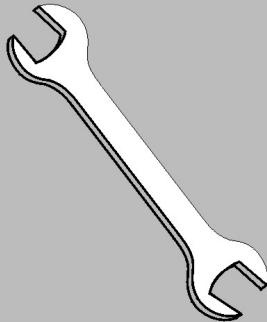


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Kit Instruction— KYSSRPV001



Please Read

About the Manual Identifying Information on the Cover

The front cover displays pertinent identifying information for this manual. Most important, are the published manual number (part number) /ECN (date code). Generally, when a replacement manual is furnished, it will have the same published manual number, but the latest available ECN. This provides the user with the latest information applicable to his machine. Similarly all documents comprising the manual will be the latest available as of the date the manual was printed, **even though older ECN dates for those documents may be listed in the table of contents.**

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References to Yellow Troubleshooting Pages

This manual may contain references to "yellow pages." Although the pages containing troubleshooting procedures are no longer printed on yellow paper, troubleshooting instructions, if any, will be contained in the easily located "Troubleshooting" chapter or section. See the table of contents.

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MSSM0958AE/9829AV
INSTRUCTIONS FOR
RETROFIT OF MILNOR SINGLE-STAGE PRESS
CAN PRESSURE REGULATING VALVE
VERSION 2.0
July 21, 1998
PAGE 1 OF 2

DESCRIPTION OF RETROFIT – The purpose of this modification is to change one (1) existing pressure regulating valve cartridge P/N 96DH475A to a newer version of this cartridge which will provide better regulation of can pressure. The new cartridges are being installed on all Milnor Single Stage Presses currently in production.

The Milnor Service Department estimates that a maximum of one half (1/2) man-hour will be required to accomplish this modification. Milnor will reimburse up to two (2) man-hours of labor to perform this retrofit. The old can pressure regulating valve (marked PFBF-LAN on the nut portion of the valve) and a bill for the labor should be sent to the Milnor Service Department, attn: Harold Daigle, in order to be reimbursed for the labor cost.

MAKE THE MACHINE SAFE FOR PERSONNEL ACCESS – This retrofit requires that personnel enter the interior areas of the machine where the hydraulic cylinders which position the can are located. Prior to any personnel entering the machine, the following must be accomplished:

- Using appropriate manual functions, move the can to the full-down position.
- Lock off and tag out electrical power to the machine at the external disconnect box.

CHECK THE KIT CONTENTS – Upon receipt of this retrofit kit, check and verify that it contains the following:

- (1) Part Number 96DH475A valve cartridge
- (1) Retrofit instructions

If any kit components are damaged or missing, contact the Milnor Parts Department.

TOOLS REQUIRED – In order to remove and replace the valve cartridge the following tools are required:

- 1 – 1/8” (29 mm) socket, at least 1 – 1/8” (29 mm) deep;
- Torque wrench with full-scale range of at least 100 ft-lbs. (135 newton-meters);
- 4 mm Allen wrench (to adjust valve cartridge).

WARNING

Prior to removing the existing valve cartridge, check and verify that the can is in the full down position. If the can is not fully down and the cartridge is removed the can will fall rapidly and uncontrollably, possibly causing damage to the machine and/or personnel injury.

There will be approximately four (4) ounces of hydraulic fluid leakage from the valve block when the cartridge is removed. Remove the cartridge slowly to avoid being sprayed with fluid. **SAFETY GLASSES SHOULD BE WORN AT ALL TIMES!**

MSSM0958AE/9829AV
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VERSION 2.0
July 21, 1998
PAGE 2 OF 2

REMOVE THE EXISTING VALVE CARTRIDGE – Locate the existing 96DH475A valve cartridge (it is marked PBF-B-LAN on the nut portion of the cartridge) as shown on Figure 1 and in the machine's service manual (reference BMP970014, Milnor SS Press Hydraulic Schematic). With the can in the down position, and using a 1 – 1/8" (29 mm) wrench, remove the valve cartridge from the machine. This cartridge is to be returned to Milnor; contact the Milnor Service Department for shipping instructions.

REPLACE THE VALVE CARTRIDGE – Clean up any hydraulic fluid which has leaked out as a result of removing the old cartridge. Thread the new cartridge into the valve block (it is marked PBF-B-LWN on the nut portion of the cartridge). Torque the cartridge to 45 – 50 ft-lbs. (60 – 70 newton-meters)

DISCONNECT THE CAN UP PROXIMITY SWITCH – Prior to performing adjustments on the replaced valve cartridge, it is necessary to disconnect the top proximity switch which senses the full-up position of the can. Unplug the electrical connector from the proximity switch body. Cover the exposed electrical contacts on the proximity switch body and the connector to protect them while they are disconnected. Temporarily relocate the electrical connector and wire away from the can.

REAPPLY POWER TO THE MACHINE – Reconnect main power to the machine and energize appropriate control circuits.

ADJUST CAN PRESSURE – Using appropriate manual functions, command the can UP. Because the can proximity switch has been temporarily disconnected the can will travel upward until it contacts the hard stop. Observe the can pressure gauge on the press hydraulic gauge panel and, using a 4 mm Allen wrench, turn the adjusting screw on the valve cartridge until the pressure reads 600 PSI.

RECONNECT THE CAN PROXIMITY SWITCH – Using appropriate manual functions, command the can DOWN. Reconnect the electrical wiring to the proximity switch.

TEST THE SYSTEM – Using appropriate manual functions, command the can UP. Observe the can pressure gauge. Verify that pressure remains within the normal range and that the can up proximity switch functions correctly.

INSTALLATION COMPLETE –

- Replace all machine guards and cosmetic panels and secure all electric box doors.
- Return the machine to normal (automatic) operation.
- If there is a problem, contact the Milnor Service Department at (504)467-9591, Extension 75.