Technical Bulletin – E013

TOPIC:	Recommended Heated Roller Press Tapers for use with Duraseal	DATE:	03-20-06 (New)

Production Needs: *Duraseal requires less compression, and therefore a flatter taper than previous spacers from Truseal.* Regarding this subject matter, the first question to determine for users of Duraseal will be "Do you plan to run exclusively Duraseal, or do you plan to run mixed production with DecoSeal or other solid spacers from Truseal?" The chart below provides the gaps needed to achieve the resultant taper, given the product mix:

Recommended Gaps for Desired Tapers		
Duraseal Truseal spacers	Duraseal & Duralite pressing w/only	"Combined" pressing of additional *solid*
No. of roll-sets:		
*2	.030", 0	not recommended
3	.030", .015", 0	not recommended
5	.030", .020", .010", 0, 0	.075", .030", .010", 0, 0
7	.040", .030", .020", .010", 0, 0, 0	.085", .050", .030", .015", .010", 0, 0

Special Additional Recommendations for use of Duraseal/Duralite with Heated Roller Presses that contain only 2 pairs of rollers:

1. Set compression roll taper as above; as long as the exit rolls are the same gap across the 60"length of the rolls you only need to shim the top infeed roll. You do not need to remove the chain to make these adjustments.
2. Conveyor speed dial on a Besten 2-rollset unit should be set at about 4-5 which equates to approximately 2.3-3.5 fpm
3. Lamp dwell time should be set to approximately 50 sec.
4. Make sure that the units were hand pressed together prior to entering the press.
5. Exit temperature will range between 130-145F. (all lamps must be working).
6. Finished OAT should be within Truseal's airspace specification of (−0.008 and + 0.010).
7. **Units will need to cool prior to corner closing the 4th corner; Same requirement as with Bulletin IG009**