

# 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.

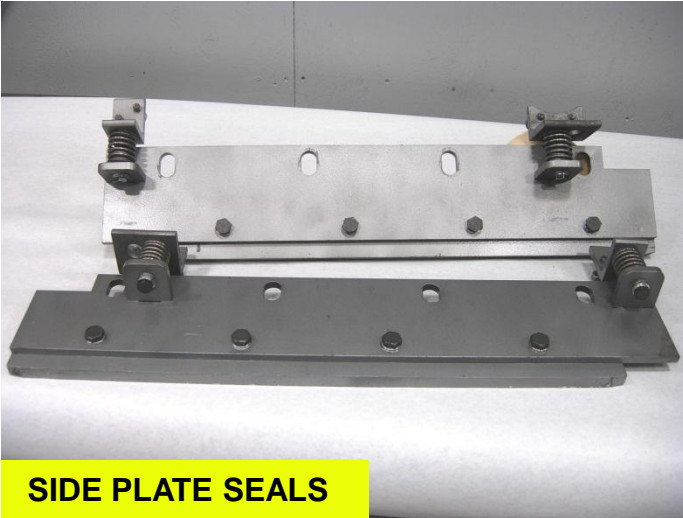
1. Inspect parts kit for damaged. Using the assembly prints check for missing parts or hardware.
2. Place the feed drawer section in a suitable position for feed drawer removal.
3. Turn off pumps and follow lockout/tagout procedures.
4. Disconnect the two (2) agitator hydraulic hoses and probe wires. 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**

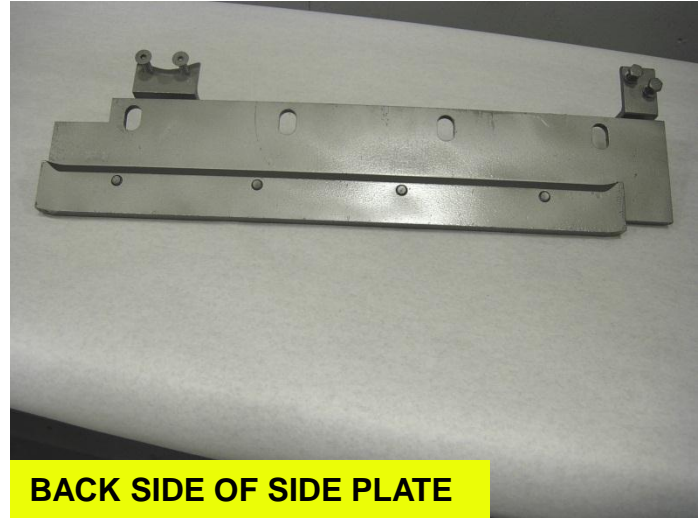
## CPM - Feed Drawer Seal Kit (continued).

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**

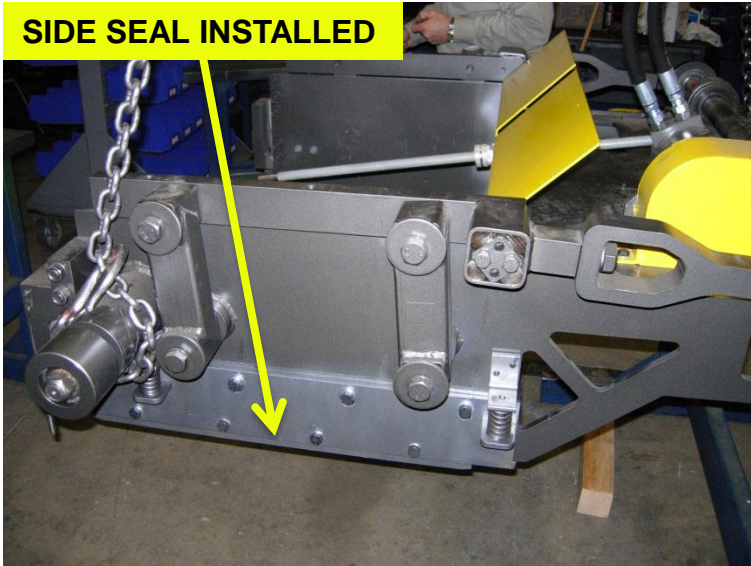


**REAR SEAL PLATE**

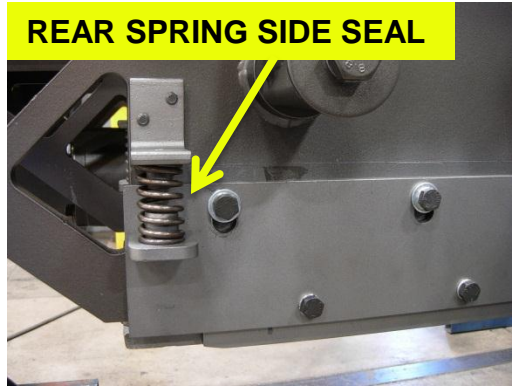


**REAR SEAL PLATE COVERS**

SIDE SEAL INSTALLED



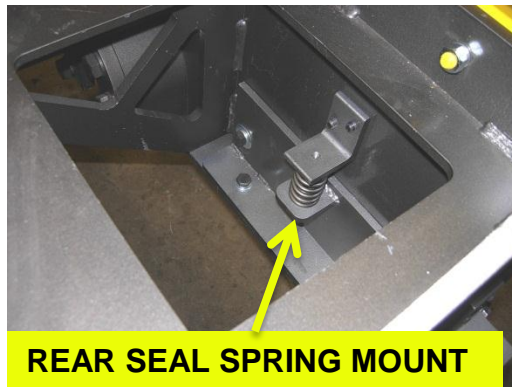
REAR SPRING SIDE SEAL



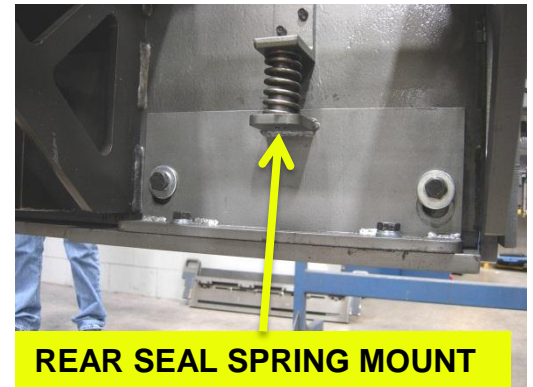
FRONT SPRING SIDE SEAL



REAR SEAL INSTALLED



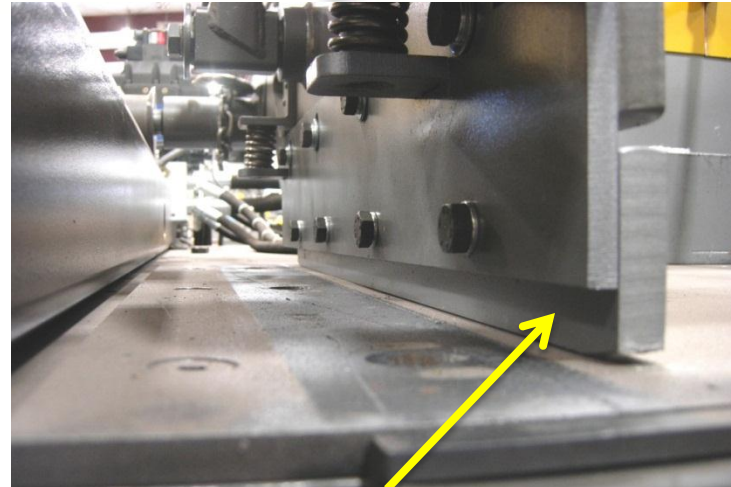
REAR SEAL SPRING MOUNT



REAR SEAL SPRING MOUNT



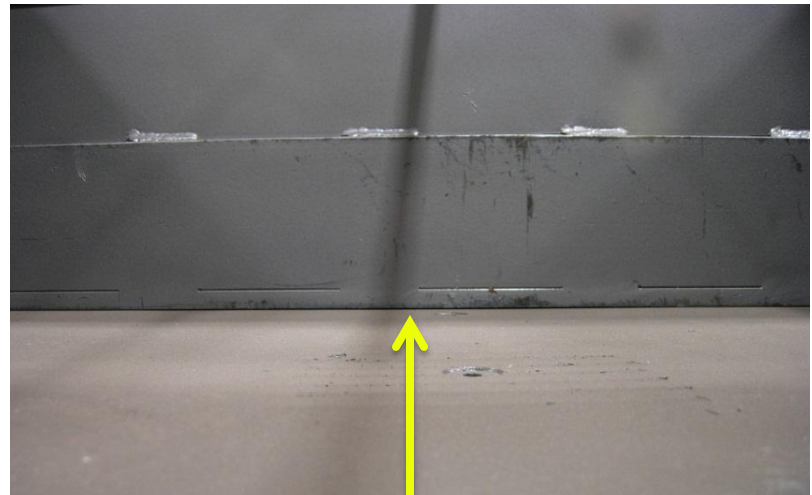
**BOTH SIDE AND REAR SEALS INSTALLED**



**SIDE SEAL WITH SIDE PAN REMOVED**



**SELF ADJUSTING SEALS WITH  
FEED DRAWER INSTALLED**



**REAR SEAL INSTALLED AND BOTTOM  
WEAR PLATE**