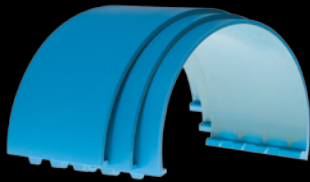


# Anvilok® Cover Installation

**Product Lines**  
**Anvilok II**  
**A2, A2R, A2W, EM**



Scan this code or visit  
[dicar.com](http://dicar.com) to watch  
instructional video



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## TOOLS



CVR-REM-2  
Pry Bar



MLT-RS4LB  
Dead Blow Mallet

## Anvilatch™ (optional)

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](http://dicar.com).

## ! CAUTION

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 contaminants 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

- 1 Insert female end
- 2 Wrap cover onto drum



- 3 Align outer edges



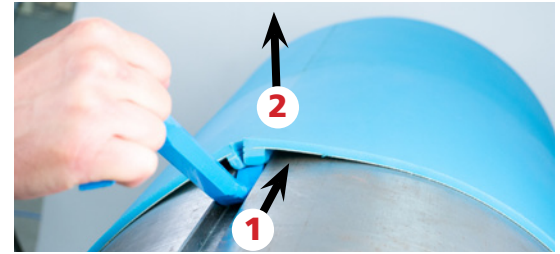
- 4 Secure by tapping the male end into the female end.



- When properly installed, the lockup area should be smooth and even with no steps.

## Removal

- 1 Insert the pry bar (CVR-REM-2) in slot beneath lockup ends.



- 2 Pry up on the male and female ends to disengage the lockup. Work your way across the cover(s) to fully disengage the lockup.

## ! CAUTION



**Do not** insert the pry bar between the cover and the anvil surface. Damage to the covers and/or anvil may occur.

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

Visit [dicar.com](http://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.

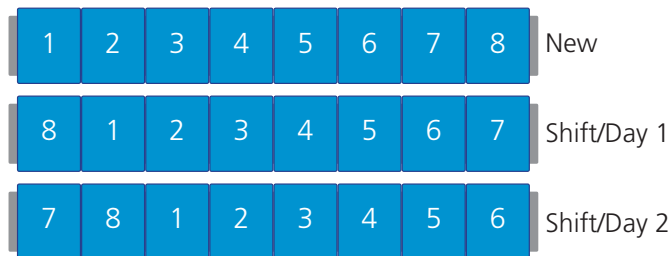
\*MicroGrind is a registered trademark of Sun Automation Group

## 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.

