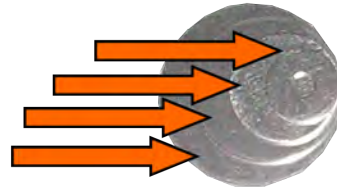


HOLLOW TUBE EXTRUSION KIT PARTS LIST AND INSTRUCTIONS

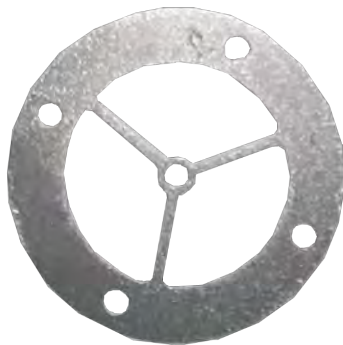
Included in the hollow tube extrusion kit are the following items:



1ea. Hollow Tube Extrusion Adapter



4ea. Inner Rings



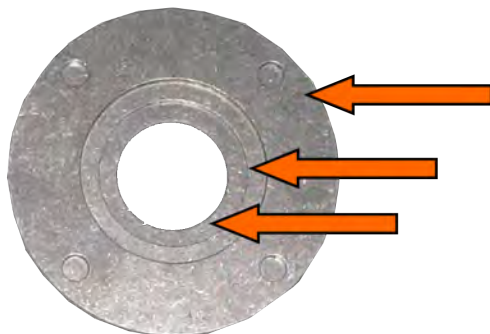
1ea. Spider



4ea. 5/16" x 3/4" lg. Cap Screws
4ea. 5/16" washers
(PREPACKAGED)



5/16" x 1 1/4" lg. Armor Coated
Socket Hd. Cap Screws



3ea. Outer Rings



1ea. 5/16" x 1 1/2" lg. S&T
Socket Hd. Cap Screw



3ea. S&T Nuts

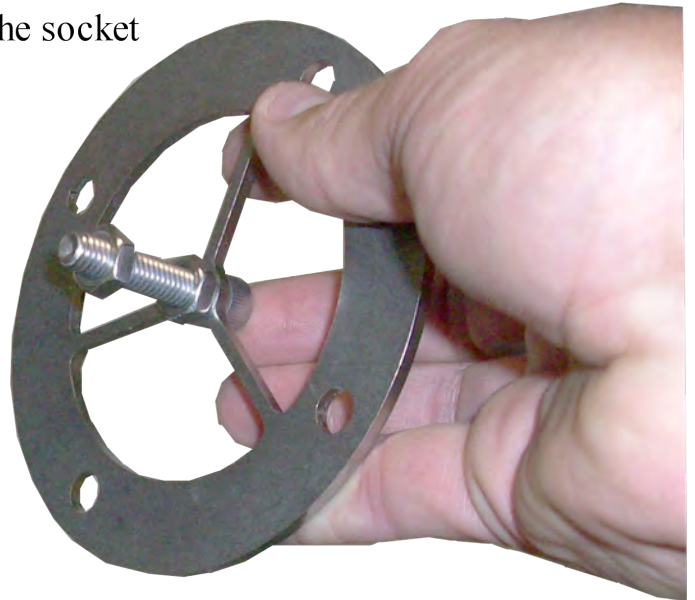
HOLLOW TUBE EXTRUSION KIT PARTS LIST AND INSTRUCTIONS

Thank you for purchasing a Peter Pugger Hollow Tube Extrusion Kit. The following instructions will describe the steps required to mount hollow tube dies to the end of your pugmill.

Please Note: Prior to the installation of the hollow tube components, it is best to prepare a batch of clay to the desired throwing consistency. Once this has been accomplished, you can proceed with the following steps:

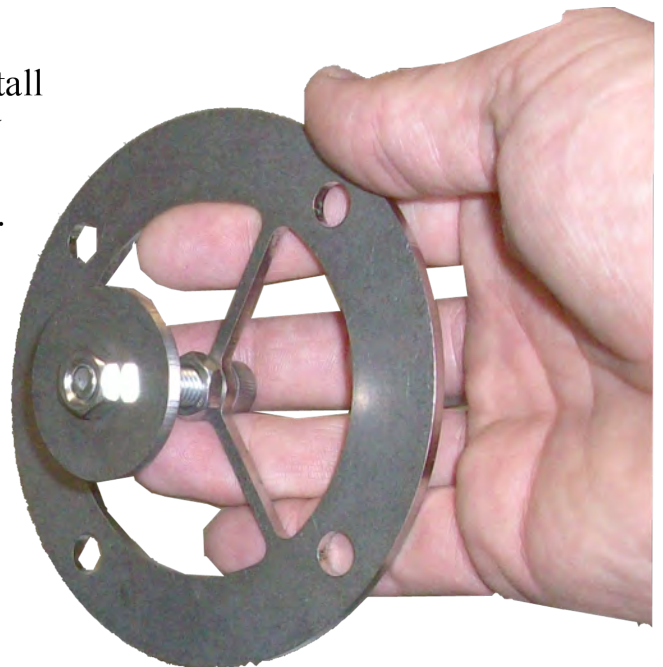
Step 1:

Install the 5/16" x 1 1/2" lg. socket head cap screw through the center of the spider. Tighten the socket head cap screw to the spider using the 5/16" nut. Install an additional 5/16" nut to house the desired inner ring as shown here.



Step 2:

Determine the diameter and wall thickness of the extrusion by matching the inner and outer rings together. Once this has been determined, install the inner ring onto the 5/16" x 1 1/2" lg. cap screw until it bottoms out on the 5/16" nut. Now install the remaining 5/16" nut on to the 5/16" x 1 1/2" lg. cap screw until the complete assembly is snug. You may need to adjust the inner ring once the complete assembly has been installed on to the pugmill. The end result should resemble the picture shown.



HOLLOW TUBE EXTRUSION KIT PARTS LIST AND INSTRUCTIONS

Step 3:

Now install the spider assembly on to the end of the pugmill via the hollow tube extrusion adapter. Place the spider up to the end of the pugmill (shown in FIG. "A"). With your other hand, match the hollow tube extrusion adapter counter bored holes up to the holes of the spider and tapped holes of the pugmill. Secure the spider and hollow tube extrusion adapter on to the pugmill using the 4ea.- 5/16" x 1 1/4" lg. socket head cap screws as shown in FIG. "B". Fasten all four screws firmly in place. The inner ring should be extended out past the end of the hollow tube extrusion adapter the thickness of the outer ring as shown in FIG. "C". In turn, the extrusion (clay) will contact both the outer ring and inner ring at the same time. Slight adjustment to the inner ring may be required.



FIG. "A"

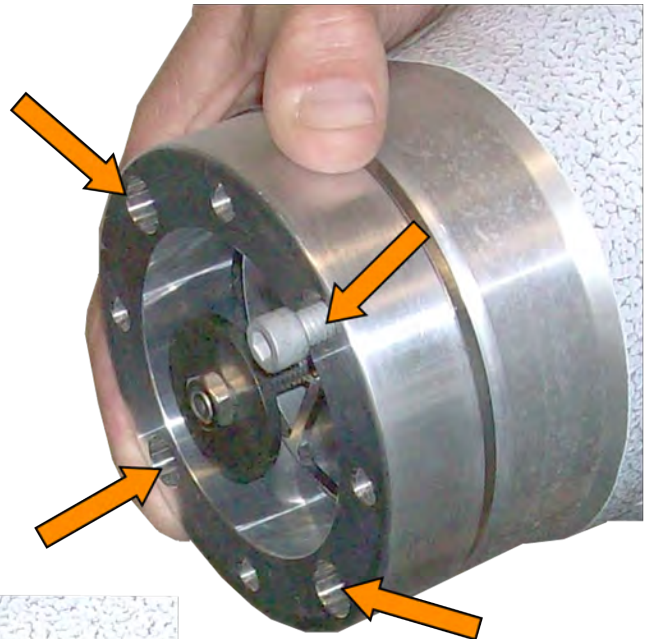


FIG. "B"



FIG. "C"

HOLLOW TUBE EXTRUSION KIT PARTS LIST AND INSTRUCTIONS

Step 4:

Install the outer ring to the hollow tube extrusion adapter using the 4ea.- 5/16" x 3/4"lg. cap screws and 5/16" washers (supplied in prepackaged bag). Please note: **DO NOT OVERTIGHTEN HARDWARE!** The outer ring screws need to be hand tightened as shown in FIG. "D". Confirm that the outer ring and inner ring are flush (clay should contact both rings at the same time).



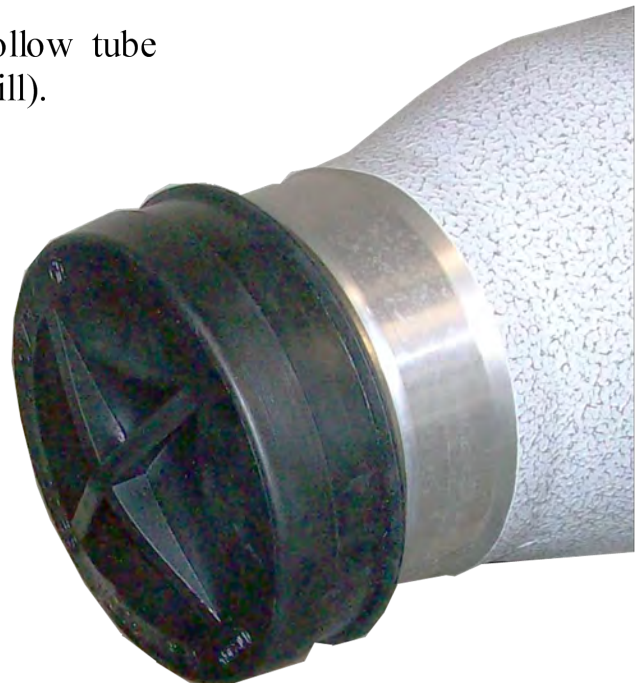
Step 5:

Now that assembly is complete, firmly place the black end cap over the hollow tube extrusion assembly. Begin remixing the batch of clay. While the batch is mixing, turn the vacuum on. Please note: Because the hollow tube extrusion assembly is not o-ring sealed, there may be some difficulty initially getting the batch to deair. This can be resolved two ways:

1. Lightly rub silicone adhesive (or equiv.) on the hollow tube extrusion adapter (side that mates up to the pugmill).

or

2. With the vacuum system still on, switch to pug. Turn down speed control and pug the clay slightly forward until the clay seals any gaps within the hollow tube extrusion assembly. Once the vacuum gauge begins to rise, stop the machine and allow the system to completely deair.



Now the system is primed and ready to extrude!