On Cleaning a Ludlow M.P. and Plunger

MOUTHPIECE

Brush the mouthpiece with LUBRICLEAN (A 945A) when it gets hot, let it sit for a few minutes, then wire brush the mouthpiece, going side to side so that you clean the vents as well, make sure some goes into the slot, then saw it out with the M.P. cleaning blade, then wipe it off really well. Cast five or six blank slugs then wipe off the mouthpiece and the bottom of the mold again really well with a dry cotton rag, this will help keep oil from getting into your clean mats.

PLUNGER AND WELL

For the plunger, install the mouthpiece shield then remove the plunger, clean it really well, then install the cleaning tool in the back left corner and let it heat up, maybe 10-15 minutes until the metal runs off of it so you know the well cleaning tool is the same temp as the metal, lift it up and coat the tool all the way around with a small amount of the Lubriclean and insert it _SLOWLY_ into the well, if it tries to stick, let it heat up a little more, it should be snug but not really hard to go in, when it goes all the way in then you rotate it up and down _SLOWLY,_ do not push hard, then twist the cleaner around and around both ways to clean the dirt from the walls of the well. When it is clean enough and no more dirt is rising to the top. Pull the cleaner out by rotating and pulling up.

After the cleaner is removed, skim all the dirt from the top of the liquid metal, then put the cleaned plunger in the back left corner of the well and let it heat up until the metal runs off of the plunger so you know that the plunger is the same temp as the metal, then lift the plunger up and swab on a small amount of the oil all sides and bottom. The plunger should go in sort of snug, make certain that the plunger finds its own way in, the Model L is at a slight angle, top towards the front but the Model M should be almost straight up and down, as it should float on its own when you let it go and all is properly clean. _**NEVER FORCE THE PLUNGER OR THE PLUNGER WELL CLEANER DOWN!!!**_