear and therefore increase lifetime of the sliding contacts considerably. If you do the re-grooving immediately after running production, no such watering is needed. Check the rotating direction of the welding roll carefully when mounting!

∅ New (Nominal)	Type	∅ Minimum
42 mm	Welding roll	40.5 mm
49 mm	Welding roll	47.5 mm
54 mm	Welding roll	52.5 mm
62 mm	Welding roll	60.5 mm
90 mm	Welding roll	88.5 mm
90 mm	Welding disc	86 mm
120 mm	Welding disc	115 mm
130 mm	Welding roll	125 mm

Fill out the performance and control sheet after regrooving (to be found on your digital data media)!

Performance and control sheet

Customer / country

Type of welding machine

Welding speed and cans per minute

Serial number

Wire or wire groove profile

Date of first installation	Ø Outside when new	Total piece counter or operation hours

Date of redressing	Ø Outside redressed	Total piece counter or operation hours

Date of removal	Ø Outside when fail	Total piece counter or operation hours

Reason of removal ☐ Water leakage ☐ Bearing problem ☐ Normal wear ☐

Company stamp & signature

Name of examiner (in blockletters)

Wire ∅	x (mm)	y (mm)	r (mm)	Part. No. blade holder	Part. No. cutting blade	Type
1.00 mm	0.20 (+0.02/0)	1,9 (+0.02/0)	-	000913	005036	A
1,24 mm	0,30 (+0.02/0)	1,8 (+0.02/0)	-	000913	005035	A
1,38 mm	0,50 (+0.03/0)	1,8 (+0.03/0)	2,25	000913	005087	B
1,38 mm	0,40 (+0.02/0)	2,1 (+0.02/0)	-	000913	005037	A
1,5 mm	0,55 (+0.03/0)	1,8 (+0.03/0)	2,25	000913	005087	B
1,5 mm	0,45 (+0.02/0)	2,1 (+0.02/0)	-	000913	005037	A
1,8 mm	0,70 (+0.03/0)	2,3 (+0.03/0)	3,0	000913	005088	B
1,8 mm	0,40 (+0.03/0)	3,2 (+0.03/0)	-	000913	005038	A
1.8 mm	0.8 (0/-0.1)	1.85 (0/-0.02)	0.9	000913	005089	C