

Table of Contents

The Extrusion Press Maintenance Manual

Introduction, Acknowledgments, and References

Routine Inspection and Maintenance

Scheduled Maintenance.....	1-1
Mechanical Maintenance.....	1-4
Lubrication.....	1-8
“ <i>Preventive Maintenance Program Recommendations</i> ” (The Voice of Experience), by David Turnipseed	1-9
Daily Check Sheet Procedure	1-12
Daily Check Sheet (Sample)	1-16
Press Troubleshooting Chart	1-17
“ <i>Extrusion Press Maintenance – A Predictive Approach</i> ” (The Voice of Experience) by P. Gopalan Kutty, Gulf Extrusions, Dubai.....	1-24
Farrel Maintenance Training Course information: Press Installation.....	1-30
Mechanical Functions of an Extrusion Press	1-36
Mechanical Maintenance	1-39
Correct Bolting Procedures	1-45

Press Alignment

<i>Press Alignment and Its Impact on Extrusion Performance</i> , from a webinar by Richard Dickson, Hydro Aluminum, and Chris Jowett, Rio Tinto Aluminum.....	2-3
Alignment Principles.....	2-15
Alignment Procedures Using Traditional Mechanic’s Tools.....	2-16
Use of the Alignment Tool Stack	2-24
Quick Checks of Press Alignment	2-26
Modifying the Press for Easier Adjustment of Alignment.....	2-28
<i>Laser Tracker Measurement Technology for the Alignment, Correction, Condition Monitoring, and Refurbishment of Extrusion Presses</i> , from Joseph Mulder.....	2-30

Tooling

Fixed Dummy Blocks.....	3-1
Loose Dummy Blocks.....	3-4
Clean-out Blocks	3-4
Stem.....	3-6
Container.....	3-8
Container Liner.....	3-10
Recent Improvements in Container Design	3-11
Development of a Thermally Stable Container	3-13
“ <i>Extrusion Container Care and Maintenance</i> ,” by James M. Pope, Special Projects Consultant to Lake Park Tool	3-17
Container Life and Relining Frequency	3-21
“ <i>Preventive Maintenance of Extrusion Tooling</i> ,” by Gary Dion, Extrusion Consultant.....	3-23
Minimizing the Occurrence of Flared Billets	3-28
“ <i>Press Tool Lubrication Systems</i> ,” by James Dyla, Amcol Corp	3-31

Inspecting and Repairing Major Components

Procedure for Repairing Cracked Main Cylinder	4-15
How Major Components are Designed and Tested.....	4-17
Analysis of Failure of a Container Shifting Cylinder Rod	4-19
“ <i>Adapting Extrusion Presses for a High Cycle Fatigue Load Environment</i> ,” by J.O. Nøkleby, Det Norske Veritas	4-22
In-Service Inspection, Repair, and Trouble-Shooting.....	4-25
Failed Components – Repair or Replace?	4-27
Requirements for Replacement Components	4-28
“ <i>Catastrophic Failure: A 48 Hour Remedy</i> ,” by Rick Colden and Adam Cramlet, Alexandria Extrusion	4-31
Additional Recommendations for Successful Component Replacement.....	4-36

Hydraulic Equipment.....

Hydraulic Oil.....	5-1
Filtration	5-5
Temperature	5-5

Sampling & Analysis	5-6
Air Breather.....	5-6
Pumps.....	5-6
Valves	5-8
Piping.....	5-8
Pressure Gauges	5-9
System Documentation.....	5-9
Troubleshooting	5-10
<i>"Proper System Maintenance to Avoid Contamination and Cavitation," by Jack Hayes, Oilgear.....</i>	5-14
Farrel Maintenance Training Course information:	
Hydraulic Maintenance	5-22
Right and Wrong Ways to Install Hydraulic Tubing and Fittings	5-24
Troubleshooting Hydraulic Problems.....	5-26
Glossary of Hydraulic Terms	5-30
ISO/CETOP Hydraulic Symbols.....	5-34
Oilgear Training Bulletins:	
Hydraulic System Survival Techniques #90012.....	5-37
Filtration Recommendations #90007-D	5-41
Piping Information #90011-F	5-49
Resistance of Valves and Fittings to Flow of Fluids.....	5-53
Storage Recommendations #90006B	5-54
Recommendations for Hydraulic Maintenance from a presentation by	
Jeff Grube, Rexroth, at AEC Workshop.....	5-57
Oil Sampling Procedures.....	5-59
Electrical & Controls.....	6-1
Maintenance of Control Equipment.....	6-3
Container Heating	6-7
Electric Motors	6-7
<i>"Extrusion Press Electrical Systems," by David Turnipseed.....</i>	6-10
<i>"Tips for Successful Electrical Trouble Shooting of Extrusion Equipment," by David Turnipseed.....</i>	6-15
"E-Stop" Emergency Stop Buttons	6-18
Grounding	6-19
Troubleshooting & Documentation.....	6-20
Billet & Log Infeed Systems	
Billet/Log Infeed Conveyors	7-1
Billet/Log Heaters - Gas Fired.....	7-4
Refractory and Insulation.....	7-5
Thermocouple Probes	7-5
Combustion Systems.....	7-10
Billet Heaters - Induction.....	7-29
Log Shear	7-31
Log Saw	7-33
Billet Transfer Conveyor	7-34
Billet Lubrication.....	7-35
Profile Handling Systems	
High Temperature Textile Materials	8-2
Lead-out Tables	8-4
Run-Out Conveyors	8-5
Water Quench Systems	8-9
Air Quench Systems	8-11
Saws and Shears for Hot Profile Cut-Off	8-13
Pullers	8-18
Profile Transfer Systems and Lift-Overs	8-22
Cooling Tables:	
Walking Beams.....	8-25
Belt Conveyors	8-27
Stretchers.....	8-29
Saw Feed Conveyors.....	8-32
Finish or Cold Saws	8-34
<i>"Aluminum Extrusion Saw Blade Lubrication," by James Dyla, Amcol Corp.</i>	8-38
Saw Length Gauges	8-43
Off-Load Conveyors.....	8-45
Profile Stackers.....	8-46

Age Ovens	9-1
Heat Treated – “T” Tempers.....	9-1
Temperature Surveys.....	9-3
Alternative Age Oven Configurations	9-5
Combustion Systems	9-8
Routine Combustion System Maintenance	9-21
Improving Age Oven Energy Efficiency	9-23
<i>“The Ageing Process for Extruded Aluminum Profiles,” paper by Al Kennedy</i>	9-24
Die Ovens	10-1
Temperature Uniformity.....	10-4
Maintenance.....	10-6
Maintenance Schedules	A-1
When to Perform Extrusion Plant Maintenance.....	A-2
Master Maintenance Schedule	A-5
Daily Maintenance.....	A-19
Weekly Maintenance	A-22
Monthly Maintenance	A-24
Quarterly Maintenance	A-28
Six Months Maintenance	A-29
Annual Maintenance.....	A-30
Spare Parts		
Recommended Spare Parts	B-1
Storage of Spare Parts.....	B-11
Modernizing Older Presses	C-1
Specifying and Purchasing a New Press.....	C-5
Modernizing the Press Feed Line.....	C-9
Modernizing the Handling System.....	C-13
Downstream Material Handling	C-17
Auxiliary Equipment.....	C-17
Complete Extrusion Press Rebuilds.....	C-19
Vendor Request form for Press Upgrades	C-22
<i>“The Extrusion Press Line for 2024: A Forecast,” by Al Kennedy</i>	C-24
Double-Length Run-out Systems	C-33
Safety & Environment	D-1
Extrusion Tooling Safety	D-2
Safe Lifting Techniques	D-6
Mechanical Press Equipment.....	D-7
Keeping Overhead Cranes Safe	D-8
Check List of Safety Hazards	D-10
Personal Protective Equipment	D-13
Lock-Out Tag-out Procedures	D-15
Environment	D-20
Managing Extrusion Plant Maintenance	E-1
The Maintenance Level Audit.....	E-1
Staffing and Required Skills	E-5
Maintenance Engineering – Continuous Improvement.....	E-6
Equipment Information Files and History.....	E-6
Spare Parts Inventory.....	E-7
<i>“High-Tech Tools for Extrusion Plant Maintenance,” by Al Kennedy</i>	E-10
Useful Tables:		
Conversion of Units	x
Temperature Conversion.....	xii
Calculating Stretcher Capacity – English Units	xiii
Calculating Stretcher Capacity – Metric Units	xiv
Weight of Extrusion Billets.....	xv
Press Specific Pressure – English Units	xvi
Press Specific Pressure – Metric Units	xvii
Millimeter Conversion.....	xviii
Time Limits for Tooling in Oven at Temperature	xix
Thermocouple Types.....	xix
Glossary of Terms for Press Components	xx
Diagrams of Press Components	xxii