



Executive Office
255 E. Brown Street
Birmingham, MI 48009
Phone: 248-433-1824
Fax: 248-433-1824
Fax2: 248-594-3433

Machine Division
3110 Permawick Drive
Columbus, IN 47201
Phone: 812-376-0703
Fax: 812-376-8305

PERMAWICK

The Industry Standard for Fractional Horsepower Motor Lubrication

Service Manual

for the

MT-2000

Permajector

DUAL INJECT, 6 STATION PERMAJECTOR

Ver. 1.0

Table of Contents

Machine Setup/Power Connections	1
Controls	2
Air System Filtration	3
Metering System	4
Permawick Hopper and Pump Unit	5
Service Policy	6

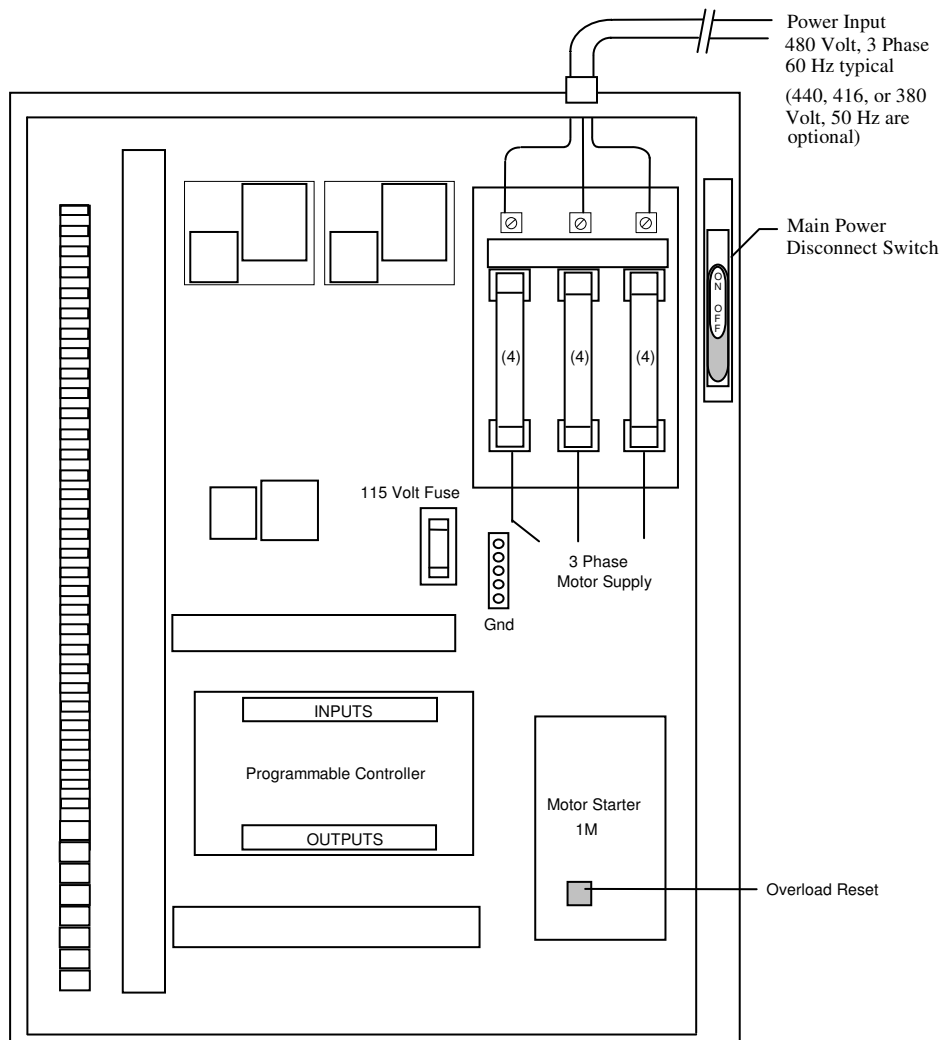
Machine Setup and Power Connection

Remove the Permajector from shipping crate and place it level on the floor. It is not advised to use the shipping skid as a machine base.

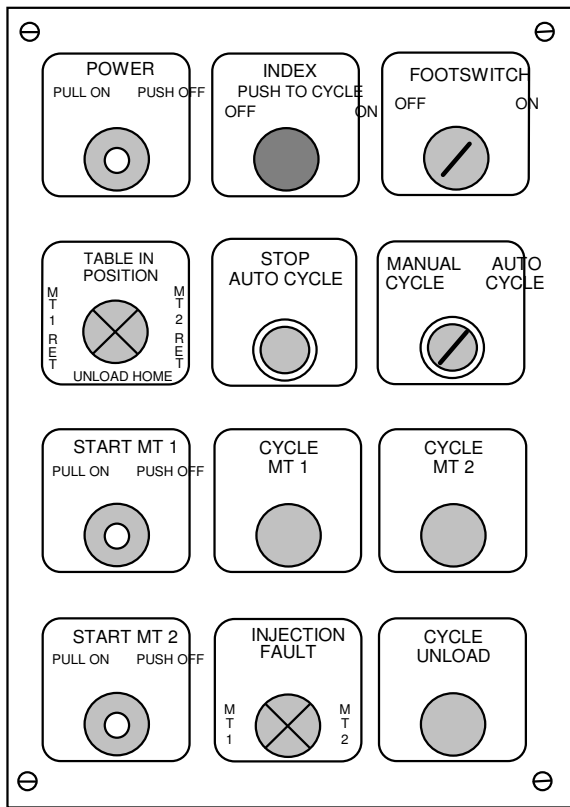
Connect air supply to the Filter-Regulator-Lubricator (see page 3) and maintain approximately 70 PSI. A fitting to adapt to your air system may be required.

Connect electrical supply. Power to supply the Permajector could be 380, 416, 440, or 480 Volts/50 or 60 Hz and must be specified.

Using one bucket of Permawick to start with, place the bucket upside down on the floor for 15 to 30 minutes before putting the Permawick in the hopper. This will provide even distribution of oil throughout the Permawick material.



Machine Controls



POWER: Pull to turn the machine on. This enables main po and air supply to the machine. Push to turn off the machine

INDEX: When in the ON position, the table can be indexed t station while in manual by pressing this button.

FOOTSWITCH (optional): Enables/Disables the use of the fi to cycle operation.

CYCLE STATUS: Indicates when both systems are ready to another cycle.

STOP AUTO CYCLE: Halts automatic operation.

MANUAL/AUTO: Allows the operator to single cycle in manu or continous operation in auto.

START MT 1: Supplies power to the unit, allows operation w inject station on line.

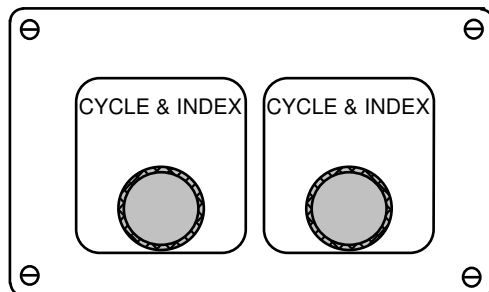
CYCLE MT 1: Used during manual operation to inject as nee

CYCLE MT 2: Used during manual operation to inject as nee

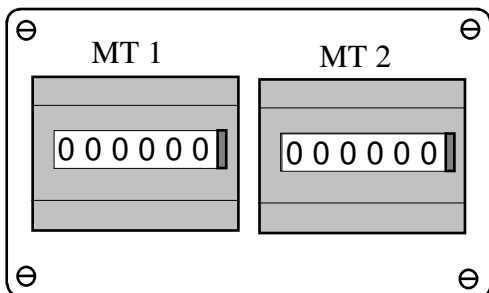
START MT 2: Supplies power to the unit, allows operation w inject station on line.

INJECTION FAULT: Indicates when a problem has been det either inject stations.

CYCLE UNLOAD: Used during manual operation to cycle th unload station.



During automatic operation, when green Cycle buttons are pressed simultaneously then released, the machine will complete 1 cycle of a operations, and, will continue as p are loaded.



The counters will keep the accum of cycles/parts run for MT 1 and N Push to reset to zero.

Air System Filtration

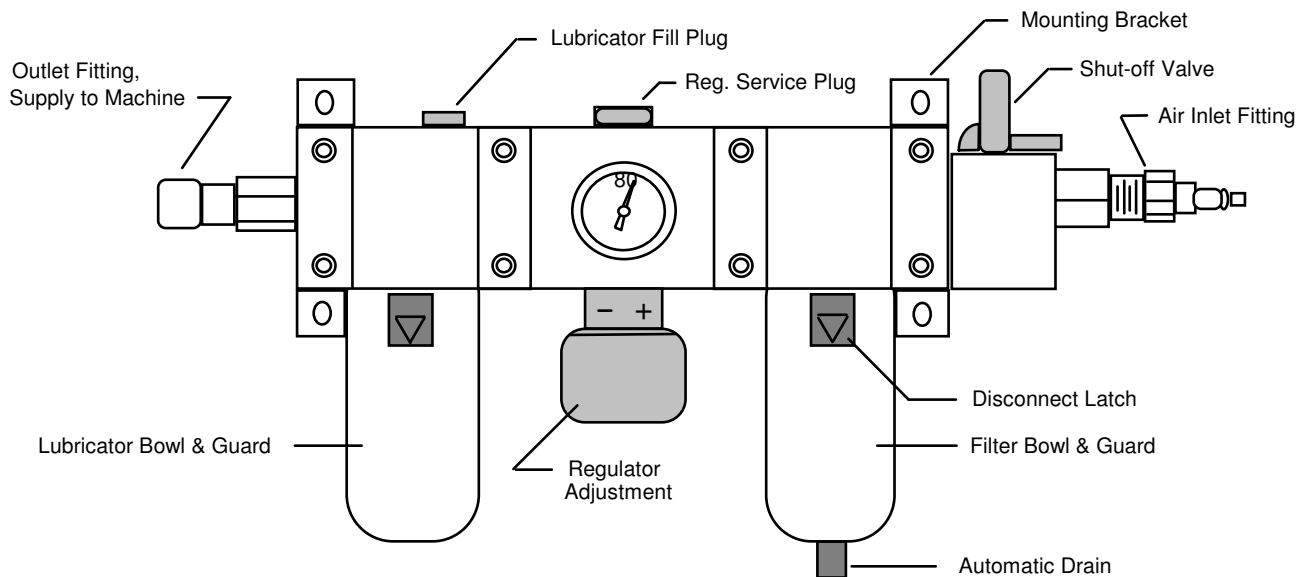
After connecting your air supply, turn the shut-off valve to the ON position. Proper air pressure (70 PSI) can be obtained using the regulator adjustment knob. When servicing the machine, the shut-off valve can be locked out in the off position.

WARNING ! Before performing any maintenance to the F-R-L, turn valve to the OFF position, and vent any pressure in the system.

The Filter unit will separate contaminated liquids from the air, and will collect in the bowl. The Bowl will be cleared of liquids automatically by the Automatic Drain or, turn the air off and remove bowl to clean.

The Lubricator will continuously supply lubricant throughout the air system. Add oil to the Lubricator bowl as needed via the Fill Plug. Recommended oil is SAE-10 or similar light oil for air systems.

Filter-Regulator-Lubricator

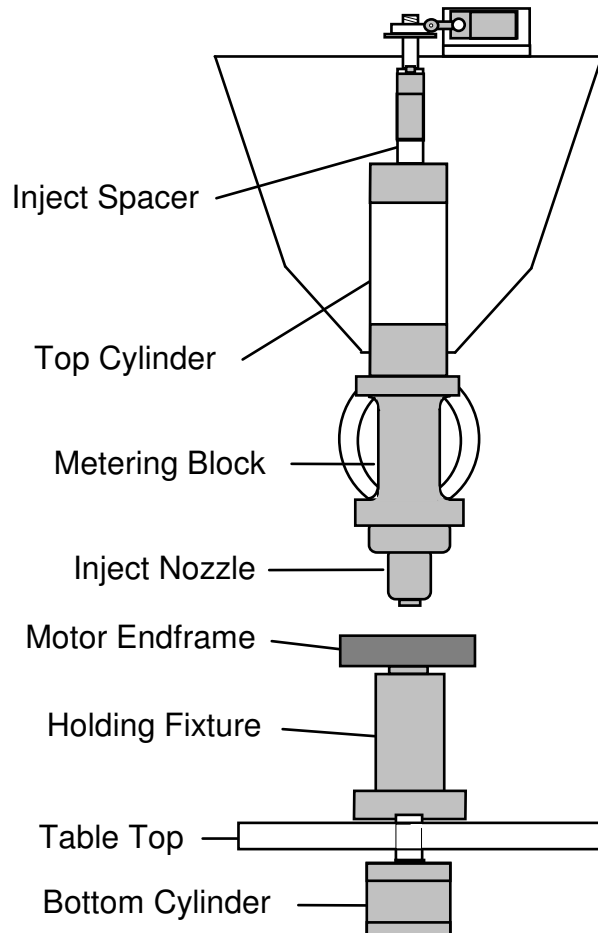


Metering System

The Metering System Assembly controls the amount of Permawick that will enter the endshield cavity during the injection. The amount of Permawick to be injected can be regulated by the metering system injection spacer. For example: a thinner spacer would increase the shot amount of Permawick material injected.

The bottom air cylinder (#2) under the table will locate the part to be injected, to the injection nozzle, then the top air cylinder (#1) will extend and make the injection.

Holding fixtures and nozzles are individually designed per application to provide a suitable fit for parts to be properly positioned together. Usually a rubber seal will be used on the nozzle assembly and/or the fixture assembly to ensure Permawick is injected in the proper areas, and to permit proper bearing contact. Check these rubber seals for wear frequently. Replacements can be ordered from Permawick Company. See the tooling drawings for rubber seal part numbers.

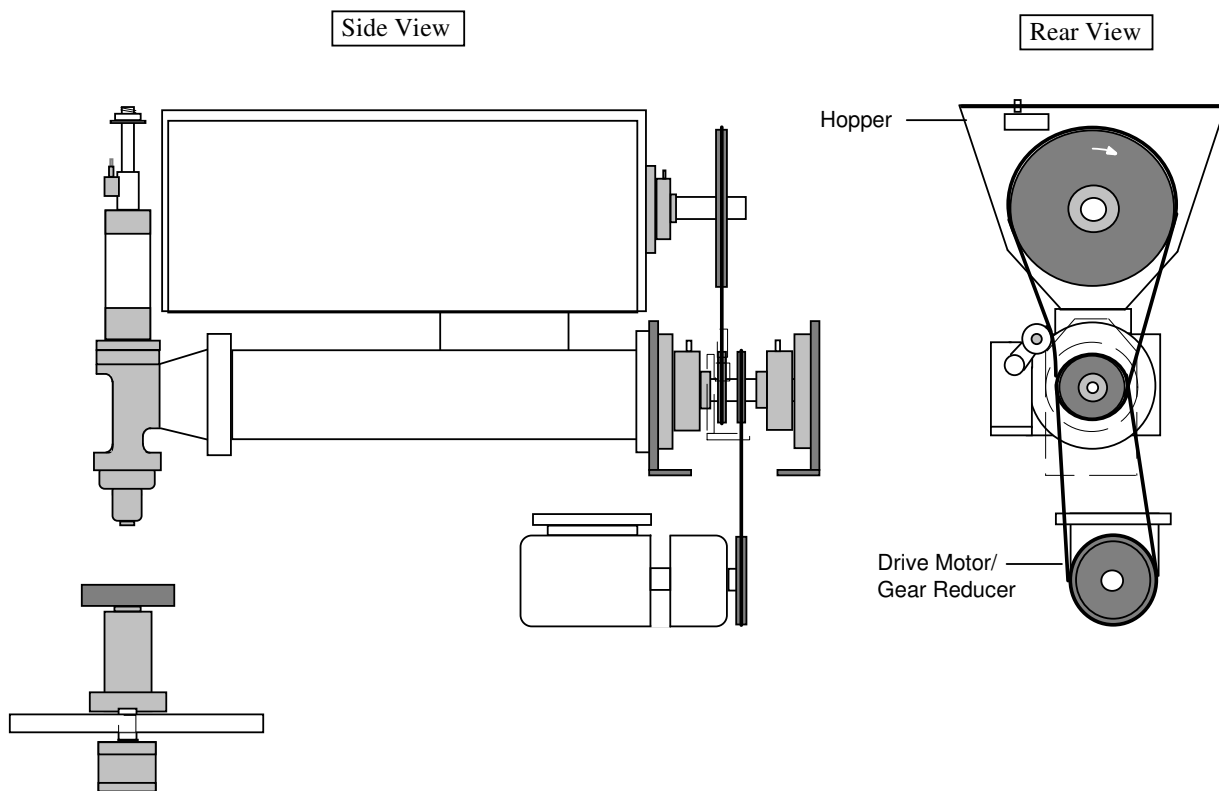


Hopper and Pump Unit

Overall, the Permajector (all components included) requires minimal maintenance. However, listed below are some typical maintenance guidelines to follow.

MAKE SURE THE ELECTRICAL AND AIR SUPPLY IS TURNED OFF AND LOCKED OUT BEFORE PERFORMING ANY TYPE OF MAINTENANCE TO THE MACHINE.

1. Occasionally check the chains for wear and proper tension. Chain tension should not be overtightened, this could cause premature wear of bearings.
2. Grease fittings, apply a minimal amount as needed to auger shaft bearings, and idler gear.
3. Check lubricant level in the gear reducer.
4. Occasionally clean the inside of the Permawick Hopper, only if noticeable amounts of Permawick residue is sticking to the walls of the Hopper for long periods of time.



Components such as controls, air valves, air cylinders, limit switches, and the hopper motor, are all standard parts that can be easily obtained from industrial suppliers. Parts for the hopper assembly, transmission/pump, and metering system must be ordered from the Permawick Company.

Replacement parts for the hopper assembly and metering system will be covered under a 1 year warranty by Permawick. Standard and purchased components will be warranted by Permawick for 90 days. Warranties will be voided if the damaged assembly has been tampered with.

It is not recommended that a Permawick customer attempt major repairs to a metering system, or the transmission/pump assembly. Although they rarely require major repair, these units usually provide ample warning of impending failure. If it is determined that an assembly is in need of remanufacture, please contact a Permawick representative.

**Ordering Information:
Permajectors, components, Permawick**

Executive Office
Phone 810-433-3500
Fax 810-433-1824
32400 Telegraph Road - Suite #102
Bingham Farms, MI 48025

Technical Support

Machine Division
Phone 812-376-0703
Fax 812-376-8305
3110 Permawick Drive
Columbus, IN 47201