



MAINTENANCE WORK INSTRUCTIONS

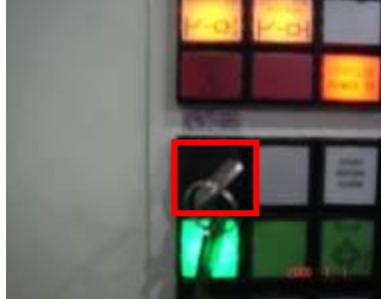
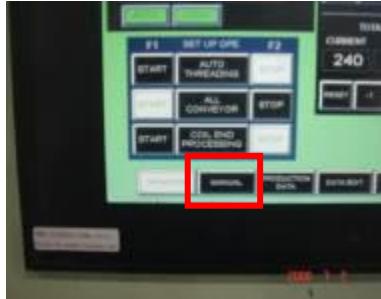
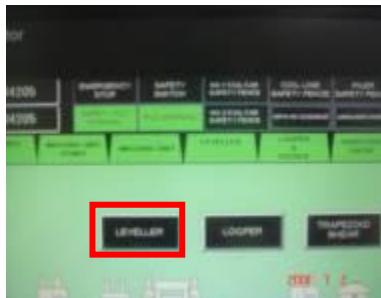
MAW93

SHEAR LINE

Rev: 01

Leveler calibration (Encoder)

Date 10/10/2024

No.	INSTRUCTIONS	KEY POINTS / CONTACTS
1	On the main operator panel, rotate the key switch to the manual position (clockwise to the right-hand position).	 <ul style="list-style-type: none">• ENSURE PERSONNAL PROTECTIVE EQUIPMENT (PPE) IS WORN IN THIS AREA: -1. HARD HAT2. STEEL CAP SHOES / BOOTS
2	Select the "Manual" option on the situation screen.	 <p>*Before starting calibration Ensure which type of Device is set to use – Refer to leveller GT2 / ENC Changeover MAW*</p>
3	Please select "Leveler" on the Manual screen.	
4	Prime the cylinders by executing the quick open function: fully extend and then retract.	 <p>Ensure that the leveler is in the fully down position and not in a midway position.</p>

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5.	Navigate to the Production Data section, then proceed to the Entry side, and record the values for Entry/Exit Work Roll Adjustment.		
6.	Adjust the values to 10.00 mm for both entry and exit work roll adjustments.		
8.	Return to the Leveler page and select "Work Roll Adjust" use the F1 key to commence adjustment.		
9.	Once the process is complete, lift the entry and exit pinch rollers and open the leveler using the quick open function.		Ensure that safety pins are properly used on both the entry and exit pinch rollers and removed when leaving the machine

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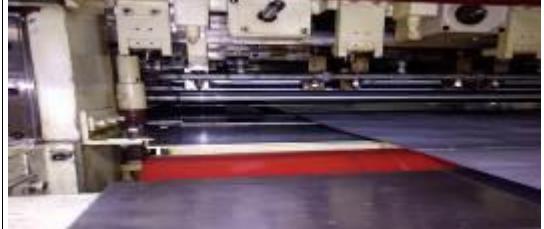
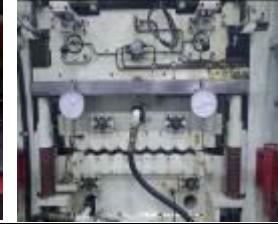
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10.	<p>Enter the machine and insert rubber mats on both sides of the leveler. Exit the machine, activate Master-on, and close the leveler. Verify that the mechanical dial gauges are set to 2 (10 mm) and adjust if necessary. Re-enter the machine and verify the measurement using a 10 mm key steel.</p>	  	<p>Remember to re-insert Safety pins when inserting Key steel. *Key steel should make Contact between 3 rollers Minimum*</p>
11.	<p>Once verification is complete, proceed to the Expansion function, scan your face, and perform a "10 mm Set." Proceed to the Production Data page, Entry Side, and restore the original values for Entry/Exit Work Roll Adjustment.</p>		<p>Remember to remove the rubber mats once verification is complete.</p>
12.	<p>Next, navigate to the Leveler page, select "Auto Work Roll Adjust," and press the F1 key. Leveler will adjust to original ADC value.</p>		

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