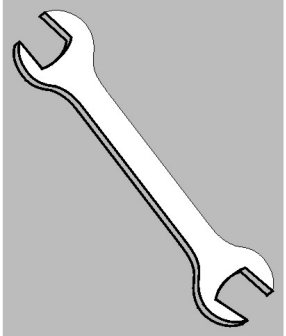
Published Manual Number/ECN: HKPRESSF4/99503N
- **Publishing System: TPAS**
- **Access date: 1/23/01**
- **Document ECN's: Exact**

Kit Instruction—

RKPRESSF4
RKPRESSF4T



Read the Safety Manual

PELLERIN MILNOR CORPORATION POST OFFICE BOX 400, KENNER, LOUISIANA 70063-0400, U.S.A.

Please Read

About the Manual Identifying Information on the Cover

The front cover displays pertinent identifying information for this manual. Most important, are the published manual number (part number) /ECN (date code). Generally, when a replacement manual is furnished, it will have the same published manual number, but the latest available ECN. This provides the user with the latest information applicable to his machine. Similarly all documents comprising the manual will be the latest available as of the date the manual was printed, **even though older ECN dates for those documents may be listed in the table of contents**.

When communicating with the Milnor factory regarding this manual, please also provide the other identifying information shown on the cover, including the publishing system, access date, and whether the document ECN's are the latest available or exact.

References to Yellow Troubleshooting Pages

This manual may contain references to "yellow pages." Although the pages containing troubleshooting procedures are no longer printed on yellow paper, troubleshooting instructions, if any, will be contained in the easily located "Troubleshooting" chapter or section. See the table of contents.

Trademarks of Pellerin Milnor Corporation

The following, some of which may be used in this manual, are trademarks of Pellerin Milnor Corporation:

Ampsaver®	Dye-Extractor®	Gear Guardian®	Milnet®	Staph-Guard®
Autolint®	Dyextractor®	Hands-Off®	Milnor®	System 4®
Auto-Purge®	E-P Express®	Hydro-Cushion®	Miltrac	System 7®
Autovac	E-P OneTouch®	Mildata®	Miltron	Totaltrol®
CBW®	E-P Plus®			

Comments and Suggestions

Help us to improve this manual by sending your comments to:

Pellerin Milnor Corporation
Attn: Technical Publications
P. O. Box 400
Kenner, LA 70063-0400

Fax: (504) 469-1849

July, 1997

INSTRUCTIONS FOR PRESS FRAME RING ADDITION - RKPRESSF4 & RKPRESSF4T

1. Clean press - remove all lint and oil.

2. Air lines - remove or push aside, away from welding area.

3. Protruding above the pre-press tamper is a strainer for the high pressure pump. The strainer and associated hoses must be removed temporarily so welding and cutting will not effect the hoses and strainer.

4. This retrofit includes stiffener plates which will be welded to the front (pre-press side) and rear (discharge end) of the main bell upper cylinder weldment. The main bell cylinder weldment in the area where you will add these plates must be cleaned of all paint, to allow for a good weld.

4. Install the load and discharge side stiffener plates **before** the reinforcing ring.

5. Any cracks found on the main dome cylinder weldment should be beveled and welded. Please insure 100% penetration on these gussets. These can be beveled with a grinder tool or with a torch. This is left to the discretion of the welder.

6. If the press is an "End loaded press" there will be a bracket to mount the load scoop to the main cylinder weldment. This holds up the load scoop on the main bell side. The weldment must be cut off in order to install the additional frame plates which will be fitted to both sides, "load end" and "discharge end" of the main bell weldment. After welding is completed, you must reinstall the bracket for the load scoop mounting bracket.

7. There is a lifting bracket on the pre-press side of the main bell cylinder weldment which is used for rigging. This bracket must be cut off and the weld ground flat.

8. A stiffener ring will be added to the upper main dome cylinder weldment. The stiffener ring is shipped in two pieces. Each piece may be too long and should be cut to length as necessary. This ring should be fitted to the upper main bell cylinder weldment. Any paint under the added ring should be removed to insure a good weld.

9. The stiffener plate, on the load and discharge side of the upper main bell cylinder, must be welded 3/4" high than the existing frame structure. Be sure to remove all paint in the weld area. The new stiffener plates will be positioned at the center line of the main bell cylinder weldments. Be sure to remove the paint under the round holes in the additional plate.

10. Have water hose available to put out small fires, if any.

11. Air hoses on the press - have extra hose and couplings to replace if weld splatter burns one.

12. Dome and air lines - keep wet at all times.

13. Be sure to remove all weld slag from the top of the dome and the dome lock area. If possible, keep this area covered with a welding blanket to prohibit weld slag from falling on the dome and dome locks. **DO NOT operate the press unless all weld slag has been removed from this area.**

TOOLS NEEDED

- Tip grinder

- Cutting torch

- This retrofit can be applied using an arc welder with welding rods. However, a MIG machine will expedite the process. We anticipate that you will need an additional 4-5 hours if you utilize a stick machine rather than a MIG machine with wire feeder.

- This retrofit has been successfully completed using .035 flux core wire through a MIG machine.

- Anticipate using 50 lbs of weld rods or wire. You should have some welding material remaining after the retrofit is completed