



Cleaning Procedure for Seized Bolt on Continuous Screen Changers

*NOTE – Continuous bolt type screen changers can ‘freeze’ if cleaning and lubrication of the machine is not properly maintained. Refer to page 24, section 7.3 of the manual for proper cleaning and page 23, section 7.2 for lubrication procedures.

1. Open the bypass valve up on the hydraulic power unit located on the back of the manifold until the pressure gauge reads 4,000 PSI. With the pressure at 4,000 PSI try moving the screen bolt in/out of the housing.
2. If this doesn't work, shut off the extruder and let the line cool down completely (below 100° F).
3. After cooling the machine turn all heaters back on and set the heat controller to the normal operating temperature (Ramp Rate Set To 100%).
4. After approximately 15 minutes start trying to move the seized bolt in/out of the housing.
5. Keep trying to move the bolt in/out of the housing until the full operating temperature is achieved. In most cases the seized bolt will start to move slowly. As the bolt moves clean and lubricate the bolt immediately per procedure on page 24, section 7.3 and page 23, section 7.2 of the manual.
6. If there are still no results utilize an Ener-Pac or similar hydraulic unit (See website www.enerpac.com) to provide enough force to move the seized bolt. This will require some research and guidance from PSI or the website.
7. Once the operating temperature of the screen changer has been met, or within 15 minutes of the temperature being met, allow the specified time (per machine size) in the table below to go by before moving the cross bolts to allow thermal equilibrium to set in. Machine sizes smaller than 116BF require minimum 2 hours. If the bolts begin to move during heat up/cleaning and they start to seize after the temperature is met let the machine soak for the time specified below before trying to move the machine for further cleaning. If the machine is still stuck after the heat cycle is completed but it did move some during heat up/cleaning repeat the procedure and try to gain access to the dirty sections of the machine quicker the 2nd time.

CSC-Model	CSC-116BF	CSC-125BF	CSC-148BF	CSC-176BF	CSC-200BF	CSC-230BF	CSC-250BF	CSC-270BF
Time for Thermal Equilibrium	3 Hours	3 Hours	3 Hours	3 Hours	4 Hours	4 Hours	4 Hours	4 Hours

*NOTE – If the screen bolts are cleaned on a regular basis the hydraulic pressure should never exceed 1,500 PSI. If the hydraulic pressure is above 1,500 PSI under normal operating conditions the pistons need to be cleaned and lubricated in accordance to the procedures outlined in the manual on page 23, section 7.2, and on page 24, section 7.3.

Department: Engineering	SOP No. ENG-0212-003	Revision No. 1
Prepared By:	Approved By:	Approval Date:
Effective Date: 02/15/2012	No. of Attachment: 0	Page #: 1 of 1