

MORGAN-PRESS

BARREL CLEANING KIT #69BCK

USE AND FUNCTION

The Barrel Cleaning Kit is used for the final and thorough cleaning of the Barrel Bore (material melt cylinder).

The Kit includes a Barrel Cleaning Tool and a supply of abrasive Hand Pad material.



BARREL CLEANING TOOL

The Abrasive Material Provided is 3M Scotch-Brite Heavy Duty Hand Pad No. 7440. This is 3M's most aggressive hand pad. This product or equivalent is available at most Industrial Hardware Supply Outlets.

PROCEDURE FOR USE OF BARREL CLEANING KIT

WARNING: ALWAYS OBSERVE STANDARD SHOP SAFETY PROCEDURES WHEN WORKING ON OR WITH MORGAN-PRESS EQUIPMENT.

NOTE: The following instructions for the use of the Barrel Cleaning Kit have been written assuming that the operators are thoroughly familiar with the operational characteristics of the Morgan-Press.

1. Purge and clean the Barrel Bore as described on Pages 19 through 22 of your Operating Instructions.

Note: For best results use the "Maximum Clean-out Technique" which is described on Page 21.

2. Put the Table Platen into the unclamped position (lowered).
3. The Barrel Piston should be up and out of the Barrel throat.
4. Turn off air and electric power to machine during cleaning operation.

5. Remove nozzle from the Barrel.
6. Barrel must be at room temperature. Elevated temperatures will damage the "Abrasive Hand Pad."
7. Cut a piece of hand pad to the following size:

G-55 and G-55T: 1 ½" wide x 2 ¾" long

G-100T: 1 ½" wide x 3" long

G-125T: 1 ½" wide x 3 1/2" long

These sizes are nominal and you may want to alter them per your application.

8. Place a sized hand pad into the jaws of the Mini Mandrel which is on one end of the "Barrel Cleaning Tool."
9. The other end of the Tool has a hexed shaft that is to be chucked into a ¼, 3/8" or ½" variable speed hand drill.

WARNING: BEFORE PROCEEDING THE TECHNICIAN SHOULD BE WEARING SAFETY GLASSES.

10. Insert the loaded Mini Mandrel into the Barrel Bore at the nozzle end.
11. Slowly begin the rotation of the Barrel Cleaning Tool and carefully hone the length of the Barrel Bore.

Note: It is wise to adjust your strokes so that the mandrel does not exit barrel during the cleaning process.

12. After polishing, a clean rag should be run through the barrel bore to remove loose particles.