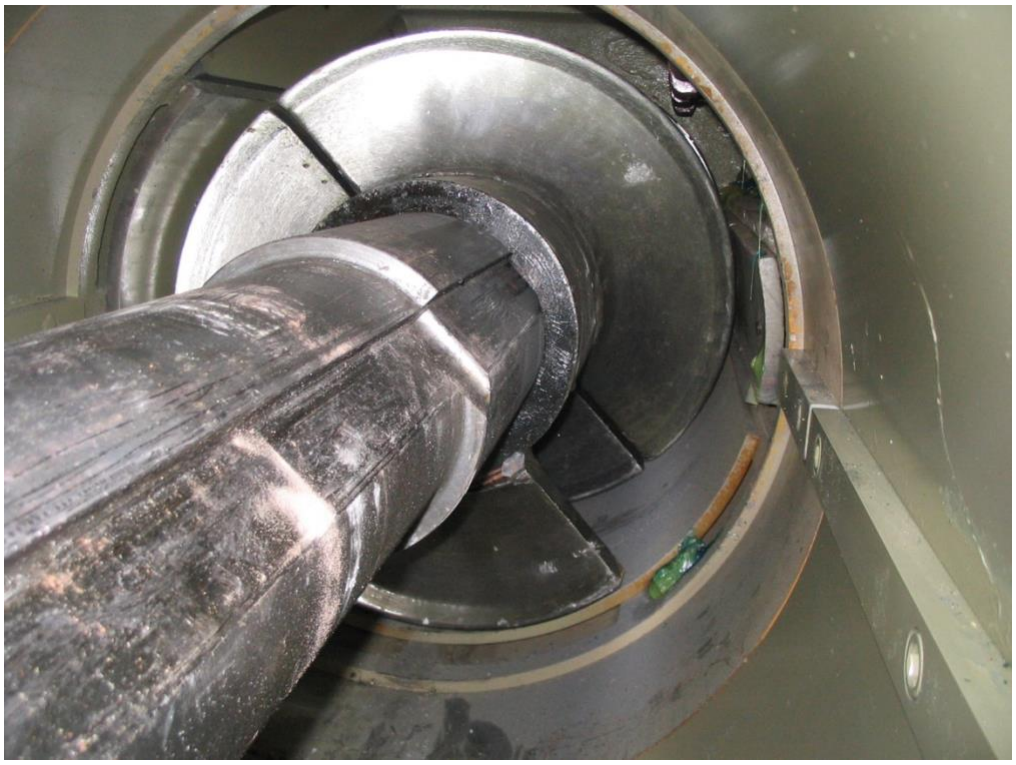
Recommended 90 Extruder Auger Removal Procedure Using Auger Pullers

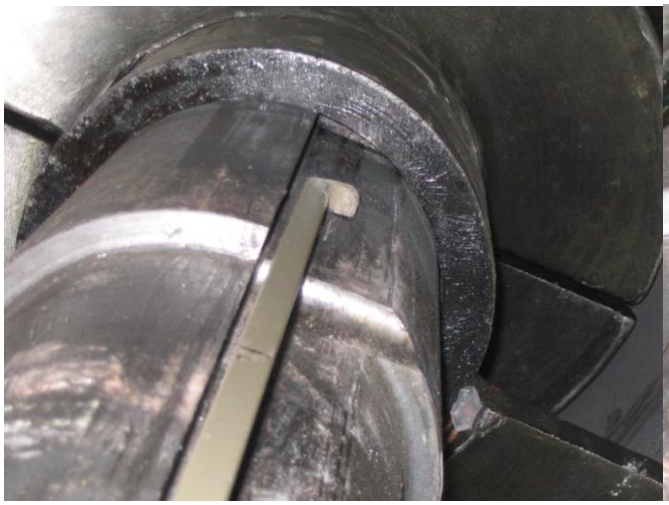
Use the following procedure with the auger pulling tools and 90 augers with pulling pockets to make the removal process safer and easier. This process applies to the 6, 5, 4, 3, and 1-2 augers for both the HCV and HTR auger sets. Don't use it on the point auger or the number 7 back-up spiral (HTR or HCV).

The auger removal tools are detailed in drawing DSD-D-1700-CB. The kit includes auger hooks, hook locking guides, puller cross bar and necessary hardware.

1. **Remove the necessary retainers, liner, and preceding augers to expose the target spiral. The following picture illustrates this for the number 5 spiral.**

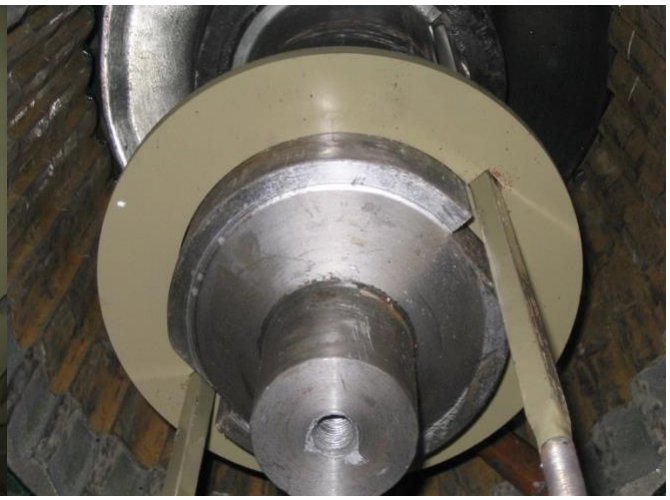


2. **Insert one of the short hooks into the auger pulling pocket as shown. This is simplified if the augershaft keyway can turn to the 12 o'clock position. Do this by sliding the rod with the hook turned flat and then rotating the rod counterclockwise, engaging the hook in the auger pulling pocket. This is illustrated in the following pictures for the number 5 auger.**



3. **Repeat the same with the second puller rod.**

4. **Holding both rods with the hook ends engaged in the auger pulling pockets, slide one of the locking hook guides into place. Slide this guide just far enough on the shaft so the square section of the rods is locked and the rods can't rotate. This is necessary so neither hook rod disengages from the auger pulling pocket when force is applied. Use both locking guides with the long hooks.**



5. **Place the pulling cross bar onto the two puller rods and install the washers and nuts.**

6. **Position a hydraulic port-a-power (not supplied by Steele) between the end of the augershaft and the pulling cross-bar. The estimated minimum gap between the pulling cross bar and the end of the augershaft is 5 inches.**

7. **Blocks must be used between the port-a-power and the pulling cross bar as the gap increases.**

8. **Use the port-a-power until the auger can slide freely to the end of the auger shaft by hand. Use extreme care when removing augers from the shaft.**

Important Note

- **Proper installation of the augers will help ensure that minimal force is required to remove the augers. This includes using anti-seize compound or grease on the auger shaft, applying silicone sealant to the rear hub of each auger, smoothing it out to roughly 1/16" thickness, and allowing it to air cure before installation. The silicone will also help keep dirt out of auger pulling pockets.**