

**GENERAL INSTRUCTIONS
RDN MODEL 218 & 226 BELT PULLER
WITH AC VECTOR DRIVE OR SERVO**

**"CAUTION"
"DO NOT OPERATE MACHINE WITH GUARDS 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 nameplate on it, 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 an 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. Pull out the Emergency stop button and depress the Power On/Reset button.
2. Select the desired puller speed by turning the speed control knob, clockwise will increase motor speed; counter clockwise will decrease motor speed.
3. Depress the START push-button. The puller will accelerate to the setpoint speed.
4. To change speed at any time repeat step 2.

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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.

If a belt needs to be changed, it may be accomplished by:

1. Loosening bearing block positioning screws and slacking off belt.
2. Removing the old belt and putting on the new one.
3. Taking up on the bearing block positioning screw and adjusting tracking as described above.

Keep a coating of light oil on all shafting.

Give ball bearings a shot of grease once a month.

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.

Optional, The RDN take-up frame spur gearbox is filled to the center of the sight glass with Mobil brand SHC634 synthetic gear oil. Check and maintain this level. This is a fully synthetic oil and should not need to be changed however because of possible contaminants and gear wear, RDN recommends it be changed every 12 months.

Procedure For Removable & Reinstallation Of The RDN Gearbox

Remove the front take up frame bearings and front plates.
Remove the drive pulleys.
Remove the RDN gearbox.

Re-install;

Gearbox leave (4) mounting bolts loose.

It is recommended to install an new front shaft seal. Oil shaft to protect seal when sliding on.

Install the drive pulleys.

Install the front take up frame bearings and front plates and tighten.

This will pull the gearbox into alignment with the take-up assemblies.

Tighten RDN gearbox.

Install back door and tighten.

It is recommended to install a new door shaft seal. Oil shaft to protect seal when sliding on.

Before you install the rear pillow block bearing;

If you have one, use a dial indicator to read the height of the lower shaft height.

Call the height zero.

Install the bearing spacer and mounting tube. Tighten the bolts to achieve the zero and install jamb nuts.