

**GENERAL INSTRUCTIONS
RDN MODEL 212 BELT PULLER
WITH AC FLUX VECTOR**

**"CAUTION"
"DO NOT OPERATE MACHINE WITH GUARD REMOVED"**

UNCRATE AND INSPECT

This machine has been carefully crated to assure safe arrival to your plant. It is important that you immediately inspect the equipment upon arrival at your plant and report any possible damage incurred in transit to the trucker.

It is suggested that you uncrate the equipment as soon as possible so that any concealed damage may be discovered. Compare the packing list with items received and in turn cross check the items with your purchase order and report any discrepancies to RDN MFG. CO. INC. at the address or phone number above.

Your puller has been factory tested and lubricated before shipment and is ready to plug in and operate.

As the operator stands facing the side of the machine with the name plate on it, (for R-L operation) the direction of rotation of the bottom belt is counter-clockwise and the direction of the top belt is clockwise.

This machine is equipped with a AC Flux Vector Drive.

Adjustment of belt clearance is controlled by a single handwheel located in the center of the machine. Turning handwheel to left will increase the opening between belts and turning handwheel to the right will decrease opening.

This machine was designed to pull plastic rod, tubing, and profiles. If you want to test this machine, use the material for which it was designed.

OPERATION:

1. Turn on Disconnect switch.
2. Pull out the Emergency Stop button and press Power On button.
3. Press Start button.
4. Select the desired power speed by turning the speed control Potentiometer clockwise, this will increase motor speed.
5. To change speed repeat Step 4.

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The belts on this machine have positive gripping action and do not slip, but do flex. They are taut on the pull side and slack on the far side. Therefore, if you mark the tube and belt, do not expect these lines to stay aligned.

The machine is mounted on swivel casters for portability. Adjusting the center height is accomplished by raising or lowering the leveling screws at each corner of the machine.

MAINTENANCE AND LUBRICATION

Before any maintenance to machine, stop operation by pushing the stop button, and unplugging the machine from main power.

This puller was designed for continuous operation with a minimum amount of maintenance. Keep the machine cleaned and lubricated, and it will remain in good working condition.

Facilities should be made to remove water from the extrudate before it reaches the puller. Water will corrode the machine and reduce its useful life. Also, water on the belts will reduce traction.

The pulleys are aluminum Poly V groove, which eliminates all tracking problems. If dirt or a piece of plastic should stick to one of the pulleys, it could cause a variation in the precision extrusion. Stop the machine and clean off pulley with knife or scraper.

To obtain good traction, the belts should be kept taut. New belts may stretch a bit. If adjusting of belts is required, this may easily be accomplished by taking up on the bearing block positioning screw, located at the entrance end on each side of the belt frame assembly.

Note: AC vector and AC Servo motors are designed to run hot. It is not uncommon for the motor temperature to reach 180-200f, depending upon ambient temp.

IF A BELT NEEDS TO BE CHANGED:

- Disconnect the machine from the power source.
- Loosen the idler pulley adjustment screws till shaft is seated in pocket.
- Remove the belt from the drive pulley first (keeping the belt over the idler pulley). Then remove the belt the rest of the way.

INSTALLING THE NEW BELT

- Put belt fully over the drive pulley (past the aluminum plate)
- Then slide the belt over the idler pulley.
- Align the V grooves.
- Retighten the idler pulley adjustment screws till the belt is taught.
- Start the puller and run at a slow speed, check the tracking, and let the belt seat.
- Stop the puller, disconnect power and retighten if necessary.

- Check motor brushes for wear every 3 months or 500 hours of operation.

- Keep a coating of light oil on all shafting.

- Give ball bearings a shot of grease once a month.