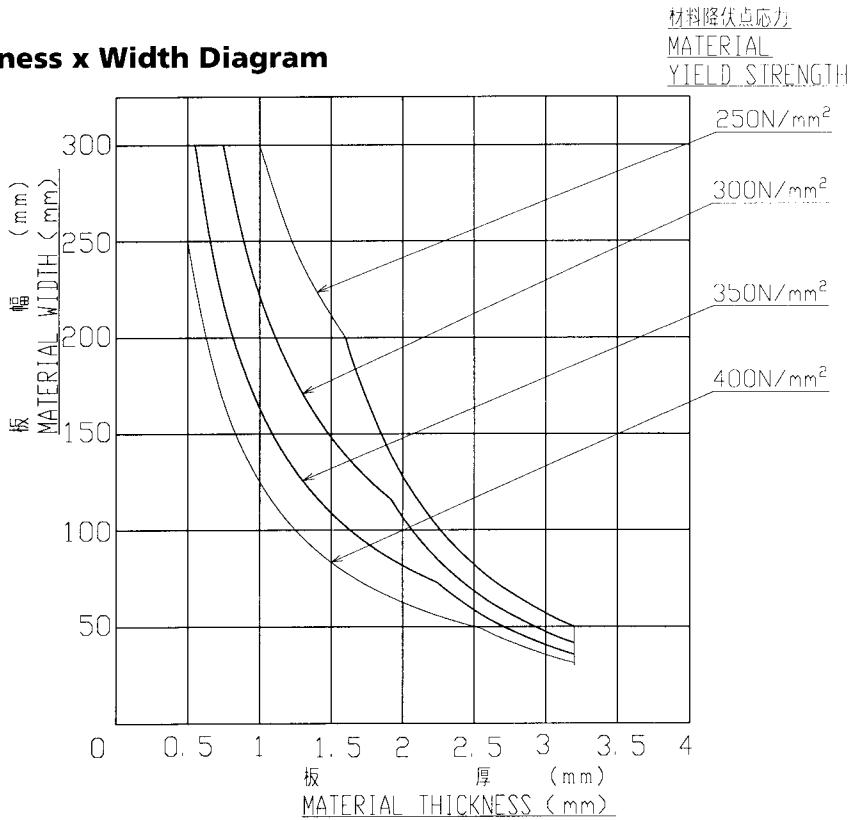


**AIDA**

## ACCESS L-SERIES

### NC STRAIGHTENER UNCOILER

**Material Thickness x Width Diagram**



**Work Roll Adjustment Chart**

WORK ROLL ADJUSTMENT					
MATERIAL THICKNESS (mm)	ADJUSTMENT OF WORK ROLL FOR FEED-IN				ADJUSTMENT OF WORK ROLL FOR FEED-OUT (REFERENCE VALUE)
	MATERIAL YIELD STRENGTH(N/mm²)				
	250	300	350	400	
0.3	9966.5	9959.2	-	-	0003.0
0.5	9983.1	9978.7	9974.3	9969.9	0005.0
0.8	9994.3	9991.6	9988.8	9986.1	0008.0
1.0	9999.0	9996.9	9994.7	9992.5	0010.0
1.2	0002.9	0001.0	9999.2	9997.4	0012.0
1.6	0009.2	0007.8	0006.4	0005.0	0016.0
2.3	0018.2	0017.3	0016.3	0015.4	0023.0
3.2	0028.6	0027.9	0027.2	0026.5	0032.0

NOTES

1. Select the value of adjustment of work roll for feed-in given in this table and appropriate to the thickness and yield strength of the material. Adjust work roll for feed-out so that the material is straightened.
2. For limitation of material thickness, width, and yield strength, refer to the instruction manual. (Ask the material supplier for yield strength of the coil stock.)