

FINAL MILL CONDITION CHECK LIST

FINAL INTEGRITY CHECK OF YOUR MILL, PRIOR TO ALIGNMENT SERVICE

PURPOSE:

The purpose is to insure that your mill is mechanically sound and ready for our alignment services. Even if you have had a tube mill evaluation done by **ROLL-KRAFT** in the past, this serves as a final check list, informing us that the repairs have been made.

BENEFIT:

You, the customer, will save time and money. As a result of going through this check list, you can insure a more efficient and effective mill alignment. This will assist in allowing your alignment to be performed as scheduled.

CHECK LIST:

Please Initial

- _____ **IS THE O.D. OF THE DRIVEN SHAFTS WITHIN TOLERANCE?** Industry standard, .001" per 1.000" diameter of shaft. Example: If you have a 2.000" O.D. driven shaft, the maximum undersize before needing replacement would be .002" undersize.
- _____ **ARE ALL THE DRIVEN SHAFTS CHECKED FOR RUN OUT? (BENT)** Same standard applies to this area as it did to the O.D. check. Example: If you had the same size shaft, 2.000" O.D. and the run out in the center of the shaft exceeds .002", the shaft has to be replaced.
- _____ **ARE ALL BEARINGS ON ALL DRIVEN SHAFTS TIGHT AND WITHIN THEIR RESPECTIVE BEARING BLOCKS? ARE THESE BEARINGS PROPERLY PRELOADED? NO END PLAY SHOULD EXIST.**
- _____ **ARE ALL INBOARD DRIVEN SHAFT BEARING BLOCKS TIGHT TO THE INBOARD STAND? NO END PLAY SHOULD EXIST.**
- _____ **ARE ALL OUTBOARD STANDS IN GOOD REPAIR?**
- _____ **ARE ALL SIDE ROLL BOXES IN GOOD REPAIR?**
- _____ **IS THE WELD BOX IN GOOD REPAIR?**

(OVER)

_____ **IS THE TURKS HEAD UNIT IN GOOD REPAIR?**

_____ **IS THE MILL CLEAN FOR THE ALIGNMENT?**

MILL SHOULD BE EMPTY, (NO TOOLING INSTALLED), WITH THE EXCEPTION OF THE WELD ROLLS AND CUTOFF JAWS.

ALL KEYS TO BE REMOVED FROM THE KEYWAY ON THE DRIVEN SHAFTS.

This represents the primary areas of concern to insure that your mill is ready for alignment.

*The optical alignment equipment is capable of setting the shaft shoulders within .001” of each other. Whatever clearance you allow in these units should be done with this factor in mind.

For example, if you allow .010” of play, the best alignment would result in a variable of .011”. In short, the tighter the integrity of the components, the better the result of the alignment. If you have any further questions regarding the integrity of any component of your mill, please call **ROLL-KRAFT**.

SIGNATURE OF ACCEPTANCE

This is to certify that all areas listed above are in order and the mill is ready for the scheduled alignment.

It is also understood that if **ROLL-KRAFT** technicians find the mill in disrepair upon their arrival to perform the alignment, it may become necessary to reschedule the alignment. However, per day charges and expenses will be incurred regardless.

If you have not had a tube mill evaluation, our technicians can perform this service before they leave. If you have had an evaluation, and the repairs were still not done according to the evaluation report, the technicians will provide you with another report.

PLEASE BE ADVISED THAT ROLL-KRAFT TECHNICIANS WILL NOT BE DISPATCHED TO YOUR PLANT FOR YOUR ALIGNMENT UNLESS THIS FORM IS SIGNED AND RETURNED, PRIOR TO YOUR SCHEDULED DATE.

Company: _____

Signature: _____ **Date:** _____

Printed Name: _____

(PLEASE FAX BACK TO: 1-402-786-2609)