

Instructions for Cleaning Elrod Plunger Well

Mold Housing and Sealing Valve

TO MAINTAIN AND EFFICIENT STRIP CASTING MACHINE, IT IS ESSENTIAL THAT THE CRUCIBLE PLUNGER, WELL, SEALING VALVE AND MOLD CHAMBER BE KEPT AS CLEAN AS POSSIBLE FROM FOREIGN DEPOSITS. THE GRAYISH BLACK SUBSTANCE WHICH FORMS ON THESE PARTS IS CAUSED BY OXIDATION OF TYPE METAL. THIS DEPOSIT CAN BE EASILY REMOVED BY THE USE OF LUDLOW LUBRICLEAN FLUID (A945), TO OBTAIN THE BEST RESULTS, CLEAN THE CRUCIBLE AT LEAST TWICE A WEEK IN THE FOLLOWING MANNER.

PLUNGER AND WELL

- 1 SEAL A MOLD IN THE CRUCIBLE MOLD CHAMBER TO PREVENT METAL FROM RUNNING OUT.
- 2 REMOVE PLUNGER FROM WELL (WITH A LARGE PAIR OF PLIERS), AND WIPE OFF LOOSE METAL AND DROSS.
- 3 APPLY LUBRICLEAN FLUID TO PLUNGER WITH ASBESTOS SWAB (964A) COVERING THE ENTIRE OUTER SURFACE.
- 4 OPEN SEALING VALVE, REPLACE PLUNGER IN WELL, AND WORK UP AND DOWN TEN TO FIFTEEN TIMES.
- 5 LEAVE PLUNGER IN WELL APPROXIMATELY THREE MINUTES.
- 6 REMOVE PLUNGER FROM WELL AND BRUSH OUTER SURFACE WITH WIRE BRUSH (No. 943).
- 7 IF THE PLUNGER HAS NOT BEEN GIVEN ANY ATTENTION FOR SOME TIME IT MAY NEED A SECOND TREATMENT. REPEAT THE FOREGOING.
- 8 AFTER CLEANING THE PLUNGER, APPLY A THIN COAT OF LUBRICLEAN TO THE OUTER SURFACE AND REPLACE IT IN THE WELL.

SEALING VALVE

- 1 SEAL A MOLD IN THE CRUCIBLE MOLD CHAMBER TO PREVENT METAL FROM RUNNING OUT.
- 2 REMOVE SEALING VALVE STEM AND WIPE OFF LOOSE METAL AND DROSS.
- 3 APPLY LUBRICLEAN WITH THE ASBESTOS SWAB, COVERING THE ENTIRE SURFACE OF THE VALVE STEM.
- 4 REPLACE VALVE STEM IN VALVE BODY AND ROTATE IN AN UP AND DOWN MOTION, THEN LEAVE IN PLACE ABOUT THREE MINUTES.
- 5 REMOVE VALVE STEM AND BRUSH WITH WIRE BRUSH AND WIPE CLEAN. APPLY A THIN COATING OF LUBRICLEAN AND REPLACE IN VALVE BODY.
- 6 IF THE SEALING VALVE HAS NOT BEEN GIVEN ANY ATTENTION FOR SOME TIME, IT IS ADVISABLE TO FOLLOW UP WITH ANOTHER TREATMENT.

MOLD HOUSING

- 1 SHUT OFF SEALING VALVE AND LOWER THE PLUNGER TO THE BOTTOM OF THE WELL TO STOP METAL FROM FLOWING IN TO THE MOLD HOUSING.
- 2 REMOVE THE DIFFUSION TUBE.
- 3 APPLY LUBRICLEAN TO INSIDE OF MOLD HOUSING THROUGH HOLE FROM WHICH DIFFUSION TUBE HAS BEEN REMOVED AND THOROUGHLY SWAB THE INSIDE WALLS.
- 4 TURN ON SEALING HEATERS UNTIL METAL IN INDICATOR ON TOP OF THE MOLD HOUSING IS MELTED.
- 5 SHUT OFF HEATERS AND SCRAPE INSIDE OF MOLD HOUSING WITH SCRAPER (AEC1715B).

LUDLOW LUBRICLEAN FLUID IS NOT ONLY APPLICABLE FOR CLEANING, BUT IS ALSO RECOMMENDED FOR LUBRICATING MACHINE PARTS SUBJECTED TO HEAT SUCH AS THE PLUNGER LEVER FULCRUM, PLUNGER LEVER YOKE PIN AND THE PLUNGER LEVER SAFETY PIN. TO PREVENT EXCESSIVE WEAR ON THESE PARTS, WE ADVISE LUBRICATING THEM DAILY.

ELROD CRUCIBLE CLEANING OUTFIT (AEC-1015)

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| SYMBOL No. | A-945 – 1 QT. | CAN LUBRICLEAN FLUID |
| “ “ | AEC-1715B | MOLD HOUSING SCRAPER |
| “ “ | 943 | WIRE BRUSH |
| “ “ | 946A | ASBESTOS SWAB |
| “ “ | 961B | WOOD CASE |
| “ “ | FI-82 | INSTRUCTIONS |