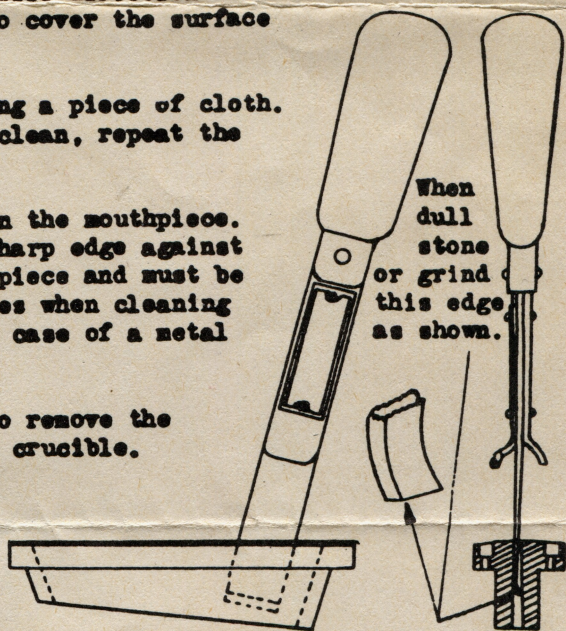


CRUCIBLE SLOTTED MOUTHPIECE CLEANING INSTRUCTIONS

To maintain an efficient slug casting machine it is essential that the crucible mouthpiece be kept as clean and free from foreign deposit as possible. The grayish-black substance which accumulates on the surface and in the slot of the mouthpiece is formed by oxidation of type metal. This deposit can be easily removed by the use of the Ludlow Lubriclean Fluid, A945A. To obtain the best results, clean the crucible mouthpiece at least twice a week in the following manner:

- (1) Apply Lubriclean fluid sparingly with the asbestos swab, 946A, on the vented surface of the mouthpiece while the mouthpiece is hot and allow the cleaning fluid to remain on the vented surface for two minutes.
- (2) Using the wire brush, 943, brush the vented surface vigorously, both lengthwise and crosswise using about ten strokes in the lengthwise direction and sufficient strokes in the crosswise direction to cover the surface at least twice.
- (3) Wipe the top surface of the mouthpiece dry, using a piece of cloth. If the top of the mouthpiece is not thoroughly clean, repeat the foregoing operations.
- (4) Use slot scraper, A939B for cleaning the slot in the mouthpiece. The end of the scraper is curved to force the sharp edge against the angular side walls of the slot in the mouthpiece and must be kept sharp. It is advisable to use canvas gloves when cleaning the mouthpiece, as a protection to the hands in case of a metal splash.
- (5) After each cleaning, cast several blank slugs to remove the Lubriclean and scrapings from the throat of the crucible.



To keep the inside of the crucible throat open for free passage of metal, remove the mouthpiece from the crucible at least once a month and clean as follows:

- (1)a To remove the mouthpiece from the crucible apply Lubriclean around the screw heads, when the mouthpiece is hot, and allow the Lubriclean to remain on the surface about three minutes, at which time the mouthpiece screws should be easily removable.
- b If the mouthpiece can not be removed easily, increase the heat in the mouthpiece heaters; lower the metal level to approximately 2½" below the top of the rear of the crucible, and fill slot with Lubriclean. Allow the Lubriclean to remain in the slot for approximately ten minutes. It should then be possible to remove the mouthpiece without difficulty.
- (2) With the mouthpiece removed, scrape both side walls of the throat with the slot scraper. The loose dross should be removed from the slot before reassembling the mouthpiece to the crucible.

If the foregoing instructions are carefully followed, the mouthpiece and the throat in the crucible will be kept clean, thereby producing solid slugs with a good face.

MOUTHPIECE CLEANING OUTFIT

(A950) for cleaning slotted mouthpiece consists of:

- No. A945A- 1 qt. Can of Lubriclean
- " A939B - Mouthpiece Slot Scraper
- " 943 - Wire Brush
- " 946A - Asbestos Swab
- " 961 - Wood Case
- " FI-68 - Instructions
- " A939½B - Throat Scraper