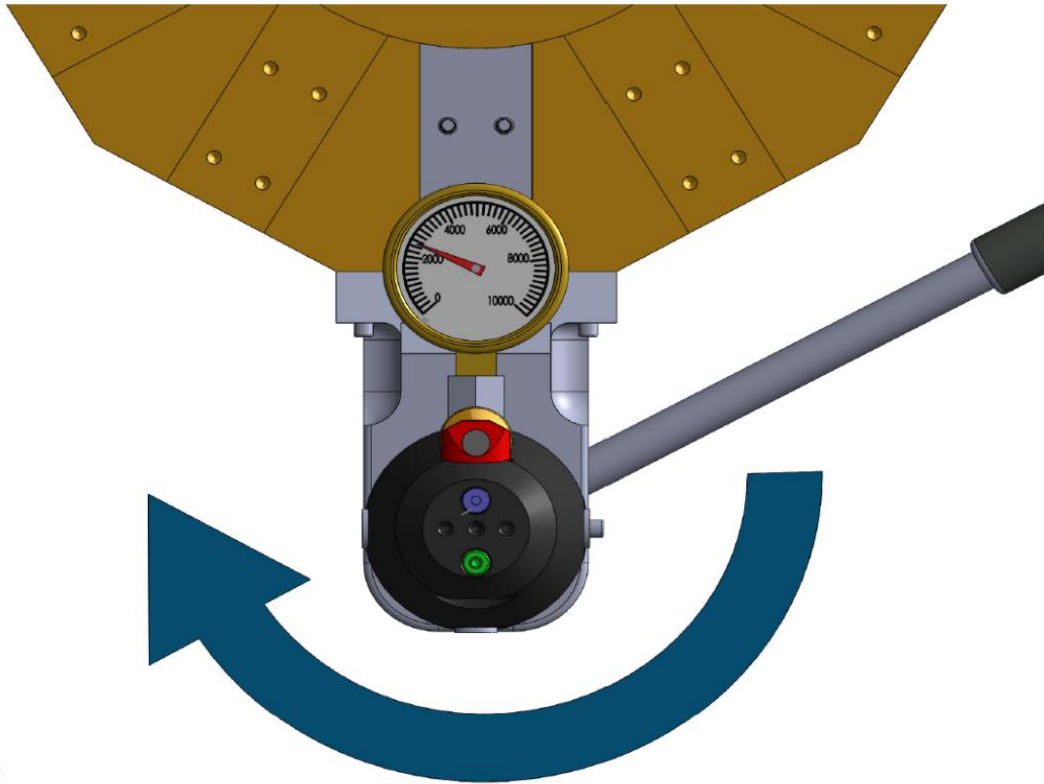


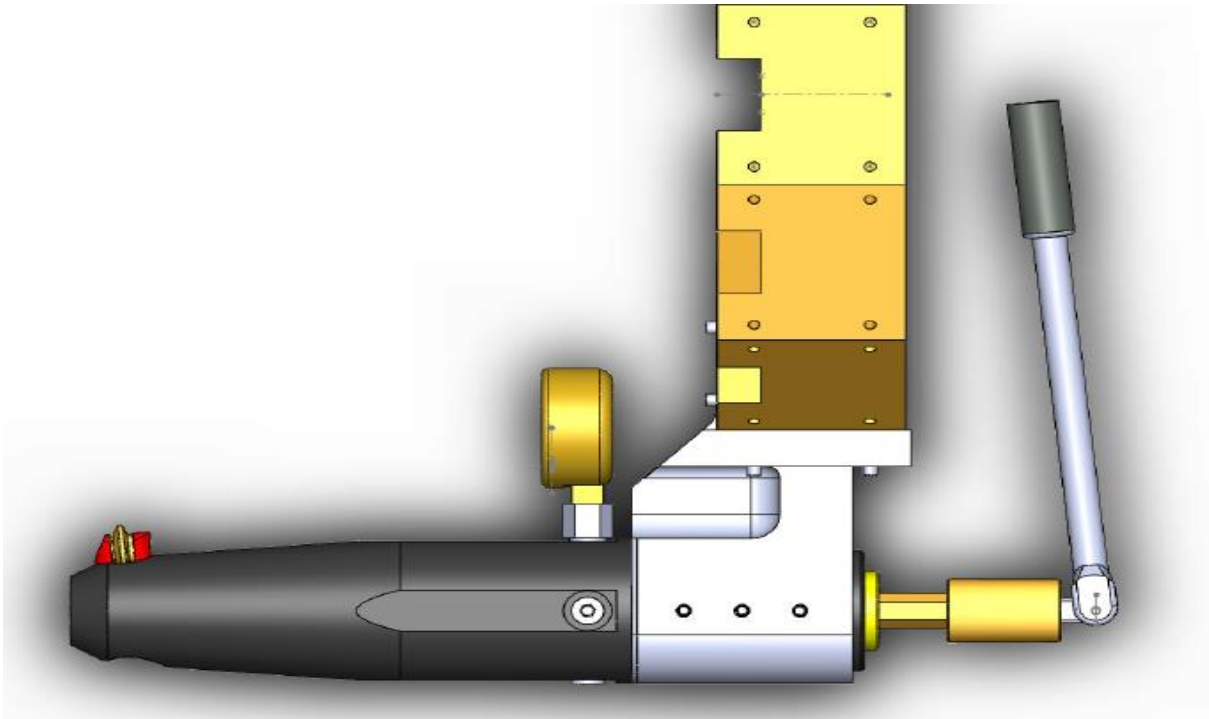
## Instructions for Pre-Loading Pressure on Cold Roll Tools

1. Insert tool into the lathe turret or tool post and secure it in the correct orientation
2. You must pre-charge your tool pressure to 95% of the required roller force before use; The required roller force can be found under pin or box pressure value in the connection type table of the CJ Winter cold rolling instruction manual
3. Take the required roller force value and multiply it by a factor of 0.95 to get the pre-charge pressure; example calculations below
  - **NC50 11070 Box Connection (1<sup>st</sup> & 2<sup>nd</sup> Figure):**  
Required Roller Force =2700 PSI       $2700 \times 0.95 = \underline{2,565 \text{ PSI}}$
  - **NC50 11072 Pin Connection( 3<sup>rd</sup> & 4<sup>th</sup> Figure)**  
Required Roller Force =2025 PSI       $2025 \times 0.95 = \underline{1,923 \text{ PSI}}$
4. Attach the given Allen socket to a half inch socket wrench
5. Insert Allen Socket into the course adjustment screw to pre-charge the tool; It is located on the opposite end of the tool as the roller (This also happens to be the largest screw on the tool)
6. Turn wrench clockwise slowly as shown in the picture below until the gauge reads the correct pressure.
7. Your tool is now Pre-Charged and ready for use

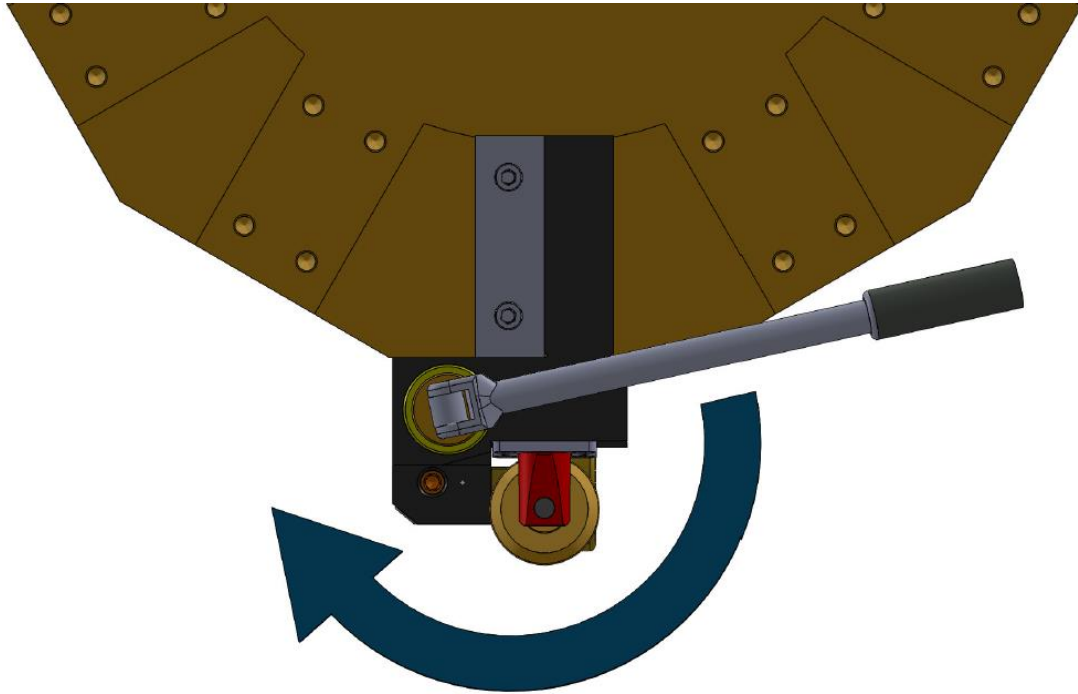
**Figure 1). Front View** (11070 NC50 box connection)



**Figure 2). Side View** (11070 NC50 box connection)



**Figure 3). Front View** (11072 NC50 pin connection)



**Figure 4). Side View** (11072 NC50 pin connection)

