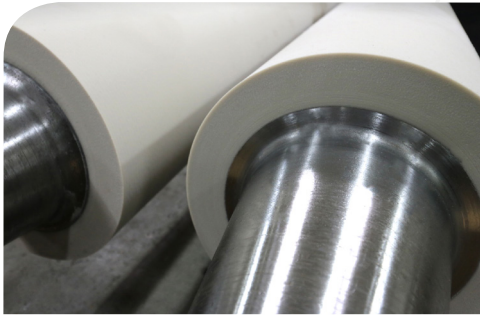


MONKAL® QUICK START MANUAL FOR APPLICATOR ROLLERS & WHEELS



Monkal® is a unique and patented polyurethane technology, developed by Hannecard with the objective to optimize the quality and the performance in roll coating applications, specifically for coating and varnishing on metal coils, sheet and cans.

This short manual will allow you to obtain maximum results using Monkal® coated rollers and sleeves.

Handling and storing

- Hannecard supplies the covered rollers and wheels with a **protective packaging** (sunlight, humidity, shocks).
- **Never place the rollers on the coated body.** The rollers need at all times to be supported on the journals for storage or manipulation.

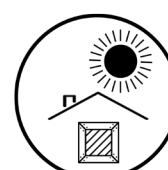
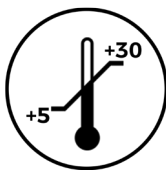


NO




YES

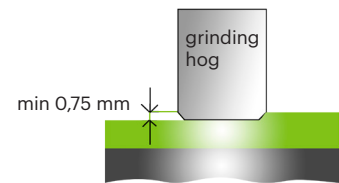
- The rollers can be stored in a (wooden) crate or in a metal frame, but always supported on the journals, with protective paper and film.
- Covered wheels can be placed on their side or can be held in free state using a central spindle.
- The storage area should be **dry** and within **temperature limits of 5 to 30 °C** (41 to 86 °F).



- When static storage time is **longer than 6 months**, it is recommended to **reground** the rollers to restore the geometry of the surface.

Using and grinding Monkal® rollers and wheels

- Monkal® can be used for water based and for most solvent based roller coating applications.
- When Monkal® is used for solvent based coating, it will absorb some solvents ("**swelling**").
- In order to maintain the functionality, the rollers need to rest before regrinding can occur :
 - **48 hours** in case of production run \leq 2 days
 - **72 hours** in case of production run $>$ 2 days  **48-72 h**
- Make sure the odour of solvents has disappeared before regrinding.
- In order to restore the right properties, it is recommended to grind away **minimum 1,5 mm on the diameter of the roll** (0,75 mm on radius).
- Grinding tolerances and precision :
 - **Surface roughness :**
According to the needs of the application.
If no surface roughness is required, Hannecard recommends $Ra = 1 \pm 0.2 \mu$.
 - **Dimensional tolerances :**
If no other requirements are defined, XP tolerance class according to ISO standard 6123/3 (cylindricity and run-out) is recommended.



Hannecard can help you to optimize your grinding on Monkal covers.
Ask for our grinding instruction guide : Monkal-Grinding Guidelines.

Other recommendations

For a good result, your rollers need to be in **good mechanical shape** :

- **Dynamically balanced** (recommended ISO class G 6,3 at max rotation speed).
- The journals, bearing seats and drive **seats within tolerance** (as indicated on the concept drawing).
- The roller **flanges** need to be **smooth** (no grooves, no vent or balancing holes).

Contact your nearest Hannecard partner to help you restore the mechanical shape of your rollers and wheels.

For more information,
please contact the Hannecard Main Office at +32.55.23.76.30
or your nearest Hannecard partner :
<https://www.hannecard.com/en/contact/>