

Measuring Drum Shingle Cutter Maintenance Tips

A series of practical tips from Reichel & Drews

INSPECTION SECTION

#7

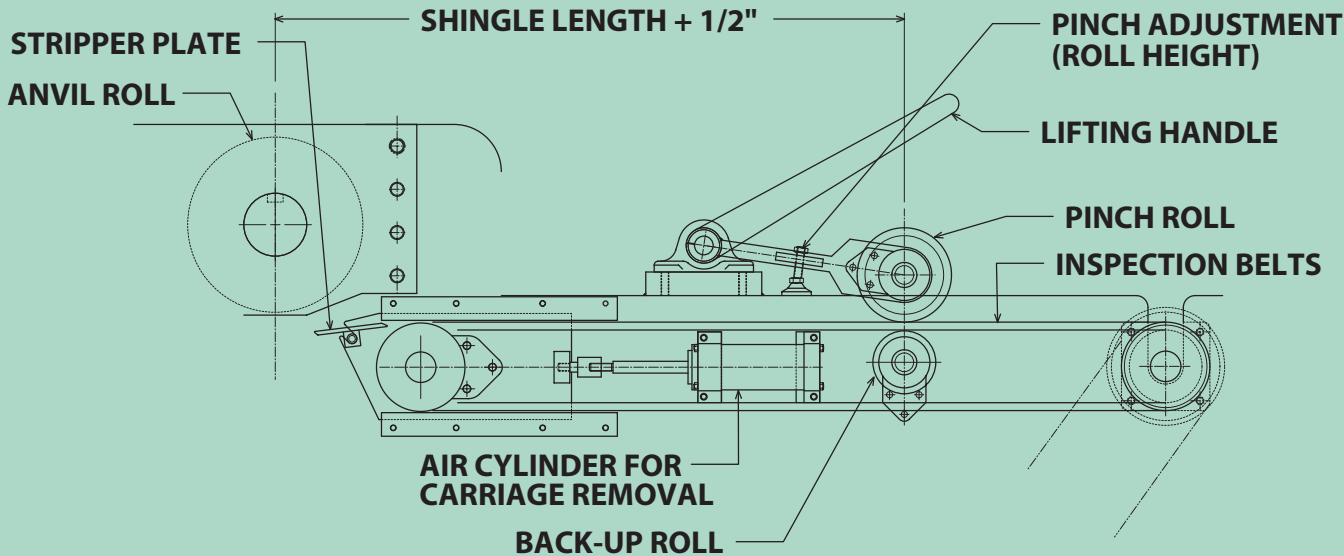
The main role of the inspection section is to separate shingles after they are cut and transport them to the overhead delivery belts of the stacking system. This is accomplished by running the belt conveyor system of the inspection section at a speed 25% faster than shingle cutter speed. To ensure separation, a pinch roll on top of the inspection belt pinches the shingles slightly just after they are cut. Once cut, the shingles accelerate to speed, pulling away from the next shingle and creating a gap. A secondary function is to provide a location where the cut shingles can be removed and inspected.

The inspection section consists of round, urethane belts on grooved urethane covered rolls at each end. A urethane covered hold-down roll and accompanying steel support roll are located one shingle length from the cutting cylinder.

The belts in the inspection section are designed to run 25% faster than the shingle cutting speed. This greater speed creates a gap between the cut shingles so that the stacking system can function properly. The pinch roll is positioned so that once the shingle cut, the roll will create contact between the inspection section belts and the shingle to ensure that the shingle travels at the conveyor speed as it enters the delivery belts to the stacker.

The tail roll of the inspection section is positioned by pneumatic cylinders to provide tension on the urethane belts. The pneumatic cylinders also allow the operator to retract the roll for access to the cutting cylinder.

(continued on back)



Maintenance Check List:

- Belts should be tightened so that there is no sag in the belts.
- Pinch Roll assembly is pivoted in case shingles get “jammed” and has adjustment leveling bolts on each side to position the height of the roll above the belts. The pinch roll has physical stops under each of the pivot arms. The stops are adjustable in height to create a fixed gap between the roll face and the conveyor belts. This gap should be set so that the roll doesn’t bounce every time a shingle passes underneath it.
- All surfaces must be kept clean of asphalt build up. Belt grooves should be periodically cleaned so even transition occurs from the stripper plate and all round belts operate at the same surface speed so shingles won't become skewed.

Reichel & Drews Upgrade

- Convert inspection head & tail rolls to urethane covered rolls and belts. Individual belts also facilitate tab fallout and minimize water transfer.
- Urethane covered pinch roll with gap adjusting stops and seal down grooves. Roll can also be slave driven from head pulley for pair chop cuts.

Stay sharp.

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



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