COPPER
QUESTIONNAIRE TO DETERMINE COPPER DIMENSIONS

PRELIMINARY WORKS

→ Dismount cylinder from machine
→ Clean cylinder properly
→ Ensure that the cylinder sits properly on the stands and can be rotated easily when resting on the bearings or flanges

Take the following tools for measuring:

<table>
<thead>
<tr>
<th>Sliding caliper (metric system)</th>
<th>Depth gauge (flush pin gauge, metric)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Video 02:41min</td>
<td>Video 03:11min</td>
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REQUIRED MEASUREMENTS FOR YOUR ORDER

**Width of Copper Strip**

- **Width of Groove**
  - Tool: Sliding caliper
  - Measure the width of groove.
  - Video 03:00 – 03:11min

- **Tool: Sliding caliper**
  - Measure the blade thickness at the blade bottom after you have removed the blade from the cylinder.
  - Video 03:45 - 03:50min

**Width of Groove** = \( M \) mm

**Thickness at bottom of blade** = \( H \) mm

**Formula for the width of copper**

This copper strip should always be wider than the difference between groove width and blade thickness. The minimum excess should be 0.1mm and can be up to 0.3mm maximum.

As a rule of thumb: the more excess the tighter the blades sits in the groove and the better the blade performance.

\[ M - H + 0.1 \text{ to } 0.3 \text{mm} = \text{mm} \]

**Height of Copper Strip**

- **Tool: Depth gauge**
  - Measure the depth of the groove
  - After caulking the upper end of the copper MUST be 0.5mm – 1.5mm below the edge of the groove.
  - Video 04:09 – 04:18min

**Remind:** After caulking the upper side of the copper MUST be 0.5mm – 1.5mm below the edge of the groove.

Depth of groove = \( \text{mm} \) + 2 mm

\[ M - H + 0.1 \text{ to } 0.3 \text{mm} + 2 \text{mm} = \text{mm} \]