



INSTRUCTIONS

FOR

SINGLE DRUM TUMBLER

MODEL NO.

STS-5501

SERIAL NO.



PPE Drum Tumblers are manufactured and sold direct by Plastic Process Equipment, Inc. We are not associated with any other manufacturer except Budget Molder's Supply, Inc. Always specify genuine PPE or Budget Machinery! Do not accept substitutes.

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PLASTIC PROCESS EQUIPMENT, INC.

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6385 Montessouri Street, Las Vegas, Nevada 89113
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11218 Challenger Avenue, Odessa, Florida 33556
727-834-8888 • 800-282-6783 • Fax: 727-834-8873

8303 CORPORATE PARK DRIVE, MACEDONIA (Cleveland), OHIO 44056, USA

Toll Free: USA, Canada & Mexico

216-367-7000 • Toll Free: 800-321-0562 • Fax: 216-367-7022 • Order Fax: 800-223-8305

800-362-0706

Thank you for buying a Drum Tumbler from Plastic Process Equipment, Inc. These instructions are intended as a guide for your new product. If you have any additional questions, contact PPE at 800-321-0562.

RECEIVING & INSTALLATION

Please thoroughly inspect your tumbler and report any damage to the motor freight carrier before uncrating for setup. Select a suitable location away from all traffic, preferably close to a stationary wall. Position your tumbler to allow for easy access for loading and unloading drum holders.

OSHA SAFETY

Fasten your tumbler base **securely** to the floor with the lag bolts provided. This must be done to avoid tipping or walking of the machine. The drum tumbler **must** be installed in a safety enclosure to keep all personnel away from the tumbling machine during operation. Mount start-stop switch or PPE control panel outside enclosure and preferably in a remote location. Keep drum safety chain fastened while tumbling drum.

DRUM CAPACITY

DANGER, STAY WITHIN THE RECOMMENDED DRUM WEIGHT CAPACITY 275 lbs PER DRUM! Overloading drums will cause premature wear on gears, shafts, bearings, and motor increasing the risk of damaging the machine. It will also negatively affect your color blending due to reduced head space.

ELECTRICAL

All tumblers are prewired and tested prior to shipping. Wire units for the voltage in your plant per the wiring diagram located on the motor. We insist you mount your motor starter and fused disconnect in a suitable location **away** from the tumbler which will allow complete control without approaching the machine. A complete drum tumbler control panel is available from PPE. Part # DTCP-01

LUBRICATION: BEARINGS & GEARS

All PPE tumbler drive gears are lubricated, operated, and inspected at our factory prior to shipment. We suggest you lubricate the pillow block bearings and drive gears once each four to six months. We recommend using **MOLY 29 OPEN GEAR COMPOUND** for the drive gears.

LUBRICATION: WORM GEAR REDUCERS

For normal operating conditions where surrounding temperatures are within the limits of 50°F to 120°F, we recommend the use of **AMGA Lubricant #8 Comp, 8EP**, or similar oil of equal viscosity and composition. Below 50° F, the oil recommended is **AMGA Lubricant #7 Comp, 7EP**.

The maximum efficiency of worm gear reducers is obtained after a "Run-In" period. The length of time required will depend on the load applied. At full rated load, the "Run-In" period will take approximately 24 hours. At reduced loads this time will increase considerably.

Overloading the unit will not decrease the "Run-In" period and may cause damage to internal components. During the "Run-In" period, higher than normal current consumption and temperatures can be expected, as well as lower efficiency and output torque.

Fill units only up to oil level and maintain this level. After the first 500 hours or 4 weeks of operation, and after each succeeding 2500 hours or every 6 months of thereafter (which ever occurs first), drain the oil, flush out the case, and refill to the proper level using the recommended oil or equivalent.

CAUTION

Both primary and secondary reducers have individual oil reservoirs. Each unit must be filled to, and maintained at its individual oil level. See below for listing of typical manufacturer's worm and worm gear reducer oils meeting AGMA standards 250.04 Sept. 1981.

FOR OPERATIONS IN 15 to 50°F ambient	FOR OPERATIONS IN 50 to 120°F ambient
Chevron Oil NL Gear Guard COMP 220	Chevron Oil NL Gear Comp 620
Exxon Petroleum Spartan EP 220	Exxon Petroleum Spartan EP 680
Mobil Oil Company Mobilgear 630	Mobil Oil Company Mobilgear 636
Shell Oil Company Omala 71	Shell Oil Company Omala 81
Texaco Oil Company Meropa 220	Texaco Oil Company Meropa 680
Phillips Petroleum All purpose gear oil SAE 90	Phillips Petroleum All purpose gear oil SAE 140

LUBRICATION: MITER AND BEVEL GEARBOXES

For normal operating temperatures within the limits of 40° to 120° F we recommend multipurpose gear oil, SAE 90W. Temperatures below 40° F, use 80W or contact factory.

APPROVED LUBRICANTS

Texaco	Multigear EP90
American	Multipurpose gear lubricant
Gulf	Transgear EP
Exxon	Gear oil GP
Shell	Spirax EP
Mobil	Mobilube EP
Chevron	RPM Multiservice
Phillips	Philube all purpose gear oil
Conaco	Polar start 600 GM (for amb. temp. below 15°F)

Or any oil that meets MIL-L-2105B and GL5 specifications

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WARRANTY

All PPE machinery is warranted to be free of defective material and workmanship for a minimum period of 1 YEAR from date of sale. Some machinery components may carry longer warranties per our suppliers policies, which are passed on to our customers. (i.e., our drier compressors, conveyor motors, etc.)

SPECIFICATIONS:

Motor-right angle gear head type,
1750 RPM x 60:1 29.1 RPM output shaft T.E.N.V.
1 HP 230/460/60/3 3.4 amps @ 230V
1.7 amps @ 460V
Tumbling speed - 22.6 RPM
Bearings - 2 1/4" Pillow block ball bearings
Floor space required with drums in holders:
60" wide x 72" deep
Gross weight 1000 lbs.



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**PPE
SOUTH**

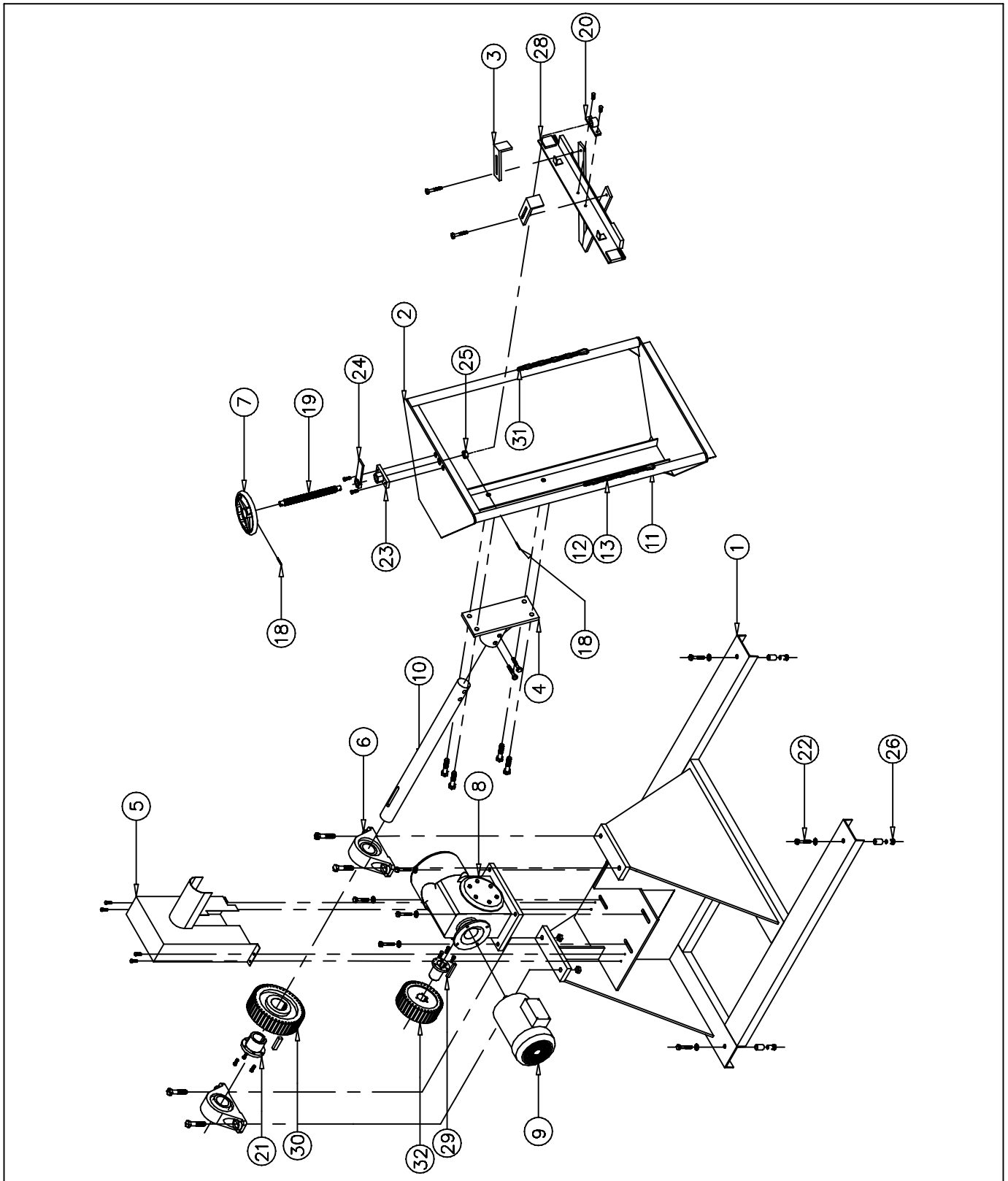
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SINGLE DRUM TUMBLER PARTS



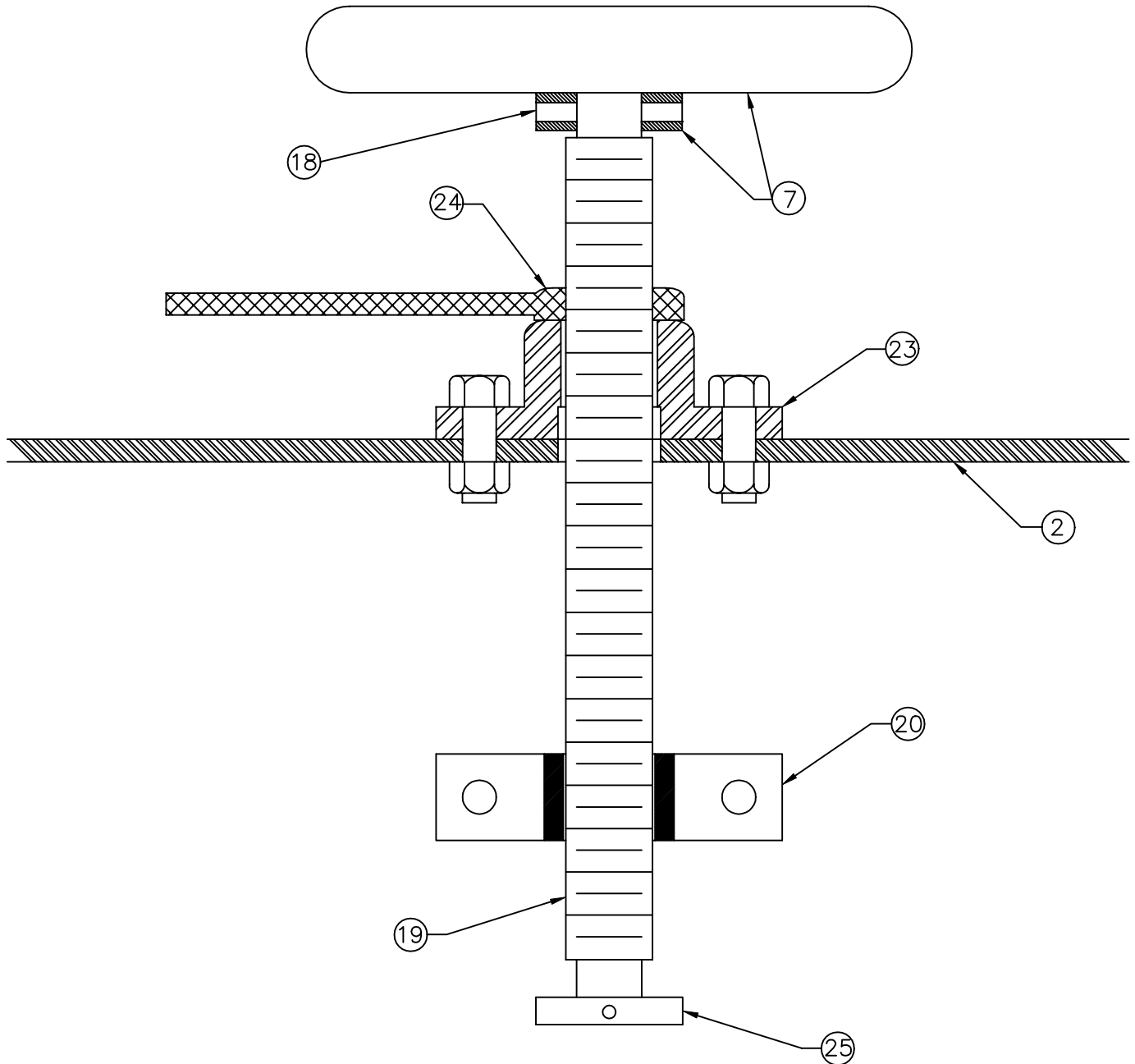
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DRUM TUMBLER HANDWHEEL ASSEMBLY



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05/28/21 PARTS LIST

ID NUMBER	QTY	PART NUMBER	DESCRIPTION	UOM
1	1	D-1234	BASE FOR STS	EA
2	1	D-1205	DRUM HOLDER FRAME	EA
3	2	A-7377	DRUM EAR CLAMP (each)	EA
4	1	B-1199K	DRUM HOLDER HUB KIT (WITH HARDWARE)	EA
5	1	C-1690	GEAR GUARD	EA
6	2	PB251	2-1/4 PILLOW BLOCK BEARINGS	EA
7	1	A-1744	HAND WHEEL H3192	EA
8	1	HLZ11772S	BOSTON GEAR SPEED REDUCER	EA
9	1	121067	1HP MOTOR FOR STS- OLD # 120024	EA
10	1	2143138	B-1221 2-1/4X31-3/8" DRIVE SHAFT	EA
11	1	3885T11	3/16" CHAIN SNAP HOOK	EA
12	3	2400-1150	3/16 CHAIN FOR DRUM TUMBLER (PER FOOT, 3' NEEDED)	EA
13	1	206-1620	3FT LENGTH CLEAR CHAIN LINK COVER 1-1/4" OD.	EA
14	1	OSHA-7	GEAR WARNING TAG	EA
15	1	PPETAG	PPE SERIAL NO. TAG	EA
17	1	OSHA-6	CAUTION TAG	EA
18	1	1/4X2SP	SPLIT PIN 1/4 X 2	EA
19	1	A-1194-C	1"-6 X 11 ACME SCREW	EA
20	1	A-1193	SCREW BUSHING	EA
21	1	Q1X2-1/4	2-1/4 BUSHING FOR DRIVEN GEAR	EA
22	4	1/2LB	1/2-13 X 2-1/2" LAG BOLTS	EA
23	1	A-1192	ACME NUT BRACKET INCLUDING PAINT	EA
24	1	A-1191	LOCK LEVER, INCLUDING ORANGE POWDERCOAT	EA
25	1	A-1195	3/4" SCREW COLLARS	EA
26	4	1/2MA	1/2-13 MACHINE SCREW ANCHORS	EA
27	4	1/2LB	1/2-13 X 2-1/2" LAG BOLTS	EA
28	1	D-1227	V-BRACKET ONLY FOR DRUM TUMBLER W/PAINT	EA
29	1	P2X1-5/8	1-5/8 BUSHING FOR DRIVE GEAR	EA
30	1	YCS5Q45	SPUR GEAR 45 TOOTH	EA
31	2	3579T71	LAP LINK-HOLDS CHAIN TO DRUM HLDR	EA
32	1	YSS5P35	SPUR GEAR 35 TOOTH	EA
33	1	1/4x11/2SP	SPLIT PIN 1/4 X 1 1/2	EA