970 Tray Oven Graphite to Performance Fluids CL1800F1 Lubricant Change Guide

The following document details the whole process of performing the changeover.

Reasons for Change

- The product can be applied during production REDUCING oven down time.
- No flash point = NO FIRE RISK!
- No smell or fume.
- 4-week lubrication frequency provides extra production capacity during busy periods.
- NSF H1, Halal and Kosher Certified.
- Reduced Power Consumption, saving you kWh.
- White and CLEAN! (NO MORE GRAPHITE)

Change Over from Graphite

1. Prior to changing over, we would look to visit your bakery and inspect things before going forward.
2. In order to make the change the oven chains need to be as clean as you can get them, this can be performed by one of the following methods: -
    a. Ice clean the chains. (Preferred method)
    b. Pinging the chain with a hammer on the chain returns to knock off the graphite powder and wire brushing off the excess.
3. After cleaning remove the piles of graphite that have been deposited at the oven return feed end so that this does not get picked up again by the returning chain.

The cleaner the chain the easier it is to make the change!

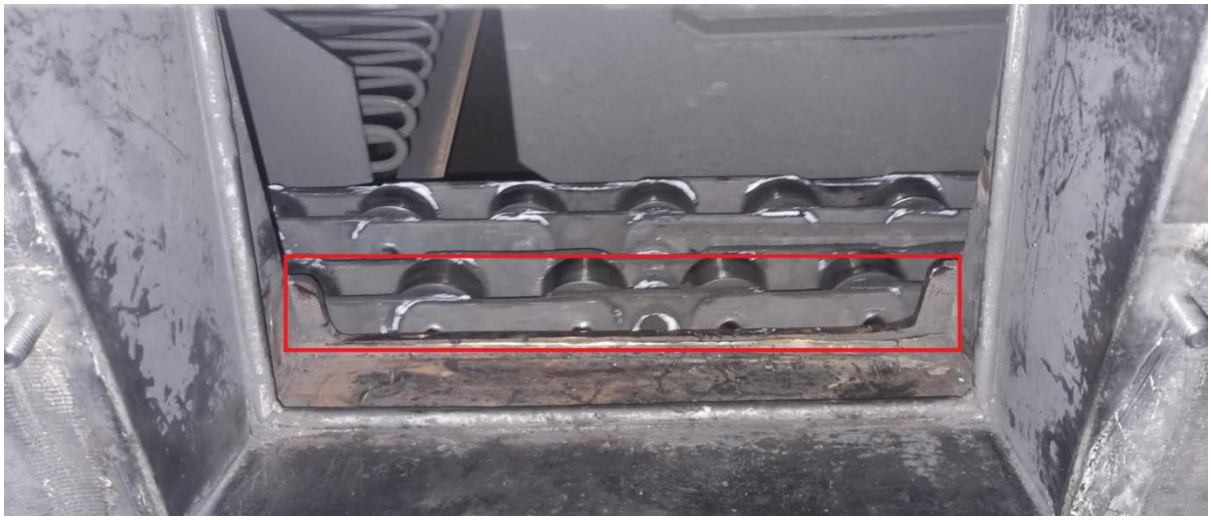
4. **Chain Roller Turning** - Ideally all the rollers need to be able to turn, this is so the CL1800F1 product will be pulled down into the chain's internal surfaces / moving parts. If the rollers cannot be seen to be turning as the chain passes the lubrication point hatch check if they still move by hand. If you are able to move the rollers by hand then this is fine, they will rotate at some stage as they travel around the oven and on the sprockets.

If you have a large number of seized rollers discuss this first before going ahead.

Lubrication Point

1. The oven chains and tray pins are to be lubricated from the oven side hatches.
2. It is important before making the change that correct access to the chain is possible at both these locations and the chain rails do not impede the chain. It has been noted on previous conversions that in some instances the chain rails have at some point been replaced and they then impede the chain. When this is the case, the rails will need to be cut down so that the required access is available.

Access is needed in the area outlined in red on both sides of the oven.



Lubrication Application

1. The CL1800F1 product is applied using the free of charge on loan Applicator as shown.

2. The chain is lubricated with the single tip attachment.

3. Here is a photo of the lubricant being applied to the chain.

4. The oven pins are lubricated with the Patent Pending Nozzle Attachment.

5. Here is a photo of the lubricant being applied to the tray pins.

Key Points for all Lubrications both Initial and ongoing

1. The square end of the nozzle applicator has been specially designed to fit in between 2 sizes of oven chain, even though the end looks square there is a slight difference, rotate through 90 degrees to identify the correct orientation to fit inside your chain.
2. During application It is important to see white CL1800F1 lubricant ooze out of the tubes that the tray pins rotate in as the CL1800F1 is injected.
3. Here are photos showing where the lubricant needs to ooze out of: -

Initial Lubrication

1. The Initial lubrication takes place in the following way: -
    a. 1 pass to lubricate the chain on the single side.
    b. 1 pass to lubricate the pins on the single chain side.
    c. 2 pass to lubricate both chains on the twin chain side.
    d. 1 pass to lubricate the pins on the twin chain side.

Second Lubrication (150 hours after the Initial Lubrication)

1. The second lubrication takes place in the following way: -
    a. 1 pass to lubricate the chain on the single side.
    b. 1 pass to lubricate the pins on the single chain side.
    c. 2 pass to lubricate both chains on the twin chain side.
    d. 1 pass to lubricate the pins on the twin chain side.

Depending on how clean the chain is (removed graphite) will determining if another lubrication is then required between 150 hours and 650 hours. We recommend you monitor your ovens current draw (Amps) and once you see a large increase in this area an additional lubrication is performed.

Ongoing Lubrications (Every 4 weeks / 650 hours)

1. Further lubrications take place in the following way: -
    a. 1 pass to lubricate the chain on the single side.
    b. 1 pass to lubricate the pins on the single chain side.
    c. 2 pass to lubricate both chains on the twin chain side.
    d. 1 pass to lubricate the pins on the twin chain side.