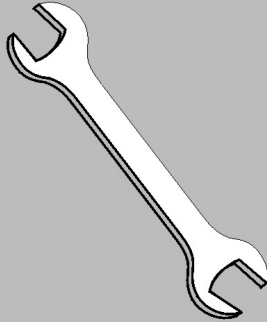


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Kit Instruction— KYSSRHRS01



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.**

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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.

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Pellerin Milnor Corporation
Attn: Technical Publications
P. O. Box 400
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MSSM0961AE/9831AV
INSTRUCTIONS FOR
RETROFIT OF MILNOR SINGLE-STAGE PRESS
INSTALLATION OF HYDRAULIC RAM SHIMS
VERSION 1.0
07-22-98
PAGE 1 OF 3

DESCRIPTION OF RETROFIT – The purpose of this modification is to add shims to the hydraulic ram’s forward ring to ensure that the packing gland is aligned with the shaft and to provide an easy way to adjust the packing as it wears. These shims are being installed on all Milnor Single Stage Presses currently in production.

This retrofit involves removing the eight (8) bolts and washers which presently secure the ring to the forward end of the hydraulic ram, installing the shim stacks, and installing eight (8) new bolts and washers (supplied with this retrofit kit). The bolts and washers removed for this retrofit will not be reused.

The Milnor Service Department estimates that a maximum of two (2) man-hours will be required to accomplish this modification.

CHECK THE KIT CONTENTS – Upon receipt of this retrofit kit, check and verify that it contains the following:

- (56) Part Number 15U314C Clipped Washers (Shims)
- (8) Part Number 15K227BB 5/8 – 13X3.5 Hex Bolt, Zinc Plated
- (8) Part Number 15U315 – 5/8 lockwasher
- (1) Retrofit instructions

If any kit components are damaged or missing, contact the Milnor Parts Department.

MAKE THE MACHINE SAFE FOR PERSONNEL ACCESS – This retrofit requires that personnel enter the interior areas of the machine where the hydraulic cylinders which position the can and diaphragm are located. Prior to any personnel entering the machine, the following must be accomplished:

- (1) Using appropriate manual functions, move the ram and can to their full down positions.
- (2) Lock off and tag out electrical power to the machine at the external disconnect box.

TOOLS REQUIRED – In order to install the backup plates the following tools are required:

- 1 – ¼” (32 mm) socket;
- Torque wrench with full-scale range of at least 200 ft-lbs. (270 newton-meters).

MSSM0961AE/9831AV
INSTRUCTIONS FOR
RETROFIT OF MILNOR SINGLE-STAGE PRESS
INSTALLATION OF HYDRAULIC RAM SHIMS
VERSION 1.0
07-22-98
PAGE 2 OF 3

CAUTION

There may be some hydraulic fluid leakage when the bolts which secure the ring to the forward end of the ram are removed. Remove these bolts SLOWLY to avoid being sprayed with fluid. SAFETY GLASSES AND APPROPRIATE PROTECTIVE CLOTHING SHOULD BE WORN AT ALL TIMES!

MAKE EIGHT (8) SHIM STACKS – Make eight (8) stacks of P/N 15U314C clipped washers, with each stack containing seven (7) washers.

LOOSEN THE EXISTING BOLTS – Locate the eight (8) existing 5/8” bolts which secure the ring to the hydraulic ram (see Figure 1). Using an appropriate wrench, loosen these bolts in a star pattern and remove seven (7) bolts from the machine. Loosen the remaining bolt just enough to create a gap between the ring and the forward end of the ram which will allow shim stacks to be inserted at the other seven (7) locations (approximately 3/4” is sufficient). Don’t completely remove the last bolt – if you do, the ring will drop and could cause personnel injury. Clean up any hydraulic fluid which has leaked out.

LOCATE FOUR (4) SHIM STACKS – Place seven (7) shim stacks between the ring and the forward end of the ram as shown in Figure 1. Line up the holes.

INSTALL SEVEN (7) NEW BOLTS AND LOCKWASHERS – Install seven (7) new P/N 15K227BB bolts and seven (7) P/N TBD lockwashers common to the ring, washer stacks, and the forward end of the ram. Install these bolts hand tight only, maintaining a sufficient gap between the ring and the forward end of the ram to allow the remaining shim stack to be inserted.

REMOVE AND REPLACE THE REMAINING BOLT – With the seven (7) new bolts installed the remaining bolt can be safely removed. Remove the remaining bolt and place a shim stack between the ring and the forward end of the ram at this location. Install a new P/N 15K227BB bolt and a P/N TBD lockwasher and tighten hand tight.

TIGHTEN ALL EIGHT (8) BOLTS – Wrench-tighten all (8) bolts enough to eliminate any gaps between the ring, shim stacks, and forward end of the ram. Tighten snug only – final torque will be applied in the next operation.

FINAL TORQUE ALL BOLTS – Using an appropriate torque wrench, torque all eight (8) bolts to 150 ft-lbs (200 N-M), utilizing a star pattern.

REAPPLY POWER TO THE MACHINE – Reconnect main power to the machine and energize appropriate control circuits.

MSSM0961AE/9831AV
INSTRUCTIONS FOR
RETROFIT OF MILNOR SINGLE-STAGE PRESS
INSTALLATION OF HYDRAULIC RAM SHIMS
VERSION 1.0
07-22-98
PAGE 3 OF 3

FUNCTIONALLY TEST THE SYSTEM – Using appropriate manual functions, command the diaphragm through a number of up-down cycles. Observe the areas around the ring, the forward end of the flange, and the top of the diaphragm mounting plate. Verify that there is no hydraulic fluid leakage from the ram.

TEST THE SYSTEM AT FULL EXTRACTION PRESSURE – using a suitable load of expendable (that is, scrap) wet goods, run the machine through a number of full-pressure extraction cycles. Verify that there is no hydraulic fluid leakage from the ram.

INSTALLATION COMPLETE –

- Replace all machine guards and cosmetic panels and secure all electric box doors.
- Return the machine to normal (automatic) operation.
- If there is a problem, contact the Milnor Service Department at (504)467-9591, Extension 75.