

ROTATION AND TRIMMING GUIDELINES

The following is a guideline for rotation and trimming that should help in achieving maximum cover life.

1. The first rotation should take place at approximately **150,000** impressions or before if the covers appear overly worn. The first rotation should involve no trimming! Most dies do not utilize the full width of the machine so the outside covers are still new. Trimming will only destroy new covers at this point.

TIP:

Always mount the **center** covers first by lining up to the left and right of the centerline.

2. At approximately **300,000** impressions, the covers should be lightly trimmed to a level surface to remove ridges and high spots. Remember, trim only the high spots. The surface will appear to have a slight fluff after trimming, but it will be level.

3. The next rotation should take place at approximately **450,000** impressions. No trimming should take place.

4. Every additional **150,000** impressions or when they appear to need it, covers should be rotated, run, then trimmed, run, then rotated then trimmed, and so on.

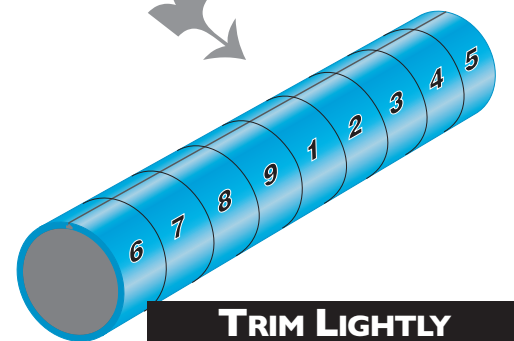
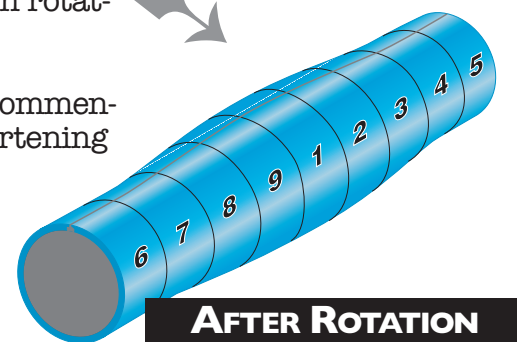
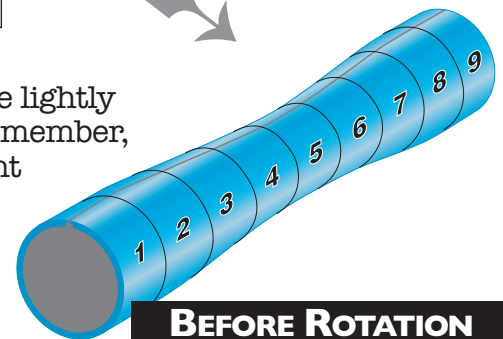
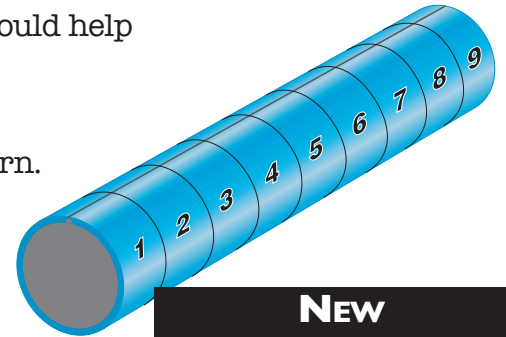
We strongly recommend that you observe manufacturer's recommendations when using a trimmer to avoid cutting too deep and shortening cover life.

TIP:

Rotation is still essential when a machine has a trimmer, especially **before** the first trim.

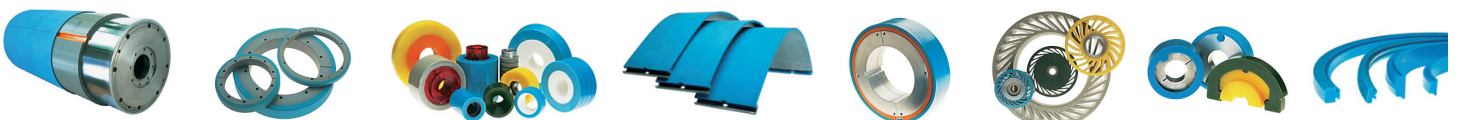
NOTE:

On machines without a trimmer, covers should be rotated every **150,000** impressions.



US & Canada Toll Free: **(800) 323-4227**

Dicar stocks and sells over 5,400 products for improving corrugated production.



10 Bloomfield Avenue, Pine Brook, New Jersey 07058 USA • (973) 575-1174 FAX (973) 575-1455 email: dicar@dicar.com or visit WWW.dicar.com

Tap-It-On and Dicar are registered trademarks of Dicar, Inc.