38223

FINEBAR
AIKAWA GROUP

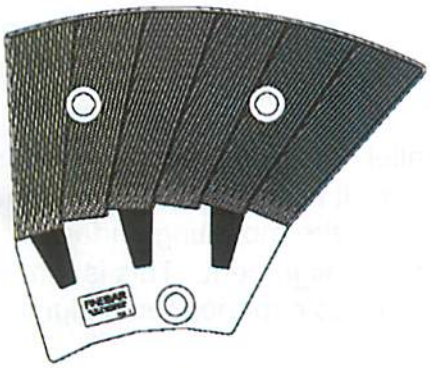
PLATE INSTALLATION FOR ALL DOUBLE DISK REFINERS

Background

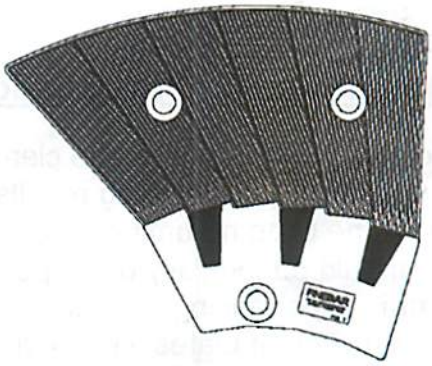
- AFT Finebar segmented plates are generally shipped in four boxes, each box containing one complete circle consisting of four, six or eight segments. For very large or small refiners, or if plates are full circles (not segmented), less or more than one circle may be in each box. Each box is clearly labeled as to its contents.

- One complete set of plates consists of four disks or circles. Each circle is assigned a number (1 through 4) designating its mounting position in the refiner. Within a given position, the segments are identical and may be installed in any circumferential orientation – but they must be mounted as a complete circle. Plates are clearly marked. **Do not interchange segments from various circles.**

Plate Identification



POSITION 1&2
(Right Hand)



POSITION 3&4
(Left Hand)

- Plate position numbers are shown above. While the 1 & 2 segments appear to be the same, the segments are not interchangeable between sets due to manufacturing tolerances. The same is true for the 3 & 4 segments.

- **DISK MOUNTING POSITION WILL BE DETERMED ACCORDING TO THE REFINER ROTATIONAL DIRECTION AS DESCRIBED ON THE OPPOSITE SIDE OF THIS SHEET.**

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PLATE POSITIONING

View refiner from the front (opposite the drive end) as shown in the diagrams below. Determine if refiner rotates clockwise or counter-clockwise relative to your perspective. Plate position assignments are shown for each direction of rotation.

Circles 1 & 4 will always be installed in the stationary (non-rotating) positions. Circles 2 & 3 will always be installed on the rotor. Circles 1 & 2 always run against each other and circles 3 & 4 always run against each other.

Figure 1 – Clockwise Rotation – Number 1 position is closest to motor

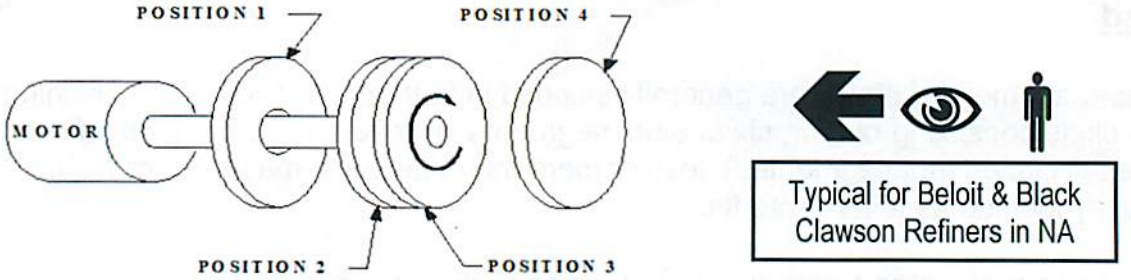
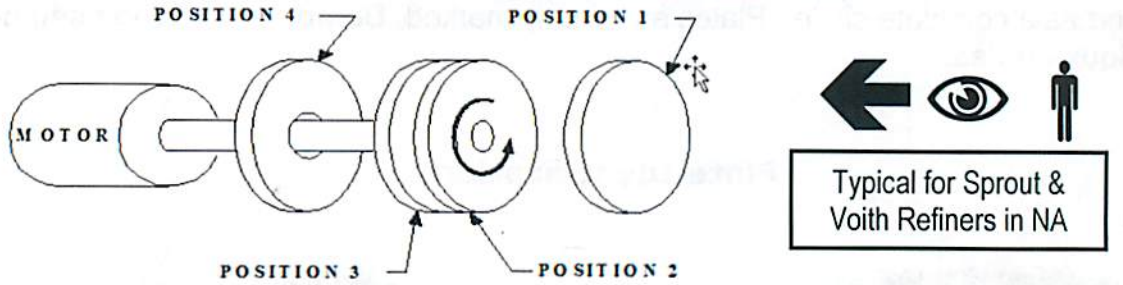


Figure 2 - Counter-Clockwise Rotation – Number 4 position is closest to motor



Refiner Preparation and Installation Precautions

- Plate mounting surfaces must be clean, smooth and parallel. Irregularities in the mounting surface will cause poor refining results and premature wear. It is critical to ensure that helicoils for the plate mounting bolts are not protruding above the mounting surface.
- Refiners should periodically be inspected for proper tram and alignment. This is mandatory if the refiner is experiencing uneven or unusual plate wear, or has experienced a significant event (destruction of plates, coupling, etc.).
- Bolts are installed to the same torque specifications used with conventional cast or machined plates. Collar bolts are strongly recommended. Recommended bolt torque: 100 ft*lbs dry, 80 ft*lbs lubricated (anti-seize compound) for 5/8" bolts (135 N*m dry, 108 N*m lubricated for M16 bolts); 60 ft*lbs dry, 50 ft*lbs lubricated for 1/2" (81 N*m dry, 68 N*m lubricated for M12 bolts).
- The limit switch for initial position of the adjusting head should be set according to the manufacturer's recommendations.
- During plate changes, it is highly recommended that gloves be worn as there may be sharp edges.

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