

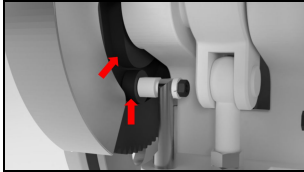




## TDP 6s Lubrication Schedule

Part	Location	Image	Frequency	Type of Lubricant
Tooling heads	The heads of the Upper Punch and Lower Punch		Visually inspect and apply when dry	Assembly paste
Tooling (after cleaning)	Storage container		After cleaning	Mineral oil
Top Cam	The topmost Grease Nipples		Apply after (a) every 5000 tablets, (b) after a deep clean, or (c) when the press has not been used for a prolonged period of time	NLGI Grade 2
Cam Drive Cog	Teeth on cog		Apply after (a) every 5000 tablets, (b) after a deep clean, or (c) when the press has not been used for a prolonged period of time	NLGI Grade 2



Part	Location	Image	Frequency	Type of Lubricant
Boot Timing Cam	Cam track and top of Boot Timing Bar		Apply after (a) every 5000 tablets, (b) after a deep clean, or (c) when the press has not been used for a prolonged period of time	Mineral oil
Pinion Gear and Top Cam	Grease Nipples on Cam Drive Cog and Pinion Gear		Apply after (a) every 5000 tablets, (b) after a deep clean, or (c) when the press has not been used for a prolonged period of time	NLGI Grade 2
Lower Drift Pin Assembly Timing Rod	The points at which the Lower Drift Pin Assembly, Upper Drift Pin Assembly Mounting Block, and TDP 6s Base meet.		Apply a small amount whenever the press will be left unattended for an extended period of time	Mineral oil