

Measuring Drum Shingle Cutter Maintenance Tips

A series of practical tips from Reichel & Drews

MEASURING DRUM AND BELTS (or BLANKET)

#3

The measuring belt section controls the accuracy of the amount of sheet that is metered to the cutting cylinder. For every complete revolution of the cutting cylinder, the measuring drum and belts will allow only one shingle length of material to pass between the cutting cylinder and the anvil roll. Since the sheet is securely captured between the measuring drum and the belts, slippage is prevented, guaranteeing accurate shingle length control.

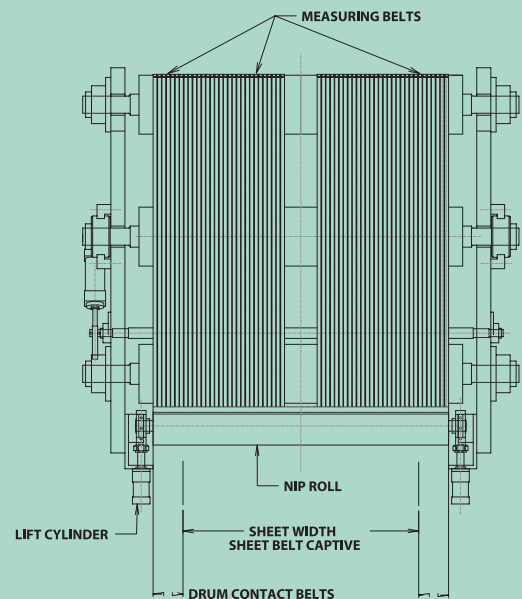
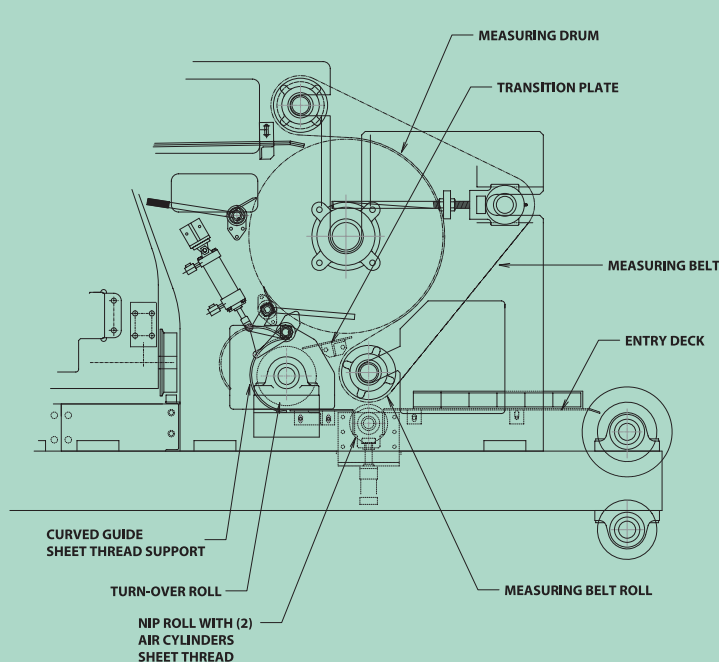
The actual amount of material that is metered is dependent on the diameter of the measuring drum, and the sprocket ratios between the drive motor, measuring drum and cutting cylinder and the theoretical cutting diameter of the shingle. Different pattern lengths require changing the cutting cylinder and measuring drum sprocket ratio and possibly the drive belt.

The measuring section consists of the measuring drum, multiple measuring belts, a tensioning roll, two belt rolls and a counter weighted roll scraper. The chrome-plated measuring drum is the driving element of this section. The two free running belt rolls and the free running tension roll are driven by the measuring belt. In turn, the measuring belt is driven by its contact with the measuring drum and the sheet that is touching the measuring drum.

Maintenance Check List:

- Tracking of the single measuring blanket and the measuring blanket's physical condition are the main maintenance concerns. Sheet taper, uneven sheet press, or misalignment of the sheet to the cutting cylinder will all require adjustment of the measuring belt for proper tracking.

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(Maintenance Check List cont)

- A minimum of 2" of the measuring blanket or two urethane belts must contact the measuring drum surface on either side of the sheet. This ensures that the sheet does not slip or "run away" on the drum face of the measuring drum.
- Measuring blanket tension should be set to prevent slipping and squealing but not so great that the belt stretches excessively. Ply separation in the belt carcass is often due to excessive belt tension or rubbing of belt edges against the framework.
- A worn measuring drum equals a change in diameter, which will affect the amount of material metered to the cutting cylinder and the length of cut shingles. Check the measuring drum face regularly for worn chrome or grooves.
- Verify that sheet tension is even across the sheet width when it exits the measuring drum.

Reichel & Drews Upgrades

- Twin "V" belts to replace the measuring blanket for greatest gripping power with increased surface area. Easy to maintain. Easy-to-replace when worn.
- Measuring drum resilient finish for accurate measurements and coefficient holding power with comparable results to hard chrome.

Stay sharp.

Contact us for questions on maintenance, check lists and tips on making your shingle cutting equipment last longer.



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