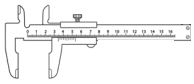
COPPER

QUESTIONAIRE TO DETERMINE COPPER DIMENSIONS

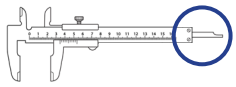
PRELIMINARY WORKS

→ 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:



Sliding caliper (metric system)
Video 02:41min

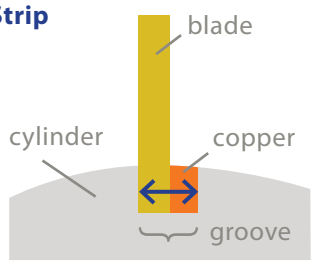


Depth gauge (flush pin gauge, metric)
Video 03:11min

REQUIRED MEASUREMENTS FOR YOUR ORDER

Width of Copper Strip

Width of Groove



Tool: Sliding caliper

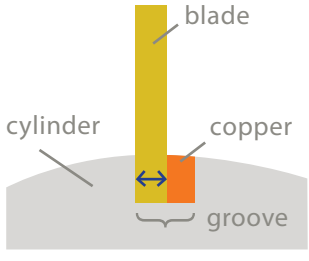
→ Measure the width of groove.

Video 03:00 – 03:11min

Width of Groove = M

_____ mm

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

Thickness at bottom of blade = H

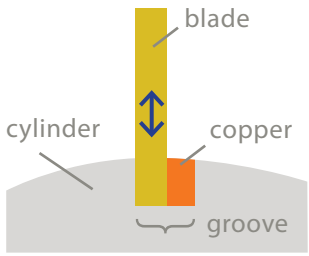
_____ mm

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 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 to 0.3mm
= _____ mm
M – H + 0.1 to 0.3mm

Hight 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

Depth of groove

_____ mm
+ 2 mm
= _____ mm

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

Heusch GmbH & Co. KG Tel + 49 (0)241 . 168 95-0 Fax + 49 (0)241 . 168 95-255 sales@heusch.de **www.heusch.de**