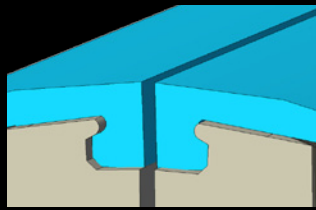


# Anvilok® Cover Installation

## Product Lines QLA, QLAW



Scan this code or visit [dicar.com](http://dicar.com) to watch instructional video



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### TOOLS



CVR-REM  
Pry Bar

### AnviLatch™ (optional)

The unique **AnviLatch** system increases the efficiency and enhances the safety of mounting rotary diecutting blankets/covers by eliminating the need to use a mallet to lock the cover. For more information visit [dicar.com](http://dicar.com).

### ! CAUTION

Use only tools recommended by Dicar to remove and/or install anvil covers. Use of improper tool may result in injury or damage to covers and/or die cylinder.

### ! IMPORTANT

Prior to installing anvil covers inspect lockup slot for damage, sharp edges or burrs, and ensure slot is free of contaminants to ensure proper lockup.

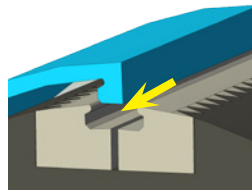
### ! WARNING

Remove cutting dies prior to removing, installing or rotating anvil covers. Failure to do so can result in personal injury and/or damage to tooling.

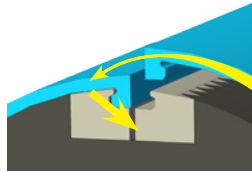
## Installation

**1** Install the female end of the cover into the slot, under the lip, as shown.

- Make sure the lock mechanism is open before beginning installation



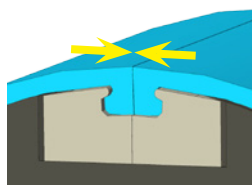
**2** Wrap the blanket around the cylinder and align with the end already installed.



### ! WARNING

To prevent injury, **do not** allow fingers to enter the nip between the die drum and anvil cylinder when rotating cylinder. Keep fingers and hands clear of lockup area when closing mechanism.

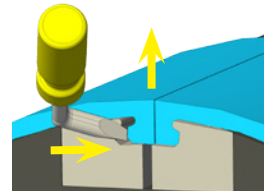
**3** Tighten the mechanism to close the lock section, per the machine manufacturer's instructions.



## Removal

**1** Open the lock mechanism per machine manufacturer's instructions.

**2** Place Pry Tool (CVR-REM) between the cover and slot lip as shown. Pry away from lip and then up.

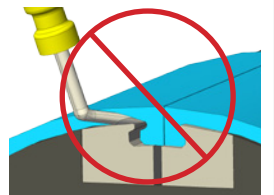


Continue working tool across the cover.

- If rotating, keep blankets off of floor to prevent contamination.

### ! CAUTION

Do not attempt to remove the blankets by inserting the pry tool between the blankets and the cylinder surface. Doing so can cause damage to the blankets and/or cylinder.



Dicar offers a full range of anvil cover styles and sizes, and other urethane products.

Visit [dicar.com](http://dicar.com), or contact your local Dicar Representative to view our catalog of quality Dicar diecutting and die-making products and services.

# Anvil Cover Rotation Log

Shift/Crew	Impression Count	Die #	Date of Rotation or Change	Notes

## Cover Storage

- It is best to keep covers stored in the original box and in the round (coiled) until the time of installation for easier mounting.
- Store at room temperature. Cold, will be stiff and more difficult to mount.
- For best performance, covers should not be stored for more than 2 years.

## Trimming & Grinding Recommendations

- Dicar recommends to include a practice of cover rotation when operating a trimmer or grinder in order to distribute wear on uncut covers and maximize usable material.
- It is best to rotate at least once before trimming or grinding to avoid cutting unused material, and potentially causing grinding issues.

## Sun MicroGrind® Recommendations

- Make sure the lock-up seem is fully seated and flush. Damage to the wiper blade and covers may occur if the seam is not flush.
- For new covers, run production for at least 30 – 40 minutes to ensure covers have fully and properly seated before attempting to grind covers.
- Follow procedures in the MicroGrind Manual for proper grinding (provide by the OEM).
- If lock-up seem does not seat after 30 – 40 minutes of production, a manual grind may need to be performed prior to initiating the automatic grinding system.

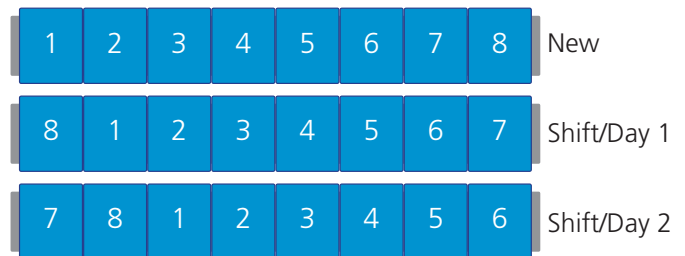
\*MicroGrind is a registered trademark of Sun Automation Group

## Cover Rotation

**Power Rot8tion** (recommended for Equamount Systems and boltless anvils) is a fast and easy way to maximize the life of your anvil covers. As illustrated below, once per shift or day,



- **For Equalizers**, simply remove one cover and bearing, slide the other down one space. Then reinstall the cover and bearing.
- **For boltless** covers, unlock all covers, leave covers in place. Remove cover from position 8 and slide the other covers down one space. Reinstall the cover removed. Secure all covers.
- Repeat rotation process throughout cover life.



**Standard Rotation** as illustrated below will help you maximize the life of your covers and the quality of your die-cuts. Without a trimmer covers should be rotated every 150,000 impressions.

With a trimmer covers should be rotated at 150,000 – trimmed at 300,000 – rotated at 450,000 – etc.

- Number covers as shown below
- Remove numbered covers and reinstall them in the order show below
- Repeat rotation process throughout cover life.

