

**OPERATING INSTRUCTIONS
RDN EMBOSSING MACHINE
WITH AC FLUX VECTOR DRIVE**

UNCRATE AND INSPECT

This machine has been carefully crated to assure safe arrival to your plant. It is important that you immediately inspect the equipment upon arrival at your plant and report any possible damage incurred in transit to the trucker.

It is suggested that you uncrate the equipment as soon as possible so that any concealed damage may be discovered.

Compare the packing list with items received and in turn cross check the items with your purchase order and report any discrepancies immediately to RDN MFG. CO., INC. at the address or phone number listed above.

DESCRIPTION

The embossing machines are designed for mounting embossing rolls for applying a textured surface to plastic sheet and profiles. The lower shafts are driven by a AC Flux Vector variable speed control and motor. The operator speed reference is a ten turn potentiometer. Standard machines have manually adjusted threaded rods for positioning the upper rolls. For machines equipped with pneumatic operation, the rolls are opened and closed with pneumatic cylinders. The roll gap is adjusted by means of threaded stops when pneumatic operation is included.

START-UP PREPARATION

The machine should be aligned with other extrusion equipment in the line and adjusted to the proper center line height with the threaded jack screws.

The machine is regarded as portable and therefore, it is not equipped with a fused disconnect switch. If your local electrical code requires a fused disconnect, we suggest you provide one on a wall conveniently located in relation to the equipment. The embosser is supplied with a twist lock plug and should be plugged into a properly grounded socket.

Make sure that the equipment is properly wired for the voltage, phase and cycle supplied at your plant. Should there be any questions regarding the electrical connection, do not hesitate to contact us.

The air supply line to the embosser should be 1/2" diameter. Supply pressure should be 80-100 psi. The air pressure regulator should be set to 60-80 psi.

OPERATION

Adjustment of the roll clearance is controlled by handwheels for machines designed for manual roll opening and closing. For machines equipped with pneumatic operation, an Open-Close selector switch is provided to actuate pneumatic cylinders for opening and closing the rolls. Threaded adjustments are provided to set the roll gap when they are closed. Also an adjustable pressure regulator with gauge is provided for each of the top rolls to adjust the closing force of the rolls.

CAUTION - When setting the gap between the rolls, be sure to set the regulators as low as possible. After closing the rolls and adjusting the gap, increase air pressure slowly to the desired PSI.

MAINTENANCE AND LUBRICATION

- This machine was designed for continuous operation with a minimum amount of maintenance. Keep the machine cleaned and lubricated, and it will remain in good working condition.
- Facilities should be made to remove water from the extrudate before it reaches the embosser if it is positioned downstream of the water cooling tank. Water will corrode the machine and reduce its useful life. Also, water on the rolls may cause distorted embossing patterns.
- Keep a coating of light oil on all shafting.

- Grease all bearings and fittings with No. 2 Lithium base ball bearing grease every 4 - 6 weeks.
- Place a light coat of grease on the upper roll guides weekly.
- Place a few drops of oil on the roller chain each week.

Note: AC vector and AC Servo motors are designed to run hot. It is not uncommon for the motor temperature to reach 180-200f, depending upon ambient temp.