



FASTENER ENGINEERS & LEWIS MACHINE™

14343 Industrial Parkway • South Beloit, IL 61080 • U.S.A. • 815/624-2500

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Service Bulletin

Lubrication Specification for Straighten & Cut Machines:

3SV8

4SV8

6 in 1 Series

Caution:

Prior to replacing any oil or grease with a different lubricant, the old lubricant must be removed completely and the components cleaned. Mixing lubricants can cause the lubricants to chemically react. They may lose some or all of their characteristics leading to damage or failure of components.

If possible it is best to disassemble components and clean thoroughly with a solvent. However, this is not possible in certain instances, example sealed bearings. In these cases purge old lubricant by pumping new lubricant into component until only the new lubricant is being extruded from component.

The trip cam pin and clutch rolls should be oiled with Santotrac 50 oil. See illustration on page #2.

The release sliding components should be oiled with a light spindle oil, sus @ 100 degrees F. Mobil Velocite #6. The release components should slide freely and therefore require periodic cleaning

The arbor assembly **must** be greased with Mobil synthetic grease SHC-32. The high-speed bearings require the extreme-pressure and wear additives.

The input sleeve bushings on D6 clutch and the (2) pillow blocks for the clutch shaft should be greased with Mobil food grade grease FM101. See illustration on page #2.

The rest of the machine should use the Mobil food grade grease FM101. This includes the feed housings, cut-off assembly and extension.

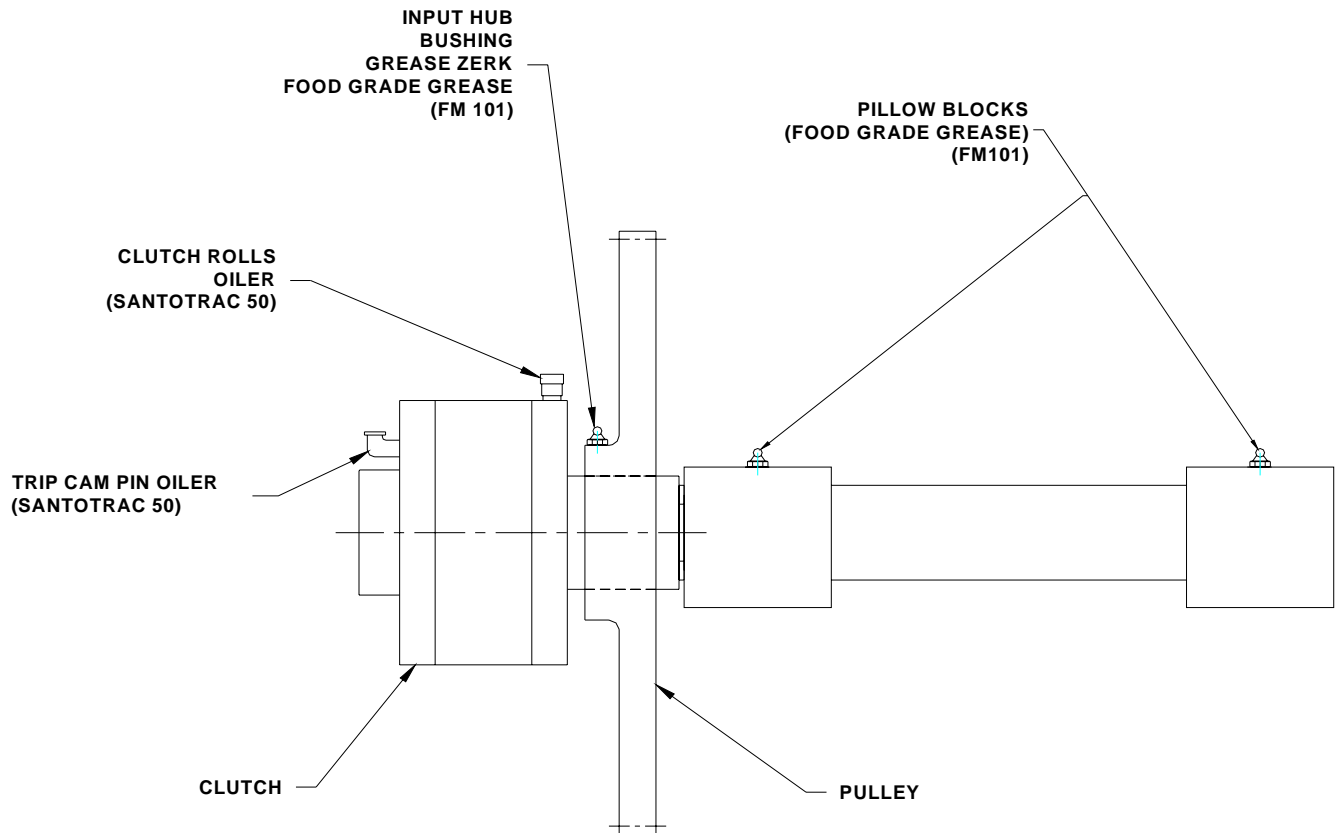
Equivalent greases and oils may be substituted for the Mobil products listed above, however, note that substituting any product for the Santotrac 50 oil that is recommended for the clutch may significantly reduce clutch life.



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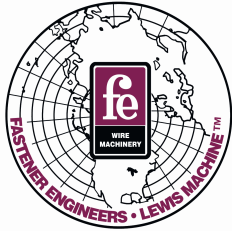
LUBRICATION OF D6 CLUTCH

Mobiltemp SHC® 32

Grease, Low & High Temperature, Synthetic, ISO 32

Description

Mobiltemp SHC 32 synthetic grease is manufactured from a synthesized hydrocarbon fluid and a nonsoap thickener. It has extreme-pressure characteristics and excellent resistance to water washout. It provides effective lubrication over an extremely wide range of operating temperatures. Mobiltemp SHC 32 synthetic grease is dark red in color and has a smooth, buttery structure with a consistency between an NLGI No. 1 and No. 2 grease. It maintains consistency under conditions of high temperature and



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high speed. In addition, Mobiltemp SHC 32 has low breakaway and running torque values and exhibits excellent low-temperature pump ability.

Application

Mobiltemp SHC 32 synthetic grease is recommended for industrial applications, such as sealed or repackable ball and roller bearings, splines, screws, some enclosed gears, and other mechanisms where high friction reduction, low wear, and low lubricant friction losses are required. Mobiltemp SHC 32 exhibits good pumpability and mechanical stability when used in centralized grease systems. The operating temperature range of Mobiltemp SHC 32 is -54°C (-65°F) to 177°C (350°F).

Combining Mobiltemp SHC 32 with some lithium-type greases may soften the mixture. When replacing any grease, clean or purge the former grease from the bearing.

Advantages

Mobiltemp SHC 32 synthetic grease provides these advantages and benefits.

- Satisfies operating temperatures of -54°C (-65°F) to 177°C (350°F)
- Excellent resistance to corrosion
- Excellent resistance to water washout
- Excellent anti-fretting capability under oscillatory and vibratory conditions
- Outstanding structural stability
- Performs well under heavy loads
- Meets USDA H2 requirements

Typical Characteristics

Physical properties are listed in the table. Except for those shown as minimum or maximum, values are typical and may vary slightly.

	Mobiltemp SHC 32
Product Number	64021-9
NLGI Grade	1.5
Specific Gravity, Calculated	0.9518
Soap Type	Clay



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Structure	Smooth
Color	Dark Red
Cone Penetration at 25°C (77°F), Worked, 60 strokes	320
Dropping Point, °C (°F), ASTM D 566	232 (450)
Mineral Oil, %	79
Viscosity of Oil	
ISO VG	32
cSt at 40°	32
cSt at 100°C	5.2
SUS at 100°F	167
SUS at 210°F	44
Low-Temperature Torque, ASTM D 1478,	
-54°C (-65°F) after 100,000 strokes	
Starting, g-cm, max	10,000
Running, g-cm, max	1,000
Copper Strip Corrosion, ASTM D 130, 24 hrs @ 100°C	None
Bomb Oxidation, ASTM D 942, psi loss, 24 hr at 212°F	8
Water Washout, ASTM D 1264, % loss	20
Load Wear Index, kg, min	30
Four Ball Wear Test, Scar, mm, max	1.3

Mobilgrease® FM Series

Food Machinery Lubricating Greases

Description and Application

Mobilgrease FM Series greases are transparent, aluminum-complex thickened lubricants formulated to replace many conventional lithium and synthetic greases in moderate- and high-temperature applications in food plants and sanitary equipment.

Mobilgrease FM 101 and 102 provide the following advantages:

“SINGLE SOURCE FOR PAYOFF • DESCALING • WIRE DRAWING • STRAIGHTEN & CUTTING • BUTT WELDING”



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- Regular duty up to 350°F
- Withstand routine water immersion
- Superior antiwear protection
- Good low-temperature pumpability
- Good protection against corrosion
- Meet FDA regulation 178.3570 requirement for incidental contact with food
- Meet USDA H-1 standards

Mobilgrease FM 101 is marginally compatible with Mobil FM 2 Grease, while Mobilgrease FM 102 is compatible with Mobil FM 2 Grease.

Typical Characteristics

Physical properties listed in the table are typical and may vary slightly.

	Mobilgrease FM 101	Mobilgrease FM 102
Product Number	64235-2	64236-3
NLGI Grade	1	2
Soap Type	Aluminum Complex	Aluminum Complex
Structure	Smooth/Tacky	Smooth/Tacky
Color	Clear Amber	Clear Amber
Penetration, ASTM D 217, Worked	330	285
Dropping Point, C° (°F)	216 (420)	216 (420)
ISO Viscosity Grade, Base Oil	100	100
Four-Ball EP, ASTM D 2596		
Weld Load, kg, min	126	160
Load Wear Index, kg	26	22
Four-Ball Wear Test, ASTM D 2266		
scar diam, mm, max	0.5	0.5
Corrosion Prevention, ASTM D 1743	Pass	Pass
Water Resistance		
Water Washout, ASTM D 1264, wt %, loss	5.1	8.7
Water Spray-off, ASTM D 4049, wt %, loss	78	52
Pumpability, US Steel Mobility, MM 1390, 0°F, g/min	24	11
Lincoln Ventmeter		
psig at 75°F	150	200
psig at 30°F	375	425



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psig at 0°F	725	1430
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Health & Safety

Based on available toxicological information, these products produce no adverse effects on health when properly handled and used. No special precautions are suggested beyond attention to good personal hygiene, including washing skin-contact areas with soap and water.