1. What's the torque on the shear bolt?

There is no recommended torque value. Tighten the nut until the shear pin lifts off the harden washer by 1/8" to 1/4" and this preloads the pin.

2. What's the torque on the pug knives?

Shanks should be torqued to 225 ft/lbs. Anything less could let the shank loosen and turn, breaking it off at the shaft.

3. How do I know when the shear pin is set correctly?

We recommend changing your pin every tie you open the die door. Once it pulls away from the washer, it's preloaded.

4. Why is the material level in the pug high in some places and low in others?

Check the pitch of your pug knives. Use a framing square to set them 1/8" back from the shank side.

5. Do I need to remove the clutch to change the driving plates?

No. Simply cut them into two or three sections and carefully replace them as you slide the clutch back into position.

6. Do you have service technicians to do work?

Yes. It's best to plan for a shutdown, but if you need us, we'll work to have a single technician or a team on site.

7. Why am I leaking oil on the back of the gearbox?

The air breathers on the gearbox inspection cover become clogged over time. When pressure builds, it causes oil to leak out between the castings.

8. What oil do I use in the gearbox and is it the same for the thrust assembly?

We recommend 220 oil in the gearbox and Luberplate #8 in all thrust bearings.

9. Why is the clutch leaking air?

Most of our clutches have two quick exhaust valves located on the outside . If they're covered in oil and dust, then air can't escape, which holds the driving plate in "run" position.

10. What can I do about hard caking?

We usually recommend changing to spiral liners to prevent hardcaking. For more severe cases, we could look at a lubrication system.

11. What is the pitch on the pug knives?

1/8" off the square in the direction of the gearbox.

12. Can I change the pitch on the knives?

We don't recommend this because it changes the retention time in the pug tub.

13. What size hole saw do I need to change pug shanks?

1 3/8" carbide tip hole saw.

14. Why does the column continue to move after I stop the machine?

Check the quick-release valves on the clutch face. They may be stopped up because of a bad diaphragm. We stock rebuild kits.

15. Why is the column swelling?

Make sure your core tips don't stick out past the cap opening. They should be flush to 1/16" inside the cap.

16. Why am I having vacuum problems?

Make sure you don't have any vacuum leaks (check lines, chamber and inspection doors).Make sure that you aren't overheating (check the circulation pump oil cooler fan). Make sure your pump is getting oil (excess sludge in the system lowers cooling/oil capability). Did you put the packing at the shredder knives? Are you running the pug tub too low? Check the lines and filters for build up, and clean them if necessary.

17. Why is material leaking out the back of the pug tub?

The labyrinth seal is worn and hasn't been greased every 4 hours. Change the seal or you could start to wear into your shaft.

18. What grease do you recommend?

EXTREME PRESSURE (EP) TYPE LITHIUM-BASED GREASE of NLGI consistency No. 2, with a Timken OK load of 40lbs. or more. DO NOT USE "ALL PURPOSE" OR BALL BEARING GREASES.

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19. Why do I get oil in my vacuum filter?

Your check valve isn't working properly. Release pressure from your vacuum chamber before turning off your pump to help prevent this from happening.

20. How do I reduce the clay from sticking on the inside of the vacuum chamber?

Some of our customers find that using good hot heat strips to heat the casting of the vacuum chamber helps prevent material from sticking.

21. Why do I lose oil from my thrust pot on the extruder?

If you always have to fill the thrust pot, then you probably have a bad Cat seal. Vacuum is pulling oil into the vacuum chamber during operation, which runs into the clay.

22. Do you have tools for changing augers?

Yes. We offer specialty tools that make working on our machines easier.

23. Will you come on-site to work on my machine?

Yes. Steele field service technicians will handle mechanical rebuilds on-site if you don't feel comfortable doing the work yourself.

24. Why won't my nut come off the cup washer stud by my point auger?

This is reverse-threaded to prevent loosening while in operation. Turn it clockwise to loosen.

25. Can parts be installed incorrectly?

Yes. It's possible to have an auger turned 180 degrees on the shaft, which could create problems. Other parts can also be installed incorrectly. Pay close attention when removing old parts!

26. Why won't the column won't come out of the die straight?

Check your lubrication pump and lines. Open the die, clean it out and inspect for worn die parts. Make sure you have good lubrication on all sides of the column.

27. My headers have cracked after coming out of the drier. Why?

You may have lubrication penetrating the clay at the bridge bar. This can be caused by too much lubrication or a foreign object at the bridge area. Take green brick and twist them to make sure you don't have a lamination problem.

28. Clay is pushing up my guards on the pugmill. How do I stop it?

Weld a long piece of angle iron on the inside of the tub to deflect the material back toward the center of the pug tub. Gravity will take it from there.

29. My brick bottoms are too slippery at the setting machine. How do I fix this?

Setters come in many styles. Some customers trim the bottom of the column to remove die lube and and reduce the slippage.

30. How fast should my pug and extruder run?

This depends on the amount of output you need. Typically, the pugmill will run 2-3 rpm faster (shaft speed) than the extruder. If one is much faster than the other, you may have problems keeping the material at the correct level. Motor rpm and sheave sizes also play a factor in machine speed.

31. Do any parts interchange between the 90 and 75?

Only the feed roll shaft shoes interchange.

32. Is it normal to see small filings on the magnetic filter trap?

Yes. Very small filings are nothing to worry about. Any large pieces should be investigated further.

33. Should I use anti-seize or never-seize on bolts and parts?

Yes. It's a good idea to use it whenever you're doing maintenance. It's also useful between the augers and shaft.