

# KEY PRE OPERATION STEPS

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## Add Gear Oil

2

## Adjust the Rollers

3

## Grinding

### 01 . Add Gear Oil First

Before starting the machine, add gear oil to the gearbox through the oil inlet. Check the oil level through the sight window and keep it around the middle of the scale.



Do not start the machine with no or insufficient oil, as this may cause severe gear wear.



### 02 . Adjust the Rollers

Tighten the outer adjustment bolts by hand until the rollers rotate with slight resistance and no looseness.

Then use a wrench to secure the bolts and run the machine briefly to check roller operation and rotation speed.

Once confirmed normal, fully tighten and lock the nuts to prevent roller movement during operation.

*Note: The adjustment method is the same regardless of the number of rollers*



Running the machine without proper roller adjustment may cause poor pellet formation, abnormal load, and accelerated wear.



### 03 . Add a Small Amount of Material

After startup, let the machine run idle for 1–2 minutes to confirm normal roller operation, then feed material slowly in small amounts. Do not cover the rollers.

*Note: Keep material moisture at 10%–18%.*

*Use a moisture meter or hand test material forms a ball and does not fall apart.*



If pellets are unstable at the beginning, reuse the ground material.

Once the die and rollers warm up, pellets form smoothly, and light white smoke appears, normal feeding can begin.

