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PELLET MACHINE OPERATION MANUAL

Established since 1988





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1. First Use Procedure

1.1 Add Gear Oil

Inject 85W/90 or GL-5 heavy-load gear oil.

The following table shows the required amount of oil for different equipment models:

Equipment Model	Oil Addition Amount
KL-150	5L
KL-160	5L
KL-180	5L
KL-210	10L
KL-230	10L
KL-260	25L
KL-300	35L
KL-400	60L
KL-500	70L

Note:

Oil level should be visible through the oil window



1.2 Wiring

- * **For single-phase:** connect one live wire and one neutral wire
- * **For three-phase:** connect three live wires

1.3 Motor Direction Check

Start the machine briefly and check rotation direction:

- * **Clockwise when viewed from above** is correct
- * **If direction is incorrect, adjust wiring** (for three-phase: swap any two wires)

1.4 Run-in Grinding

Run the machine with abrasive material for **1-2 hours** until full particles form.

Use **fine sand mixed with 10% waste oil**, repeat grinding.(the factory has the company's gift, in a bag)



Then run dried corn with cooking or waste oil for **3-5 days**, to fully smooth the die holes.

2. Grinding Steps

2.1 Adjust the Press Roller

Rotate the adjusting bolts downward so there is **no gap** between roller and die.

2.2 Initial Feeding

- Start the machine. After stable running, sprinkle **2-3 handfuls of oily material** into the die.
- Gradually tighten the bolts to allow extrusion of particles.
- Feed slowly and evenly.

Note:

Do not exceed half of the roller height. If one roller rotates slower, press its side bolt down.

If speed imbalance persists, loosen the other end slightly and readjust.



2.3 Continuous Feeding

- Once particles are extruded steadily, begin full feeding into hopper.
- If the extruded particles are smooth and shiny, the grinding

2.4 Die Blockage

- If no particles are coming out, stop and **clean the die**.
- Use a **steel nail or hand drill** to unclog the holes.
- Then repeat grinding as per steps above.

2.5 End-of-Use Cleaning

- Do not discard leftover oily particles; save them in a bowl.
- After each use, feed oily material into the machine to **"flush" the die holes**.
- When only oil-rich particles come out, the process is complete.
- If oil is skipped next time, hardened material may block the die and require re-drilling.

Notes

1. When idling, **loosen the roller bolts**; avoid long idle times to prevent wear.
2. **Raw material moisture content must be ~13%**. Proper moisture test: squeeze a handful until it forms a soft clump and slowly loosens.
3. Production with **mixed feed** follows the same gradual feeding as oily feed. Adjust roller speed until smooth output begins.

- 4. Die hole test:** Add feed of a different color. Remove the template. Holes passing new color are clear. Clear blocked holes with a drill.
- 5. After use,** clean machine material to prevent mold. If idle for long, clean out die holes and apply anti-rust protection.
- 6. Gear oil should be replaced every 3 months** if in regular use.
- 7. Install the grinding disc with larger hole on top,** smaller on the bottom to better compress particles.

Ingredients

Ingredients vary depending on livestock.

Moisture content: 13%.

Typical recipe: 50kg of corn flour, bran, soybean meal, grass meal, add 3-4kg of water. Mix evenly before use.

If water is too little: particles too dry;

too much water: soft, fragile particles.

How to identify: Grab a handful; if it clumps with a bit of force, then slowly spreads out, the moisture is suitable.