INSTALLING THE 3690 HYDRAULIC DIE CHANGER ON THE 90AD EXTRUDER
SAFETY

J.C. Steele and Sons equipment is designed to process large amounts of heavy products. To accomplish many of the required operations of our customers, high horsepower and heavy components are required. A great deal of time and effort has been invested into our equipment to make them as safe as practically possible. The safety features are no substitute of caution and common sense. A careless moment is all that is needed to cause a serious accident. Please refer to the machine’s Owner’s Manual for a detailed list of safety precautions.

GENERAL DESCRIPTION

This bulletin outlines the procedure to install the 3690 Hydraulic Die Changer for the 90AD Extruder.

SPECIAL TOOLS NEEDED

- RTV sealant

MANPOWER ESTIMATE

This procedure will require 2 men for 4 hours.
PROCEDURE

1. Remove the two **threaded rods** and **wooden retaining board** (if present) from the front of the **barrel**.

2. Remove the **hinge pins** from the **mouthpieces**.

3. Remove the **hinged mouthpieces**.

4. Remove the **barrel adapter**.

5. Remove the **liner**.

6. Clean the front of the **barrel** where the **gasket** will fit.

7. Install the **gasket** on the **die changer** (not the front barrel) with a thin film of **grease**.

8. Tighten the **mounting bolts**.

9. Install the **hydraulic pump system**.

10. Split the **die carriers** and remove the **clamp ring (42CR)**.

11. Install the **front liner**.

12. Install the **clamp ring (42CR)** with the **form-in-place gasket (42G)** or **RTV silicone sealant** behind it.

   a. Use **silicon** sparingly, just a **thin bead (⅛")** around all bolt holes and all around the diameter of the ring.

13. **Operate the die changer** to check function before running the extruder.
FIG 2: 3690 HDC attached to barrel