COPPER
QUESTIONNAIRE FOR ORDERING RIGHT CAULKING COPPER

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>Tool</th>
<th>Video Duration</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sliding caliper (metric system)</td>
<td>02:41min</td>
</tr>
<tr>
<td>Depth gauge (flush pin gauge, metric)</td>
<td>03:11min</td>
</tr>
</tbody>
</table>

REQUIRED MEASUREMENTS FOR YOUR ORDER

### Width of Copper Strip

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

- **Thickness at bottom of blade**
  - **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**

**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 sit in the groove and the better the blade performance.

- **Width of Groove = M mm**
- **Thickness at bottom of blade = H mm**
- **M – H + 0.1 to 0.3mm**

### Height of Copper Strip

- **Tool:** Depth gauge
  - Measure the depth 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.