

## Ring Die Operating Instruction

Thank you for using the products producing by our factory. Before you use it, we'd like you to read this Specification of Roller Assembly carefully, which can benefit you a great deal.

Before purchasing ring die, please ensure that its compression ratio could match related recipe, to guarantee the production and quality meeting requirement.

When using ring die, corresponding roller shell must be chosen according to hole-size of ring die, to guarantee the cooperation between each other.

When using new ring die for the first time, new corresponding roller shell must be used, rather than old one. If the ring die processes flat working face, then roller shell with flat working face will also be needed, to guarantee the stable work and balanced pressure.

When using the ring die first time, swill the ring die about ten minutes with corresponding feed pellet with little oil and steady stir (hot material coming from pellet machine will be the best. Material with modulation, compression and suitable moisture can pass the hole more smoothly). Before making pellet, condensate water must be drained away, and ensure no water mass and caking enter compression room after modulation. Feeding speed of pellet machine should be adjusted from slow to fast, while it will be about 110%-120% at beginning comparing with common speed.

After first time using, the ring die should be swilled for 1 to 2 minutes before pellet machine works. Production should take place after ring die's temperature increases. Ring die holes should be covered with oily material before shutting down.

No overloaded working for pellet machine.

Gap between ring die and roller shell: ensuring the ring die working face can rotate the roller shell fitfully will be OK. Theoretical data is about 0.1-0.3mm, not too tight.

Safety bin must work to ensure the pellet machine safety. It will be broken if any briquette or strange matter enter the ring die.

Wear of feeding scraper must be checked regularly, and must be changed if necessary. Meanwhile, feeding scraper degree must be checked and adjusted regularly, to guarantee the uniform feed in the ring die, evenly wear on ring die working face, together with standard ring die production and life.

Wear of raw-material cutter must be checked regularly, and must be change if not sharp or smooth. Angle,direction and two sides of cutter must be installed and adjusted correctly.

Axial position of the ring die and roller shell work facing must be checked regularly, and error must reduced within 1.5mm. Ring die and roller mustn't string together, or it will cause the dehiscence of them.

Pellet machine assembled by hoop, must guarantee its slope can tighten up the ring die, and no contact point between hoop chute bottom, ring die and driving wheel. The gap between ring die and driving wheel must be less than 0.3mm. Lining ring must be changed when wearing 0.2mm (when installing ring die, its concentricity must be tested by dial gauge, and control run-out error within 0.3mm).

Pellet machine assembled by screw taper, must check the wear of driving wheel regularly, to guarantee driving wheel taper slope can tighten up the ring die, and no contact point between driving wheel bottom and ring die end face. When installing ring die, ring die end face must be tested by dial gauge, and control axial wobble within 0.15mm. (Guarantee the tighten force and operation balanced, together with the gap of die roll both side consistent).

De-iron separator on pellet machine must be ensured working regularly. Steel ball or other steel briquette should be forbidden to enter into the granulation room. Otherwise, all responsibility should be undertaken if ring die breaks because of this.

Necessary maintenance must be taken frequently, including cleaning the steel briquette on working face, unchoking blocked holes, and taking out broken screw in threaded hole. Storage: in dry, airy, and clean place. Ring dies in stock, holes should be filled with anti-corrosion oil material, and surface should be covered with anti-rust oil.