



## PROCEDURE FOR FITTING A TEFLON\* SLEEVE TO A DRYING CYLINDER

### Step 1

All necessary preparations must be made by the Mill to provide all the facilities required by Holscot Engineers to ensure a quick and successful installation. ( A separate sheet detailing those requirements will be issued at the time of ordering )

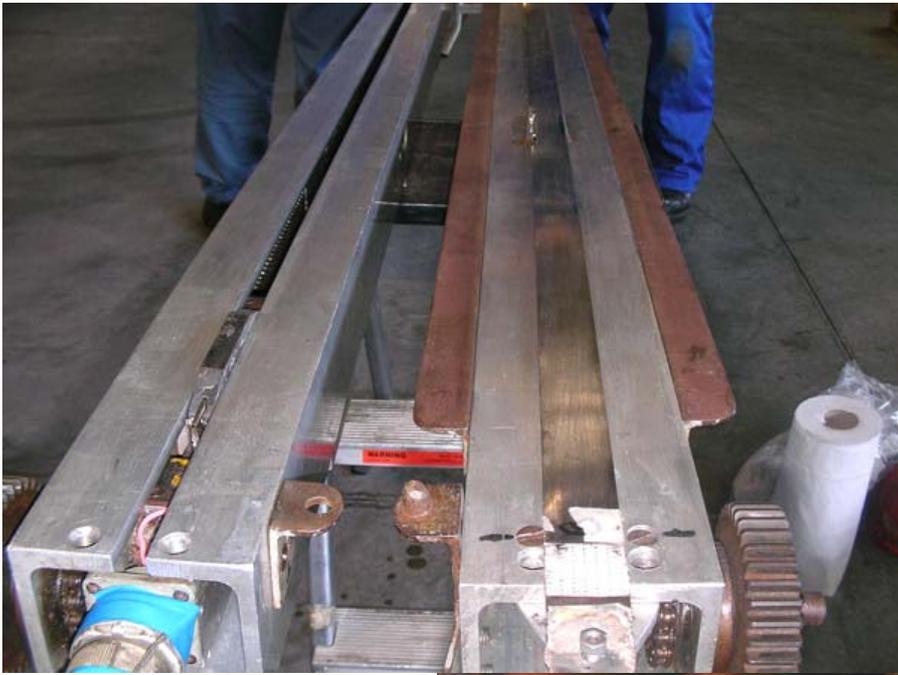
The Cylinder must be thoroughly cleaned by the Mill. All residual build up must be removed and the steelwork returned to a bright metal finish. Any previous coating treatments such as Teflon\*, Plasma or Chrome, must be completely removed by grinding.

The cylinder must be cool. Steam must be available to be introduced to the cylinder individually and the cylinder must be able to be rotated slowly and individually.

### Step 2

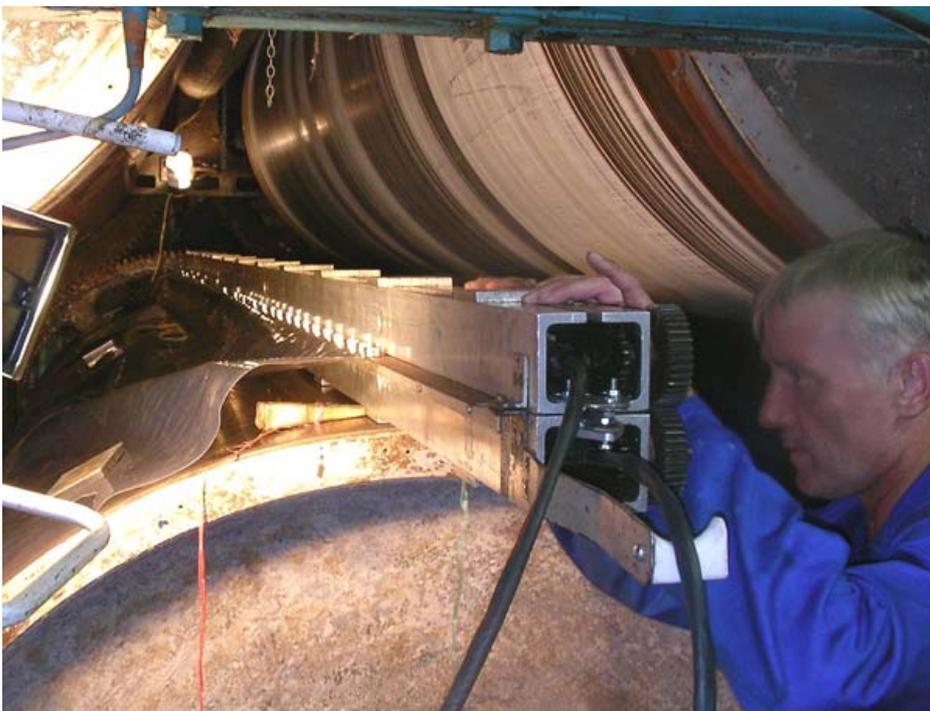
Sleeve is positioned on the cylinder – retained in position by strong magnets





### **Step 3**

The two parts of the Welding Machine are brought in and positioned



### **Step 4**

The sleeve is welded. Dependent on the length of the cylinder and the length of the beams, there may have to be a number of welding operations.

### **Step 5**

Once welding is complete, steam should be introduced into the cylinder in a controlled manner to elevate the surface temperature to 60 deg C. At that point shrinking of the sleeve will take place.



### **Step 6**

Adhesive is injected under the sleeve and spread using rubber pads





### **Step 7**

The steam is let into the cylinder to its highest temperature in order to cure the adhesive. The cylinder must continue to be rotated while this happens.

The whole installation procedure takes around 8 – 12 hours dependent on the size of the cylinder.

A successful installation relies on the cooperation of the Mill in providing all necessary facilities such as lighting, power and steam.

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*\* Teflon is the registered Trade Name of Du Pont de Nemours*