

8.5.1 Oil temperature check

The working temperature of oil must be kept between 40°C and 50°C.

Higher temperatures not only damage the seals and the hoses but determine an increase in the rate of oxidisation of the fluid with the formation of sediments and sludge.

The solenoid valve (YV76) allows the entry of the cooling fluid in the heat exchanger when the oil temperature, read by the transducer (BT60, 1.161), reaches the value already set of about 50°C. If the temperature continues to increase until the maximum limit (55°C) the PLC stops immediately the motor pump and activates the visual and acoustic alarm signalling and the display of the relative message on the screen.

To identify the cause of high working temperature, check:

- that the temperature limits have been correctly set on the screen of the operator panel,
- the functioning of the transducer (BT60, 1.161),
- the temperature of the cooling fluid coming from external source,
- the functioning of the solenoid valve (YV76) of the exchanger. If necessary, clean it as indicated in the paragraph of that name.

To identify the cause of the high oil working temperature in the extruder reduction gear, check:

- the functioning of the solenoid valves (YV75., etc.),
- that the manual valves for the entry and exit of the cooling fluid are open.

8.5.2 Oil level check

The visual checking of the oil level takes place by means of indicator (1.103) installed on the tank of the power pack even though the minimum level is constantly controlled by the sensor (SL6, 1.105) which, if activated, determines the machine functioning stop at the end of the production cycle in progress, activates the display of the relative message on the screen and the visual and acoustic alarm signalling. The visual signalling (orange) is activated only if the power pack motor is functioning.

Topping-up the level (about 90% of the maximum level) can be carried out, complying with the CAUTION to be found in paragraph 8.5, through the oil-filler plug, using the same type of oil which is already in the tank.



Warning: the machine has been tested using "ROLOIL" oil, type "LR46".

Carefully clean the pouring nozzle of the oil can, making sure that it has not been affected by infiltration of water. We recommend filling using a mobile filter unit (10µm).

8.5.3 Oil replacement

For correct functioning of the hydraulic system, use good quality oil with a suitable viscosity (about 25 ÷ 36 cSt).



Warning: when traces of amber or pale brown appear in the oil, which indicates respectively oxidization or the presence of water, immediately replace the oil and flush out the system.



NOTE: it is advisable that oil samples be examined by a laboratory on a yearly basis to check the integrity and physical-chemical properties.

CAUTION: set the machine for maintenance as indicated in the paragraph of that name.
Harmful substances, use protective gloves.



a - Act on the drain valve (1.107) to empty the tank. The operation is facilitated by use of a pump for the oil suction.



Dispose of the exhausted oil and filters in conformity with the anti-pollution laws in force locally.



Warning: do not mix products of different brands. For the filling, use a mobile transfer and filter unit (10µm).

b - Close the valve (1.107) and after the internal cleaning of the tank, as indicated in paragraph 8.5.4, fill it up to the level (about the 90% of the maximum level) through the cap (1.104).

The machine was tested using "ROLOIL" oil "LR46" type, however an alternative oil from the following table can be used (mineral oils of the HLP group, DIN5 1524 for working temperatures at rating between 40°-50°C) always adding anti-froth and anti-oxidant additives.



NOTE: it is recommended that when filling up, the date and type of oil used be noted down directly on the hydraulic power pack tank or on the special machine cards for subsequent topping up.

c - Before turning on the machine, replace the air and oil filters as indicated in paragraph 8.5.5.

BRAND	TYPO "ISO VG 46"	Q.TY
AGIP	OSO 46	900 lt
BP	Energol HLP 46	
CASTROL	HYSTIN AWS 46	
ELF	ELFOLNA 46 o DS 46	
ESSO	NUTO H 46	
FINA	HYDRAN 46	
KLÜBER	LAMORA HLP 46	
LUKOIL	GEYSER ST 46	
MOBIL	Mobil DTE 25	
Q8	Haydn 46	
SHELL	Shell Tellus OI 46	
TEXACO	RANDO OIL HD 46	
TOTAL	Azolla ZS 46	