

38222

J&L Fiber Services Certificate of Compliance PRODUCT VERIFICATION AND SPECIFICATION SHEET

J&L Fiber Services certifies that the product has been verified and conforms to customer requirements.

ITEM #: **123755**

PATTERN: **46EJ..103**

SERIAL NO.: **00731152-002**

ALLOY: **C90.**

EDGE GAP: **.180 to .390** (in inches) **4.5720 to 9.9060** (in millimeters)

ACTUAL EDGE GAP: **.270** (in inches) **6.8580** (total)
.0450 (in millimeters) **1.1430** (individual)

TAPER: **FLAT**

J&L OPERATOR: **RHUEBNER**

DATE: **07-MAR-2016**

INSTALLATION DATE: _____

REFINER: _____





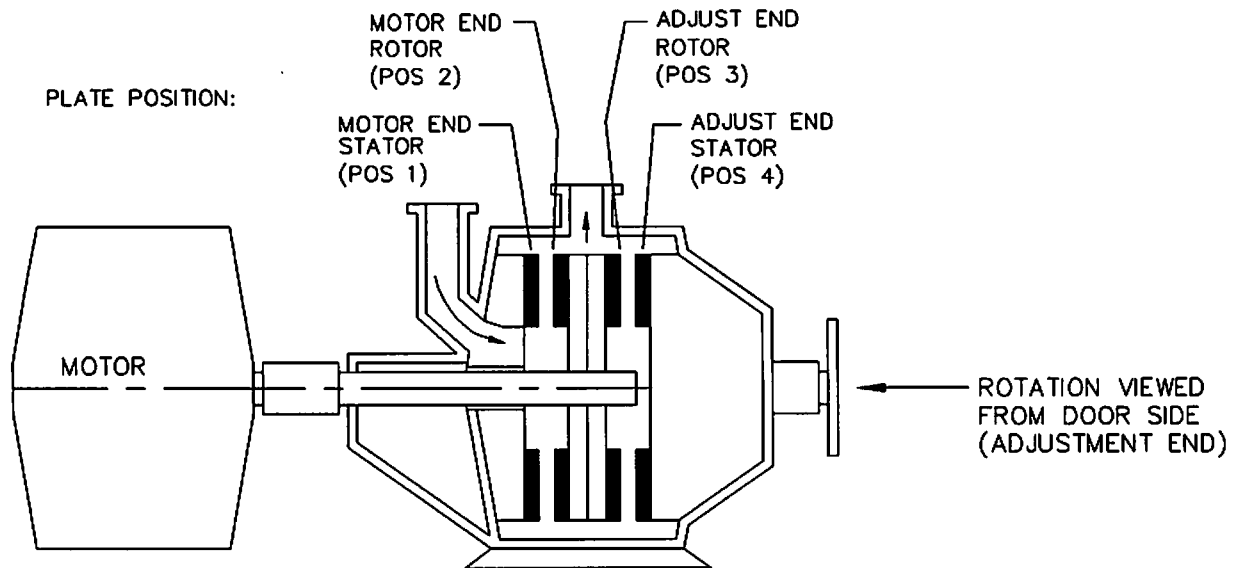
MOUNTING INSTRUCTION SHEET "A"

CAST REFINER PLATES






JONES DD REFINERS

PAGE 2 OF 2

J & L Fiber Services • 809 Philip Drive • Waukesha, WI 53186 U.S.A. • TEL (262) 544-1890 • FAX (262) 544-5627



DUO FLO INSTALLATION

POSITION NO.	MOTOR END POSITION #1	MOTOR END POSITION #2	ADJUST END POSITION #3	ADJUST END POSITION #4
CLOCKWISE ROTATION 				
PATTERN NO.	ODD MOT	ODD MOT	EVEN ADJ	EVEN ADJ

FOR BOLT TIGHTENING TORQUE SEE PAGE 1.

MONO FLO INSTALLATION

ONLY ODD NUMBERED PATTERNS ARE SUPPLIED FOR MONO FLO INSTALLATIONS.

HOLDBACK INSTALLATION

FOR HOLDBACK INSTALLATION REVERSE PLATE POSITIONS.

POSITION 1 TO POS. 4, POS. 2 TO POS. 3, POS. 3 TO POS. 2, POS. 4 TO POS. 1.

8/90

04-01-004

KYP 10-007



MOUNTING INSTRUCTION SHEET "A"

CAST REFINER PLATES

JONES DD REFINERS

PAGE 1 OF 2

J & L Fiber Services * 809 Philip Drive * Waukesha, WI 53186 U.S.A. * TEL (262) 544-1890 * FAX (262) 544-5627

1. Read all instructions carefully before proceeding with installation.
2. Refer to the maintenance and instruction manuals supplied with the refiner for the correct procedure to shut down and open the refiner.
3. Check position of used plates in the refiner before removing
4. All rust and foreign material must be thoroughly cleaned from the plate mounting surfaces.
5. Plates are precision ground as a circle to the same thickness. DO NOT MIX SEGMENTS OF ONE CIRCLE WITH SEGMENTS OF ANOTHER CIRCLE. Each segment has a manufacturing order number (circle number) painted on the backside. This number uniquely defines one circle of plates from another.
6. Install plates according to the diagram on the opposite side of this sheet.
Using shims of equal thickness evenly distribute the space between the segments.
Segments must be securely seated against the O.D. shoulder and the refiner plate mounting surface. If any segment is out of position it must be dismounted and the problem resolved.
7. Progressively tighten the mounting bolts in a circular sequence. Do not tighten the mounting bolts to final tension in one operation. The following chart lists maximum torque values.

RECOMMENDED MAXIMUM TORQUE VALUES FOR REFINER PLATE BOLTS

		Material Specification					
		Group 1 - 304SS					
		Bolt Size					
		1/2"	5/8"	3/4"	M12	M16	M20
Tapped holes without Helicoils or free running Lubricated Assembly	(ft.-lbs.)	45	80	120	45	80	120
	(N-M)	61	109	163	61	109	163
Tapped holes with Helicoils - Thread Lock Lubricated Assembly	(ft.-lbs.)	69	121	182	69	121	182
	(N-M)	94	166	247	94	166	247

NOTE:

- J&L recommends that refiner plate bolts are used only once. New bolts should be used every plate change, per industry standards.
- Do not torque the bolts when the refiner is hot.
- Use of impact wrenches is not recommended as they may damage the threads.
- Anti-sieze compounds should be applied to the bolt threads.

8/90

04-01-004

KYP 10-007

J&L Fiber Services Certificate of Compliance

PRODUCT VERIFICATION AND SPECIFICATION SHEET

J&L Fiber Services certifies that the product has been verified and conforms to customer requirements.

ITEM #: **123757**

PATTERN: **46EJ..104**

SERIAL NO.: **00731153-002**

ALLOY: **C90.**

EDGE GAP: **.180 to .390** (in inches) **4.5720 to 9.9060** (in millimeters)

ACTUAL EDGE GAP: **.330** (in inches) **8.3820** (total)
.0550 (in millimeters) **1.3970** (individual)

TAPER: **FLAT**

J&L OPERATOR: **RZO**

DATE: **07-MAR-2016**

INSTALLATION DATE: _____

REFINER: _____

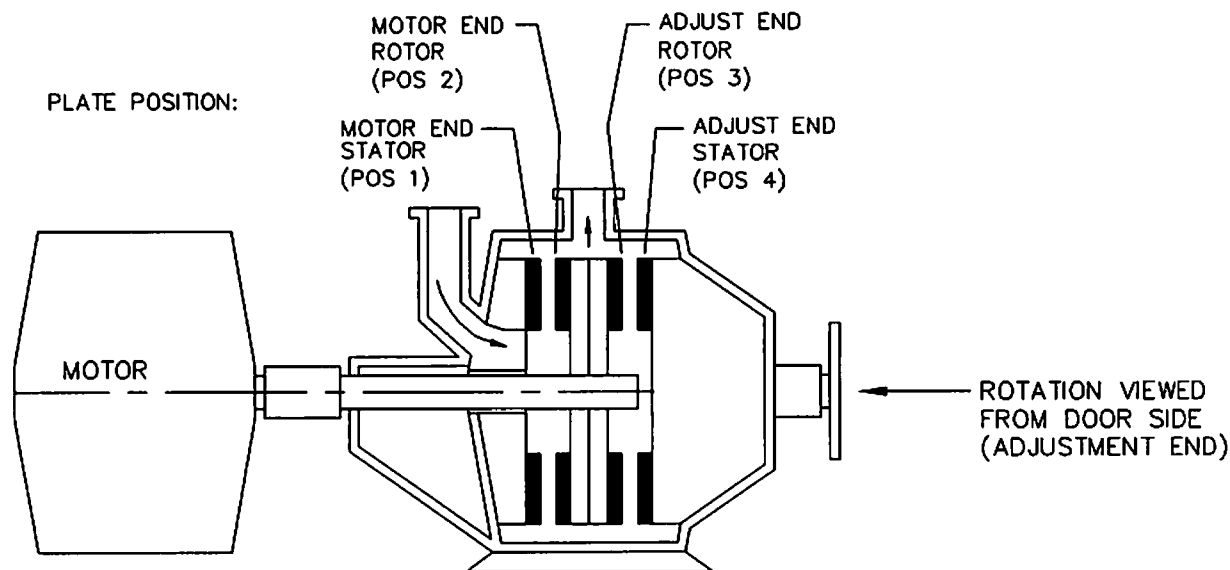









MOUNTING INSTRUCTION SHEET "A" CAST REFINER PLATES JONES DD REFINERS

PAGE 2 OF 2

J & L Fiber Services * 809 Philip Drive * Waukesha, WI 53186 U.S.A. * TEL (262) 544-1890 * FAX (262) 544-5627



DUO FLO INSTALLATION

POSITION NO.	MOTOR END POSITION #1	MOTOR END POSITION #2	ADJUST END POSITION #3	ADJUST END POSITION #4
CLOCKWISE ROTATION 				
PATTERN NO.	ODD MOT	ODD MOT	EVEN ADJ	EVEN ADJ

FOR BOLT TIGHTENING TORQUE SEE PAGE 1.

MONO FLO INSTALLATION

ONLY ODD NUMBERED PATTERNS ARE SUPPLIED FOR MONO FLO INSTALLATIONS.

HOLDBACK INSTALLATION

FOR HOLDBACK INSTALLATION REVERSE PLATE POSITIONS.

POSITION 1 TO POS. 4, POS. 2 TO POS. 3, POS. 3 TO POS. 2, POS. 4 TO POS. 1.



MOUNTING INSTRUCTION SHEET "A"

CAST REFINER PLATES

JONES DD REFINERS

PAGE 1 OF 2

J & L Fiber Services * 809 Philip Drive * Waukesha, WI 53186 U.S.A. * TEL (262) 544-1890 * FAX (262) 544-5627

1. Read all instructions carefully before proceeding with installation.
2. Refer to the maintenance and instruction manuals supplied with the refiner for the correct procedure to shut down and open the refiner.
3. Check position of used plates in the refiner before removing
4. All rust and foreign material must be thoroughly cleaned from the plate mounting surfaces.
5. Plates are precision ground as a circle to the same thickness. DO NOT MIX SEGMENTS OF ONE CIRCLE WITH SEGMENTS OF ANOTHER CIRCLE. Each segment has a manufacturing order number (circle number) painted on the backside. This number uniquely defines one circle of plates from another.
6. Install plates according to the diagram on the opposite side of this sheet.
Using shims of equal thickness evenly distribute the space between the segments.
Segments must be securely seated against the O.D. shoulder and the refiner plate mounting surface. If any segment is out of position it must be dismounted and the problem resolved.
7. Progressively tighten the mounting bolts in a circular sequence. Do not tighten the mounting bolts to final tension in one operation. The following chart lists maximum torque values.

RECOMMENDED MAXIMUM TORQUE VALUES FOR REFINER PLATE BOLTS

		Material Specification					
		Group 1 - 304SS					
		Bolt Size					
		1/2"	5/8"	3/4"	M12	M16	M20
Tapped holes without Helicoils or free running Lubricated Assembly	(ft.-lbs.)	45	80	120	45	80	120
	(N-M)	61	109	163	61	109	163
Tapped holes with Helicoils - Thread Lock Lubricated Assembly	(ft.-lbs.)	69	121	182	69	121	182
	(N-M)	94	166	247	94	166	247

NOTE:

- J&L recommends that refiner plate bolts are used only once. New bolts should be used every plate change, per industry standards.
- Do not torque the bolts when the refiner is hot.
- Use of impact wrenches is not recommended as they may damage the threads.
- Anti-sieze compounds should be applied to the bolt threads.

8/90

04-01-004

KYP 10-007