

Fitting D0015975 Friction Roller Flowline Mk3 Toothed Gripper

Fitting the D0015975 Friction Rollers on a Flowline Mk3 Toothed Gripper outfeed

Contents

Problem

Solution

Comments

Problem

The low friction roller beds on the toothed gripper upgrade for flowlines have too little friction and allow the profile to move too far. This happens when the gripper releases the profile, the spring in the gripper nose switch fires the profile an uncontrolled distance dependent on the weight and momentum. Reducing the spring pressure on the gripper switch was unsuccessful, as the spring needs a certain amount of tension to release properly, and the friction on the rollers is almost zero.

Solution

Replace some of the rollers with a solid stainless steel shaft creates the necessary friction



Parts are supplied in R0019181 Kit: Additional Friction Rollers for Toothed Gripper Mk3

Notes

- The bolts are smaller in diameter than the holes which allows adjustment to give the correct amount of friction
- 6 replacements are provided, one should be fitted every metre
- There is no fixed positioning defined, they can be moved to suit the application
- It is a good idea to place one at the machining centre side end of the transfer table to provide a definite stop for any profiles reversing at this point - this marks the point where a bar becomes a problem to push onto the transfer table