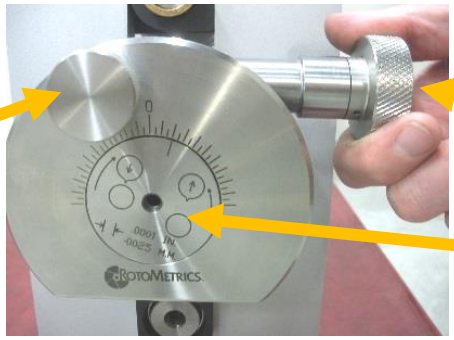
Adjustable Clearance Anvil (ACA) Installation

1. Unpack all parts and place on work table. Refer to attached assembly drawing to verify that all required components are provided. If any components are missing, please contact RotoMetrics prior to installation.

   Familiarize yourself with the control mechanism below:



2. Remove existing die station components (including the bridge, truck, and die) and anvil from the die station where the ACA will be installed.

3. Review ACA assembly drawing to determine if a new support roll is required for this installation. If a new support roll is required, remove existing press support roll.
   (Note: some press manufacturers require their representative be on-site to perform removal of support role).

   Install support roll with gear in proper location and approximately .005” to .015” (.127 - .381mm) endplay (front to back movement).

4. Install bearer wiper assembly with bearer wipers aligned with support roll bearers. See “Bearer Wiper Instructions” for further explanation.

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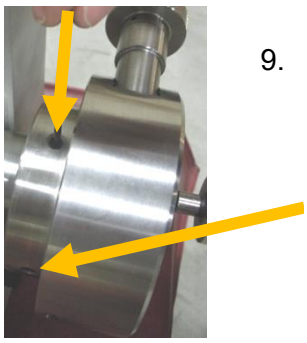
5. Locate anvil mounting blocks and slide up and down in the die slots to verify that they fit into the die slots properly.

6. Lubricate needle bearings in ACA mounting blocks with standard bearing grease. This is only done once as the shaft doesn't turn unless you make a clearance adjustment.

7. Refer to assembly drawing to determine how the anvil is secured in the press frame. Install washers and/or Ruland collars and rear mounting block on anvil journal per assembly drawing. (ACA anvil should not be installed in die station yet)

8. Remove the face plate on the control mechanism by unscrewing the locking knob from the block and installing in the center threads of the face plate. Pull on the locking knob to remove the face plate. Install the locking knob back into its original position, but do not tighten all the way.

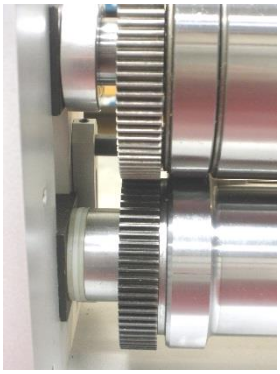


9. There are 4 clearance holes in the ACA adjustment block. Position the block by turning the adjustment knob to access the 4 set screws that are used to tighten block to the ACA mandrel.

* Arrows point to the clearance holes (2 more holes exist opposite of these)

Scribe mark in journal

10. With one of the scribe marks (it looks like an "**I**") on the end of the journal facing up at 12 o'clock, slide the front bearing block over the journal and lightly tighten the 12 o'clock set screw on to the flat. The block will still slide on the journal, but will hold the position on the flat.



11. Install the ACA into the die station and adjust the roll's alignment to the support roll underneath it, making sure the bearers and the gears are all in a parallel position to each other. If Ruland collars were used, tighten them.

12. Evenly snug all 4 set screws against the shaft and then firmly tighten all 4 set screws.

13. While looking through the adjustment block access hole at the journal, rotate the adjustment knob until the “0” mark on the journal is facing the die position.

“0” mark on journal. Needs to face die position. Die would be directly above the anvil in this example.

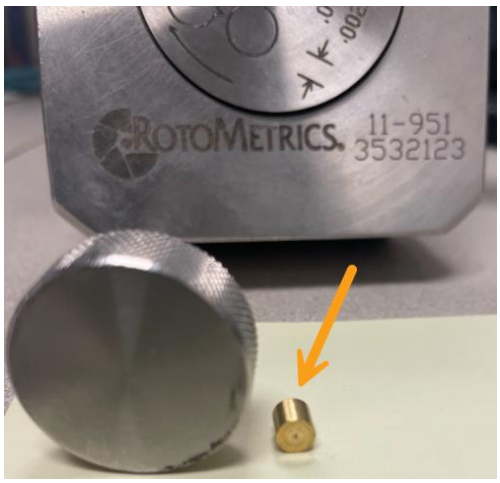
Scribe mark on journal

Reinsert the face plate on the control mechanism with the center mark aligned with the “0” mark on the block (as seen in picture to the right).

Center mark on face plate is aligned with the “0” on the block

14. Adjust bearer wipers so they wipe the anvil and support rolls. Wipers are stationary and should not turn.

CAUTION: Ensure the brass tip spacer remains behind the Adjustment knob assembly when removing the faceplate. The spacer is required for operation of the ACA.



Steps 15-22 Refer to the Operation and Adjustment of the ACA

15. Load the die into the slot and verify that the die bearers are directly over the ACA anvil bearers. Install truck, bridge and pressure gauges. Pressure gauges must be used with ACA.

16. Load material into press for which the die is tooled

17. Increase the gap between the die and ACA by turning the adjustment knob two (2) counter clockwise rotations.

18. Apply pressure to die according to the chart below:

Press Width	PSI per Side
6"-7"	450
10"	700
13"	800
16"	900
greater than 16”	1000

(Note: Some materials or shapes may require additional pressure to keep dies from bouncing. Pressure per side can vary up to 100 psi.)

19. Run some material and perform an ink stain test. Adjusting the knob clockwise will increase the depth of cut and counter clockwise will decrease the depth of cut.
    (Note: ACA can be adjusted while press is running)

20. Continue to run material making several different adjustments both cutting deeper and lighter. Stain samples to verify that the ACA is adjusting properly.

21. Locking knob can be fully tightened when desired depth of cut is achieved.

22. During normal operation of press, keep the die pressure the same as starting pressure. Regulate and maintain cutting depth with the ACA unit.

Maintenance and Care:

1. **If the ACA is in the die station and not going to be used while the press is running, it needs to have 200 lbs. of pressure per side applied to it in order to keep the bearers turning on top of the support roll. Without sufficient pressure, the ACA bearers will be stationary while the support roll turns against them. This leads to uneven bearer wear**.
2. Keep bearers and gear properly lubricated.
3. Keep bearers, body and gear free of dirt and debris.
4. Keep bearer wipers clean, rotate once a month and replace once a year.
5. When not in use, lightly lubricate body.
6. **Disclaimer: The ACA anvil is not to be used for metal to metal** converting (cutting through the material). Warranty does not apply in case of improper use.

Warranty

RotoMetrics warrants that the Product is free from defects in material and workmanship when used properly and normally for a period of one year from the date of receipt. Should any failure to conform to the above warranty appear within said one year period, RotoMetrics agrees, at its option and at its expense, either to repair or replace the defective Product, **provided that** within ten (10) days of the time when Customer discovers or should have discovered the defect: (a) Customer gives RotoMetrics written notice of the defect to the Product and RotoMetrics is given a reasonable opportunity after receiving the notice to examine the Product; (b) Customer (if requested to do so by RotoMetrics) returns the Product to RotoMetrics at RotoMetrics' cost and expense for the examination to occur; and (c) RotoMetrics reasonably verifies Customer's claim that the Product is defective. **THE FOREGOING IS A REPLACEMENT-ONLY WARRANTY AND SHALL NOT APPLY TO DAMAGE OR DEFECTS IN THE PRODUCT CAUSED BY ORDINARY WEAR AND TEAR, MISUSE, IMPROPER INSTALLATION, IMPROPER STORAGE, FAILURE TO MAINTAIN, ALTERATIONS OR REPAIRS, NEGLIGENCE, ACCIDENT, OR ANY EVENT NOT DIRECTLY RELATED TO THE OPERATION OR USE OF THE PRODUCT. THIS WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES WHETHER WRITTEN, ORAL, EXPRESS OR IMPLIED (INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE). THE REMEDIES UNDER THIS WARRANTY ARE EXCLUSIVE, AND ROTOMETRICS NEITHER ASSUMES NOR AUTHORIZES ANYONE TO ASSUME FOR IT ANY OTHER OBLIGATION.**

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Appendices, References & Attachments	None	
Revision No.	**Text Affected/Changes**	**Revision Date**
1	Added into CPRO. Previous number was EIN0311ACA. Updated using the current format/standard. Line 12 and 14 were re-worded.	
2	Remove Denmark from footer, and revise step 17 Also add pressure table for dies without crossblades.	
3	Added disclaimer to the Maintenance and Care section.	
4	Full revision. Re-ordered steps, added new pictures, revised wording per Tech Support.	
5	Added note under Maintenance and Care if press runs without adjustable anvil that there still needs to be pressure on anvil	
6	Add note after step 14 to ensure spacer is behind knob assy	Mar-19-2026