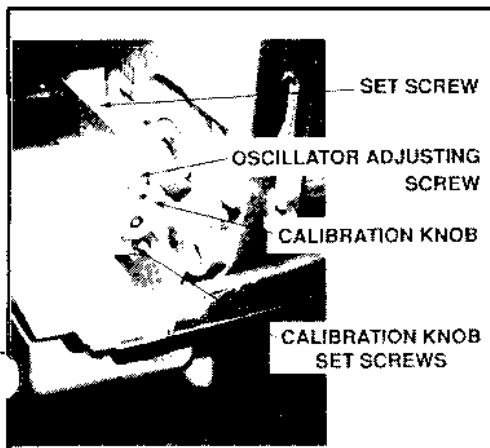


TECHNICAL AND SERVICE BULLETIN

TO: ALL KOMPAC DEALERS
NO: 29
DATE: FEB. 1991
SUBJECT: CALIBRATION PROCEDURES FOR KOMPAC-T UNITS



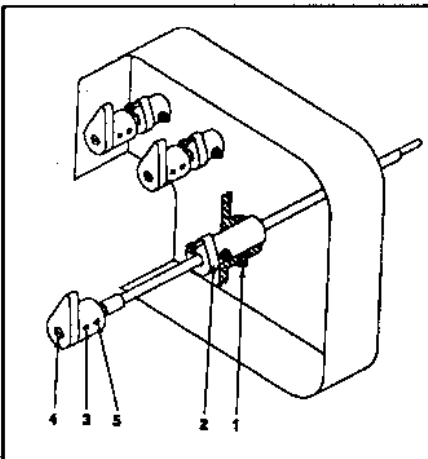
KOMPAC-T FORM ROLLER TO METERING ROLLER - FIGURE 1

1. Loosen the set screws on the top of the end frames.
2. Turn the calibration knobs counterclockwise to the "OFF" position (past the #1 setting).
3. Insert two strips of 20# bond paper between the form and metering rollers.
4. Turn calibration knobs to achieve a firm, even drag on both sides.
5. When an even drag is achieved, turn calibration knobs clockwise an additional 180 degrees (1/2 turn) and lock set screws.
6. Loosen the set screws on the sides of the calibration knobs. Turn each knob until the scribe mark aligns with the #1 setting and lock the set screw in place.
7. To adjust pressure, loosen the set screws on top of the frame, turn the screw in the center of the calibration knob to the desired setting and lock the top set screws. Higher numbered settings increase the pressure and reduce the amount of water. Initial setting for operation should be between 3 and 5.

KOMPAC-T OSCILLATOR ROLLER TO METERING ROLLER - FIGURE 1

Pressure of the oscillating roller is adjusted by using a 1/16" allen key to turn the screw found in the access hole in the end cap, which is above the calibration knobs. Rotate the screw clockwise to increase the pressure and counterclockwise to decrease the pressure.

KOMPAC-T TO PLATE PRESSURE - FIGURE 2



1. **Paralleling**
 - A. Remove the cover on the operator side. Loosen the set screw (Item 1) found in the boss, inside the side frame. Rotate the form bushing (Item 2) clockwise to decrease the pressure on the operator side of press.
 - B. Adjust the form bushing to produce an even stripe across the full width of the plate.
2. **Overall Pressure**
 - A. Loosen the set screw (Item 3) on the form handle. Turn the form shaft with a screwdriver in the slot (Item 4). Turn the shaft counterclockwise to increase overall pressure or clockwise to decrease the overall pressure.
 - B. When pressure is correct, the stripe should be between 3/32" and 1/8" across the plate.

NOTE: If shaft moves out, it creates end play in the form roller and may damage the roller drive.
3. **Changing position of the form handle.**
 - A. Loosen the two set screws (Items 3 and 5) and locate handle in proper position. Tighten the two set screws. Check the form roller stripe to be certain it has not changed.

Thank you for your continued support

Michael Pek
Technical Representative
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