

equal to the paper caliper should be maintained between the contact screw and the electrical contact. With heavy board, this gap should be only about half the thickness of the board. After setting, the following check-up of the double-sheet detector should be made: run the paper through the machine without printing and introduce an extra strip of the stock in use into the detector. This should stop the feeder.

cleaned more or less frequently depending on the paper quality in use. The control valves for suction and air-blast must be easy to adjust. During cleaning of the drop sucker, care must be taken not to oil the gliding surfaces of the plunger and the cylinder. As much air indraft as possible should be used when operating, so that the sheets are caught by the sucker immediately on contact. This ensures clean separation and avoidance of double sheets.

The sheet is transferred by the two forwarding suckers to the two transport rollers. When the paper is released from the transport suckers it must already be held by the rollers. At approximately the same moment, double-sheet checking occurs. An exact setting of the checking device is absolutely necessary in order to avoid subsequent machine stoppages. Depending on the sheet size, two or more sheets lie under the detector roller at a time. The roller must therefore be reset for different sizes of the same paper stock. A gap

Fig. 6.: Double-sheet detection

