START UP INSTRUCTIONS FOR "REYMOND" EXTRUSION DIES

1. After the unit is securely mounted on the machine and the lubrication hose is connected to the lubrication manifold, all lines should be filled by opening the valves, one at a time, until no air bubbles are seen going through the line. This step should be completed before any clay is put into the unit.

2. Once all the lines have been filled, open each individual valve about ¼ turn. Be sure to open all valves equally. Under most conditions, these settings should remain unless a little more oil is required on one particular corner of the die or shaper cap to eliminate corner pulling or checking.

3. In most cases, the stand-up by-pass regulator with the red knob is turned clockwise as far as possible to prevent by-pass of the lubricant. The amount of oil is controlled by increasing or decreasing the setting on your lube pump. However, occasionally with some materials that absorb lubricant as fast as it goes into the die, the by-pass regulator may need to be adjusted to allow oil and/or water soluble lubricant to by-pass back to the tank to prevent the lube pressure from getting too high and blowing holes in the column as the column gets harder.

4. After completion of Steps 1, 2 and 3, the unit can be filled with clay and extrusion can begin. Once the column reaches the density desired, the pressure on the front and back manifold can be set to achieve proper oiling. It is not possible to tell exactly the amount of pressure needed because different materials require different amounts of pressure. Normally, 300 to 400 lbs. on the back of the unit and 5- to 150 lbs. at the die or shaper cap is a good starting point. Simply increase or decrease the pressure using the blue or black handled regulator that goes to the shaper cap or die. Your pump can be adjusted to increase or decrease pressure, as needed. Care must be taken to prevent over oiling of the material.

5. Each individual oil line on the Reymond Die Unit comes equipped with a check valve and a grease fitting. These are installed to help eliminate clogging of the lubrication ports as they go through the daily changes of column density.

6. All 4 – 10 & 12 point systems must be checked at least 2 to 4 times during each shift to assure that the lubricant is going where it was designed. If one or more lines become clogged, it allows all of the volume to go to the other ports which may cause over oiling in certain areas.

7. Preventing this is one of the most important steps in assuring good column uniformity and equal wear within the unit.

Sincerely,
Reymond Products International, Inc.