

**KNOWLEDGE BASE**

Article Type: Instructions

**CPM Feed Drawer Seal Kit
(Self Adjusting)****Description:**

Instructions on “How to” install Feed Drawer Seal Kit conversion on CPM Series machines.

WARNING

Never work on, clean or service this unit, control panel or any machine or open or remove any protective cover, guard, grate, door, or maintenance panel until the power or energy sources has been turned off, locked out / tagged out, and all moving parts have come to a complete stop and or blocked to prevent movement. Machinery is dangerous - avoid personal injury and or death by following manufacture, Local, and OSHA safety procedures. Contact Columbia Machine for safety decals, guards, horns and beacons.

CPM - Feed Drawer Seal Kit (Self Adjusting)

Tools needed for seal kit installation: magnetic drill, drill bits, counter sink bit, hand wrenches, tape measure, square, hammer & center punch, see prints for drill sizes.

1. Inspect parts kit for damaged. Using the assembly prints check for missing parts or hardware.
2. Place the feed drawer section in a suitable position for feed drawer removal.
3. Turn off pumps and follow lockout/tagout procedures.
4. Disconnect the two (2) agitator hydraulic hoses and probe wires. Using approved lifting chains or straps remove the feed drawer from rear section.
5. Place feed drawer on adequate work stands/supports and remove the old style side and rear seals, along with mounting brackets.
6. Using supplied installation prints, layout feed drawer for new hole locations on both sides. Drill all holes, counter sink as needed for flat head fasteners.
7. Dry fit the rear blade as some feed drawers may need the inside welds ground flat. Ends of blade may need trimming, as well.

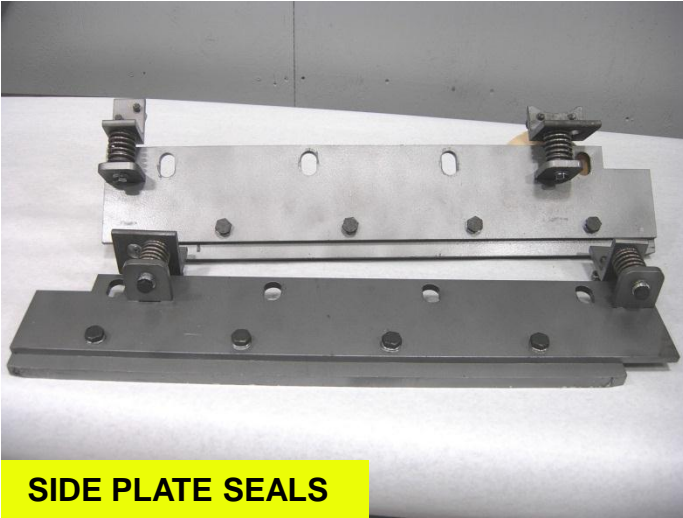
388.2.10

CPM - Feed Drawer Seal Kit (continued).

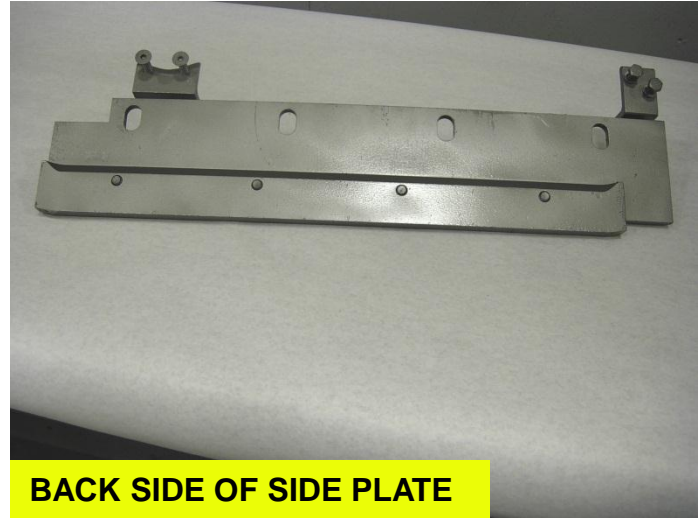
8. For ease of installation, preload the springs by installing and tightening center tension nut and bolt to compress .
9. Mount springs , install rear blade and dirt guard, and install side wear bars.
10. With all parts mounted, remove the spring tension nut and bolt from all six (6) positions.
11. Install a new bottom wear plate on top plate.
NOTE: do not reinstall the side pan angles, these are not needed.
12. Reinstall the feed drawer, be sure to connect hydraulic hoses and probe wire.
13. Unlock pump and start pump.
14. With machine in slow operation move feed drawer section back into running position over mold.
15. Using selector switch move the feed drawer forward and back three to four times checking for any clearance problems and correct as needed.

For further information

Please contact Columbia Machine Service department @ 800-628-4065 or 360-694-1501



SIDE PLATE SEALS



BACK SIDE OF SIDE PLATE

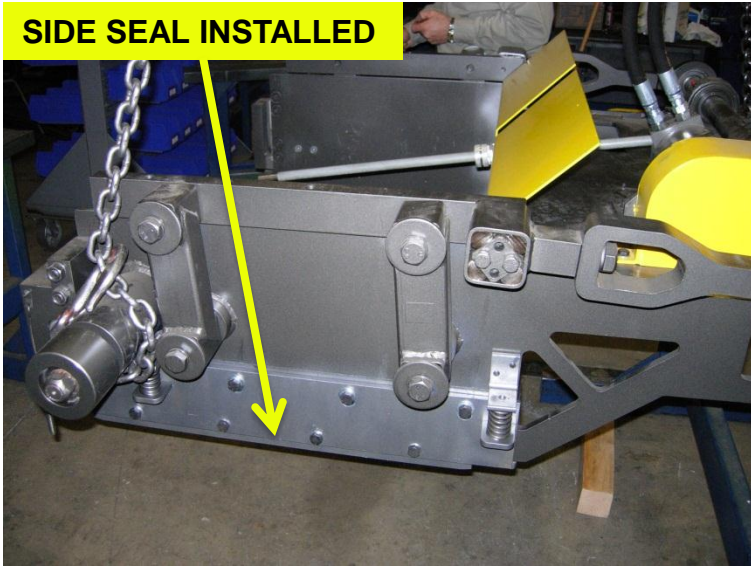


REAR SEAL PLATE

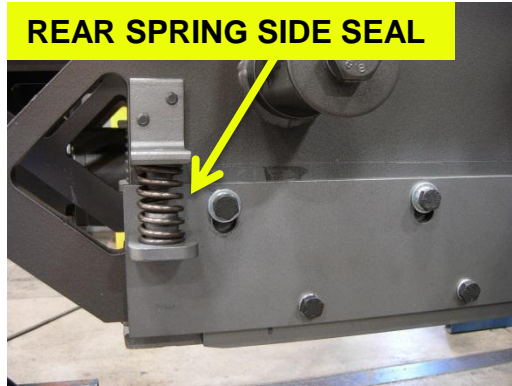


REAR SEAL PLATE COVERS

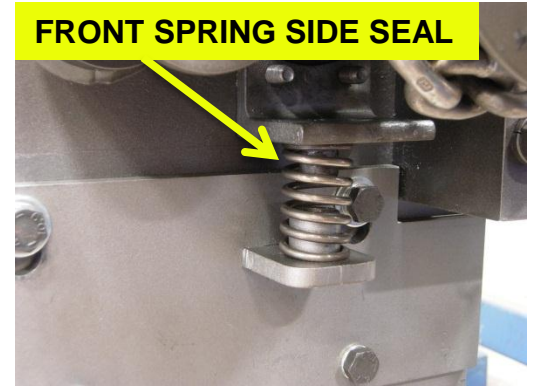
SIDE SEAL INSTALLED



REAR SPRING SIDE SEAL



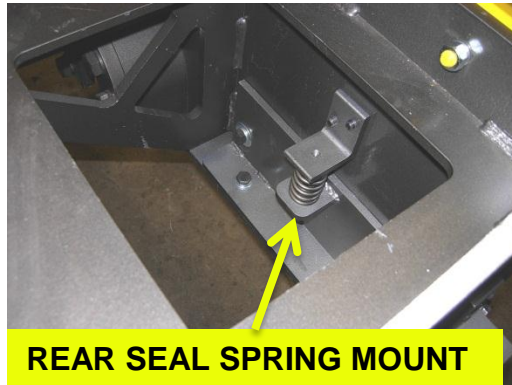
FRONT SPRING SIDE SEAL



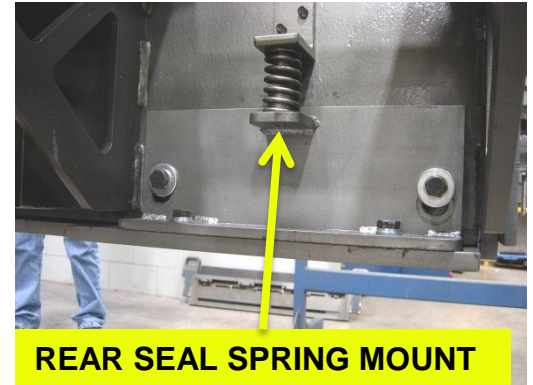
REAR SEAL INSTALLED



REAR SEAL SPRING MOUNT

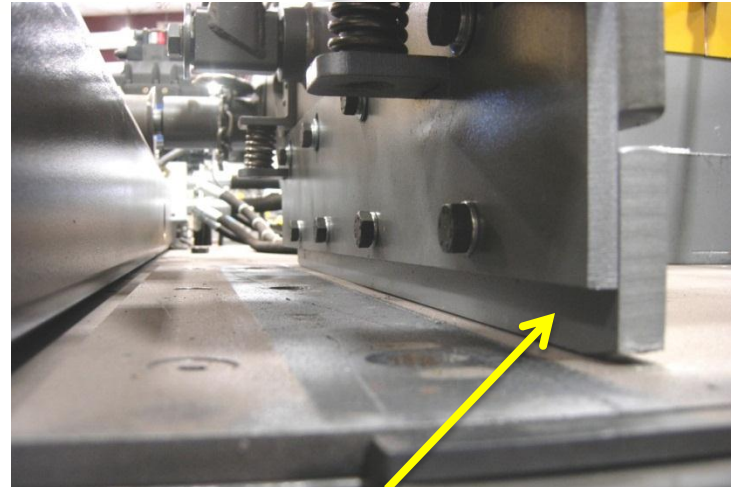


REAR SEAL SPRING MOUNT





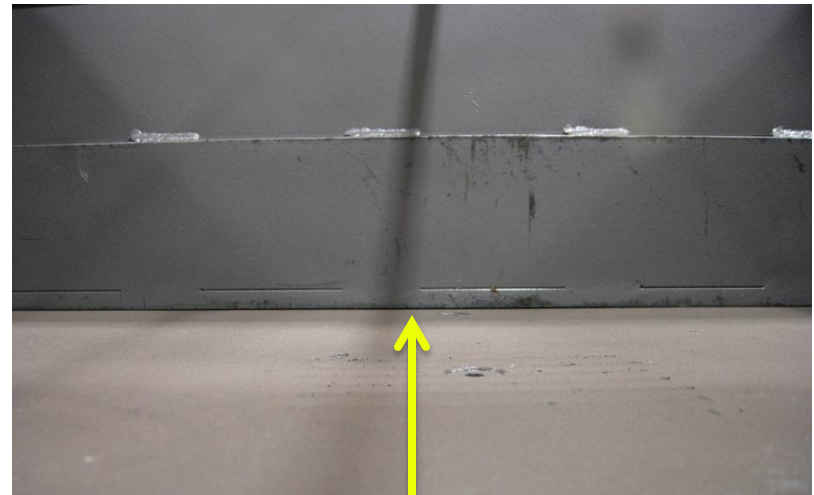
BOTH SIDE AND REAR SEALS INSTALLED



SIDE SEAL WITH SIDE PAN REMOVED



**SELF ADJUSTING SEALS WITH
FEED DRAWER INSTALLED**



**REAR SEAL INSTALLED AND BOTTOM
WEAR PLATE**