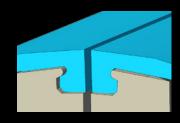
Anvilok® Cover **Installation**

Product Lines QLA, QLAW



Scan this code or visit dicar.com to watch instructional video



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Anvilatch[™] (optinal)

The unique **AnviLatch** system increases the efficiency and enhances the safety of mounting rotary diecutting blankets/covers by eliminating the need to use a mallet to lock the cover. For more information visit dicar.com.

Use only tools recommended by Dicar to remove and/ or install anvil covers. Use of improper tool may result in injury or damage to covers and/or die cylinder.

! IMPORTANT

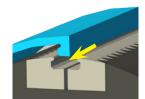
Prior to installing anvil covers inspect lockup slot for damage, sharp edges or burrs, and ensure slot is free of contaminates to ensure proper lockup.

! WARNING

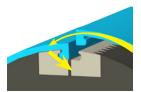
Remove cutting dies prior to removing, installing or rotating anvil covers. Failure to do so can result in personal injury and/or damage to tooling.

Installation

- Install the female end of the cover into the slot, under the lip, as shown.
 - Make sure the lock mechanism is open before beginning installation



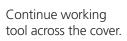
Wrap the blanket around the cylinder and align with the end already installed.



Removal

- Open the lock mechanism per machine manufacturer's instructions.
- Place Pry Tool (CVR-REM) between the cover and slot lip as shown. Pry

away from lip and then up.



• If rotating, keep blankets off of floor to prevent contamination.

! WARNING

To prevent injury, do not allow fingers to enter the nip between the die drum and anvil cylinder when rotating cylinder. Keep fingers and hands clear of lockup area when closing mechanism.

Tighten the mechanism to close the lock section, per the machine manufacturer's instructions.

Do not attempt to remove the blankets by inserting the pry tool between the blankets and the cylinder surface. Doing so can cause



damage to the blankets and/or cylinder.

Dicar offers a full range of anvil cover styles and sizes, and other urethane products.

Visit dicar.com, or contact your local Dicar Representative to view our catalog of quality Dicar diecutting and die-making products and services.

Anvil Cover Rotation Log

Shift/Crew	Impression Count	Die #	Date of Rotation or Change	Notes

Cover Storage

- It is best to keep covers stored in the original box and in the round (coiled) until the time of installation for easier mounting.
- Store at room temperature. Cold, will be stiff and more difficult to mount.
- For best performance, covers should not be stored for more than 2 years.

Trimming & Grinding Recommendations

- Dicar recommends to include a practice of cover rotation when operating a trimmer or grinder in order to distribute wear on uncut covers and maximize usable material.
- It is best to rotate at least once before trimming or grinding to avoid cutting unused material, and potentially causing grinding issues.

Sun MicroGrind® Recommendations

- Make sure the lock-up seem is fully seated and flush. Damage to the wiper blade and covers may occur if the seam is not flush.
- For new covers, run production for at least 30 40 minutes to ensure covers have fully and properly seated before attempting to grind covers.
- Follow procedures in the MicroGrind Manual for proper grinding (provide by the OEM).
- If lock-up seem does not seat after 30 40 minutes of production, a manual grind may need to be performed prior to initiating the automatic grinding system.

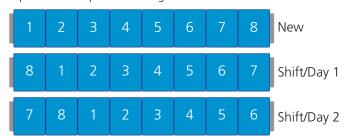
*MicroGrind is a registered trademark of Sun Automation Group

Cover Rotation

Power Rot8tion (recommended for Equamount Systems and boltless anvils) is a fast and easy way to maximize the life of your anvil covers. As illustrated below, once per shift or day,



- For Equalizers, simply remove one cover and bearing, slide the other down one space. Then reinstall the cover and bearing.
- For boltless covers, unlock all covers, leave covers in place. Remove cover from position 8 and slide the other covers down one space. Reinstall the cover removed. Secure all covers.
- Repeat rotation process throughout cover life.



Standard Rotation as illustrated below will help you maximize the life of your covers and the quality of your die-cuts. Without a trimmer covers should be rotated every 150,000 impressions.

With a trimmer covers should be rotated at 150,000 – trimmed at 300,000 – rotated at 450,000 – etc.

- Number covers as shown below
- Remove numbered covers and reinstall them in the order show below
- Repeat rotation process throughout cover life.

