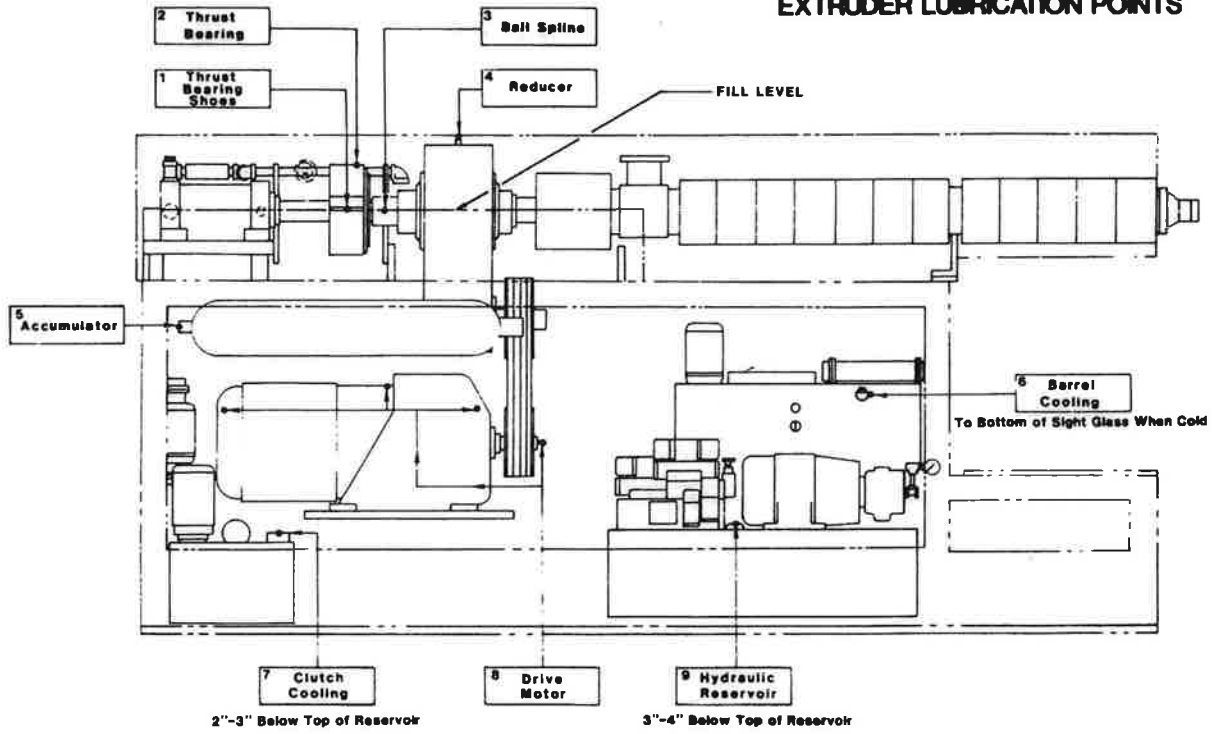


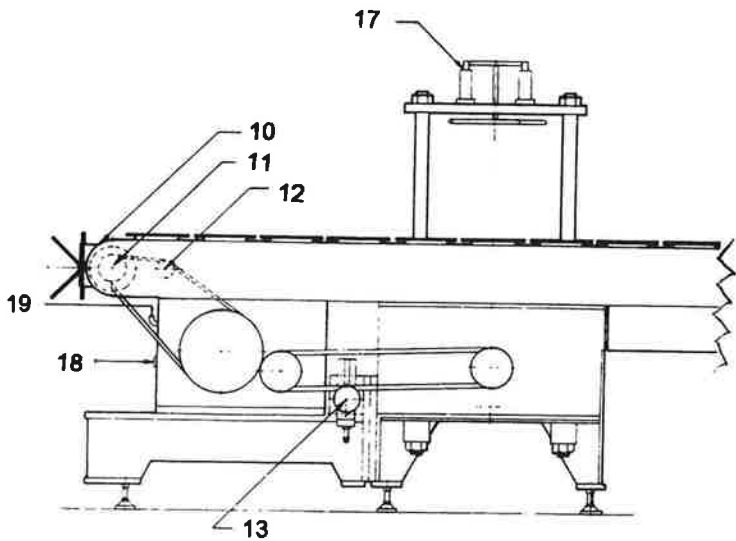
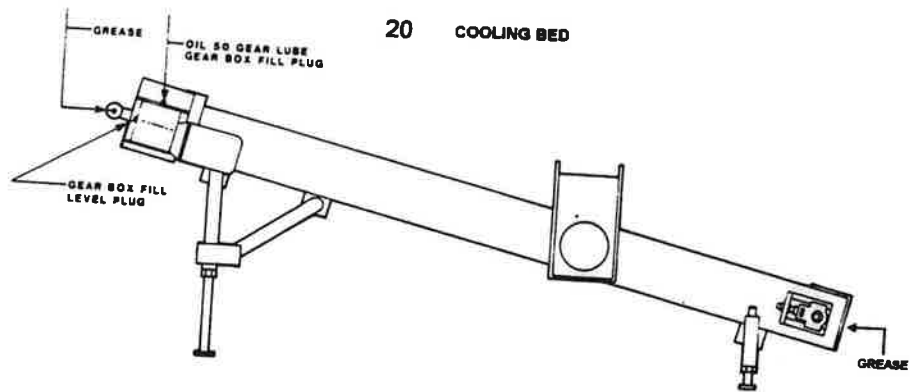
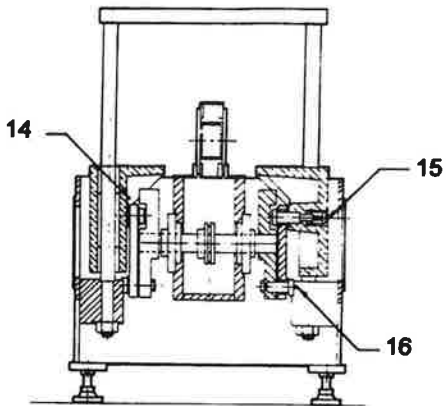
## GENERAL LUBRICATION AND MAINTENANCE INSTRUCTIONS

ITEM	LOCATION	INSTRUCTIONS	LUBRICANT REQUIRED	RECOMMENDED FREQUENCY				
				DAILY	WEEKLY	MONTHLY	QUARTERLY	YEARLY
*	Air Lubrication	Oil lightly	Mobil D.T.E.26	✓				
*	Stripper Assy	Check and adjust as required.		✓				
*	Stripper Assy	1-2 Pumps of grease	Mobilux EP1	✓				
*	Safety Doors	Check to insure proper cam valve actuation.		✓				
1	Thrust Brg	2-3 Pumps of grease on both thrust bearing shoes	Mobilux EP1	✓				
3	Ball Spline	2-3 Pumps of grease	Mobilux EP2	✓				
4	Reducer Gearbox	Check to maintain proper oil level	Mobilgear 630 or Mobil D.T.E. Oil BB	✓				
6	Barrel Cooling Unit	Adjust water flow to heat exchanger to maintain normal running reservoir temperature at 150°F to 200°F		✓				
7	Clutch Cooling	Check fluid level; add fluid as required. Maintain temperature at 90°F.	40% U-Car PM6141 - 60% Water Mixture with additives	✓				
9	Hydraulic	Check to maintain proper oil level	Mobil D.T.E.26	✓				
9	Hydraulic	Check water flow to heat exchanger to maintain 100°F to 130°F oil temperature		✓				
10-16	Trimmer	1-2 pumps of grease in each grease fitting on bucket guide chain, flange bearing, idler sprockets, platen tie rod bearings, crank shaft pins, take up sprockets.	Mobilux EP1	✓				
17	Trimmer	Lightly oil s-bar tie rod bearings	Mobil D.T.E. 26	✓				
18	Trimmer	Check fluid level; add as required.	Mobilgear 630 or Mobil DTE Oil BB	✓				
20	Cooling Bed	1-2 Pumps of grease on both grease fittings of live roller assembly and take up bearings.	Mobilux EP1	✓				
21	Clamp	2-3 Pumps of grease in each grease fitting on toggle pins, platen shoes, and tie bar bushing.	Mobilux EP1	✓ Every 8 hours				
*	Drive Belts	Check tension; 5.5 - 8.5 lbs to deflect 5/16"			✓			
6	Barrel Cooling Unit	Check fluid level. Add U-Con fluid as required	U-Con 50 HB-280X		✓			
5	Accumulator	Check nitrogen pressure - should be 70% of system pressure.				✓		
9	Hydraulic	Flush & clean suction filters, if damaged-replace				✓		
2	Thrust Brg	Remove; clean; repack 1/2 to 2/3 full	Mobilux EP2				✓	
6	Barrel Cooling Unit	Replace fluid	U-Con 50 HB-280X				✓	
8	Drive Motor	2-3 Pumps of grease on each fitting.	Mobilux EP2				✓	
20	Cooling Bed	Check gearbox fluid level; add as required.	Mobilgear 630 or Mobil DTE Oil BB				✓	
*	Temperature Controls	Recalibrate and check pivots and jewels.						✓
4	Reducer Gearbox	Drain, flush, and refill with new oil	Mobilgear 630 or Mobil D.T.E. Oil BB					✓
9	Hydraulic	Remove oil; thoroughly clean & flush tank. Replace oil.	Mobil D.T.E.26					✓
6	Barrel Cooling Unit	Remove fluid, clean, and flush tank and lines. Replace fluid.	U-Con 50 HB-280X					✓
19	Trimmer	Remove fluid, clean and flush gearbox; replace oil.	Mobilgear 630 or Mobil DTE Oil BB					✓

## EXTRUDER LUBRICATION POINTS



## 10039-10040 TRIMMER LUBRICATION GUIDE



## 21 CLAMP LUBRICATION POINTS

