

PRESHIFT STARTUP CHECKLIST



OPERATOR: _____

WEEK: ____ / ____ / ____ THRU ____ / ____ / ____



RESOURCES



DIES AND BRIDGES

TASK:	NOTES:	MON	TUES	WED	THUR	FRI	SAT	SUN
Grease the machines (see lubrication charts in "Resources") Blue Tabs Green Tabs Red Tabs	EP (Extreme Pressure) # 2 Lithium Base 40 Hours 8 Hours 4 Hours							
Ensure that all guards are properly installed	**Do not start any machine until all guards are properly installed**							
MACHINE AT IDLE - (Oil in center of Sight Glass)								
Extruder gearbox sight glass	ISO 220 or ISO 320 oil							
Pug gearbox sight glass	ISO 220 or ISO 320 oil							
Extruder thrust sight glass	Lubriplate # 8							
Pug thrust sight glass	Lubriplate # 8							
MACHINE AT IDLE								
Inspect Pug tub for foreign objects.								
Inspect conveyor Belts for foreign objects.								
Inspect vacuum chamber for foreign objects.								
Verify pug knives for proper pitch (1/8" toward rear of tub)	225 ft-lbs torque on shank in shaft							
Ensure that remaining material is sufficiently wetted.								
VACUUM SYSTEM IDLE								
Check upper tank oil level (pump power off)	Transformer Oil							
Drain water from lower tank (Use red die)								
Check lower tank sight glass level	Transformer Oil							
Check filter between vac chamber and pump.	Clean as needed							
VACUUM SYSTEM RUNNING								
Verify that oil circulation pump is running								
Verify that radiator fan is running								
Verify that pump motor is running								
Verify drip at pump shaft packings (both sides)	Adjust for 8-10 drips per minute (minimum)							
Check gauge at oil recirculation filter housing.	15 PSI differential or less.							
DIE AREA								
Inspect die to ensure dry material is removed.								
Verify that hinged door is secure (if applicable)	See instruction for super nut.							
Ensure die changer is aligned with barrel (if applicable)								
Ensure die lube tank has oil. Do not run pump without oil.								
Inspect die for loose bolts and foreign objects.								
Verify that bridge properly installed and adjusted								
Inspect for leaking die lube lines.								
Insure oil lines are not clogged.	Close all and open one at a time.							
MISCELLANEOUS								
Test slug cutter								
Test Scrap conveyor belts								
Check even feeder for foreign objects and start feeder.								
START MOTORS								
Start Pug motor.								
Start Extruder motor.								
Start Vacuum. (All valves closed)								
Start water pump.								
Ensure everything is operating correctly.								