



IMPORTANT BI-CUTTER SCREENLESS GRANULATOR MAINTENANCE INFORMATION- PLEASE DO NOT DISCARD.

August 13, 2007

Re: Preventive Maintenance

Dear Customer:

Periodically, we send information and updates to customers to assist in maintaining their Bi-Cutter screenless granulators. If you have an email address, we would appreciate it so that we may send the information in a timely manner. Please email Tina Dafoe at tdafoe@srscorp.com so that she may add you to the list. Please note that we do not give this information out to anyone- it is confidential.

It is very important to keep the Bi-Cutters in safe, good working order. By maintaining it properly, you will reduce overall costs and preserve the quality of regrind.

TROUBLESHOOTING TIPS:

Problem: Increase in fines

Solution: Dull cutters, incorrectly sized or adjusted cutters, or improper evacuation will cause more fines.

- Cutters should be sharpened or replaced
- A large diameter runner requires more tolerance or larger cutter size
- Evacuation should be set at every 3-5 minutes

Problem: Worn back-up

Solution: Premature back-up wear can be caused by not evacuating properly.

- Evacuation should be set at every 3 to 5 minutes

Problem: Granulator not shutting down when hopper is open

Solution: IMMEDIATELY pull the granulator offline- this is a safety hazard. The safety switch is defective and should be replaced. Please contact our service department at 517-333-2605 for immediate assistance.

Preventative maintenance should be performed every 3 to 4 months. Refer to your service manual before completing the following preventive maintenance procedures.

- 1- Inspect all cutting teeth surfaces for wear, damage or adjustment.
- 2- Stationary Blade – Keep a sharp, keen edge by surface grinding. A sharp stationary blade will give you a better-quality cut and longer blade life.
- 3- Remove gear reducer cover and lubricate gears with Special Moly Multi-Purpose Citgo brand Premium Lithium E.P.-2 Grease # 655212 or equivalent.
- 4- Inspect electrical cord and connections for excessive wear, looseness or corrosion.
- 5- Inspect the safety switch, hopper support brackets, safety pin and safety mechanism.

If any problems are noted, please contact our service department at 517-333-2605.