

**TOPIC:** Recommended Heated Roller  
Press Tapers for TruSeal  
Flexible Spacer System IG  
Units

**DATE:** October 29, 2001

The following heated roller press tapers for IG manufacturing recommendations are to accommodate the differences in compression requirements of different TruSeal Flexible Spacers.

**DuraSeal™ has a design compression requirement of 0.040", while Swiggle® Seal has a typical compression requirement of 0.110". Presses designed to process Swiggle® Seal from an ideal viewpoint are therefore different than a press designed for processing DuraSeal™.**

The following guide is to be used to cover what is needed for different situations, as it relates to *tapers*, or the series of gaps each roll set is shimmed to. The tapers are set by progressively shimming the roll-sets on the upper pallet, decreasing the gap towards zero as the units move forward.

Current Swiggle tapers vary by press manufacturer and actual vintage, but the following is a guide of what typically will be found for gaps:

**3-rollset: 0.077", 0.037", 0**  
**5-rollset: 0.075", 0.050", 0.025", 0, 0 or 0.087", 0.045", 0.015", 0, 0**  
**7-rollset: 0.099", 0.080", 0.056", 0.033", 0.013", 0, 0**

**Note: A three roll press can be used for production in the normal fashion, once the taper is changed (from that used for Swiggle® Seal) to that needed for DuraSeal™.**

Production Mode: If mixed production runs are planned with Swiggle® Seal and DuraSeal™. The chart below provides the gaps needed to achieve the recommended gaps and resultant taper, given the product mix:

### Recommended Gaps for Desired Tapers

No. of roll-sets	DuraSeal™ pressing only	Combined Swiggle <i>and</i> DuraSeal™ pressing
3	.026", .013", 0	Not recommended (only last roll contacts)
5	.030", .020", .010", 0, 0	.075", .030", .010", 0, 0
7	.032", .021", .013", .008", .003", 0, 0	.086", .050", .030", .013", .008", 0, 0

***DuraSeal™ requires much less compression (64% less), and a flatter taper. It is not recommended that customers' production units be run on a 2 or 3 roll set Swiggle presses, as insufficient time-under-compression will be the result.***

Conversion:

Customers with a qualified maintenance staff can consult the manufacturer on procedure, and re-shim the upper roll-sets themselves. Others may choose to use this opportunity as a general service call, perhaps coupling other items that need to be done, by calling press manufacturers such as Besten, Billco or GED for assistance.