

SUB: Instructions for Calender Oil change

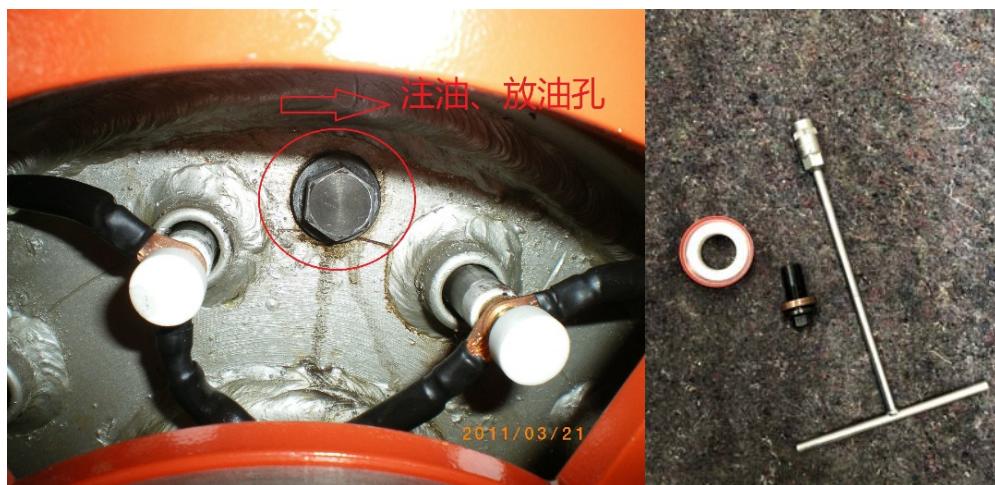
Step 1

Prepare the high temperature resistance oil, please choose the correct type refer to below chart

Density kg/m ³	0.99-1.01
Flash point °C	147
Dynamic viscosity(40°C) mm ² /s	8-13
Acid value mgKOH.g-1	<0.05
undissolved substance	0.000
Ingredient	BTX aromatics

Step 2

Open the right side of the machine door, remove the small metal window cover, then rotate the roller until see the position of the roller oil hole stop, use the wrench to remove the oil seal screw.



Step 3

Use manual oil pump to fill in the oil and fasten the screw. Below link of pump selection for your reference

https://www.alibaba.com/product-detail/Manual-Oil-Pump_62207635523.html?spm=a2700.galeryofferlist.0.0.74793618N47V4o

Model	Oil (Kg)
HT-1220P T2B	8.5
HT-1720P T2B	12
HT-1732 B2T/ T2B	50
HT-1742 B2T/ T2B	80

HT-1860 B2T	125
HT-2042 B2T/ T2B	90
HT-3242 B2T/ T2B	150



Step 4

Procedure of air release

When release air, rotate the screw to the position below red arrow marked, make sure do not remove the screw completely. (For the air release procedure, please read below messages for reference)



Air release for oil drum, the factory setting and relevant standards for blanket fixation and testing are as follows.

1、Temperature of air release

For safety, wear protective face mask, high temperature gloves. Make sure the oil seal screws top up, open with a wrench slowly and release air.

Release air when the temperature reaches at 80℃、120℃、160℃、190℃、230℃ separately.

ATTENTION: When the temperature reaches above step temperature, remain each one hour and then release air.

2、Blanket Fixation

Do not keep the blanket too tight when do blanket fixation, Stop expanding blanket when the maximum position of the blanket expansion from the machine at 10mm.

Operation period is as follows

Temperature (℃)	Operation time
140℃	3 hours
160℃	2 hours
180℃	2 hours
200℃	3 hours (Most importantly)
230℃	2 hours

When the machine stops in emergency, please release the blanket away from the oil drum.

After working, cool down oil drum at 80℃, and then power off the machine.

Notes: When the machine does not work in a long time, it is better preheat for 3-4 hours between 180℃-200℃ when starting again (especially in winter).

3、Factory setting and testing

The temperature of the machine set at 230℃ when the machine assembled in the factory, the alarm temperature is 270℃, and the trial temperature is not lower than 220℃.