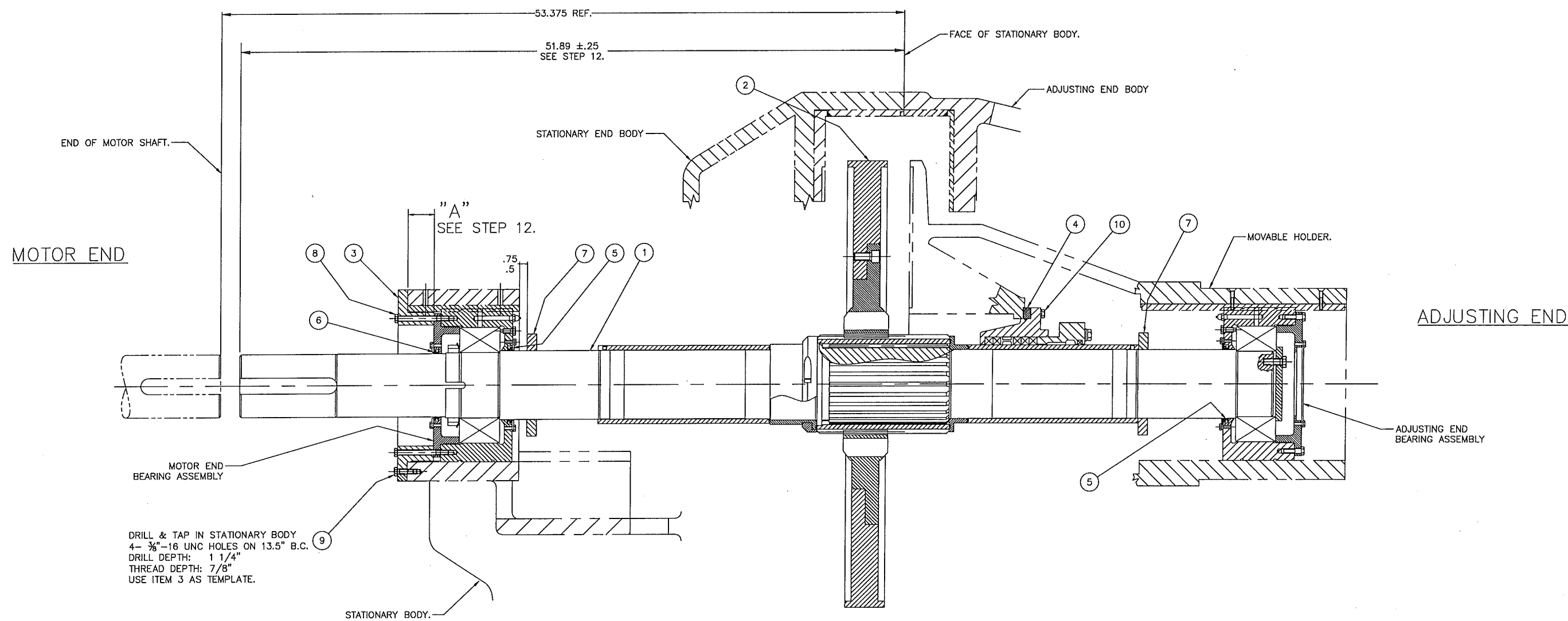


REVISIONS			
ZONE/LTR	DESCRIPTION	DATE	APPROVED
S.L. A	ITEM 5&6, ADDED DETAILS IN DESCRIPTION. ITEM 10 P/N WAS A10163-44.	13.04.07	BEH



DRILL & TAP IN STATIONARY BODY
4- 3/8"-16 UNC HOLES ON 13.5" B.C.
DRILL DEPTH: 1 1/4"
THREAD DEPTH: 7/8"
USE ITEM 3 AS TEMPLATE.

NOTES:
1. SEE SHEET 2 FOR DETAILED INSTALLATION INSTRUCTIONS.

Qty	10	PART NO.	Description (English)	MATERIAL	ITEM
4	A10163-43	HEX HD CAP SCREW 3/8"-16UNC X 2" LG	GR 5	10	
4	A10163-31	HEX HD CAP SCREW 3/8"-16UNC X 1 1/2" LG	GR 5	9	
4	A10163-81	HEX HD CAP SCREW 3/8"-16UNC X 4" LG	GR 5	8	
2	001264N63-10	FLINGER		7	
1	9800010014	V-RING CR#401300 OR EQUAL		6	
2	9800010013	V-RING CR#401400 OR EQUAL		5	
1	001263N63-10	SPACER RING		4	
1	001265N63-01	LOCKING RING		3	
1	0531907	ROTATING HEAD ASSEMBLY, SPLINED		2	
1	0520477	SHAFT ASSEMBLY		1	
Parts List - 001253N63-10					

UNLESS OTHERWISE SPECIFIED, THE FOLLOWING STDS. APPLY: DIM & TOL- ANSI Y14.5 SURFACE FINISHES-ISO 1302 ALL DIM APPLY TO FINISHED PART		NEXT ASSY.		REF.DWG.		DRAWN		DATE		CHECKED		DATE		APPROVED		DATE		MTG		DATE		REV		A	
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES		ANSI Y14.5 SYMBOLS		REMOVE ALL BURRS AND SHARP CORNERS AND COUNTERSINK ALL TAPPED HOLES TO MAJOR DIAMETER		G.SKILLING		1/30/2007		GPS		2/14/2007		3/19/2007											
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		CIRCULARITY		CYLINDRICITY		TOL		E-2167		E-3090		E-825													



TITLE
ASSEMBLY & INSTALLATION INSTRUCTIONS
FLOATING ROTOR
34 TFIH REFINER

SCALE NONE
THIRD ANGLE PROJECTION
DRAWING NO. 001253N63
REV A

COPYRIGHT 2005 GL&V INC. SHEET 1 OF 2

These instructions explain how to install the GL&V floating rotor kit P/N 001253N63-10 on a 34" TFIII Sprout refiner.

WARNING

Follow all mill lockout/tagout procedures before working on this machine. Unexpected machine operation can cause property damage, serious injury or death. All energy sources including process piping must be properly locked out and tagged before any repair work or maintenance is done. Read and follow all safety precautions in the refiner manual.

Step 1

- 1- Disconnect all water piping to both packing boxes.
- 2- Disconnect any lubrication piping to the bearing housings.
- 3- Disconnect electrical connections to the gearmotor and limit switch(es).
- 4- Drain oil from the drive coupling and disconnect the two halves of the coupling.
- 5- Drain oil from the bearing housings as required.

Step 2

1. Remove the casing bolts and retract the adjusting end body with the retraction screw to the maximum open position.
2. Mark the location of the drive coupling half on the refiner shaft and remove.

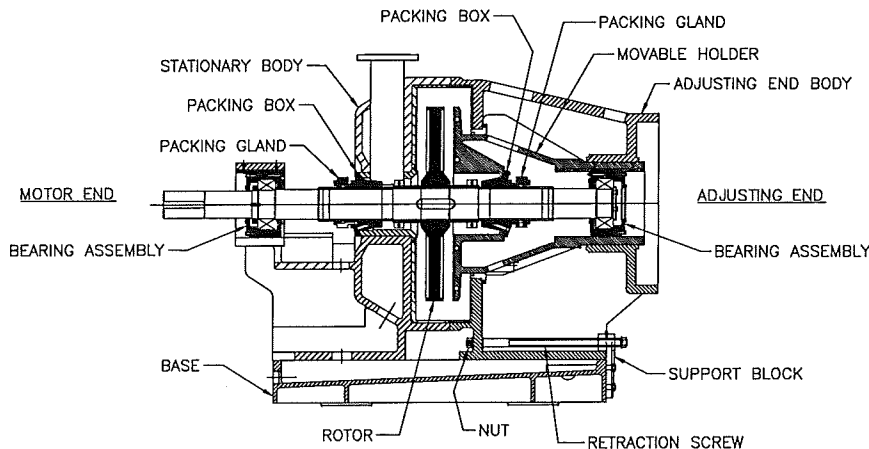


FIGURE 1

Step 3

1. Remove split packing glands and all packing from both packing boxes.
2. Remove the nut fastening the retraction screw to the adjusting end body. Remove the screws fastening the support block to the base, and set the retraction screw assembly aside for later use.
3. Install a lifting sling around the shaft between the rotor and movable holder to support the rotor shaft during bearing housing removal. Alternatively use a jack under the rotor.

Step 4

Remove the adjusting end bearing housing as follows:

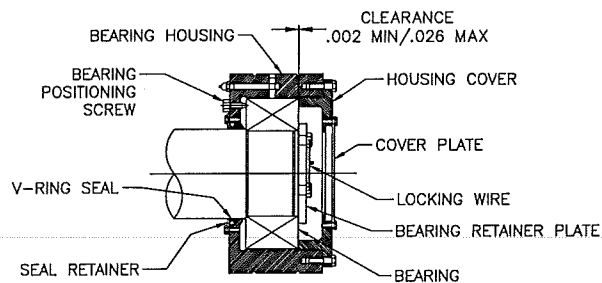


FIGURE 2

- 1- Back out the three bearing positioning screws.
- 2- Remove the bolts fastening the housing cover to the bearing housing and remove the housing cover.
- 3- Remove the locking wire and the three bolts fastening the bearing retainer plate, remove the retainer plate.
- 4- Remove the bolts fastening the seal retainer.
- 5- At this point you may use the bearing housing to pull the bearing off the shaft, or push the bearing housing inward, and use a puller to remove the bearing from the shaft.
- 6- Slide the V-ring seal and the retainer plate off the shaft.

Step 5

Refer to FIGURE 1

- 1- Unbolt and remove the adjusting end packing box.
- 2- Using a suitable lifting device, slide the adjusting end body and movable holder off the refiner shaft and base.
- 3- Install wood blocks between the rotor outside diameter and the inside of the stationary body to support the shaft during removal of the motor end bearing housing.

Step 6

Remove the motor end bearing housing as follows:

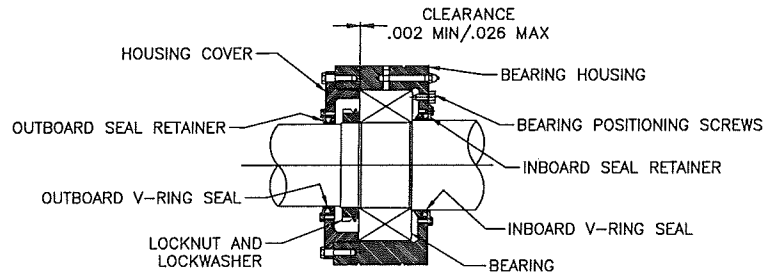


FIGURE 3

- 1- Back out the three bearing positioning screws.
- 2- Remove the bolts fastening the housing cover to the bearing housing and remove the housing cover.
- 3- Push the bearing housing inward to expose the locknut and lockwasher.
- 4- Remove the locknut and lockwasher.
- 5- Remove the bolts fastening the inboard seal retainer.
- 6- At this point you may use the bearing housing to pull the bearing off the shaft, or push the bearing housing farther inward, and use a puller to remove the bearing from the shaft.
- 7- Slide the V-ring seal and the retainer plate off the shaft.

Step 7

Refer to FIGURE 1

- 1- Unbolt the motor end packing box and slide it out from the stationary body. Support the shaft with a sling, remove the wood blocks and slide the packing box off the rotor shaft.
- 2- Slide the rotor shaft out of the refiner.
- 3- Remove the refiner plates from the rotor. If they are in usable condition, install them on the new splined rotor provided with the kit.

Step 8

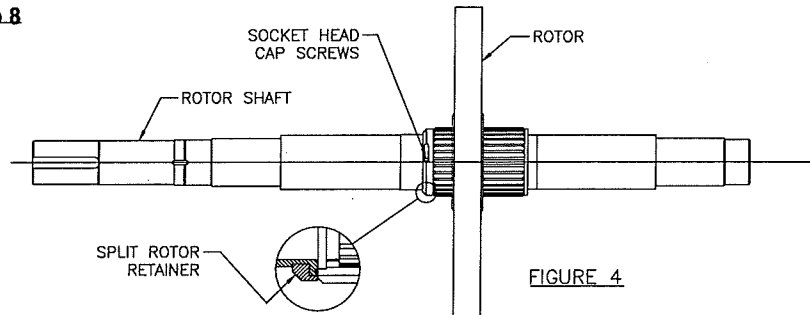


FIGURE 4

- 1- Remove the split retainer from the rotor shaft supplied with the kit.
- 2- Verify the splined surfaces of the rotor shaft and rotor are clean and free of debris. Apply light machine oil to both splined surfaces.
- 3- Slide the rotor onto the splines of the rotor shaft, and secure with the split rotor retainer. NOTE: Apply high strength thread locking compound to the two socket head cap screws that fasten the two halves of the split rotor retainer. IMPORTANT: Verify the rotor is installed with the refiner plate patterns facing the right way.

Step 9

Refer to FIGURE 1

- 1- Slide rotor shaft into the stationary housing
- 2- Slide the motor end packing box onto the shaft.
- 3- Install the motor end bearing assembly, in reverse order of disassembly outlined in step 6. Note: Use the new V-ring seals provided with the kit.
- 4- Install the flinger, item 7.
- 5- Remove the motor end sling support, and bolt the motor end packing box to the stationary body.
- 6- Install the drive coupling half on the refiner shaft in the same location as before.
- 7- Slide the adjusting end housing and movable holder onto the shaft and base.
- 8- Slide the adjusting end packing box onto the shaft.

Step 10

Refer to FIGURE 2

- 1- Install the adjusting end bearing assembly in the reverse order of disassembly outlined in step 4. Note: Use the new V-ring seal provided with the kit.
- 2- Install the flinger, item 7.

Step 11

Refer to FIGURE 1

- 1- Bolt the adjusting end packing box to the movable body NOTE: Install the spacer provided, item 6 between the packing box flange and the movable holder.
- 2- Reinstall the retraction screw assembly previously removed.
- 3- Using the retraction screw, close the adjusting end body against the stationary body and fasten the casing halves together with the bolts previously removed.

Step 12

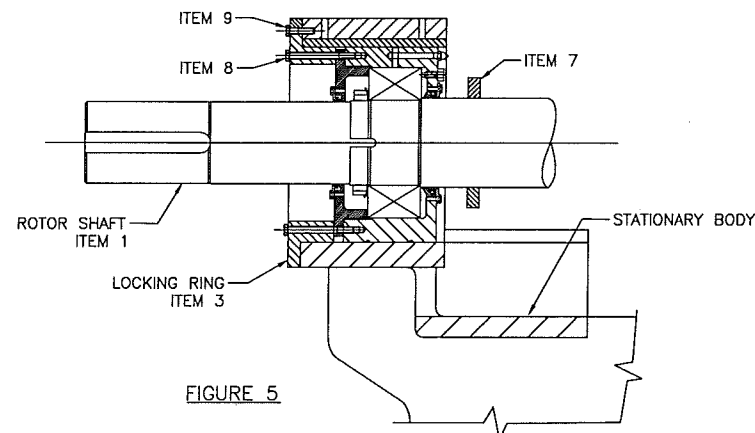


FIGURE 5

- 1- Locate the shaft such that its end is 51.89" +/- .25" from the face of the stationary body. See sheet 1.
- 2- Measure the distance "A" (See sheet 1) from the face of the stationary body to the face of the bearing housing cover. Remachine the locking ring, item 3 if necessary to obtain this dimension.
- 3- Remove the existing 3/8"-16 UNC x 1 1/4" cap screws from the bearing housing cover and install the locking ring using the 3/8"-16 UNC x 4" bolts provided.
- 4- Drill and tap 4 holes in the stationary body for cap screws item 10. See details on sheet 1.
- 5- Install the 3/8"-16 UNC x 1 1/2" bolts provided to attach the locking ring to the body.

Step 13

- 1- Fasten the motor and refiner halves of the coupling together and lubricate as required.
- 2- Repack both packing boxes, and fasten the split gland. NOTE: do not overtighten.
- 3- Reconnect electrical connections, lubrication piping if applicable, and seal water piping.
- 4- Lubricate both bearings as recommended by manufacturer.
- 5- Verify the shaft alignment is within recommendations.
- 6- Return the refiner to service.

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES		ANSI Y14.5 SYMBOLS		UNLESS OTHERWISE SPECIFIED, THE FOLLOWING DIMENSIONS APPLY TO ALL DIMENSIONS TO FINISHED PART		NEXT ASSY.		GL&V		NASHUA N.H.	
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		⊕	CONCENTRICITY	WELD	E-3090	THRD	E-825				
		Ⓢ	MAX MAT. CONDITION								
		Ⓢ	CYLINDRICITY								

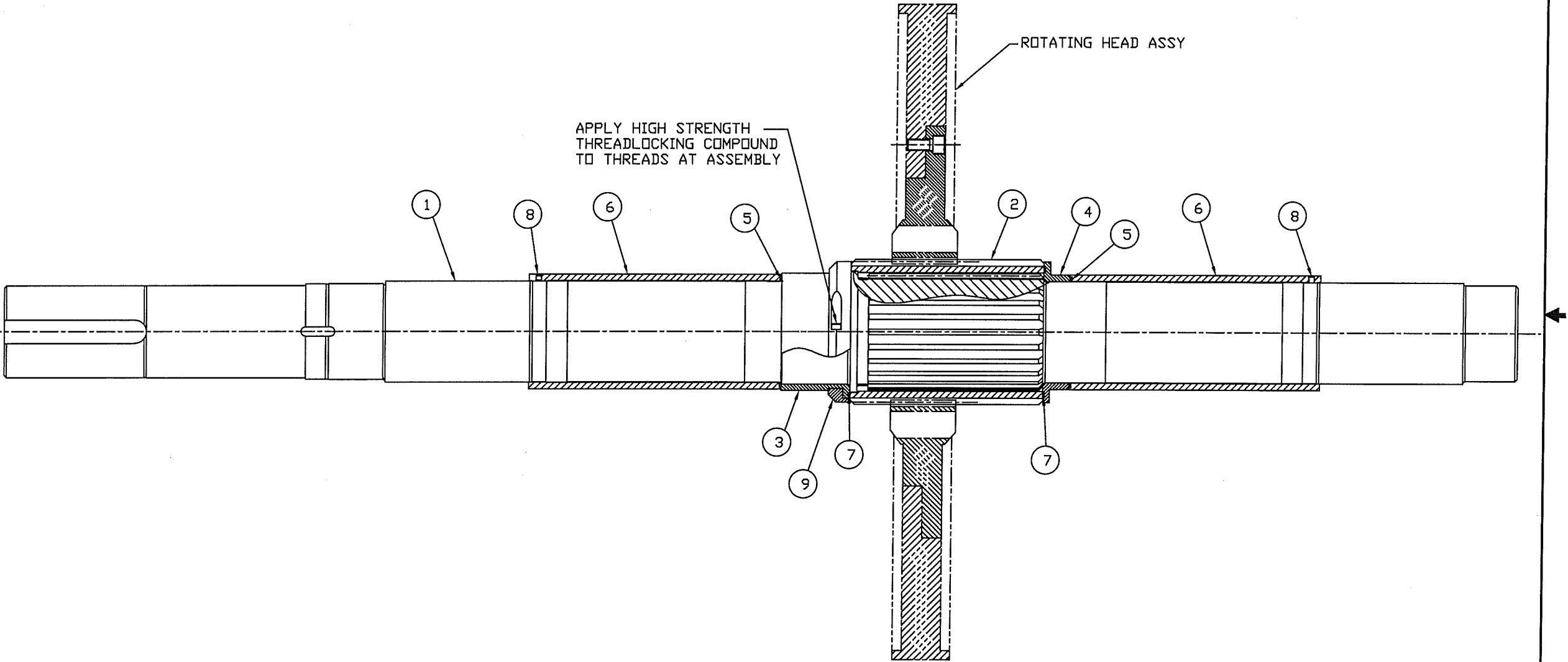
ITEM	PART NO	QTY	DESCRIPTION
1	0531903	1	SHAFT,MACH SPLINED 34TF
2	0531908	1	HUB,SPLINED MACH 34TF
3	0531910	1	RETAINER,HUB M/E 34TF
4	0531911	1	RETAINER,HUB A/E 34TF
5	9800008018	2	O-RING,5.609x0.139 2-255
6	0530586	2	RSPT,TF3,34"SLEEVE,PACK BOX
7	9800008037	2	O-RING,6.484IDx0.139 2-260
8	9900059006	4	SET SCR, SCH 3/8-16X5/16
9	0531913	1	RETAINER,SPL ROTOR 34TF
10			

LET	LOC	ECO	DESCRIPTION	DATE	BY	CHECKED BY
A	*	*	ADDED ITEM 10	7/6/05	JBM	JBM
B	*	*	REMOVED SLEEVE P/N 0531921, ITEM 10.	02.07.2007	GPS	

1

2

3



DO NOT SCALE DRAWING

UNLESS OTHERWISE SPECIFIED:	
MACHINING TOLERANCES	
INCHES	
1.	OR 1.~0000 = ±.040
1.0	OR 1.0~000 = ±.020
1.00	OR 1.00~00 = ±.010
1.000	OR 1.000~0 = ±.005
1.0000	OR 1.0000~ = ±.002
125	SURFACE FINISH
PROJECTION	ANGULARITY TOL. ±.5°

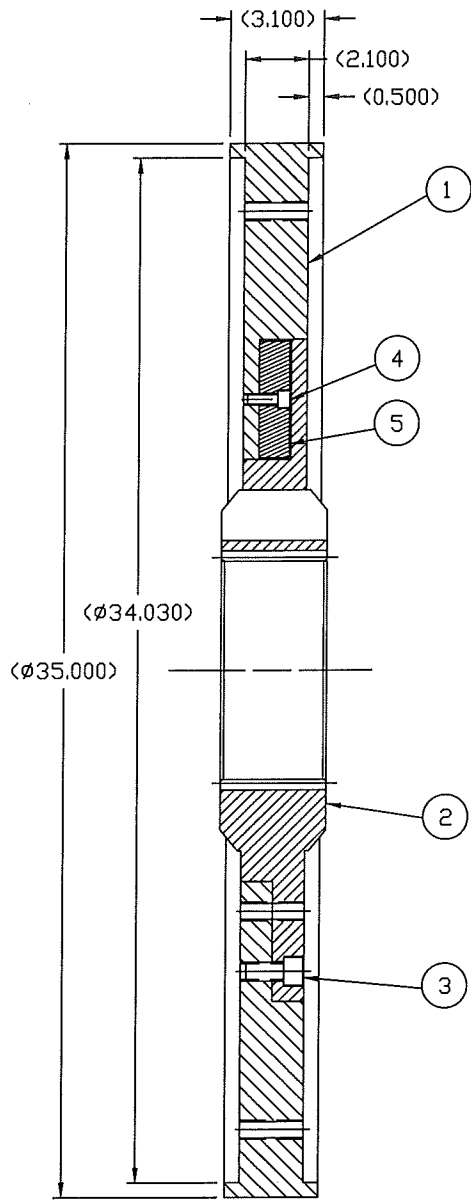


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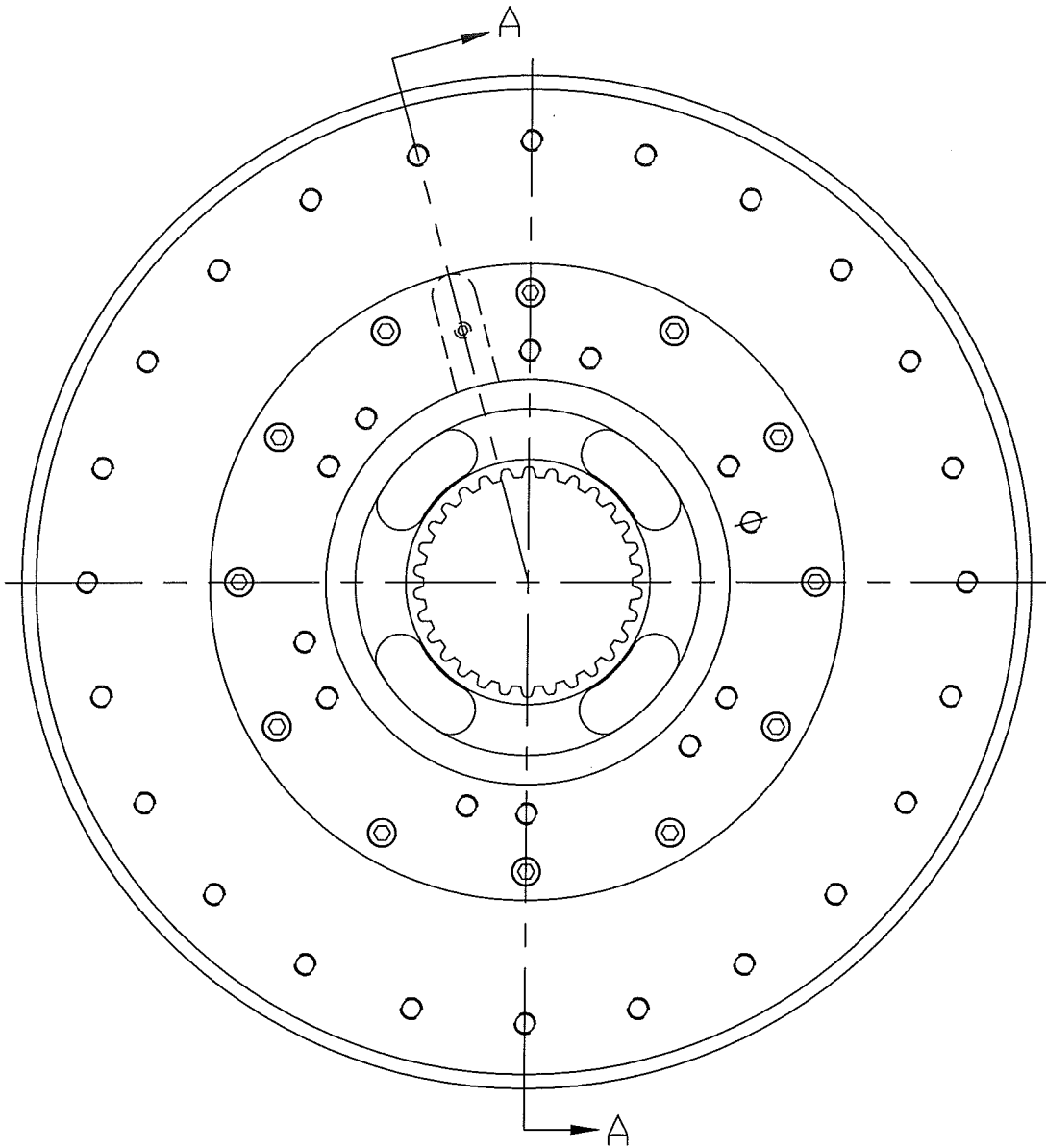
SCALE: 1:4	APPVD: *	DRAWN: JBM
DATE: 5/24/05	DATE: *	CHECKED: JBM
DESCRIPTION: ASSY,SHAFT 34TF		
PART NO.:	SIZE C	DRAWING NO. 0520477
FIRST USED:	REV. B	SHEET 1 OF 1

ITEM	PART NO	QTY	DESCRIPTION
1	0531904	1	HEAD,ROTATING OUTER 34TF
2	0531905	1	INSERT,SPLINED 34TF
3	9900011048	12	CAP SCR, SCH 5/8-11X1-1/4
4	9900011023	1	CAP SCR, SCH 3/8-16X1
5	9900052084	1	KEY,1.5X1.0X3.875LG CDS1018

LET	LOC	ECO	DESCRIPTION	DATE	BY	CHECKED BY
*	*	*	*	*	*	*



SECTION A-A



DO NOT SCALE DRAWING

UNLESS OTHERWISE SPECIFIED:	
MACHINING TOLERANCES INCHES	
1.	OR 1.0000 = ±.040
1.0	OR 1.0000 = ±.020
1.00	OR 1.0000 = ±.010
1.000	OR 1.0000 = ±.005
1.0000	OR 1.0000 = ±.002
125	SURFACE FINISH
PROJECTION	ANGULARITY TOL. ±.5°



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SCALE: 1:4	APPVD: JBM	DRAWN: JBM
DATE: 5/24/05	DATE: 5/24/05	CHECKED: JBM
DESCRIPTION: ASSY,ROTATING HEAD 34TF		
PART NO.:	SIZE C	DRAWING NO. 0531907
FIRST USED:	REV. -	SHEET 1 OF 1