

## PLATING

### Preparing Plates

Full width plates should be cut to 36-1/4 inches long by  $23^{+0.0}_{-1/32}$  inches. Be sure edges are square and mark a center line on the tail end.

### Bending Plates

See the U-S-C Plate Bender Manual for plate bending instructions.

### Preparing and Installing Plate Packing

Correct thickness of plate plus packing is 0.014 inch. If thinner plates are used they must be packed to bring the total thickness to 0.014 inch. Any type of packing material can be used although Mylar packing is recommended because it will not swell if wet by the dampener solution.

1. Cut the packing to the size shown in Figure 13. Cut all edges square and mark the center line.
2. Make a 3/4 inch bend parallel to the tail end. This bend may be made in the plate bender.
3. Inch the press around until the plate cylinder opening is accessible.
4. Turn the adjusting screw on the bottom of the block on both ends of the plate cylinder until the packing can be inserted under the tail bar as shown in Figure 14.

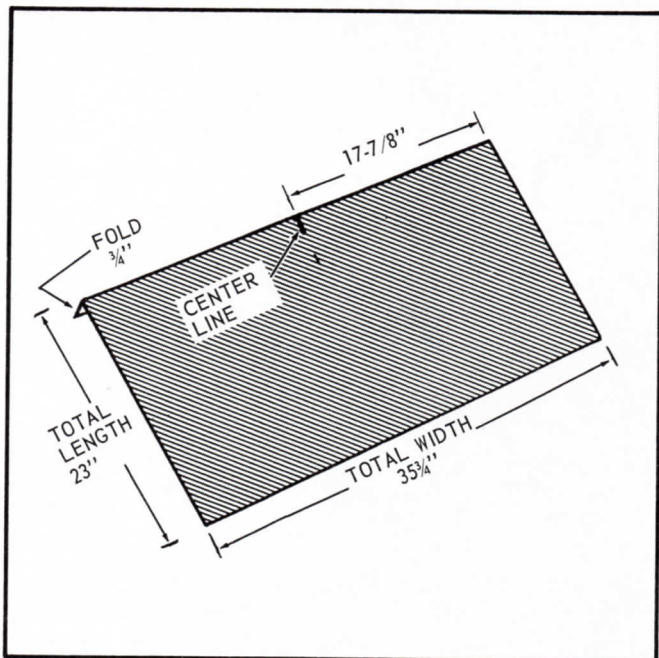


Figure 13

PLATE PACKING

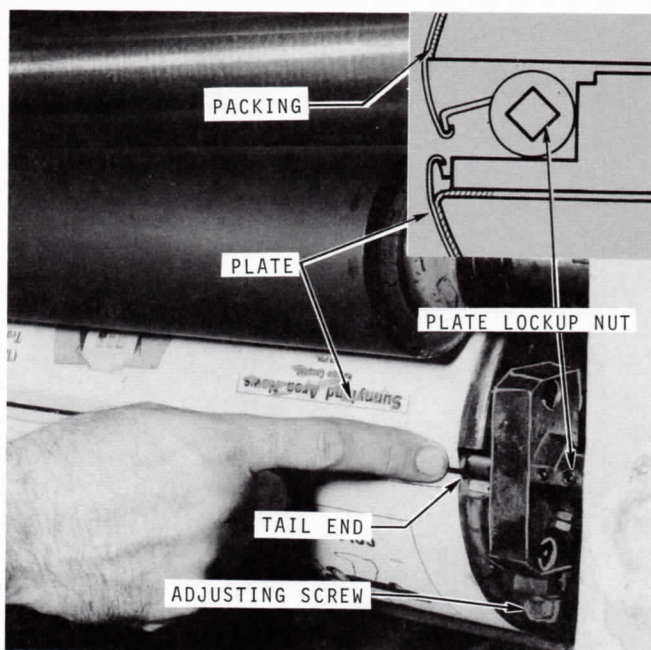


Figure 14

INSTALLING PLATES

5. Tuck the tail end of the packing into the open slot under the lockup bar and line up the center line of the packing with the cylinder register mark. Tighten the adjusting screws.

6. Inch the press until the cylinder slot comes up again. Pull the packing tight around the cylinder and trim the end of the packing flush with the head edge of the slot. The cylinder is now in position to install the plate.

### Installing Plates (Fig. 14)

1. Throw the unit on impression.
2. Open the plate lockup. Hook the tail end of the plate on the tail bar. Align the centerline on the plate with the marked line on the block in the center of the slot. Carefully check that the tail end of the plate is hooked on the bar over its full length.
3. Inch the press around until the opening in the cylinder is again accessible.
4. Open the plate lockup springs by raising the wrench on the plate lockup nut at either end of the plate cylinder.
5. Remove the wrench and inch the press around one full revolution. The lockup automatically locks as the cylinder rotates. Check that the head end of the plate is gripped firmly and the plate is tight on the cylinder. The mounted plate is shown in Figure 14.
6. Throw the unit off impression.

### Removing Plates

1. Throw the unit off impression.
2. Inch the press until the opening in the cylinder is accessible. Open the plate lockup spring by moving the wrench upwards on the lockup nut at either end of the cylinder.

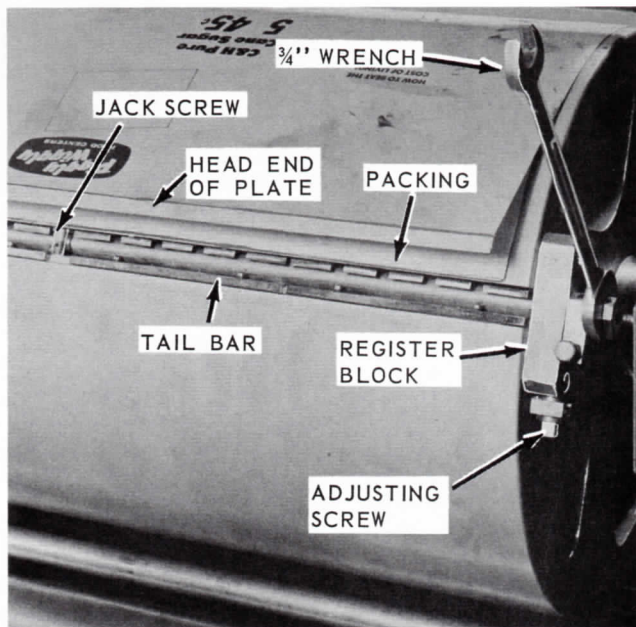


Figure 16 INSTALLING A PLATE