

# Lubrication Requirements

## Die Drive Unit

Lubricating oil for use in enclosed gear units with anti-friction bearings should be of high quality, turbine grade, well-refined, straight mineral oil within recommended viscosity as noted in chart.\* It must not be corrosive to gears or bearings. It must be neutral, and free from grit or abrasive material.

Check dip stick on top of gear case in matching compartment for correct oil level. Remove pipe plug in top cover of gear case to fill. Refer to lubrication plate on side of change gear compartment door.

\*Chart V

## Cam Drive Unit

Use a compounded steam cylinder oil containing 5% to 10% acidless tallow having a viscosity of about 145 S.U.V. at 210°F. Fill oil through oil cup in change gear compartment. Check oil sight gage along side oil cup for level.

## Recommended Oil Changes

After a gear unit is first installed and filled with oil the original oil should be changed at the end of first or second week, flushing the case thoroughly with a light flushing oil. Following this, a change of oil every three months should be sufficient unless there are unusual temperature conditions or the lubricant becomes contaminated with dust, dirt, water, etc. In this case a change of oil may be necessary at from one to two month intervals.

## Work Coolant and Lubrication of Die Holder Spindles

Use oils recommended in Table XIII or a compounded cutting oil of the following characteristics.

Viscosity at 100°F.	175-250 S.U.V.
Saponifiable	8.0-10.0%
Sulphur	1.0-3.0%

Keep oil reservoir filled at all times for best results. A marked reduction in volume of coolant may be an indication that filter cartridge is becoming clogged with dirt and foreign particles. Change filter cartridge at this point. Clean strainer in reservoir and sediment at bottom of settling out section of reservoir every week. When oil has become contaminated with minute particles that are not filtered out, the system should be flushed out and new oil introduced.

## Lubrication Pump Pressure

The lubrication pump pressure should not drop below fifty pounds with Die Holders installed and coolant lines open.

## Motor

The standard motor has anti-friction bearings. Some makes have lifetime grease sealed bearings while others require lubrication every four to six months. Use motor manufacturer's specifications.

TABLE XII  
LUBRICATION CHART

Lubricant Application	Die Drive Unit	Cam Drive Unit	Work Coolant and Die Holders	Pivot Blocks	Oscillating Head, Cam Lever Unit
Method	Bath	Bath	Pump Circulation	Pump Circulation	Pressure Grease Fittings
Reservoir Capacity	4 Pints	9 Pints	13½ Gallons		
*Frequency	Check Oil Level Weekly	Check Oil Level Weekly	Keep Filled	Keep Filled	Weekly
Viscosity S.U.V.	700-1000 @ 100°F.	145 @ 210°F.	175-250 @ 100°F.		

\*Refers to Recommended Oil Changes.

## Chart V

# Reed® A22 Cylindrical Die Thread Rolling Machine

The brand name lubricants listed in **bold type** on this chart are the standard approved and recommended lubricants used at Reed® for the proper lubrication of this machine. All other brand name lubricants on this chart are alternate manufacturer's suggested substitute products and may or may not be exact replacements. These lubricants are benchmarks and do not relieve the lubricant supplier of the responsibility to supply the correct product for particular conditions. This chart includes product code numbers (PC) which can be used to obtain material safety data sheets.

OIL COMPANY	DIE DRIVE GEAR BOX	CAM DRIVE GEAR BOX	WORK COOLANT DIE SPINDLES PIVOT BLOCKS UNIVERSAL JOINTS CHANGE GEARS	OSCILLATING HEAD BEARINGS CAM LEVER BEARINGS CAM ROLLER BEARING FLEXIBLE COUPLING #1		AIRLINE LUBRICATION VALVES, CYLINDERS, ETC.
				HAND GUN	AUTOMATIC	
EXXON		Cylesstic TK 460	Pennex N47	Andok B PC 419100	---	Nuto H32 PC 363010
FISKE	Lubriplate CP-8 Gear Oil PC 14040	Lubriplate CP-7 Gear Oil PC 13940	Fiske's 405 Cutting Oil PC F0587	---	<b>Lubriplate 930AA</b> <b>PC 09640</b>	Lubriplate H0-0 PC 76062
KEYSTONE	Keygear 90 PC 200110	Keygear K-600 PC 200123	Keycut 101 PC 200564	Zeniplex EP-2	---	---
MOBIL	Mobil Gear 629 PC 61086	600W Cyl. Oil PC 60126 or 600W Super Cyl. Oil PC 60121	Mobilmet 766	---	---	<b>DTE 24</b> <b>PC 60262</b>
PENNZOIL	Cyl. Oil #8 PC 037404	Cyl. Oil #6 PC 037401	Pennzkut B-3 PC 037840	---	---	Pennzbell AW32 PC 37001
SHELL	<b>Valvata Oil J680</b> <b>PC 63053</b>	<b>Valvata Oil J460</b> <b>PC 63150</b>	No Product	---	Darina EP-1 PC 71521	Tellus 32 PC 65208
TEXACO	Vanguard 680 PC 631	Vanguard 460 PC 620	Transultex H PC 1575	---	---	Rando HD46 PC 1658