
KAMADUR industrial knives B.V. is a member of the KAMADUR Holding B.V.

OPERATIONAL Instructions/103-2121-01.

Die plate unit of underwater pelletizing system.

- **Store die plate unit in cool, dry, dust-free and moderately ventilated area.**
- **During transit, die plate bolts can be loosen, so tighten all bolts which taking die plate unit in operation.**
- **Fix die plate unit on pelletizing system with torque wrench and align it perfectly so each blade/knife touch die plate body perfectly.**
- **Check blade pressure advancement to avoid high pressure of blades on die plate and uneven wearing of die plate unit.**
- **During die plate surface grinding, align grinding tool properly and apply specified pressure by OEM to avoid uneven grinding of surface, uneven grinding can lead TC/TIC failure.**
- **Do not use hammer on die plate unit surface.**
- **Do not use sharp tools, rods to clean die plate unit holes, it may damage holes and that cause surface TC/TIC failure.**
- **Do not clean die using open flame and furnace, this may lead to weak bonding of TC/TIC surface.**
- **Use only vacuum pyrolysis furnace in case of necessity, and remove die plate unit less than 50-degree centigrade die body temperature, removing in hot condition will create oxidation and it can be reason of failure of TC/TIC surface.**
- **Carry out grinding of TC/TIC surface at each 0.1-.0.2 mm groove to get good life of die plate unit.**
- **Use sharpen blades/knives only for good pelletizing.**