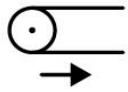


Wire drive



Check whether the rollers of the profiling unit are worn. In this case, you can adjust the wire feed roller by approx. 3 mm to get a new wire passage position. Do not forget to order new profiling rings after this.

CM article no. 006730

Pneumatics / cooling



NOTE

For more information refer to [chapter 5.7.2](#)



Both cooling circuits (cold and warm water) have to be replaced every 6 months during multiple shift production or every 12 months during single shift production.

The cold water circuit has to be cleaned before the replacement.

For this, follow the instruction below:

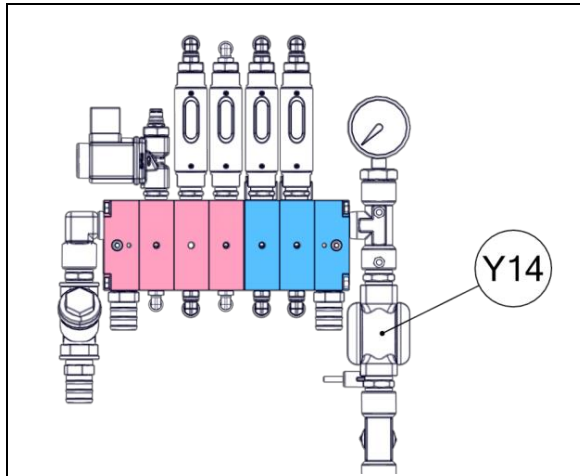
Cleaning of the cooling circuits without production

NOTE

The cleaning process must be done without production. Reason of this are the silver contract in the lower welding roll (PowerROLL), which could be damaged in a cleaning process during production.

WARNING

Inappropriate cleaning of the emulsion system may reduce the service life of the emulsion.



1. Stop production.
2. Open the water valve Y14 (2) on the water station in the settings.

NOTE

For the required water quality please refer to [chapter 5.7.1](#).



3. Pour 5 liters of water into a clean receptacle.
4. Slowly add 3.5 litres of the PowerRoll H1 system cleaner and keep stirring until the cleaner is thoroughly mixed.

NOTE

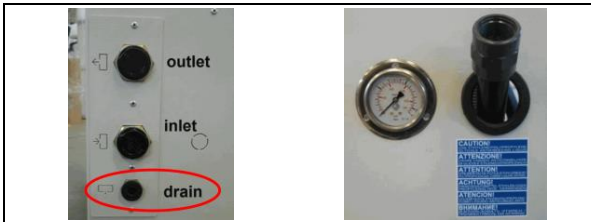
Refer to [Safety data sheet](#) of the system cleaner

Suitable for use in food

Cooling system cleaner PowerRoll™ H1
(suitable for use in food)
Dose 5 – 6%

CM article no.

011495
(1l container)



5. Open the drain tap of the cooling unit and drain 5 liters of emulsion.
6. Pour the cleaning emulsion into the filling nozzle of the cooling unit.
7. Start the pump and run it for 5-8 hours without interruption

NOTE

Dispose the cooling emulsion in accordance with the local regulations.

Waste disposal

8. Empty the tank and the whole cooling circuit and dispose the cleaning emulsion.

Rinsing the tank

NOTE

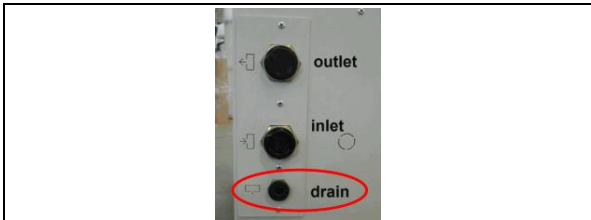
For the required water quality please refer to [chapter 5.7.1](#).



1. Fill in 70 litres of water into the filling nozzle of the cooling unit.
2. Start the pump and run it at least 5 minutes without interruption.

NOTE

Refer to [Operating manual cooling unit](#)



3. Empty the tank and the whole cooling circuit.
4. Clean the condenser according to the supplier's instructions.

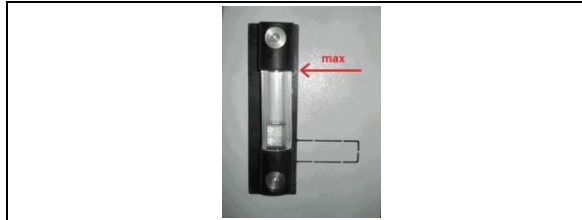


5. Replace the fine filter in the fine filter unit
- CM Article no. 002446

Refilling the cooling circuits

NOTE

For the required water quality please refer to [chapter 5.7.1](#).



1. Refill the tank and cooling circuit with 70 liters of water.
2. Put the cooling additive (dosage see below) into the cold water circuit.

NOTE

Use the cooling additive only in the water circuits with cold water (blue in the cooling diagram).

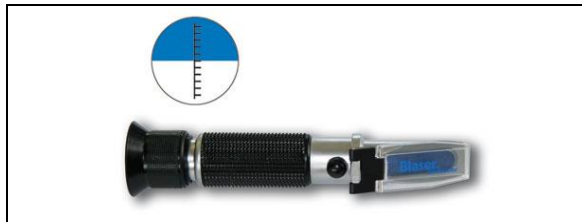
Refer to cooling system in [chapter 4.3.4](#).

Refer to [Safety data sheet](#) of the cooling additive

Suitable for use in food

Cooling additive PowerRoll™ H1
(suitable for use in food)
Dose 5 - 6%

CM article no.
011494
(7l container)



3. Check the mixing ratio of the cooling water in the cold circuit with the help of a refractometer. The emulsion content should be approx. 5 – 6 %.



The emulsion mixing unit works according to the principle of a jet pump. It is used to create a stable and homogeneous emulsion.

CM article no. 002612