



Quik Lining Systems Calibration Roller Owners Guide

Quik Lining Systems, Inc. calibration roller fills the need to calibrate the CIPP liner material to the design specification needed for the liner. The roller is easy to operate and maintain with a few simple steps to keep it tuned and ready. The unit can be used independently from the insertion method of the liner into the host pipe, or can be set up to automate the process by feeding calibrated liner directly into a continuous feed gun such as the Quik Shot™.

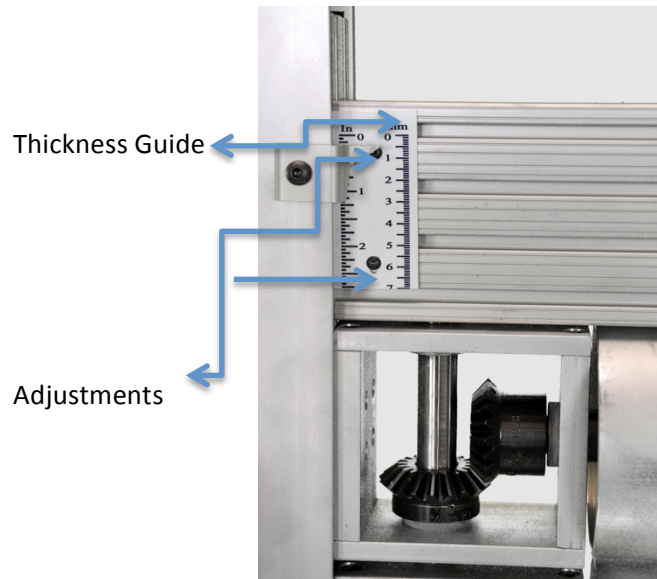


The Calibration Roller is aluminum with steel gears designed to maintain alignment, however, normal operation and transportation can cause misalignment. This guide will help you through standard maintenance practices to keep your unit fresh and fully functional.



Prior to heading to the field, the unit should be inspected to insure that all moving parts are moving. A best practice would be to have a designated location to store the unit and a designated location to transport the unit to the jobsite. Trouble usually follows when an unsecured roller rolls around in a trailer or van, breaking handles and parts from sliding around.

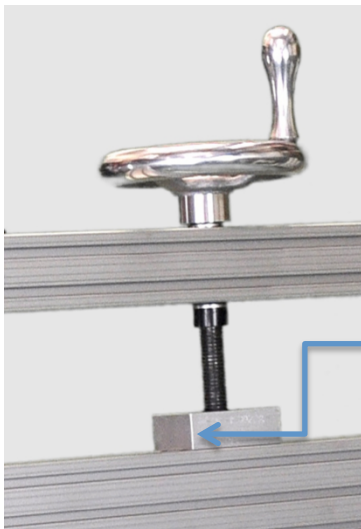
Once on the jobsite, prior to “wet out”, the roller guide should be calibrated by the operator. The unit has a guide that tells the spacing of the rollers in inches and millimeters. That guide is to be maintained as transporting and handling may move the thickness so that the reading at Guide is different than the actual measurement. A mechanical fixed thickness bar provided should be placed between the two rollers. Once the bar is placed between the rollers, move the rollers to pinch the bar and hold. Observe the Thickness Guide. If the Guide is not showing the same measurement that is the actual thickness of the bar, adjust the guide to match the bar. Slide the bar the full width of the rollers. If the bar maintains the same spacing the full width, you are set to go. If not, see Squaring The Roller below.



After finishing the “wet out” process, be sure to clean the roller, removing any resin left on the roller. Resin build up on the roller will cause variations in thickness due to the resin on the roller. Resin left on the gears will cause the gears to bind and not move over time. After cleaning, stow the roller in the space you’ve designated.

Squaring The Roller

There are 3 adjustment planes for the roller. The first adjustment adjusts the top roller to be lined up with the lower roller. The process requires you to loosen four screws $\frac{1}{2}$ turn counterclockwise. This will allow the roller to move left or right. Once aligned, retighten the 4 screws



Location of four screws

Adjustment Block to Square the Rollers to Parallel

The second adjustment allows for adjusting the squaring up of the bottom to top roller so that both ends of the rollers are plumb with each other. There are two set screws located on the bottom roller gear. Both screws need loosening by turning each set screw $\frac{1}{2}$ turn. This allows the bottom roller to be squared with the top roller. Use a rubber mallet to move the roller left or right as needed.

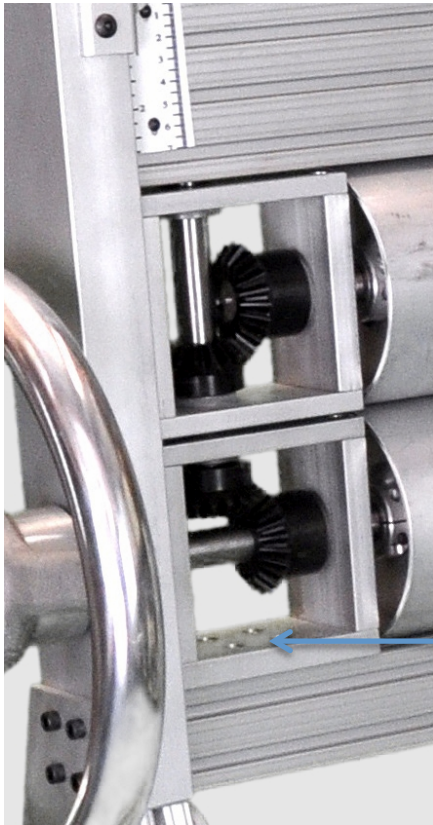


Location of set screws 90 degree from each other

Adjustment of rollers side to side



The third adjustment allows for adjusting the vertical shaft that adjusts both rollers left or right. If the rollers are rubbing against the edge of the frame, this adjustment will allow for centering both rollers to the frame. Again, turn each screws $\frac{1}{2}$ turn only counterclockwise. This adjusts the vertical shaft pictured either left or right.



Location of 4 screws

Be sure to turn the screws no more than $\frac{1}{2}$ turn. Further turning may allow the clip nut to fall into the rail, and the entire roller will need to be disassembled to retrieve the clips and reinstall them.

Final Notes

The gears are machined to allow for play in the gears to prevent binding. Pushing the gears too close together will cause the unit to bind.

Keeping the unit clean and free of debris will insure years of trouble free service.

The final adjustment of the unit involves the pivot point for the folding legs. Over tightening the bolts that attach the pivot arm to the frame needs to be loose enough that the whole bolt and nut turn in the holes. (See On Next Page)



Quik-Lining Systems



Location of the pivot bolts each side

For technical support, contact your qualified distributor

