




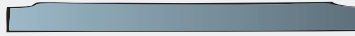




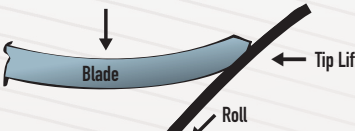


Essco Blade Wear Identification Troubleshooting

Blade Appearance and Symptoms	Probable Causes	Remedy
<p>UNEVEN WEAR – Frequent blade change</p> 	<p>A. Poor roll surface. B. Damaged or dirty blade holder. C. Deposits.</p>	<p>A. Use more flexible blade. B. Clean, repair or replace holder. C. Use abrasive blade.</p>
<p>EXCESSIVE WEAR IN CENTER OF BLADE, OR AT ENDS</p> 	<p>A. Doctor not machined to roll crown. B. Old doctor sagging into/away from roll.</p>	<p>A. Refit and shim holder to doctor back as necessary. (Return new doctor for replaning if mismatch is excessive.) B. Replace old, sagging doctor.</p>
<p>EXCESSIVE WEAR ON ONE END</p> 	<p>A. Doctor misaligned – not parallel to roll axis.</p>	<p>A. Shim, or move bearings and brackets as necessary to align doctor parallel to axis of roll.</p>
<p>EVEN WEAR BUT ROUGH EDGE</p> 	<p>A. Deposits on roll. B. Excessive pressure on blade. C. Blade material too hard.</p>	<p>A. Use abrasive blade as required. B. Reduce pressure. C. Use softer blade.</p>
<p>EXCESSIVE WEAR IN SHEET RUN</p> 	<p>A. Deposits left on roll by sheet.</p>	<p>A. Use abrasive blade as required. B. Trim blade edges frequently. C. Use end slotted blades to prevent build-up of excessive pressure on roll ends.</p>
<p>EXCESSIVE WEAR OUTSIDE SHEET</p> 	<p>A. Sheet lubricates roll.</p>	<p>A. Slot blade ends to relieve pressure.</p>
<p>LOCALIZED PITTING</p> 	<p>A. Blade attacked by (1) Electrostatic Discharge, (2) Electrolysis, (3) Heat.</p>	<p>A. Insulate doctor from machine frame or use non-metallic blade.</p>
<p>BLADE DEVELOPS FEATHERED EDGE</p> 	<p>A. Blade material too soft. B. Excessive pressure. C. Blade angle too flat.</p>	<p>A. Use harder blade. B. Reduce pressure. C. Move bearings or brackets to increase angle. Check for correct angle with gauge.</p>
<p>HOOKS ON BLADE OUTSIDE ROLL SURFACE</p> 	<p>Blade overhangs roll. A. Not centered. B. Too long. C. Not oscillating properly.</p>	<p>A. Center blade. B. Trim length. C. Adjust oscillation stroke.</p>
<p>DENT IN BLADE EDGE</p> 	<p>A. Blade caught scab on roll at start-up. (Most common on old dryers.)</p>	<p>A. Change blade and remove scab.</p>
<p>INCREASING PRESSURE INCREASES DEFLECTION</p> 	<p>A. Blade pressure changed after initial wear-in; opens blade tip to trap particles and lift blade – may cause wrap.</p>	<p>A. Reduce blade pressure or change blade.</p>

NOTE: ALWAYS INSPECT WORN BLADES FOR CLUES TO ANY PROBLEMS.



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