

HEDEMORA

One (1) DISC FILTER Ø 5000 X 16/22

SAVEALL

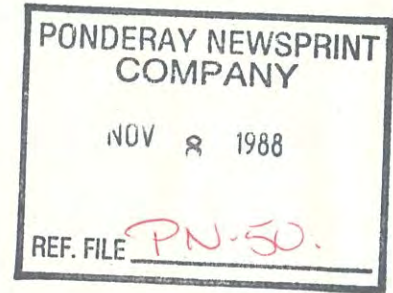
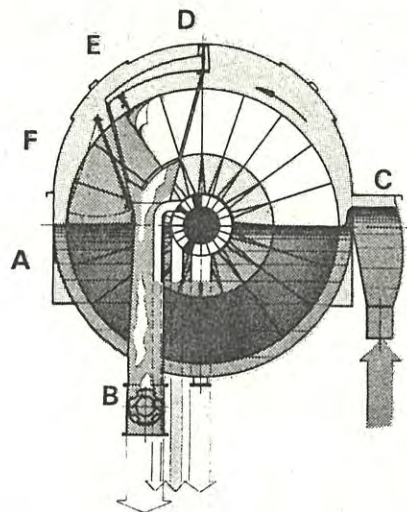
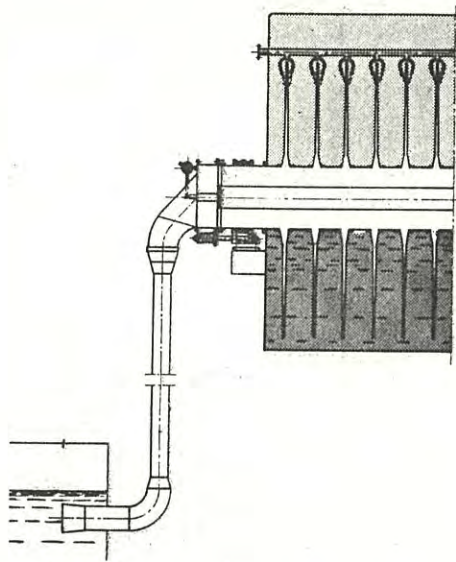


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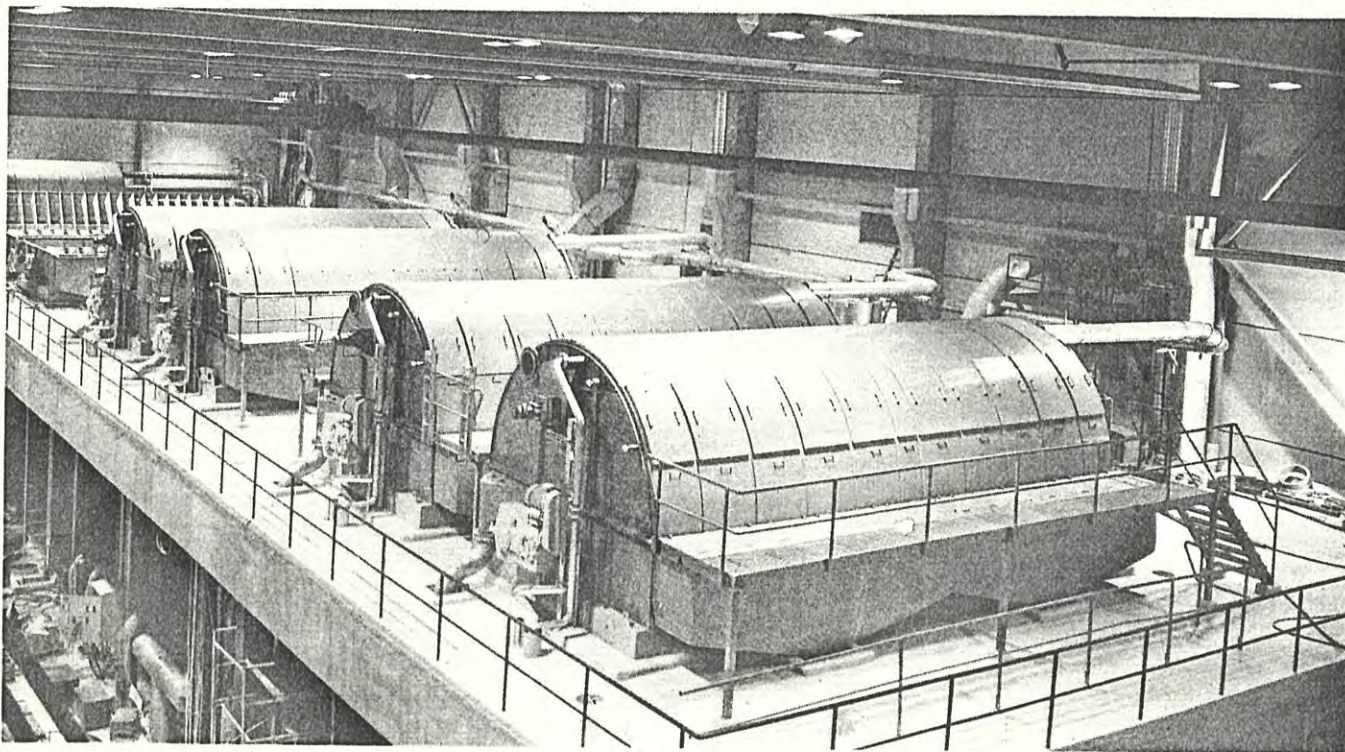


The filter is built around a horizontal shaft with internal axial filtrate channels leading to one end of the shaft (or both ends if the filtrate quantities are very large). A number of filter discs are mounted on the shaft, each disc consisting of 20 sectors, connected to corresponding channels in the shaft.

50—70 % of the disc area is submerged in a vat, containing the suspension to be filtered.

The open end of the shaft is connected to a filtrate valve, which opens and closes the channels to a vacuum created by means of a barometric leg and/or vacuum pump.

- A. The filter sector enters the suspension in the vat. The fibre mat starts to form under atmospheric pressure, which optimizes the dewatering properties of the bottom layer. Cloudy filtrate is drawn through the filtrate valve.
- B. The valve flap changes from the cloudy to the clear filtrate zone.
- C. The sector is drained as air is sucked through the pulp mat to displace the filtrate, drying the cake.
- D. Vacuum is shut off by a bridge in the valve.
- E. The fiber cake is discharged by shower.
- F. The filter cloth is cleaned by oscillating showers.



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Dimension data

Cloudy filtrate & excess P.M. white water	3358 GPM e 0.2 %
Couch Trim and showers	1419 GPM e 0.2 %
with Sweetener Stock of	679 GPM e 3.5 %

Minimum pulp discharge of 3.5 % and a clear filtrate of 75 PPM.



LUBRICATION INSTRUCTIONS

CLEANING SHOWER BEARING

The bearing on the drive side of the oscillating cleaning shower is an articulated bearing of steel, equipped with automatic grease arrangement, which means the bearing is maintenance-free during 12 months at an ambient temperature of 25°C.

To calculate the length of function of the grease cartridge, the temperature at the grease point should be measured.

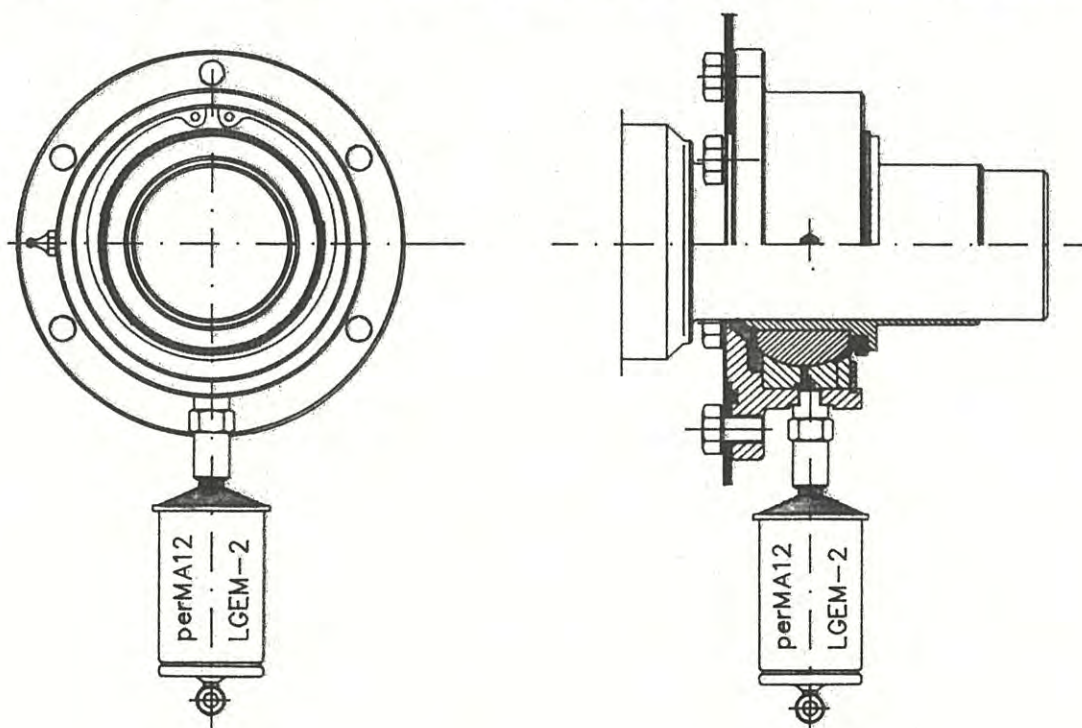
Temperature increase of 10°C will decrease length of function with 3 months (i.e. 25°C + 35°C = wear life 9 months).

When installing a perMa grease arrangement the bearing must first be filled with LITIUM grease.

If there is a hose or a piping between the bearing and the grease arrangement they must also be filled with grease.

The perMa grease cartridge is activated by turning the grey screw on top of cartridge completely to a stop.

Type of grease: perMa 12 LGEM 2 order No. 2-82780/14



START UP

- a) Check the level in the clear filtrate tank. Water should be filled up automatically to a minimum level for start up purpose.
- b) Start the filter with associated equipment. The motors should be interlocked for right start sequence. The order should be as follows:
 - 1. The shower water pump
 - 2. The motor for the oscillating cleaning shower
 - 3. The main drive of the filter
 - 4. The pump for white water, and cloudy filtrate to the filter.
 - 5. The pump for sweetener.

If some motor stops, all the other ones later in the sequence should stop as well. One exception from this list is the motor for the oscillating shower. It is good if this motor could be stopped during operation for cleaning of the nozzles if necessary. For service purposes it should be possible to operate the oscillating shower and the main drive from local switches at the filter.

- c) The level in the filter vat is controlled automatically by the speed of the filter. The speed range is 0.3-1.5 rpm. The set point of the level should be as high as possible without overflow of pulp to the screw conveyor. Start the filter with the level control in automatic position.
- d) When the vat level has stabilised, a vacuum is created by means of a barometric leg. The vacuum is indicated on the filtrate valve. Normal values are 10-40 kPa.
- e) The amount of sweetener should be controlled for good operation to obtain the right value of this flow, the thickness of the fibre mat on the discs has to be checked. The fibre mat should be about 5 mm thick.
- f) Check the three shower systems:
 - 1. Discharge shower
 - 2. Wire cleaning shower
 - 3. Sluicing shower.

All the nozzles should be open and adjusted to right positions (See "inspections during normal operation".) Use maximum valve openings for the discharge and wire cleaning shower (7 bars).

SHUT DOWN

- a) Stop the pulp flow to the filter and let the filter be running for 3 minutes with only white water and cloudy filtrate.
- b) Stop the pumps for white water and cloudy filtrate.
- c) Stop the filter drive, the oscillating shower, the shower water pump.
- d) For a short shut down (shorter than 24 hours) the remaining pulp could be left in the filter vat.

When shutting down for extended periods, the vat has to be drained and the filter carefully cleaned. Use the wire cleaning shower for the discs and a water hose for the rest of the filter.



INSPECTIONS DURING NORMAL OPERATION

CHECK ONCE A SHIFT

A. Discharge shower

Check that no nozzles are plugged. The nozzles can be cleaned during operation of the filter. There is a cut-off valve for each pair of nozzles. Remove the nozzles and clean it with a metal wire. **When reinstalling the nozzle, don't tighten it too hard.** The thread is conical to make it possible to have the nozzles fixed in the right angle to the disc. If necessary, use "Loctite 572" or teflon tape to fix it.

B WIRE CLEANING SHOWER

Check that the nozzles are open, and that the whole discs are covered by the showers. The motor for the oscillating movement has a brake which makes it possible to stop the shower at the disc peripheri. In that position the nozzles can be reached from the openings in the hood.

The same type of nozzles are used as for the discharge shower, and they are cleaned the same way. The angel between the shower water and the disc is shown in the drawing. **Don't tighten the nozzles too hard.** If not the whole discs are covered by the the showers adjust the connection between the main pipe and the drive. (see maintenance instructions.)

C. FILTRATE QUALITY

The filtrate is divided in cloudy and clear. The amount of cloudy is 20-25% of the total filtrate flow. The division between cloudy and clear filtrate can be changed by moving one sector of the wearing plate between the shaft and the valve. The sector in the wearing plate can bee controlled by a hand wheel on the valve. Moving the sector downwards will give a higher percentage of cloudy filtrate, and to some extent a cleaner clear filtrate.

Too much cloudy filtrate can on the other hand give a clear filtrate with higher content of suspended solids. (Depending upon higher filter speed.) Try to find the optimum position of the filtrate dividing sector.



Measure the suspended solid content regular in both cloudy and clear filtrate. Higher values than normal indicates hole in the filtrate. Higher values than normal indicates hole in the filter bags.

D. LEAKAGE

Check that there is no leakage in the following positions:

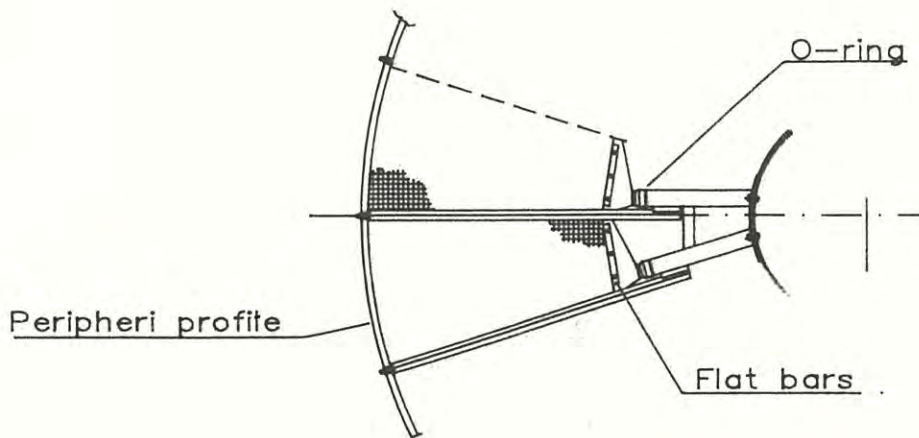
- * The two stuffing boxes between the vat and the shaft.
(some drops leakage is normal.)
- * The rubber connection between the filtrate valve and the drop leg. Hole in the connection gives a low vacuum.
- * The rubber hose for water feed to the oscillating cleaning shower.

For measures, see maintenance instructions.



CHANGE OF FILTER BAGS, CASSETTE SECTOR

1. Take out the damaged sector from the filter, work from the feed box side. Use a key for the nuts at the peripheri.
2. Remove the flat bars at the bottom of the sector and cut clear the old bag.
3. Check that no sharp edges may damage the new bag.
4. Open the zip fastener. Put the filter bag on to the sector. Pull down the zip fastener and take away the zip joint. Melt the zip fastener on a length of about 20 mm with a not too hot soldering iron. Fold the zip fastener under the bag.
5. Check if the bag is in correct position all around. Melt holes in the cloth for the screws to the flat bars. That can be down with a 2 mm pin which is moved around until the required hole diameter has been obtained. The pin must be heated so that the threads will melt. A small soldering iron could be used. Then fasten the flat bars with its screws.
6. Immerse the sector in a water bath (temp. about 85–90°C during 5–6 minutes) until the bag shrinks and is stretched close to the sector, without folds. Also steam can be used to shrink the bag.
7. Change O–ring if necessary, put the sectors back, mount the peripheri profile and tightened the nuts.

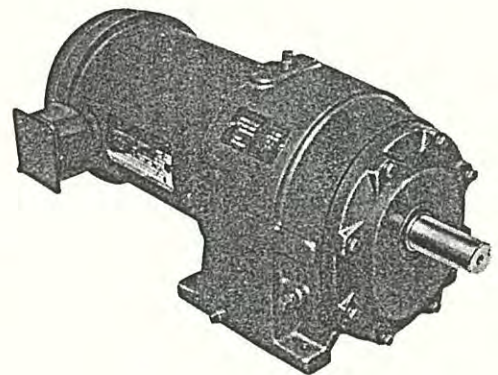
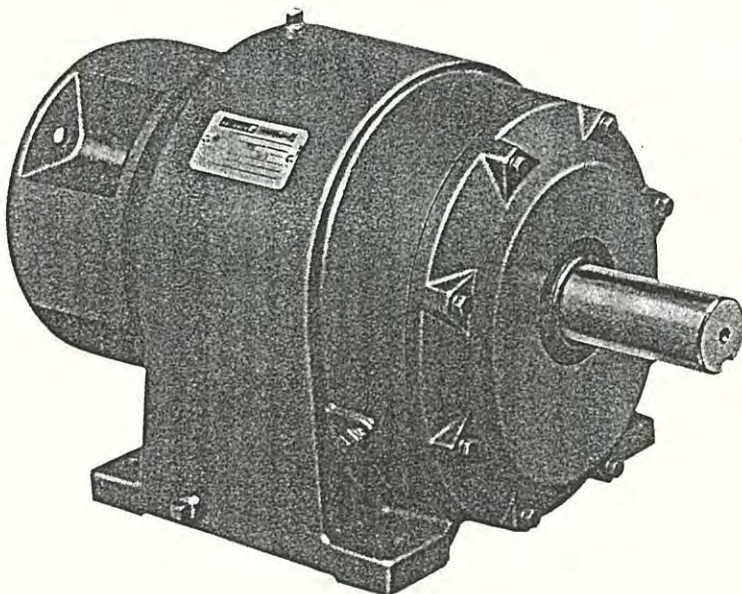


MASTER® XL PARALLEL GEARMOTORS AND C-FACE REDUCERS

SERVICE AND REPAIR

FOR SIZES 16, 21, 28

TM 21 A Model # M61119 (129.7:1)



WARNING

BECAUSE OF THE POSSIBLE DANGER TO PERSON(S) OR PROPERTY FROM ACCIDENTS WHICH MAY RESULT FROM THE IMPROPER USE OF PRODUCTS, IT IS IMPORTANT THAT CORRECT PROCEDURES BE FOLLOWED: PRODUCTS MUST BE USED IN ACCORDANCE WITH THE ENGINEERING INFORMATION SPECIFIED IN THE CATALOG. PROPER INSTALLATION, MAINTENANCE AND OPERATIONAL PROCEDURES MUST BE OBSERVED. THE INSTRUCTIONS IN THE INSTRUCTION MANUALS MUST BE FOLLOWED. INSPECTIONS SHOULD BE MADE AS NECESSARY TO ASSURE SAFE OPERATION UNDER PREVAILING CONDITIONS. PROPER GUARDS AND OTHER SUITABLE SAFETY DEVICES OR PROCEDURES AS MAY BE DESIRABLE OR AS MAY BE SPECIFIED IN SAFETY CODES SHOULD BE PROVIDED, AND ARE NEITHER PROVIDED BY RELIANCE ELECTRIC NOR ARE THE RESPONSIBILITY OF RELIANCE ELECTRIC.

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GENERAL

The Master Parallel Gear line is composed of one basic reducer. This reducer is used to make up two types of motor and gear reduction packages.

1. THE GEARMOTOR — is a compact integral power package. Partial motor is directly connected to the reducer input shaft by means of a semi-rigid coupling.
2. THE C-FACE REDUCER — is also a compact power package utilizing a standard "C" Face motor, adapter, and flexible coupling connecting to the reducer.

The Master Parallel gearing is Helical design with ball bearings on input shaft and Taper roller bearings on intermediate and output shafts.

MOUNTING

Before servicing the gearmotor, check diagrams on tags supplied to see that oil level plug location and oil level are correct for position in which gearmotor is to operate.

ROTATION

To reverse the direction of rotation of a 3-phase A-C Gearmotor, interchange any two of the lines going to the motor. If it is a 2-phase gearmotor, interchange the wires of one phase. Four wire 2-phase gearmotors have lead marking conforming to NEMA standards.

D-C Gearmotors may be reversed by interchanging the armature leads. In all cases, connection diagrams are furnished with the motors.

LUBRICATION AND MAINTENANCE INFORMATION

Lubrication is extremely important for satisfactory operation. Proper oil level must be maintained in the gearcase at all time. Red plugs indicate oil level check points. Frequent inspections with the unit not running (preferably when warm) should be made by removing this plug to check for proper lubricant level. If the level is low, add lubricant through one of the upper openings until it begins coming out of the oil level hole. Replace the oil level plug securely.

RECOMMENDED LUBRICANTS

Use only the best grade of automotive engine lubricants, unless otherwise specified. Where gear units are used out-of-doors, seasonal changes may be necessary. The proper grade of oil is listed as follows:

Ambient Temp. (Room)	Oil Grade for Countershaft Speeds			
	13.5 to 500	501 to 1000	1001 to 3000	Over 3000
110°F to 165°F	SAE 50 (A)	SAE 40	SAE 30	SAE 20W
60°F to 110°F	SAE 40	SAE 30	SAE 20W	SAE 10W
35°F to 70°F	SAE 30	SAE 20W	SAE 10W	SAE 10W
10°F to 40°F	SAE 20W	SAE 10W	SAE 10W	
-10°F to +20°F	SAE 10W	NOTE (B)		
-30°F to +10°F	NOTE (B)	NOTE (C)		
-65°F to -20°F	NOTE (C)			

Note (A) — Use automotive heavy duty oil, SAE 50 grade with oxidation inhibitor.

Note (B) — Use Gulf Paramount No. 22 which is a naphenic base oil with a low pour point and viscosities of 109.8 SUS at 100°F or 39.1 SUS at 210°F. Any other oil meeting these specifications would be a suitable substitute.

Note (C) — Use Mobil Oil Co. Avrex No. 903.

Note (D) — For temperatures below 10°F special oil seals are required.

WARRANTY

This equipment is warranted under Reliance's published "Standard Conditions for Sale of Electrical Apparatus."

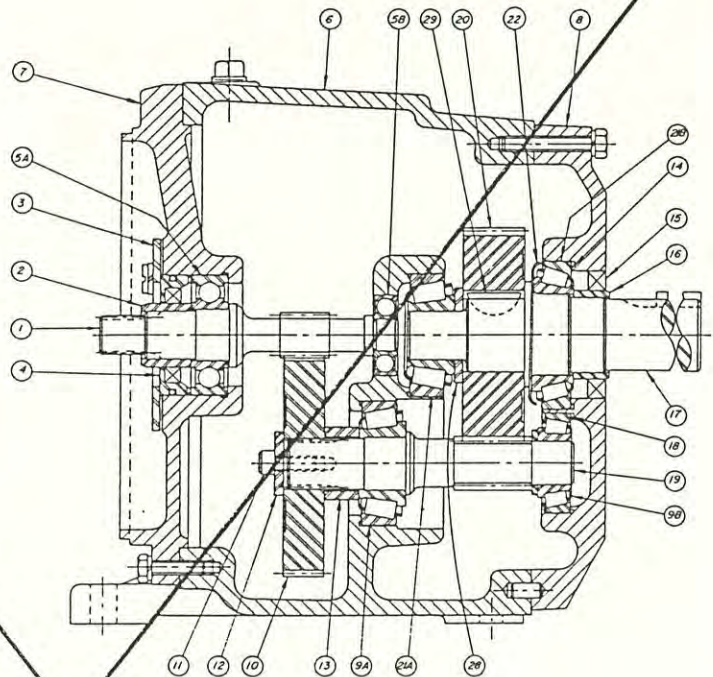
Warranty claims on any such apparatus must be submitted to the company within the initial service year and prior to the expiration of any applicable terminal claim period.

Parts, service, and repairs, in or out of warranty may be arranged through any Reliance Authorized Service Shop, Distributor, or District Sales Office.

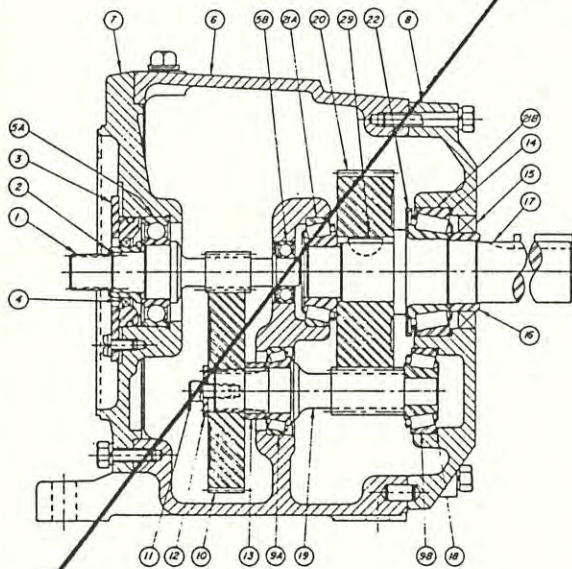
Damage in shipment, abuse, misuse, applicable maintenance and repair and periodic adjustments, as required, are not part of this warranty.

SIZES D-16-21-28

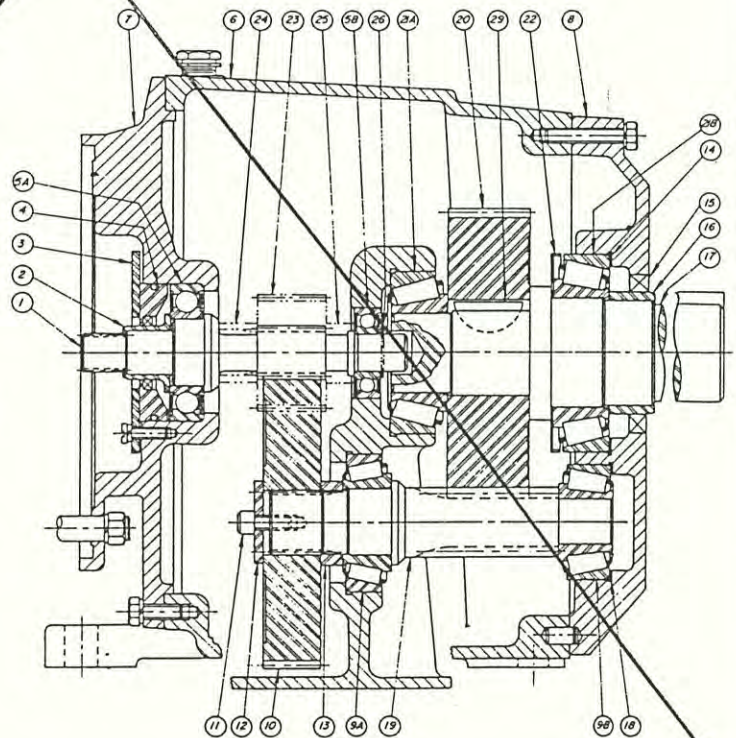
1. Input Shaft (driver gear)
2. Seal Sleeve
3. Lock Ring or Clamp
4. Seal (input)
- 5a. Ball Bearing (input shaft)
- 5b. Ball bearing (input shaft)
6. Gearcase
7. Cover Plate
8. Bearing Housing
- 9a. Roller Bearing
- 9b. Roller Bearing
10. 1st Stage Driven (gear)
11. Screw
12. Washer
13. Spacer (gear)
14. Shims
15. Seal (output)
16. Seal Sleeve (output)
17. Output Shaft
18. Shims
19. 2nd Stage Driver (gear)
20. 2nd Stage Driven (gear)
- 21a. Roller Bearing
- 21b. Roller Bearing
22. Grease Retainer (shaft up mounting only)*
23. Shell Pinion } Shell pinion
24. Spacer } in some D-28
25. Spacer } ratios
26. Lock Ring
27. Key
28. Spacer (gear)
29. Key



D21



D16



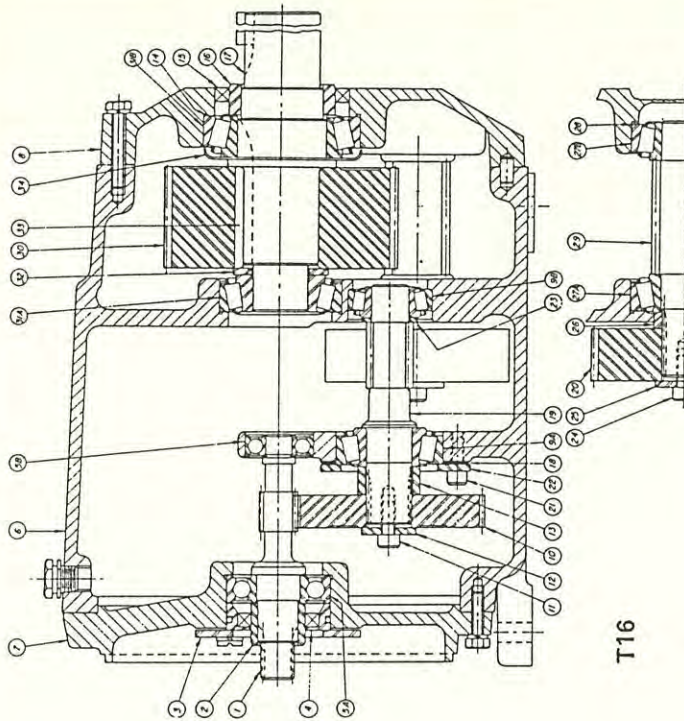
D28

INSTRUCTIONS FOR DISASSEMBLY AND REASSEMBLY FOR TRIPLE PARALLEL GEARMOTORS AND REDUCERS

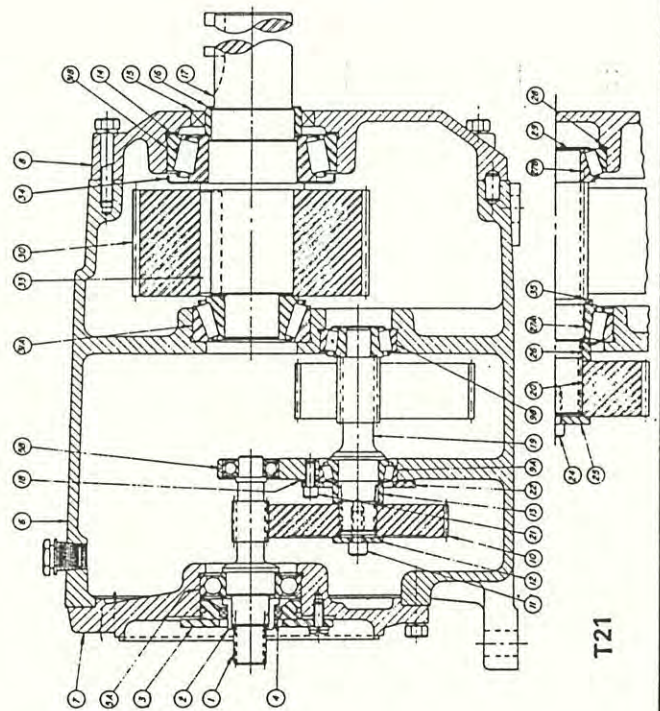
1. Remove the drain plug and drain the lubricant from the gearcase. It is suggested that disassembly begin at the input shaft end of the reducer. Present manufacturing of gearmotors utilize a seal clamp and screws.
2. The input shaft seal (4) and bearing (5A) were locked into the coverplate (7) by means of a lockring in earlier designs. Remove the bolts holding the coverplate and tap cover so as to loosen it at the gasket joint. The coverplate and the input shaft assembly can be removed as a unit. Be careful not to hit or damage the gear teeth. Remove the lockring or clamp and tap or pull the pinion shaft (1) bearing, and seal from the coverplate (7).
3. Remove the screw (11) and washer (12) holding the first stage driven gear (10) on the second stage pinion shaft (19). This gear should slip off freely.
4. Remove the screw (24) and washer (25) holding the second stage driven gear (20). This gear will not normally come off of the shaft until output shaft and bearing housing (8) are removed.
5. Remove the three bolts (21) holding the bearing clamp (22) on the second stage pinion shaft. By moving gear (20) on the third stage pinion shaft, the second stage pinion shaft (19) can now be removed. This shaft assembly should now be pulled out, at the same time one bearing cup and shims will also come out.
6. Loosen all screws on bearing housing (8) and remove all except one on each side to keep output shaft in place. With bearing housing loose you can now reach into the gearcase from opposite end and slip off second stage driven gear (20) from third stage pinion shaft (29).
7. Stand gearcase on end with output shaft vertical. Remove remaining screws and lift off bearing housing. Lift out output shaft assembly (17) also the third stage pinion shaft (29).
8. All parts and castings should be washed and inspected for possible replacement. It is our suggestion that the shimming of bearings be done to one shaft at a time, this allows for better freedom and less possibility of too much preloading or looseness of bearings.
9. If new seals and bearings are being installed it is a good idea to press on the new seal sleeve. Apply some sealer to the shaft at sleeve location.
10. Install the third stage pinion shaft (29) in the gearcase. Place the shims (28) under the bearing cup (27B) in the bearing housing (8). Install the bearing housing with several bearing housing screws. Check the shaft from the inside of the gearcase for proper shimming of the roller bearings (27A-B). The shaft (29) should be free to turn with no side motion in the bearings.
11. Remove the bearing housing screws, bearing housing and lift out the third stage pinion shaft.
NOTE: Grease retainer (34) used only in vertical output shaft up mounting only.
12. Place the final output shaft (17) into the gearcase. The bearing shims should be placed under the bearing cup (31B) in the bearing housing (8). Install the bearing housing and secure with several screws. Check the output shaft to be sure that the shaft turns freely and there is no side motion in the bearings.
13. Remove the bearing housing (8) again and re-install the third stage pinion shaft (29).
NOTE: It is now necessary to place the second stage driven gear (20) and spacer (26) onto the third stage pinion shaft (29) from the input end of the gearcase. Use screw (24) and washer (25) finger tight in order to keep the gear on splined shaft while completing assembly of output shaft end. Apply silicone rubber adhesive to gasket surface and re-install bearing housing with all screws. You should now be able to turn the third stage pinion shaft freely from inside the gearcase.
14. From the input end you can now place the second stage pinion shaft (19) into the bearing bores. You will need to loosen the screw (24) which was finger tight and slide gear (20) on spline in order for bearing on pinion shaft (19) to clear gear and go into bearing bore. To secure these shaft bearings (9A-B) the shims (18) are placed under the bearing clamp (22). Again shim so there is no side motion in the bearings and shaft turns freely.
15. Secure the second stage driven gear (20) onto the third stage pinion shaft (29) with screw (24) and washer (25).
16. The first stage driven gear (10) and spacer (13) can now be placed on the second stage pinion shaft (19). Lock this gear on the shaft with screw (11) and washer (12).
17. If new bearings (5A-B) have been installed on the input shaft (1), a new seal sleeve (2) should also be installed. Apply some sealer to the shaft at the seal sleeve location and press the sleeve in place. The input shaft assembly should be placed in the coverplate (7).
NOTE: In T-28 reducers, some ratios have a shell pinion (37) on the input shaft. There are additional spacers (36-38) and lockring (39) on this input shaft.
18. Apply silicone rubber adhesive to the gasket area. Take input shaft (1) and coverplate assembly and install on gearcase making sure that pinion meshes with driven gear and outboard bearing (5B) slides into the bearing bore properly. Install coverplate screws and secure them.
19. The oil seal assembly (4) can now be placed in the coverplate (7). A bit of lubricant should be applied to the seal sleeves and to the O-Ring. This will allow the seal to slide into place much easier. Install the seal clamp (3) and secure with clamp screws. If the unit is a gearmotor with a lockring, add ball bearing shims as required, between the lockring and the seal housing, to limit the end play of the input shaft to the internal clearance of the ball bearing.
20. If the output shaft oil seal has not as yet been installed, it should now be placed in the bearing housing and a tube of proper dimensions used, to tap the seal flush with the casting surface.
21. Fill the reducer with the proper lubricant to the correct oil levels for test. Reassemble motor in reverse order.

SIZES T16-21-28

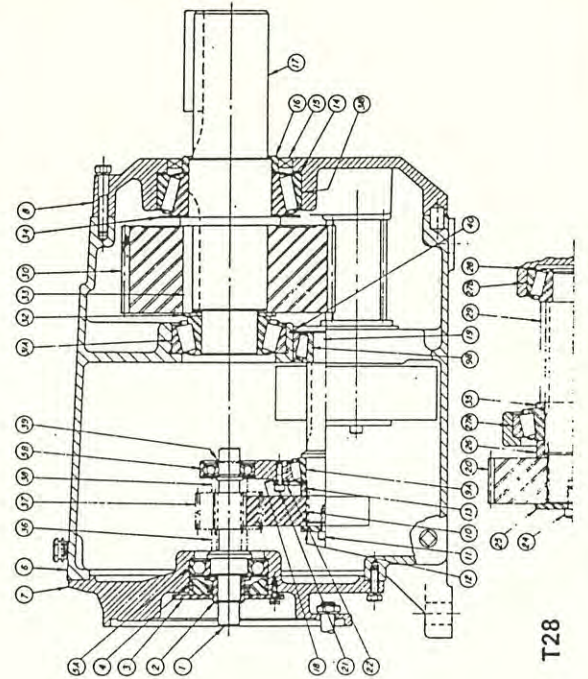
1. Input Shaft (1st stage driver)
2. Seal Sleeve
3. Lock Ring or Clam
4. Seal
- 5a. Ball Bearing (input shaft)
- 5b. Ball Bearing (input shaft)
6. Gearcase
7. Cover Plate
8. Bearing Housing
- 9a. Roller Bearing
- 9b. Roller Bearing
10. Gear (1st stage driven)
11. Screw
12. Washer
13. Spacer (gear)
14. Shims
15. Seal
16. Seal Sleeve (output)
17. Output Shaft
18. Shims
19. Gear (2nd stage driver)
20. Gear (2nd stage driven)
21. Screws (bearing clamp)
22. Clamp
23. Spacer (T-16)
24. Screw
25. Washer
26. Spacer
- 27a. Roller Bearing
- 27b. Roller Bearing
28. Shims
29. Gear (3rd stage driver)
30. Gear (3rd stage driven)
- 31a. Roller Bearings
- 31b. Roller Bearings
32. Spacer (T-16 & T-28)
33. Key
34. Grease Retainer (shaft up mounting only)*
35. Spacer (T-21 & T-28)
36. Spacer
37. Shell Pinion } in some T-28 ratios
38. Shell Pinion }
39. Lock Ring
40. Lock Ring



T16



T21



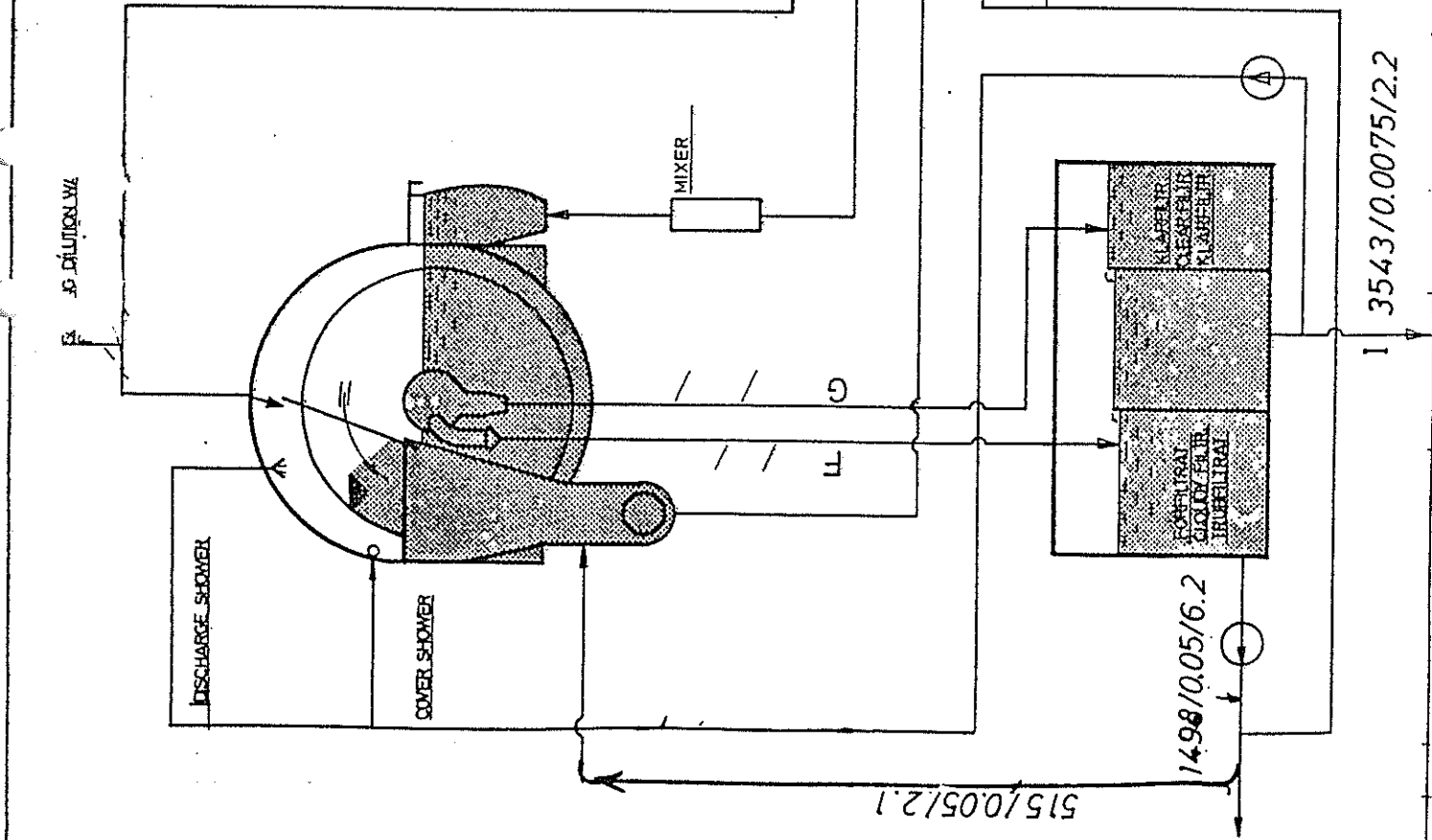
T28

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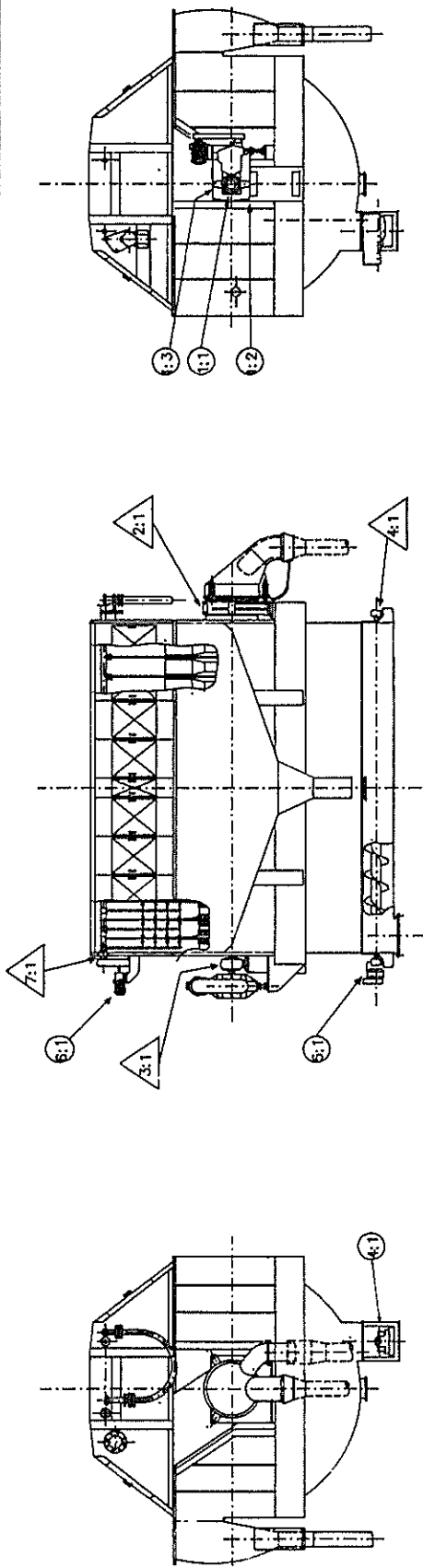


Direkt anordnes gæller Unless specified the following is valid			
Vejledning Re	Surface roughness	Tolerance for	Tolerance for
Skarp kant brydes	mm	Skarp kant brydes	mm
Sharp edges to be dressed		Sharp edges to be dressed	
Observed. Yt	Unmachined surface	Observed. Yt	Unmachined surface
SMS 715 = ISO 2768	Series grov	SMS 715 = ISO 2768	Series grov
Coarse series		Coarse series	
Andr. Rev.	Spec.	Datum	Sign

Legend:
GPM/%/min.

C	B	A	Det No	Benaming och metodim	Material	Vekt Weight	Ann Note
Util/Art	Design/Number	Drawn	87.05.25.	FLÖDESKEMA / FLOW DIAGRAM			
Scale	Scale	Checked		Ponderay Newsprint			
				SKIVFILTER / DISCFILTER			

HEDEMORA



SVÖRSTÄLLE NAME SCHMIERSTELLE	BESKRIVNING DESCRIPTION SCHMIERMETODE	Nr	ANTAL NUMBER ANZAHL	INTERVALL FÖR KONTROLL OCH SVÖRNING INTERVAL FOR CONTROL AND LUBRICANT INTERVALL FÜR KONTROLLE UND SCHMIERUNG	OLJEKVALITET LUBRICANT ÖLSORTE	OLJEMÄNGD QUANTITY ÖLMENDE	ANMÄRKNING NOTE ANMERKUNG
Tapvåxel, Shaftgear, Getriebe Separat instruktion se Instruktionsboken	Kontroll oljenivå Oil level control Kontrolle Ölstand	1:1	1	1 gång/vecka Every week Jede Woche	Shell Omala Oil 460 Mobilgear 634 BP Energol GR-XP 460	~100 l ~150 l	
Separat operating instruc- tion in the manual Separat instruktion siehe Instruktionsbuch	Oljbyte Oil change Ölwechsel	1:2 1:3	1	Första oljbytet efter 500 drifttimmar. Därefter var 8:e mån. The first oil change after 500 operating hours, then every 8th month. Erste Ölwechsel nach 500 Betriebsstunden, dann jede 6 Monat			
Gidlager Plane bearing Getrläger	Fettsmörjning Grease lubricating Fettschmierung	2:1	4	1 gång/vecka Every week Jede Woche	Shell Relinox AM Mobilgrease Special BP Energol L21-M		
Sfärisk rullager Roller bearing Pendelrollen läger	Fettsmörjning Grease lubricating Fettschmierung	3:1	1	1 gång/vecka Every week Jede Woche Var 6: månad Every 6th month Jede 6 Monat	Shell Relinox EP Grease 2... Mobilux EP2 BP Energol LS-EP2	4,4 kg 5,5 kg	
Sfärisk rullager Roller bearing Pendelrollen läger	Fettsmörjning Grease lubricating Fettschmierung	4:1	2	1 gång/vecka Every week Jede Woche Var 6: månad Every 6th month Jede 6 Monat		0,85 kg	
Tapvåxel Shaftgear Getriebe	Se separat instruktionsbok See separate operating manual Sehen Sie separate Instruktionsbuch	5:1	1		Shell Omala Oil 460 Mobilgear 634 BP Energol GR-XP 460	~1,6 l ~2,4 l ~3,0 l	
Kuggevåxel Geared motor Zahnradg.motor	Se separat instruktionsbok See separate operating manual Sehen Sie separate Instruktionsbuch	6:1	1		Shell Tellus Oil C 220 Mobil DTE Oil BB BP Energol HLP 220	~10 l	
Dukspårläger Cleaning snower Tuchspritzläger	Se separat instruktionsbok See separate operating manual Sehen Sie separate Instruktionsbuch	7:1	1		perMA 12 LCEM 2		Patron Cartridge Patrone

SKIVFILTER ø5000 DISC FILTER ø5000 SCHEIBENFILTER ø5000
Smörjschema Lubrication chart Schmierschema
THEDEMORA FORSÄKRING INSURANCE

FILTRATE VALVE

Drawing No. 1-86733-A

The sealing between the shaft and the filtrate valve is a plastic wearing plate. The thickness of a new plate is 40 mm. The wearing depth is 5 mm. The valve with the plastic plate is pressed against the shaft with 3 springs. The 3 bolts holding the valve have one stop ring each behind the valve. The distance between the valve and the stop rings should be adjusted to 5 mm for a new wearing plate after some hours run so the valve is warm. Before this distance is zero it is time to change the wearing plate.

To change the wearing plate the filtrate valve has to be removed. The plate is fixed to the valve with a number of screws at the periphery and 3 screws in the centre. These 3 screws are counter-sunk and covered with plastic washers. Use new washers to cover the holes when the new plate is installed. Check the above mentioned distance between the valve and the 3 stop rings when the valve is back in the right position.

A possible small leakage between the shaft and the wearing plate is collected by a ring around the valve and recircled to the drop leg by means of a rubber hose. The collecting ring is sealed with a V-ring on the shaft. Check the condition of the V-ring and change if necessary.

WIRE CLEANING SHOWER

Drawing No. 1-86742-B

The cleaning shower shall cover the whole disc area. The movement range of the shower can be adjusted. The connection between the shower drive and the pipe is a friction coupling.

Adjustment:

- Stop the shower in the lower position.
- Loosen the coupling. Unscrew all screws. If necessary change the 3 white screws to one dimension bigger screws and tighten them. That will loosen the coupling.
- Lift the shower pipes to the position where the lowest shower nozzle is about 50 mm above the flat bar at the bottom of the disc sector.
- Tighten the coupling screws in 2 or 3 steps to a torque of 70 Nm.
- Run the shower with water and check that the whole disc area is cleaned.

STUFFING BOXES

Shaft sealings - Drawings No. 1-86650-A, 1-86652-A

Use a sealing material with 3/4" square section in a good quality. Cut the sealings in a way that there is no gap when they are bent around the shaft. The length should be:

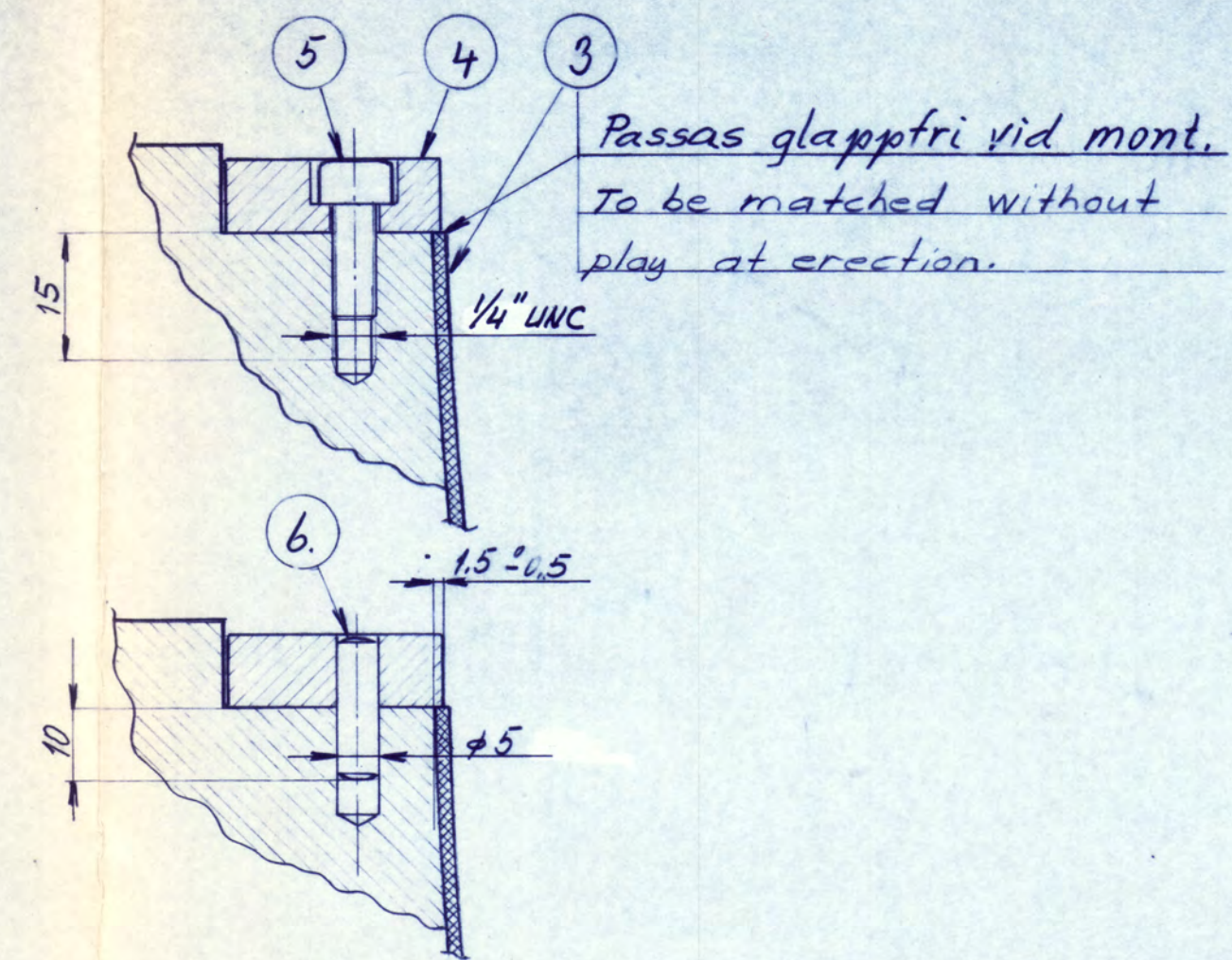
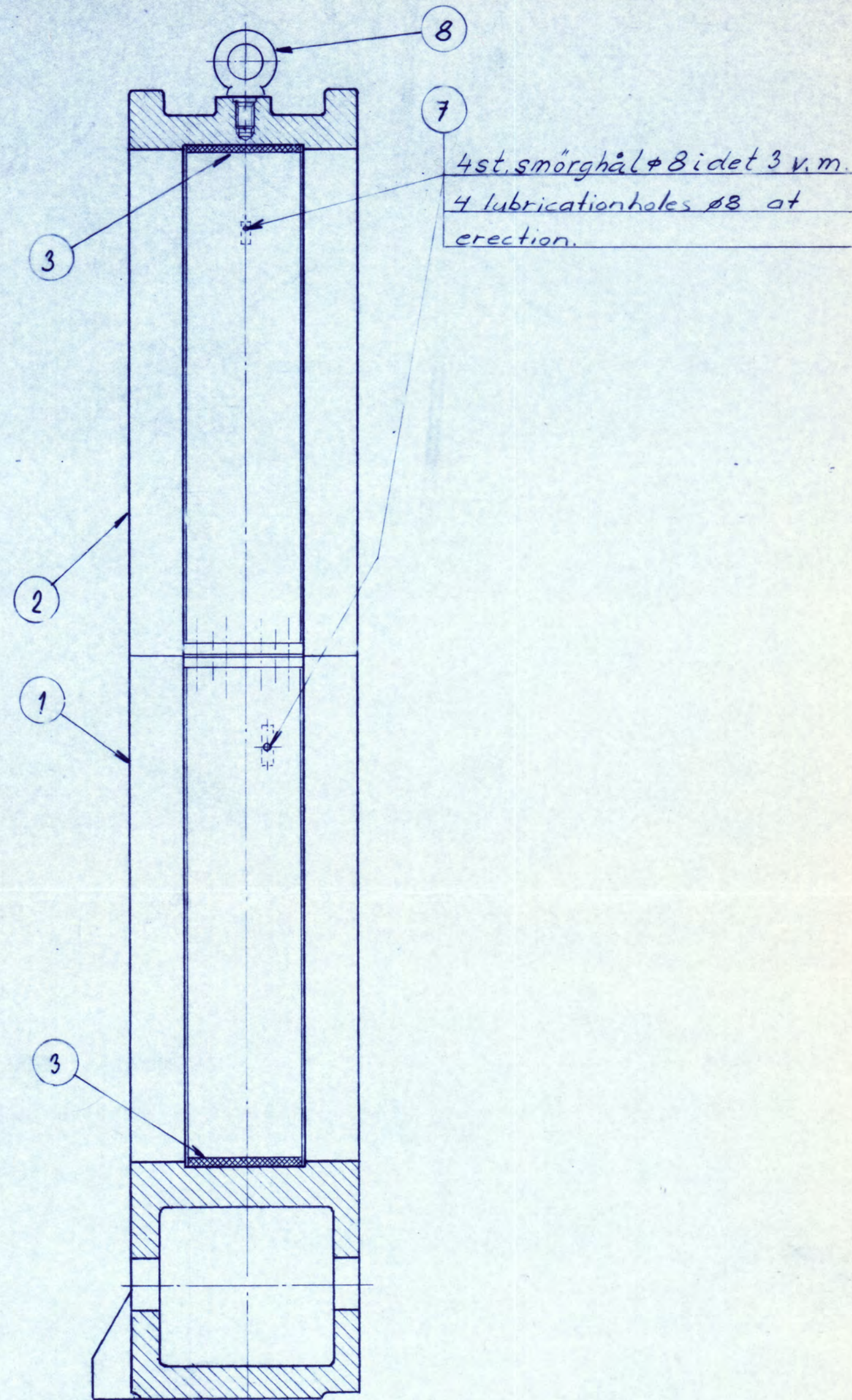
Drive end, mm	820
Filtrate enc, mm	3820

Install the sealings with the joint on top of the shaft. Press the sealing to the bottom of the box with the gland. Unscrew the gland nuts and tighten them **by hand force only**. Start the filter. If there is too much leakage in the sealings tighten the nuts alternately with maximum 1/4 rotation each. A leakage of 15-20 drops per minute is normal.

[illegible]

Denna ritning förblir vår egendom och får icke utan vårt medgivande kopieras visas eller utlämnas till konkurrent-firmor eller eljest obehöriga personer. (Överträdelse beivras med stöd av gällande lag.)

2-85 328



Där ej annat anges gäller Unless specified the following is valid				
Ytjämnhet Ra μm Smoothness		Tolerans för Tolerance for		
Skarpa kanter brytes mm Sharp edges to be dressed		Bearb. yta Machined surface	SMS 715 = ISO 2768 Serie medel Medium series	
		Obearb. yta Unmachined surface	SMS 715 = ISO 2768 Serie grov Coarse series	
Ändr. Rev.	Spec.		Datum Date	Sign.

Jämför ritn. 2-74102

USA:

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Före montaget infettas det. 3 med smörjfett
Mobil Plex 48.

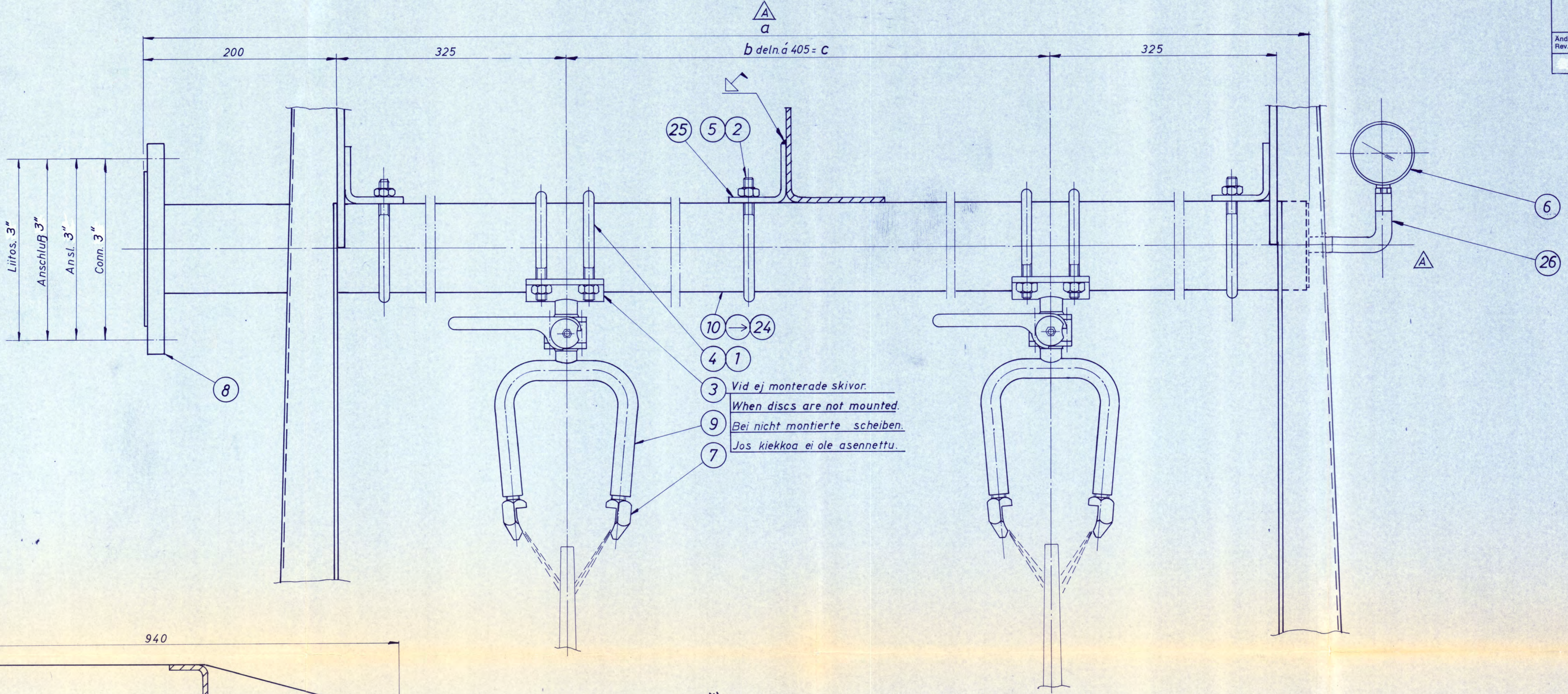
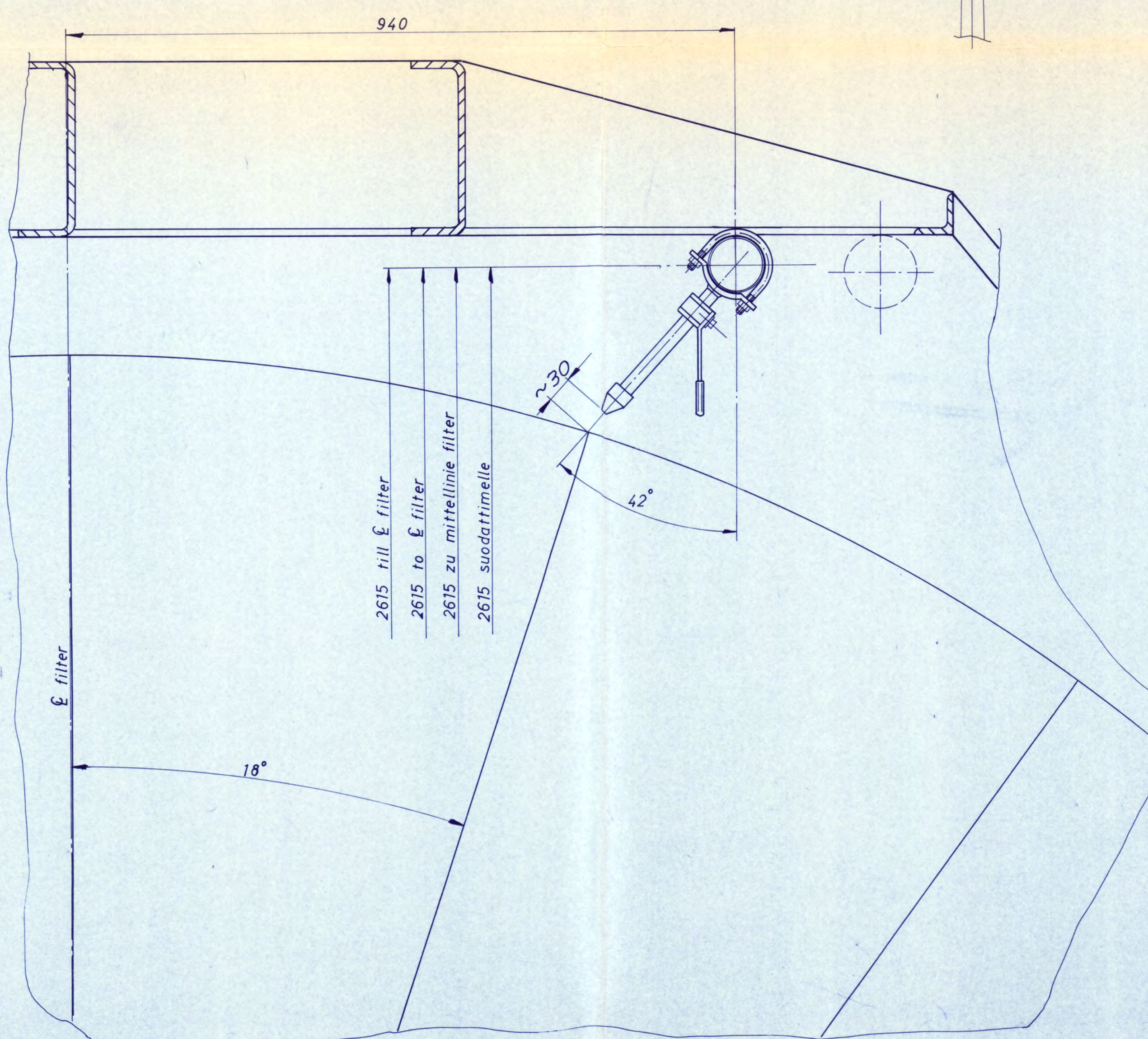
Detail 3. is to be lubricated with grease Mobil Plex 48 before erection.

1	8	Lyftögla LT 3/4" UNC	SS 1915	-	10	Eye bolt nut
4	7	Smörjnippl AH KR18	SMS 1568	-	-	Lubricant nipple
8	6	Pinne CP-h6 5x20	SMS 2374	1630-06	-	Pin
16	5	Skruv U65 1/4" UNC x 16		8.8 f.x.b.	-	Screw
4	4	Klämlist	3-74105		10	Clamping ledge
2	3	Lagerskalshalva	2-74104		10	Bearing cup
1	2	Överdel	1-85336-2		350	Upper part
1	1	Underdel	1-85336-1		400	Lower part
	A	Det. No.	Benämning och nettodim. Description and net dim.	Ritn. Drwg.	Material	Vikt Weight Anm. Note Description
Antal Number		Ritad Drawn	380223 KfB		Skivfilter 4 5000	
Skala Scale		Kontroll Checked	Centrumaxel		Total vikt Total weight 762 kg	
1/16 520 gela			Glidlager 2125 smst		Erättes av Replaced by	
HEDEMORA ☆			Disc filter 4 5000		Reg. av Reg. by	
AB HEDEMORA VERKSTÄDER SWEDEN			Plainbearing Ass. drwg.		2-85328	

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1-86 646



*) Gäller antal installerade skivor.
Valided installed discs.
Anzahl gültig für angebaute scheiben.
Koskee asennettujen kiekkojen määrä.

Tämför ritn. 1-86 017.
Jmfr. 1-76818.

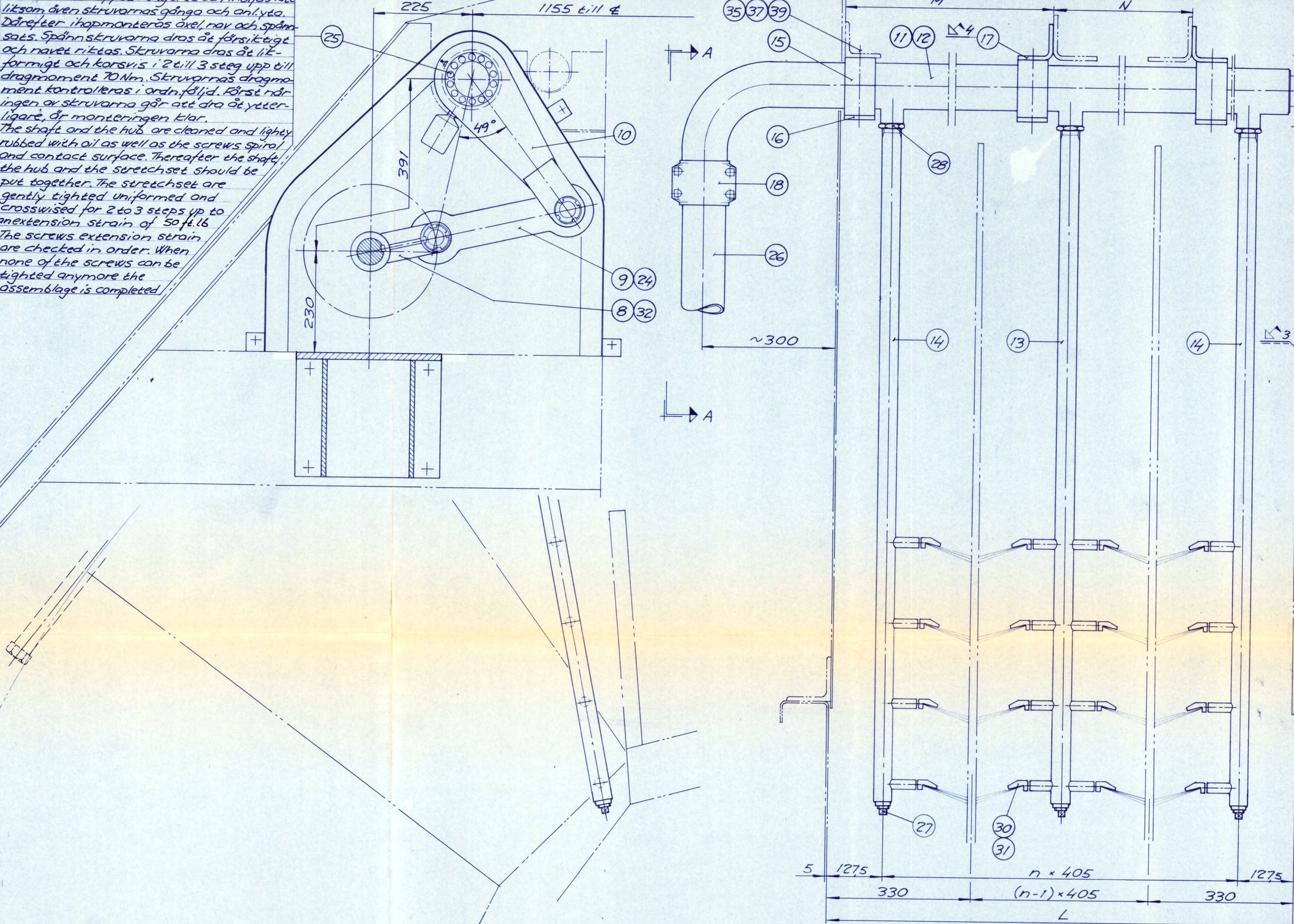
USA :
STANDARD

			Antal skivor / Number of discs / Anzahl scheiben / Kiekkojen lkm.																STANDARD																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																									
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Nimike	Benennung	Description	O	N	M	L	K	J	I	H	G	F	E	D	C	B	A	Det. No.	Benämning och nettdim. Description and net dim.	Ritn. Drwg.	Material	Vikt Weight	Anm. Note																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																					
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Axeln och navloppet rengöres och inoljias lätt
liksom även skruvarnas gänga och anlyta.
Därefter i hopmonteras axel, nav och spädn
sats. Spädn skruvarna dras åt försiktigt
och navet riktas. Skruvarna dras åt lik-
förmigt och korsvis i 2 till 3 steg upp till
dragmoment 70 Nm. Skruvarnas dragmo-
ment kontrolleras i ordning. Först när
ingen av skruvarna går att dra åt ytter-
ligare, är monteringen klar.
The shaft and the hub are cleaned and lightly
rubbed with oil as well as the screws spiral
and contact surface. Thereafter the shaft,
the hub and the stretchset should be
put together. The stretchset are
gently tightened uniformed and
crosswise for 2 to 3 steps up to
an extension strain of 50 ft.16
The screws extension strain
are checked in order. When
none of the screws can be
tightened anymore the
assemblage is completed.

Den här teckningen är en del av en teknisk dokumentation och ska inte användas för att kopiera eller återge tekniska lösningar utan tillstånd från HEDEMORA AB. Detta gäller även om teckningen inte är märkt som "Självaändring".

1-86742



USA-STANDARD

Utf. A: Enl. ritning (moturs rotation)
Utf. B: Spegelvänd (medurs rotation)
Design A: acc. to drawing (Anti-clockwise rot.)
Design B: mirror inverted (Clockwise rot.)
Imfr. 1-85749

x	x	39	Bricka	R8135x24	2343	Washer
18	18	38	Bricka	BRB 17x30	f2v	Washer
x	x	37	Mutter	UGM 1/2" UNC	2343	Nut
7	7	36	Mutter	UGM 5/8" UNC	f2v	Nut
x	x	35	Skruv	UGS 1/2" UNC x 6 1/2"	2343	Screw
7	7	34	Skruv	UGS 5/8" UNC x 2 1/2"	f2v	Screw
4	4	33	Skruv	UGS 5/8" UNC x 1 3/4"	f2v	Screw
1	1	32	Stoppskruv	USKGS 3/8" UNC x 5/8"		Stopscrew
*	*	31	Plugg	NPT 3/8" Sandvik	2343	Plug
*	*	30	Dysa	NPT 3/8" P3530	2346	Nozzle
29						
n-1	n-1	28	Mutter	R 1 1/4" RM160	2343	Nut
n-1	n-1	27	Propp	R 3/4" RP110	2343	Plug
1	1	26	Slang	TR 25/25-80 Trelleborg L=3700		Hose
1	1	25	Spädnset	BILON 4000-75-115		Stretching set
2	2	24	Stållager	2208-2RS1 SKF	x	Sph. roller bearing
2	2	23	Axelmutter	KM7 SKF	x	Nut
2	2	22	Låsbricka	MB7 SKF	x	Washer
1	1	21	Kuggväxel	motor TM21A/2137C 2hp		Gear motor
1	1	20	Slangstöd	2-82967		Hose support
1	1	19	Slanganslutning	2-84270		Hose conn.
2	2	18	Kidmskal	1-82950		Hose conn.
x	x	17	Fäste	3-74304		Bracket
x	x	16	Lagerstöd	3-83105	x	Bearing support
x	x	15	Lagerhalva	3-82972	x	Half bearing
2	2	14	Spritsrör	2-86274-B		Spray pipe
n-1	n-1	13	Spritsrör	2-86274-A		Spray pipe
1	1	12	Fördeln. rör	2-86273-		Distributing pipe
1	1	11	Fördeln. rör	2-86272-		Distributing pipe
1	1	10	Arm	2-69309		Arm
1	1	9	Arm	3-86271		Arm
1	1	8	Verslång	2-86746		Crank elbow
2	2	7	Tapp	3-69219		Tap
2	2	6	Bricka	4-69221		Washer
4	4	5	Bricka	4-78071		Washer
1	1	4	Skydd	2-86745		Shield
1	1	3	Skydd	2-86744		Shield
1	1	2	Lager	2-84063	x	Bearing
1	1	1	Motorhylla	2-86743		Motor bracket

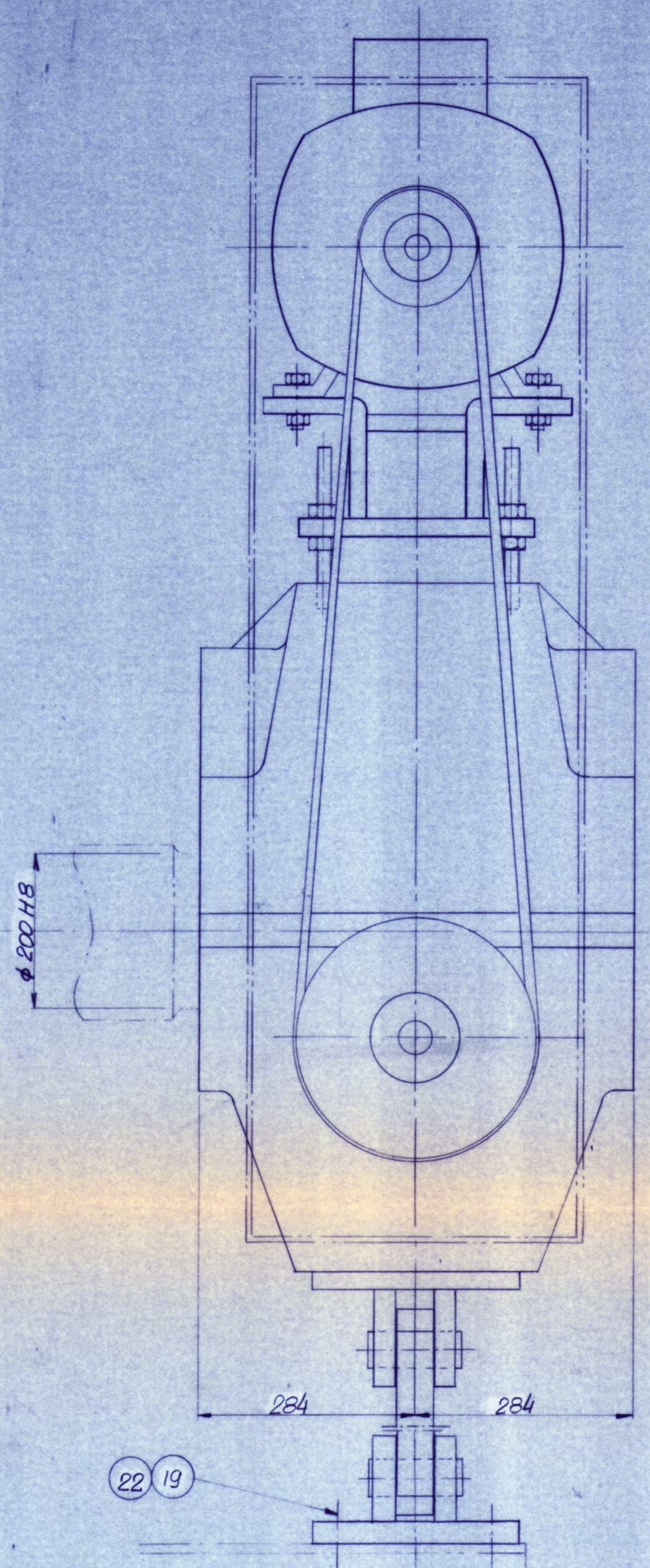
Antal skivor	n	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22
Number of discs	n	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22
Antal/Number	15	4	4	4	4	4	4	4	4	6	6	6	6	6	6	6
	16	2	2	2	2	2	2	2	2	3	3	3	3	3	3	3
	17	1	1	1	1	1	1	1	1	2	2	2	2	2	2	2
	35	4	4	4	4	4	4	4	4	6	6	6	6	6	6	6
	37	4	4	4	4	4	4	4	4	6	6	6	6	6	6	6
Antal/Number	39	8	8	8	8	8	8	8	8	12	12	12	12	12	12	12
L	3495	3900	4305	4710	5115	5520	5925	6330	6735	7140	7545	7950	8355	8760	9165	
M	1282	1282	1687	1687	2092	2092	2497	2497	2497	2497	2902	2902	3307	3307	3307	
N											1711	2116	1711	2116	1711	2116

HEDEMORA AB
SWEDEN

Skivfilter Ø5000 ANS
Högt tryck Ø-22 skivor
Dukspries smst
Discfilter Ø5000 ANS
Wire cleaning shower, ass. draw

1-86742 A

1-877-52



	H	G	F	E	D	C	B	A	Det. No.	Description	Ritm.	Materia l	Vikt kg/stück	Artikel	Nr.
Torque rod	1	1	1	1	1	1			26	Momentstöd HA=208		Santasalo			
Washer	4	4	4	4	4	4			24	BRB 10,5x22		fzb			
Nut	4	4	4	4	4	4			23	UGM 1/2" UNC					
Nut	12	12	12	12	12	12			22	UGM 1" UNC					
Screw	4	4	4	4	4	4			21	UGS 3/8" UNC x 20					
Screw	4	4	4	4	4	4			20	UGS 1/2" UNC x 60					
Screw	6	6	6	6	6	6			19	UGS 1" UNC x 60					
Studscrew	4	4	4	4	4	4			18	Pinnskruv 1"x190		fzb			
V-belt guard	1	—	—	1	—	—			17	Kilrepsskydd		1-86588 E			
V-belt guard	—	1	—	1	—	1			16	Kilrepsskydd		1-86588 A			
Motor bracket	1	—	—	1	—	—			15	Motorhylla		2-86588 E			
Motor bracket	—	1	—	—	1	—			14	Motorhylla		2-86588 B			
Motor bracket	—	1	—	—	1	—			13	Motorhylla		2-86588 A			
Flat key	1	1	1	1	1	1			12	Plattkil 45x25x300		BMS 2306			
V-belt	3	3	3	3	3	3			11	Kilrep 3Vx1000					
Bush	1	—	—	1	—	—			10	Bussning nr 2517 för axel Ø1 5/8"					
Bush	—	1	—	—	1	1			9	Bussning nr 2517 för axel Ø48					
Bush	1	1	1	1	1	1			8	Bussning nr 2517 för axel Ø35					
V-belt sheave	1	1	1	1	1	1			7	Remskiva Ø8,0" OD					
V-belt sheave	1	1	1	1	1	1			6	Remskiva Ø6,5" OD					
Motor	(1)	—	—	(1)	—	—			5	Motor Reliance 256 T		Håller av kund			
Motor	—	(1)	—	—	(1)	—			4	Motor 480 L		Håller av kund			
Motor	—	—	(1)	—	—	(1)			3	Motor 180 M		Håller av kund			
Shaft gear	1	1	1	—	—	—			2	Tappväxel STKC 400 (dl) Medursrotation		Santasalo			
Shaft gear	—	—	—	1	1	1			1	Tappväxel STKC 400 (öR) Motursrotation		Santasalo			
Description	H	G	F	E	D	C	B	A	Det. No.	Description	Ritm.	Materia l	Vikt kg/stück	Artikel	Nr.

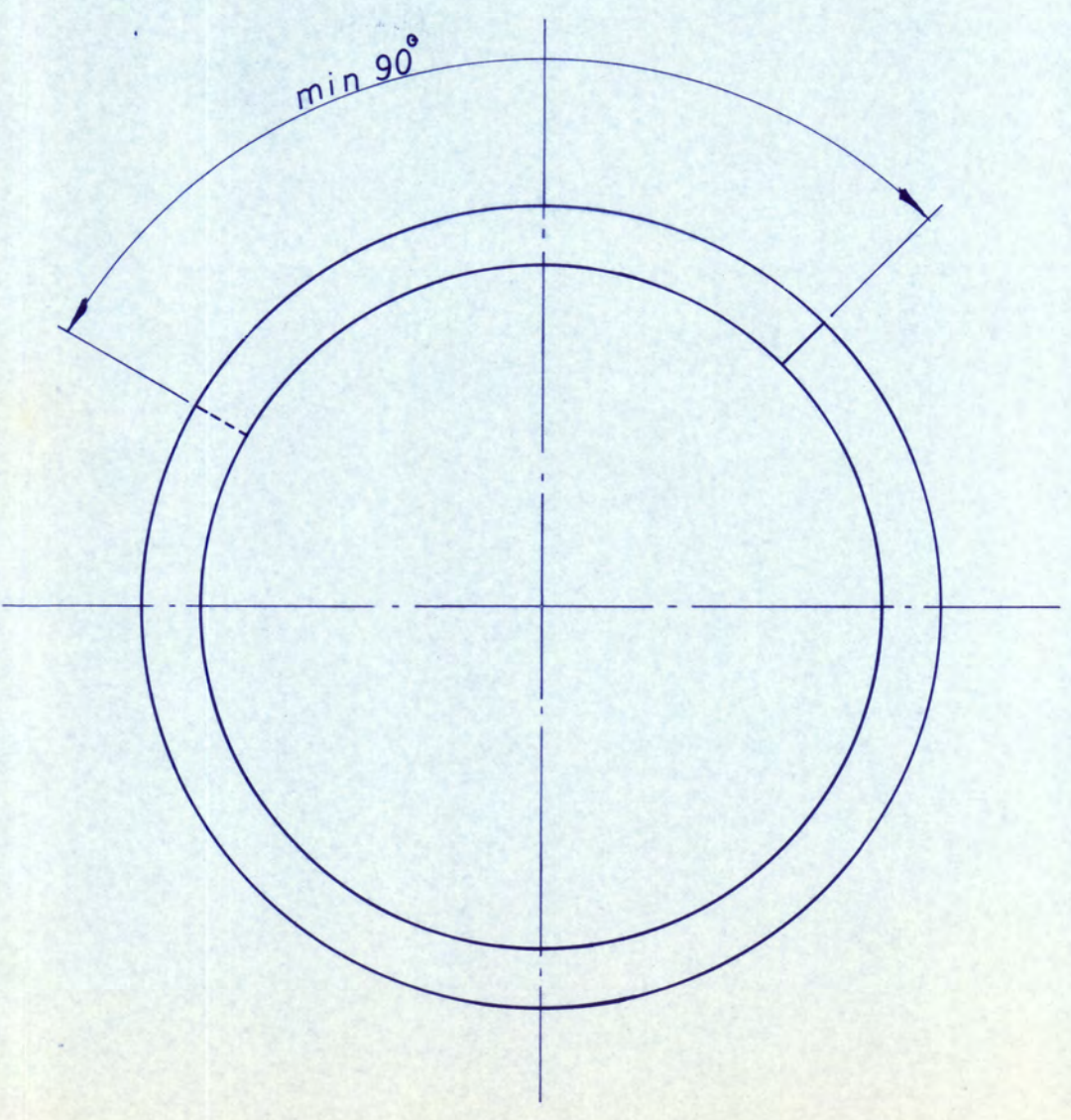
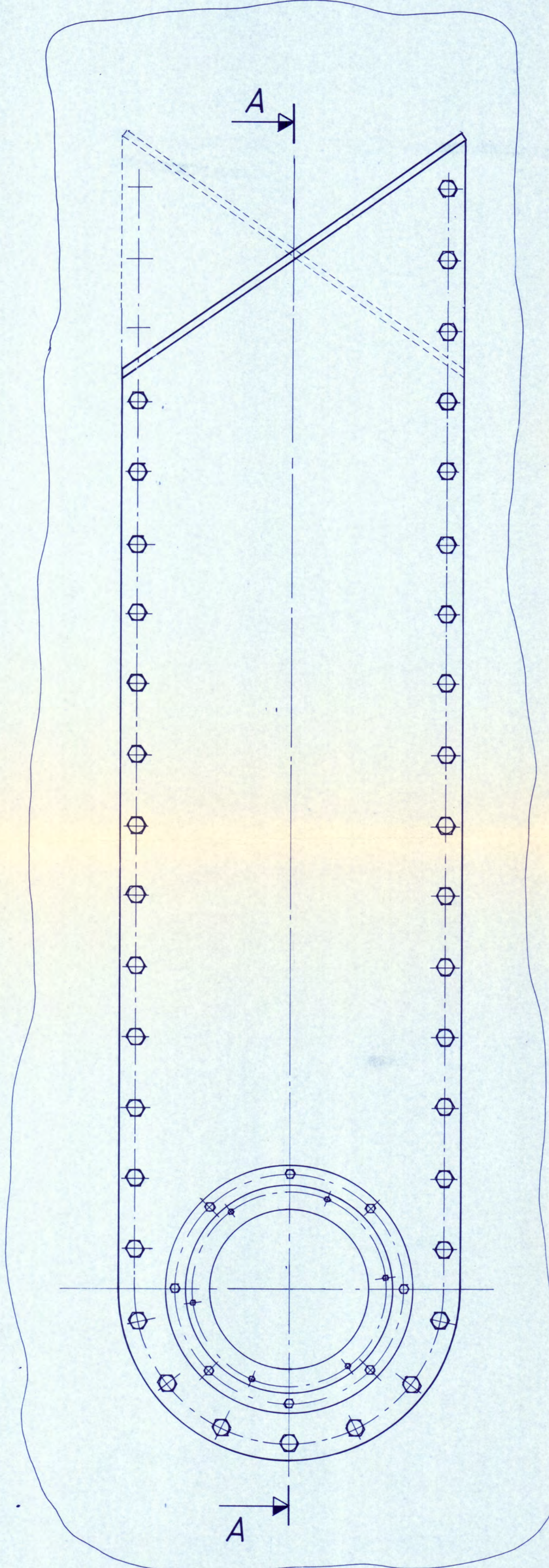
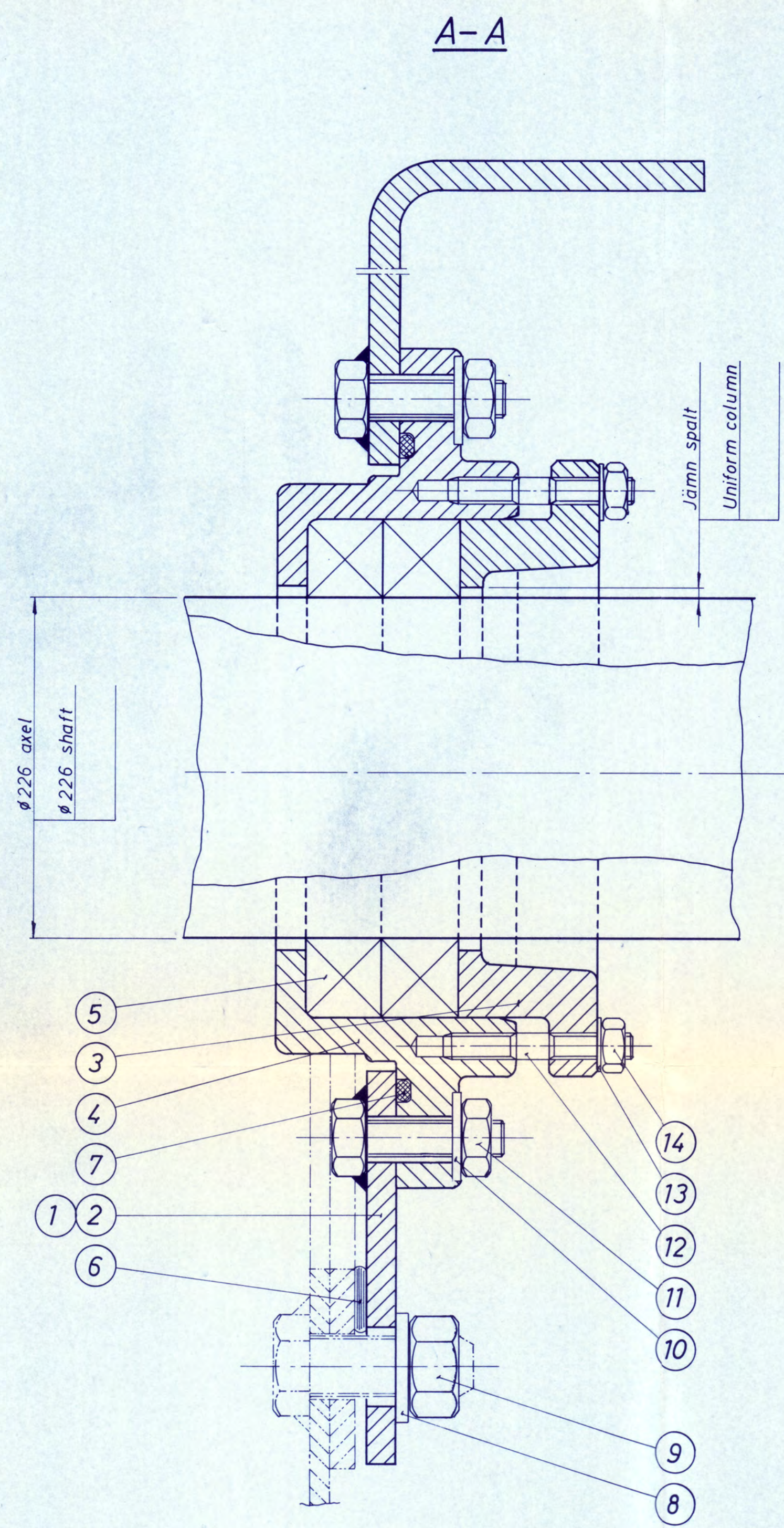
[illegible]

Där ej annat anges gäller Unless specified the following is valid				
Ytjämnhet Ra Surface roughness	µm		Tolerans för Tolerance for	
Skarpa kanter brytes mm Sharp edges to be crossed		Bearb. yta Machined surface	SMS 715=ISO 2768 Serie medel Medium series	
		Obearb. yta Unmachined surface	SMS 715=ISO 2768 Serie grov Rough series	
Ändr. Rev.	Spec.		Datum Date	Sign.

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Placering av skarv på flätorna.
Placement of joints.

Not.1 Packningarna det. 5 monteras med skarvarna förskjutna min 90°. Glandret åtdrages så att packningarna kommer i rätt läge, därefter lossas glandret och åtdrages erforderligt för tätning. Flätan skall vara ca. 50 mm för lång när den skall monteras i tätningsboxen.

Note.1 The stuffing boxes item 5 will be assembled with the joints displaced min. 90°. Tighten the flange until the packings reaches the final position. After that loosen the nuts and retighten to obtain sealed condition. The packings should be about 50 mm to long when mounting it.

USA:
STANDARD
1987-11-12 JE

A Utf. B. Moturs rotation / Design B. Counter clock-wise direction
Utf. A. Medurs rotation / Design A. Clock-wise direction.
Jfr. ritn. 1-85666 / Comp. drwg. 1-85666

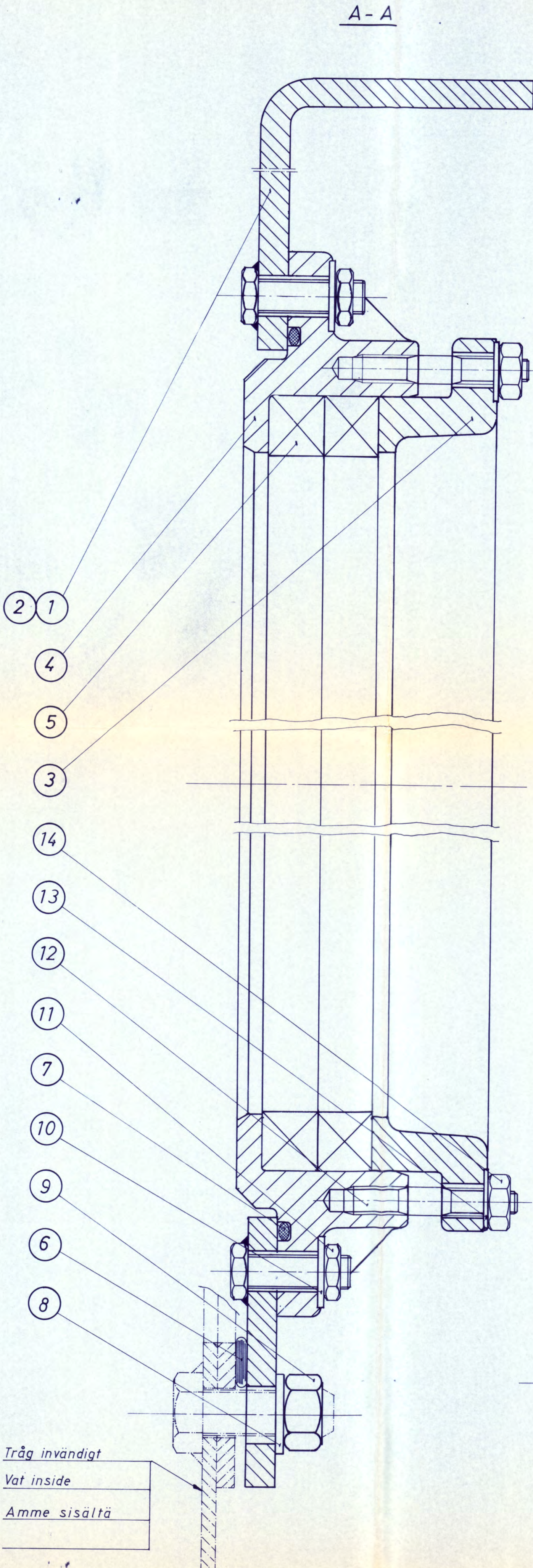
Jämför 1-85 663.

	Nut	6	6	14	U6M 5/16"UNC		2343		
	Washer	6	6	13	BRB 8,4x16	SMS 70			154210647
	Stud bolt	6	6	12	UHGS 5/16"UNC x 50				
	Nut	8	8	11	U6M 3/8"UNC				
	Washer	8	8	10	BRB 10,5 x 22	SMS 70			154210648
	Nut	36	36	9	U6M 5/8"UNC				
	Washer	36	36	8	BRB 17x30	SMS 70	2343		154210650
	O-ring	1	1	7	O-ring 299,3 x 5,7		EPDM		15120357
	Gasket	1	1	6	Kronlist 15x8 L=3496	Cellgummi	EPDM L=4000		154250040
	Stuffing box packing	2	2	5	Packboxfläta Ø 19 L=820	L=1000	Lattyflon 4789		154250072
	Stuffing box	1	1	4	Packbox	1-86651			
	Gland	1	1	3	Gland	1-84264			15120631
	Shield	1	—	2	Sköld	1-86649			
	Shield	—	1	1	Sköld	1-86648			

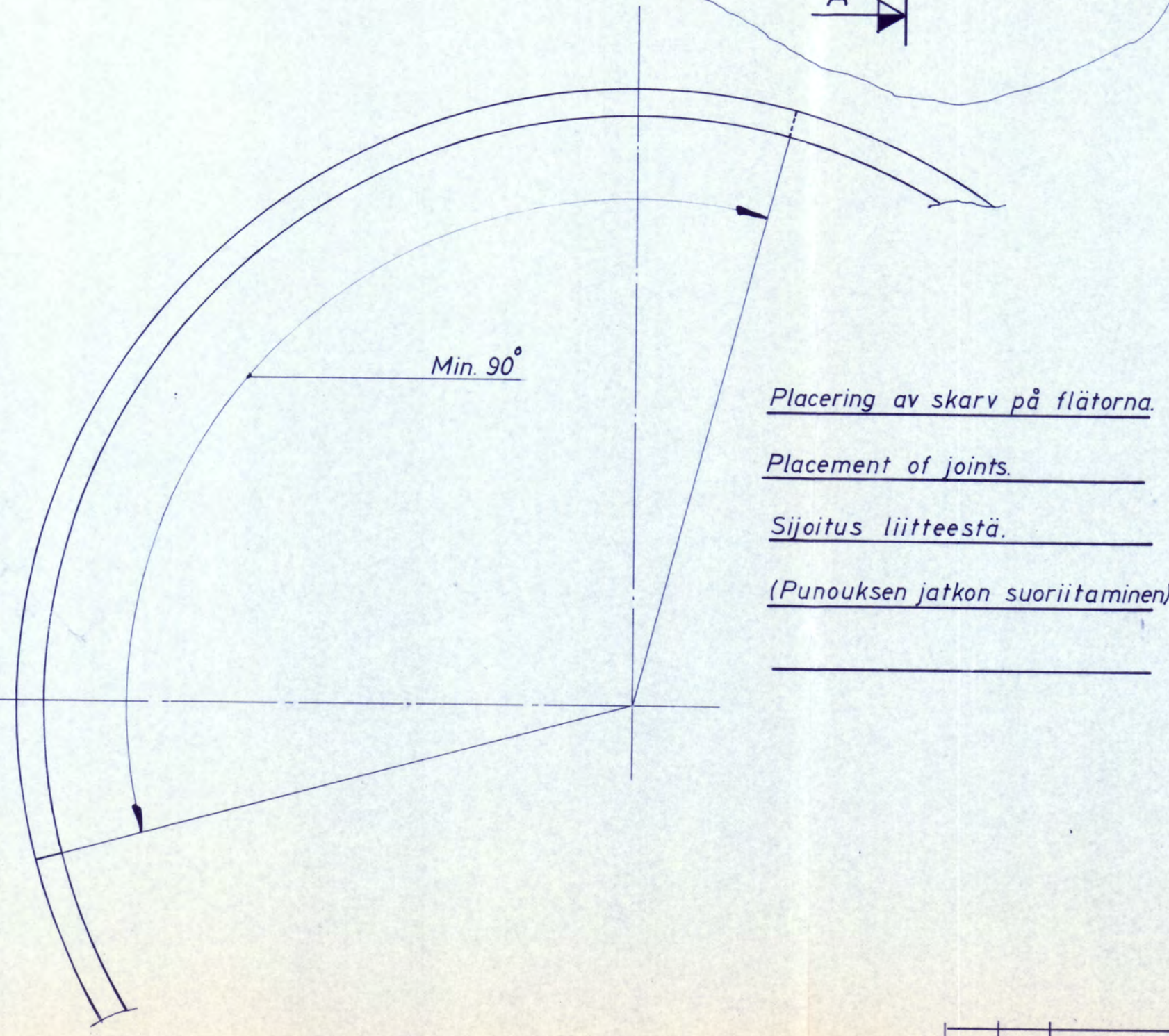
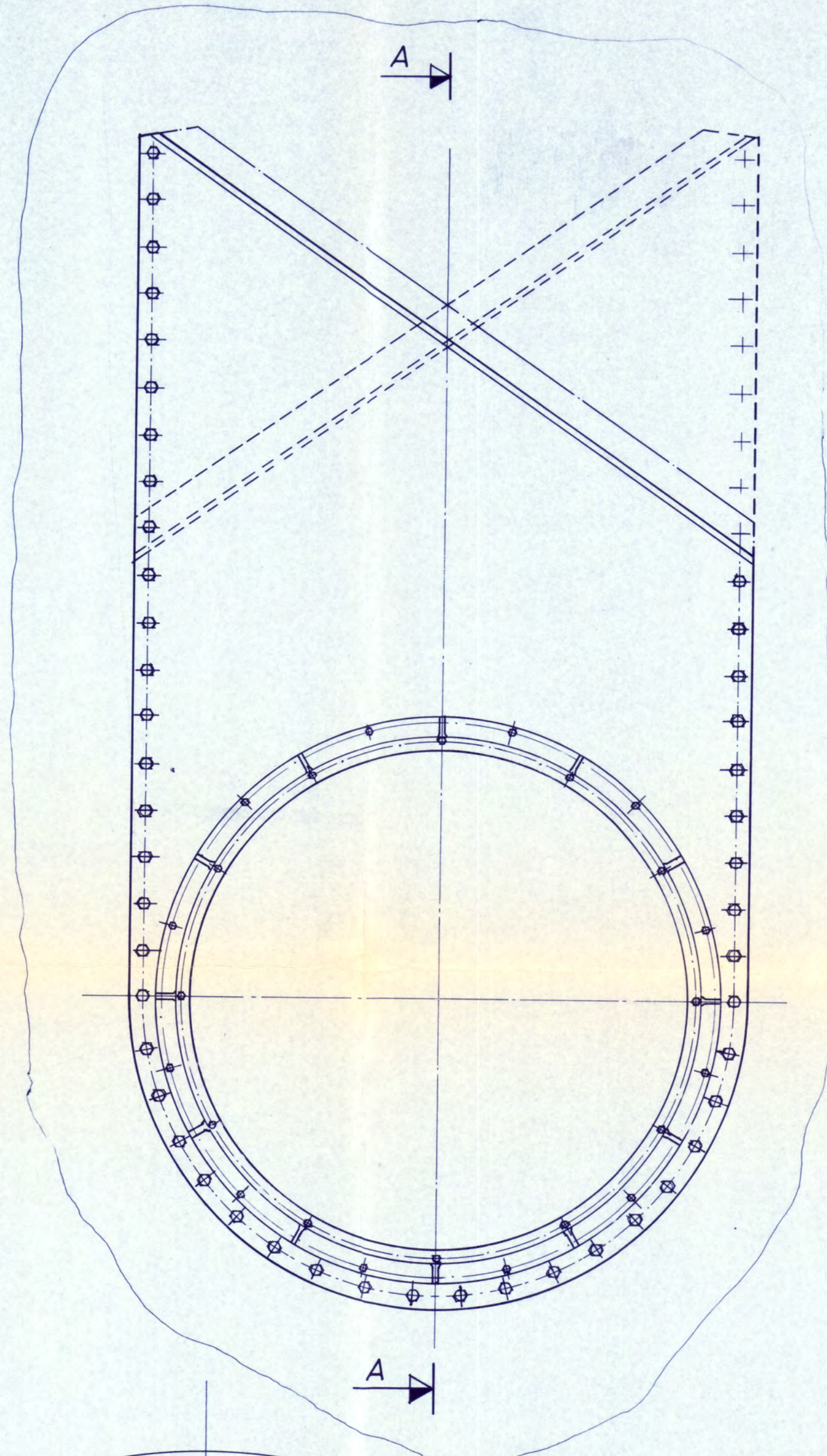
Ant.	Utf.	Anläggning	Best. nr	Lev.	Utfämnad	Anm./Smsl	Skivfilter	Axeltätning	Högt tryck	Smst	Ant.	Utf.	Anläggning	Best. nr	Lev.	Utfämnad	Anm./Smsl
							HEDEMORA	HEDEMORA AB	SWEDEN								

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Tråg invändigt
Vat inside
Amme sisältä



Placering av skarv på flätorna.
Placement of joints.
Sijointus liitteesä.
(Punouksen jatkon suorittaminen)

Not.1 Packningarna det 5 monteras med skarvarna förskjutna min 90°.
Glandret åtdrages så att packningarna kommer i rätt läge,
därefter lossas glandret och åtdrages erforderligt för tätning.
Flåten skall vara ca:225 mm för lång när den skall monteras
i tåtningsboxen.

Note.1 The stuffing boxes item 5 will be assembled with the joints displaced
min.90°. Tighten the flange untill the packings reaches the final position.
After that loosen the nuts and retighten to obtain sealed condition.
The packings should be about 225mm to long when mounting
it.

Not.1 Tiiviste saumat 5 asennetaan vähintään min. 90° toisistaan.
Laippa kiristetään, että tiivisteet asettuvat oikein paikalleen.
Laippa ivotetaan ja sen jälkeen kiristetään tasaisesti.
Täytyy olla noin 225 mm yli pitkä, kunse asennetaan
tiivisteboxsiin.

USA:
STANDARD
1988-01-13 JE

Jämför 1-86038

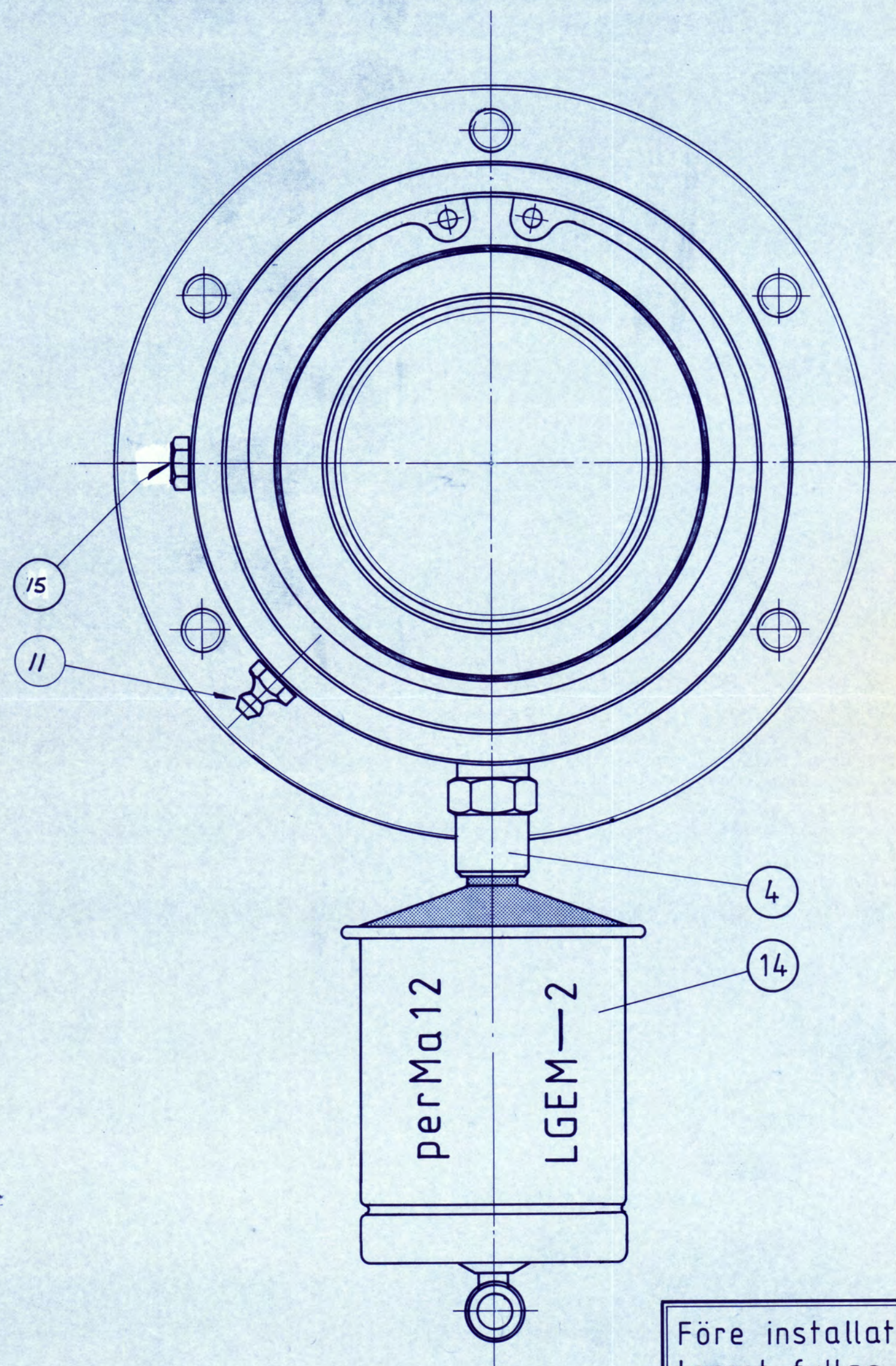
Utf. A. Medurs rotation / Utf. B. Moturs rotation / Jmfr. ritn. 2-85662 (Utf. B enl. ritn.)
Design B Counter clock-wise rotation / Design A Clock-wise rotation.
Suoritus B. Takaisin / Suoritus A Ympäri

Mutteri	Nut	12	12	14	U6M 3/8" LINC					
Levy	Wascher	12	12	13	BRB 10,5 x 22	SMS 70	2343		154210648	
Ruuvi	Stud bolt	12	12	12	UHQS 3/8" LINC x 65					
Mutteri	Nut	12	12	11	U6M 1/2" LINC					
Levy	Wascher	12	12	10	BRB 13,5 x 24	SMS 70			154210649	
Mutteri	Nut	47	47	9	U6M 5/8" LINC					
Levy	Wascher	47	47	8	BRB 17 x 30	SMS 70	2343		154210650	
O-rengas naru	O-ring string	1	1	7	O-ringssnöre ~ 1200x5,7			EPDM	15120360	
Tiiviste	Gasket	1	1	6	Kronlist 15x8 L=5116	Cellgummi EPDM Rygum L=5275			154250040	
Tiiviste	Stuffing box pack	2	2	5	Packboxfläta φ19 L=3820	Lattifylon 4789 L=4200			154250072	
Tiivisteboxsiin	Stuffing box	1	1	4	Packbox	1-86 655			15120629	
Laippa	Flange	1	1	3	Gland	1-84262			15120632	
Kilpi	Shield	1	-	2	Sköld	1-86 654				
Kilpi	Shield	-	1	1	Sköld	1-86 653				
Kannake	Description	C	B	A	Det. No.	Benämning och nettodim.	Ritn. Drwg.	Material	Vikt Weight	Anm. Note

Utt./Ant. Design/Number	8803/5 Krb	SKIVFILTER Axeltätning Högt tråg Smst.	Ø 5000 Ø 1125	Total vikt Total weight	Erättes av Replaced by		
Skala Scale	1:20, 1:10, 1:1	HEDEMORA	HEDEMORA AB SWEDEN	Erättes Replaces drwg	Rag av Reg by		
Ant.	Utt.	Anläggning	Best. nr	Lev.	Utlämnad	Anm./Smst	Andr. Rev.

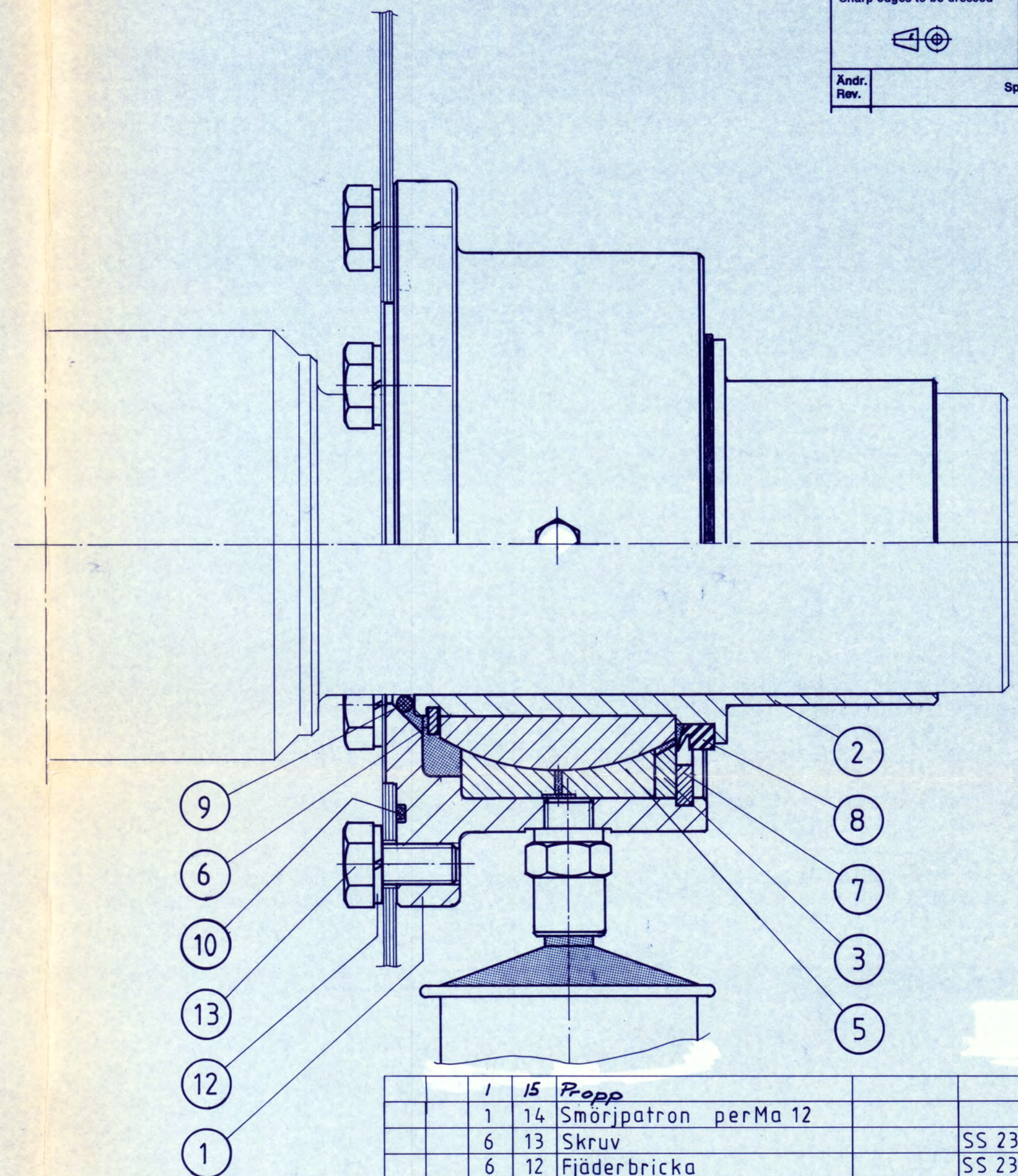
1-86 652

1-86 652



VIKTIGT

Före installation av smörjpatronen skall lagret fyllas med LITIUM-fett med hjälp av en handspruta



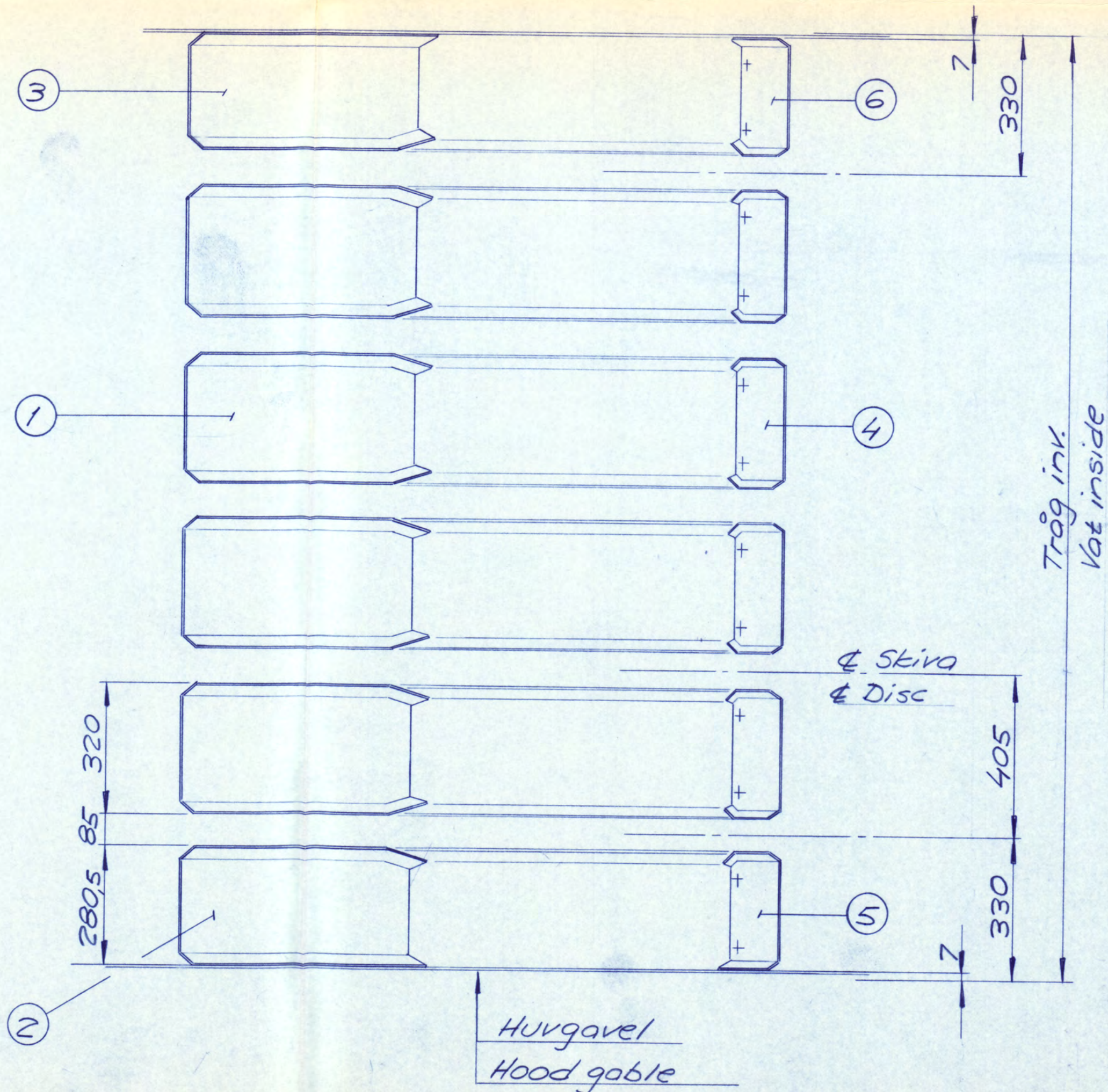
Där ej annat anges gäller Unless specified the following is valid				
Ytjämnhet Ra μm Surface roughness		Tolerans för Tolerance for		
Skarpa kanter brytes mm Sharp edges to be dressed		Bearb. yta Machined surface	SMS 715=ISO 2768 Serie medel Medium series	
		Obearb. yta Unmachined surface	SMS 715=ISO 2768 Serie grov Coarse series	
Ändr. Rev.	Spec.		Datum Date	Sign.

		1	15	Popp				RP 140 R 1/8"
		1	14	Smörjpatron perMa 12				LGEM 2
		6	13	Skruv		SS 2343		M6S-H 1/2"UNCx2
		6	12	Fjäderbricka		SS 2343		FBB 13
		1	11	Smörjnippel				AH 1/8"-27 PTF
		1	10	O-ring				Ø 123,42 x 3,53
		1	9	O-ring				Ø 70 x 4
		1	8	V-ring				V-85 A
		1	7	Seegersäkring				SgH 120
		1	6	Seegersäkring				A80 x 2,5V
		1	5	Lager				GE80 ES - SKF
		1	4	Nippel	3-82334			
		1	3	Bricka	3-82785			
		1	2	Klämhylsa	3-82788			
		1	1	Lagerhus	2-84064			

C	B	A	Det. No.	Benämning och nettdim. Description and net dim.	Ritn. Drwg.	Material	Vikt Weight	Anm. Note
Utf./Ant. Design/Number			Ritad Drawn	SKIVFILTER Duksprits Dukspritslagring – drivända Smst.			Total vikt Total weight	Ersättes av Replaced by
Skala Scale			Kontr. Checked				Ersätter Replaces drwg.	Reg. av Reg. by
1 : 1								
HEDEMORA							2-84063	
HEDEMORA AB SWEDEN							Andr. Rev.	

1	A	Sweetwater	70.86.2579	V717	870108 MK	1-8375
Ant.	Utt.	Anläggning	Best. nr	Lev.	Utiämnad	Anm./Sms

05 / C0-1

[illegible]

							Utt./Ant. Design/Number	Ritad Drawn 271117 MK	Weight Note		Total vikt Total weight	Erstatas av Replaced by
							Skala Scale 1:10	Konstr. Checked			Erstatar Replaces drwg.	Reg. av Reg. by
							HEDEMORA ☆ HEDEMORA AB SWEDEN		Skivfilter Ø5000 ANS Rännor smst. Disc filter Ø5000 ANS Aprons, ass. drwg.		1-85730	
Ant.	Utf.	Anläggning	Best. nr	Lev.	Utlämnad	Anm./Smsl	Andr. Rev.					

Där ej annat anges gäller Unless specified the following is valid				
Ytjämnhet Ra Surface roughness	µm	Tolerans för Tolerance for		
Skarpa kanter brytes mm Sharp edges to be dressed		Bearb. yta Machined surface	SMS 715=ISO 2768 Serie Med Medium series	
		Obearb. yta Unmachined surface	SMS 715=ISO 2768 Serie grov Coarse series	
Ändr. Rev.	Spec.		Datum Date	Sign.

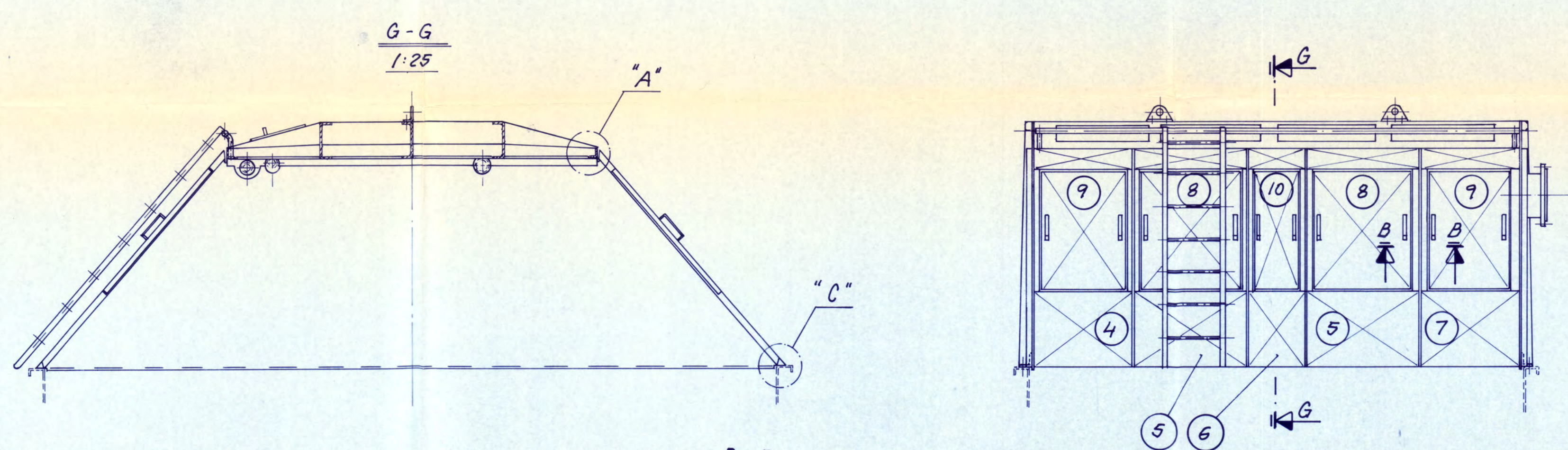
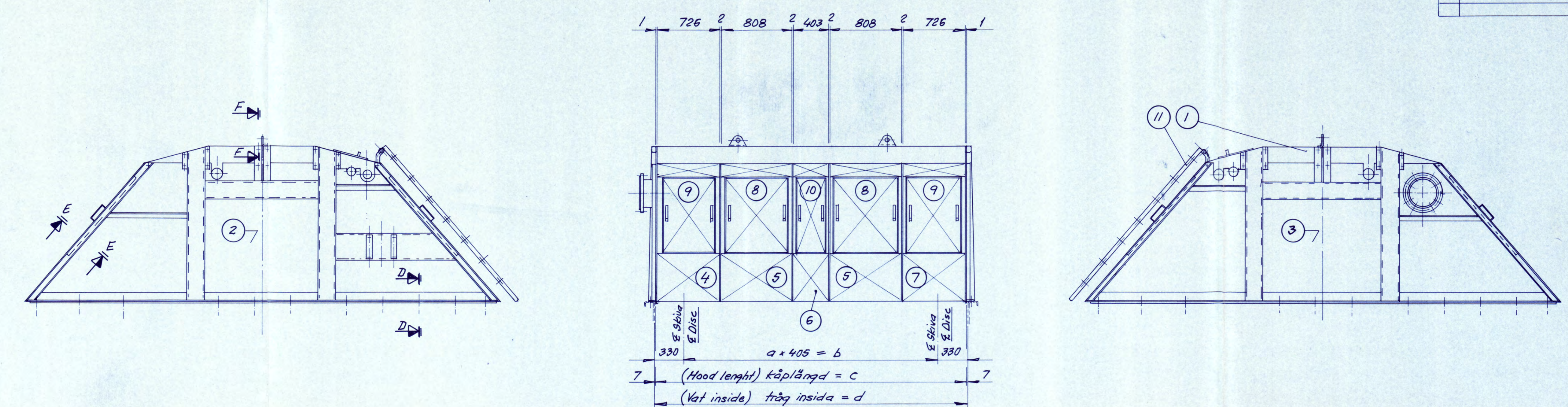
STANDARD

(For USA)

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1-85 319

Där ej annat anges gäller Unless specified the following is valid			
Ytjämnhet Ra Surface roughness		Tolerans för Tolerance for	
Skarpa kanter brytes Sharp edges to be dressed	mm	Bearb. yta Machined surface	SMS 715-ISO 2768 Serie medel Medium series
		Obearb. yta Unmachined surface	SMS 715-ISO 2768 Serie grov Coarse series
Andr. Rev.	Spec.	Datum Date	Sign.



Utt. Design	Ant. skiv Nu. of discs	a	b	c	d
A	8	7	2835	3481	3495
B	9	8	3240	3886	3900
C	10	9	3645	4291	4305
D	11	10	4050	4696	4710
E	12	11	4455	5101	5115
F	13	12	4860	5506	5520
G	14	13	5265	5911	5925
H	15	14	5670	6316	6330
I	16	15	6075	6721	6735
J	17	16	6480	7126	7140
K	18	17	6885	7531	7545
L	19	18	7290	7936	7950
M	20	19	7695	8341	8355
N	21	20	8100	8746	8760
O	22	21	8505	9151	9165

Antal skivor / Number of discs															STANDARD					
22	21	20	19	18	17	16	15	14	13	12	11	10	9	8						
50	50	50	50	50	50	50	50	50	50	50	50	50	50	13	Skruv	U68 5/8" UNC x 38	SS 2343	316L	Screw 5/8" UNC x 1 5/8"	
22	22	22	22	22	22	22	22	22	22	22	22	22	22	12	Mutter	U68 5/8" UNC	SS 2343	316L	Nut 5/8" UNC	
1	1	1	1	1	1	1	1	1	1	1	1	1	1	11	Steg		2-85 314		Ladder	
2	2	2	2	2	2	2	2	2	2	2	2	2	2	10	Lucka		2-83 215-C		Aperture	
4	4	4	4	4	4	4	4	4	4	4	4	4	4	9			2-83 215-B			
18	18	16	16	14	14	12	12	10	10	8	8	6	6	4	8	Lucka		2-83 215-A		Aperture
2	2	2	2	2	2	2	2	2	2	2	2	2	2	7	Huvdel		1-86 279		Aperture Hood part	
2	2	2	2	2	2	2	2	2	2	2	2	2	2	6			1-86 278			
18	18	16	16	14	14	12	12	10	10	8	8	6	6	4	5		1-86 277			
2	2	2	2	2	2	2	2	2	2	2	2	2	2	4	Huvdel		1-86 276		Hood part	
1	1	1	1	1	1	1	1	1	1	1	1	1	1	3	Gavel, ventil sida		1-85 324-		Gable, valveside	
1	1	1	1	1	1	1	1	1	1	1	1	1	1	2	Gavel, driv sida		1-85 323-		Gable, driveside	
1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	Bärbalk		1-85 317		Cross beam	
O	N	M	L	K	J	I	H	G	F	E	D	C	B	A	Det. No.	Benämning och nettdim. Description and net dim.	Ritn. Drwg.	Material	Anm. Note	
															Utt./Ant. Design/Number	Ritad Drawn			Total vikt Total weight	
															880203 K-B				Erstättes av Replaces by	
															Skall Scale	Kontroll Checked			Reg. av Reg. by	
															1:25, 1:25, 1:1					
															HEDEMORA					
															HEDEMORA AB SWEDEN					
															Skivfilter Ø 5000 ANS Medurs rot. Hög tråg Filterkåpa. Smst. Discfilter Ø 5000 ANS Hood. Ass. drwg.					
															1-85 319					