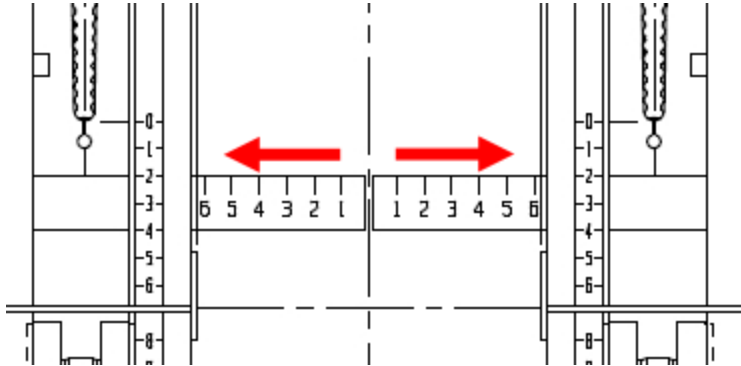


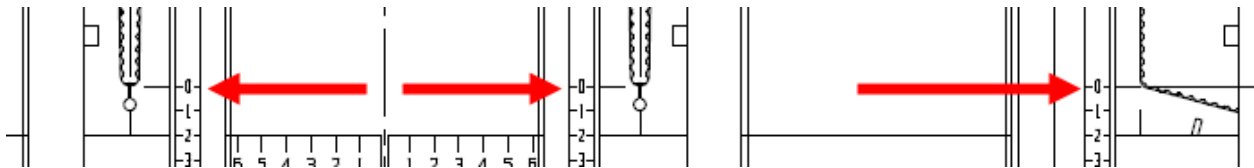
How to install and use your Sauer System RSC ring system

Installation Instructions:

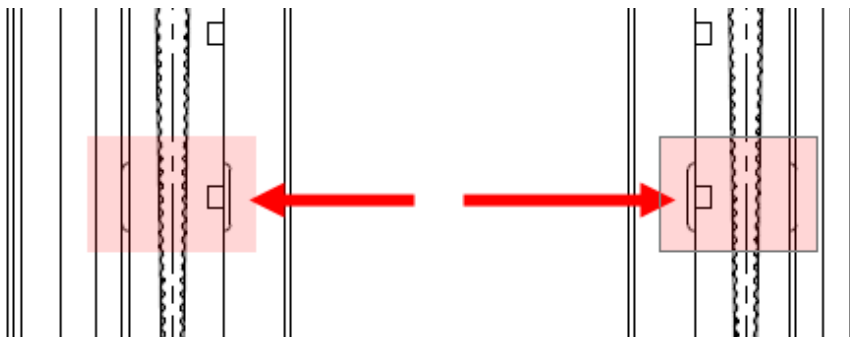
- 1) Attach horizontal keys to die cylinder using existing tapped holes. The keys should be installed with the numbers increasing away from the center line of the cylinder in each direction.



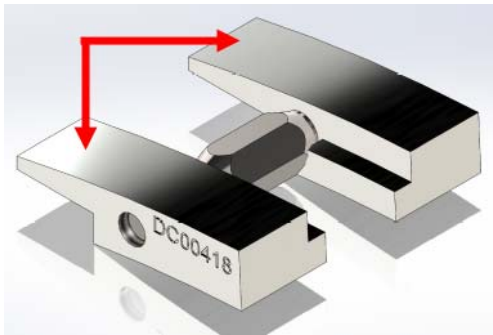
- 2) Mount the rings directly to the cylinder, tightening the screws marked "TIGHT" first (the screws opposite the "OPEN" side sticker).
- 3) Rotate the die cylinder until the vertical "0" marks are facing the operator.



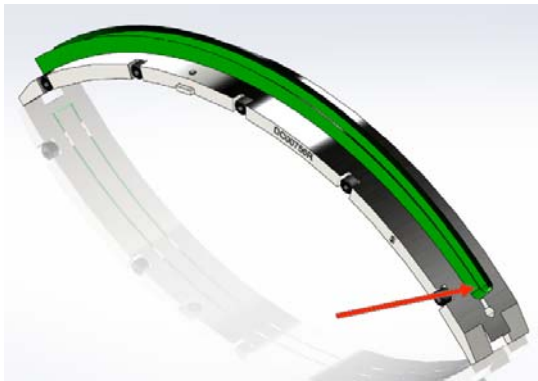
- 4) Insert the adjustable clamps and adjustable knife holders into the rings in the order shown below. The clamps and holders must be inserted through the notches in the ring grooves. The location of the notches is shown below:



- First, install a clamp, with the tapers pointed down. The tapers are indicated by the arrows. Then slide up clearing entry slot area for next piece:

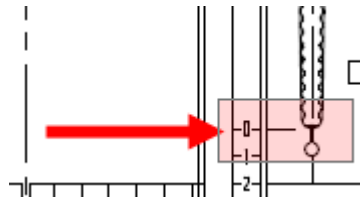


- Next, install the adjustable holder with the closed end of the knife facing up. Then slide up clearing entry slot area for next piece:



- Finally, install another clamp with the tapers pointing up. Then slide up clearing entry slot area for next piece:

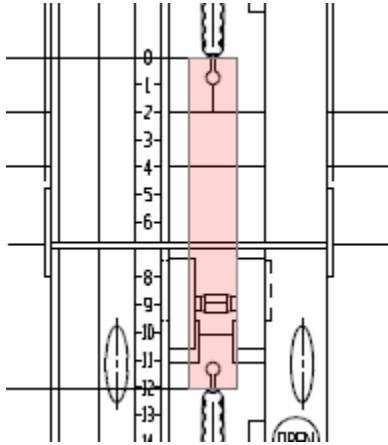
- 5) Install the stationary holders in the grooves with the screws provided and use the provided ratchet wrench to tighten the screws. Note that the closed end of the knife should be installed opposite the "0" on the vertical scale.



The system is now ready for setup and use.

Usage Instructions:

- 1) Position the adjustable holders in each ring such that the closed end of the knife lines up with the index mark on the vertical scale that signifies the depth of the box. In the example shown, the box depth would be 12”.



- 2) Position the rings laterally such that the widths between slots match the box dimensions and tighten them down by tightening the “OPEN” side screws. Note that “0” on the horizontal key corresponds to the center line of the cylinder. One ring will typically remain on “0” at all times, like a center slotter head on a flexo folder-gluer.

The system is now ready for operation.