

DIE BREAK IN PROCEDURE

A. Material Needed

1. Two gallons (8 liters) new mineral oil.
2. Two bushels whole oats
3. Twenty five pounds (11kg) sand with a coarse grain size similar to table salt.

B. Procedure

1. Mix oil and oats together
2. Mix three to four handfuls of sand into mixture (use shovel to mix)
3. Cover cooler inlet with a sheet of wood or metal
4. With pellet mill door closed, start pellet mill and then centrifeder * (follow any safety procedures)
5. Feed the mixture into the pellet mill through the centrifeder inspection door – feed in as fast as possible – without plugging mill or overloading the motor amperage.
6. After all of the mixture has been pelleted and collected underneath the pellet mill discharge, mix in three or four more handfuls of sand.
7. Again, feed mixture through mill as fast as possible
8. Stop pellet mill – be sure all holes in die are pelleting, punch out any holes that are not extruding. If this is not done immediately, it becomes progressively harder to polish these holes.
9. Repeat procedures 6, 7, and 8 for fifteen or twenty minutes or until holes polish on the surface. The die inlet should look like a polished piece of chrome.

Note: The die holes must be open enough to receive the break in material. If not, the die will have to be punched out before this procedure will be effective.

* Disregard centrifeder if not equipped.