

Verbal

3-18-85

1352-127-M

Rexnord

Process Machinery Division

S
O
L
D*Three Limestone*
Morgantown, WV

Same

DATE ORDER RECEIVED	OUR ORDER NO.
2-28-85	C3013-6351
DATE SHIPPED	
3-28-85	
SPECIAL INSTRUCTIONS	
SPECS & ASSEMBLIES SENT TO	
DATE	
PARTS MANUAL SENT TO <i>COUNTY CONCRETE</i>	
DATE <i>4-9-85</i>	

CONE, OMNICON & GYRADISC CRUSHER SPECIFICATIONS & ASSEMBLIESSIZE & TYPE 1352 Omnicon BOWL SH Coarse LINERS Medium

SEAL: Air () Integral ()

Standard/Grease (X) ROTATION: Clockwise (X) PUMP: Independent ()

Water () Counterclockwise () Package Lube (X) 2

DRIVE: Direct () Cap Screw () Limited Hydraulic ()

Horizontal (X) ADJUSTMENT: Duckworth () Clearing ()

Vertical () Hydraulic-Electric (X) Air ()

OUTER BUSHING LOCATION: 12:00 () 9:00 () 3:00 () 6:00 (X)

ALTITUDE: 0-3,300 FT ☐3,301 - 9,900 FT ☐9,901 - 12,000 FT ☐OVER 12,000 FT ☐**DRIVE DATA**

YES	NO	CRUSHER SHEAVE: DIA. <u>30"</u>	SIZE & NO. GROOVES <u>6-8V</u>	CRUSHER SHEAVE REQ. NO. _____	
X		MOTOR SHEAVE: DIA. <u>13.2"</u>	SIZE & NO. GROOVES <u>6-8V</u>	BORE <u>3-3/8</u>	KEYWAY <u>7/8x3/16</u>
X		V-BELTS: SECTION & LENGTH <u>6-8V1900</u>	BELT REQ. NO. _____	MOTOR SHEAVE REQ. NO. _____	(SPECIFY) _____
X		MOTOR: HP _____	RPM _____	MFG. _____	FRAME _____
		ENCLOSURE _____		VOLTS _____	PH _____
		HZ _____			

MOTOR SHEAVE PART NO. 5923 8614 V-BELT PART NO. 1755 7013 MOTOR PART NO. _____

MOTOR STARTER PART NO. _____

	ASSEMBLY NAME	DWG. NO.		ASSEMBLY NAME	DWG. NO.		ASSEMBLY NAME	DWG. NO.
01	MAIN FRAME	S	14	BOWL	S	30	CLEARING JACK	
		<u>110 9428 0053</u>			<u>110 9428 0039</u>			
02	ADJUSTMENT RING	S	15	HOPPER	S	31	CLEARING JACK CIRCUIT	
		<u>110 9428 0040</u>			<u>110 9428 0007</u>			
	ADJUSTMENT RING		16	LOCK POST OR CAP	S	32	HYDRAULIC CIRCUIT	
	SEMBLY DRAWING			SCREW ADJUSTMENT				<u>110 9428 0026</u>
03	WINDING RING OR	S	17	WINDLASS OR	S	33	HYDRAULIC LOCK POST OR	
	TRAMP RELEASE	<u>110 9428 0067</u>		SWIVEL ADJUSTMENT			CLAMPING CYLINDER	<u>110 9429 0075</u>
04	COUNTERSHAFT BOX	S	18	FEED PLATFORM	S	34	BOWL ADJUSTMENT RAM	
					<u>110 9428 0031</u>			<u>110 9428 0011</u>
05	COUNTERSHAFT	S	19	OIL TANK	S	35	BOWL LOCK	
		<u>110 9428 0091</u>			P.L.			<u>110 9428 0012</u>
06	OIL PUMP	P.L. S	20	TOOLS	S	36	POWER UNIT	<u>9429 0094</u>
		<u>5942 0078</u>			<u>110 9428 0032</u>			<u>0143</u>
	PUMP & MOTOR	P.L. SLU-	21	ACCESSORIES	S		POWER UNIT GENERAL	
		<u>412</u>			<u>110 9428 0056</u>		ARRANGEMENT	
07	CRUSHER OIL PIPING	<u>110 9428 0062</u>	22	IDENTIFICATION PLATE	S		GAUGE & CONTROL VALVE	
					<u>110 9428 0033</u>		SUB-ASSEMBLY	
	OIL TANK PIPING	P.L.	23	DRIVE	S		PUMP & MOTOR	
					<u>110 9428 0076</u>		SUB-ASSEMBLY	
	COOLER OR FILTER		24	COOLER	P.L. SLU-		BOOSTER UNIT	
	OIL PIPING				<u>170</u>		SUB-ASSEMBLY	
08	THRUST BEARING	S	25	FILTER	P.L. SLU-		AIR FILTER LUBRICATOR	
					<u>506</u>		SUB-ASSEMBLY	
					<u>9436 1000</u>			
09	ECCENTRIC	S	26	MOTORIZED ROTATING	S	37	BLOWER	
		<u>110 9428 0089</u>		FEED DISTRIBUTOR				
10	SOCKET	S		MOTORIZED DISTRIBUTOR		38	SKID OR	
		<u>110 9428 0098</u>		GENERAL ARRANGEMENT			SUB BASE	
	SOCKET SEAL PIPING		27	DRIVE GUARD		39	OPERATOR'S PLATFORM	
11	SHAFT OR	S	28	DUST ENCLOSURE		40		
	HEAD	<u>110 9428 0001</u>						
12	FEED DISTRIBUTOR, FEED	S	29	PACKAGE LUBE SYSTEM	SLU-		FOUNDATION DRAWING	
	PLATE OR LOCKING NUT	<u>110 9428 0097</u>			<u>736</u>			
13	LINER	S		PACKAGE LUBE SYSTEM	<u>9820 0210</u>			
		<u>9428 0045</u>		GENERAL ARRANGEMENT	<u>9820 1015</u>			

OUR ORDER NO.	REV.	SERIAL NO.
C3013-6351	L	1352-127-M

3-8-85

S/N

1352-127-m

OWNERSHIP CHANGES

2-27-92 WAS: County Concrete Corp
Kendall, N.J.

WAS:

WAS:

WAS:

WAS:

WAS:

WAS:

PARTS BOOKS SENT TO:

4-3-92 1 Pat Duley

INSTRUCTION MANUALS SENT TO:

COPY OF SPEC CARD SENT TO:

- 3 SHIMS ARE TO BE FLAT. REMOVE ALL BURRS AND UPSETS WHICH COULD AFFECT FLATNESS OF THRUST BEARING.

- ## 7 SEAL CEMENTING INSTRUCTIONS

A. CLEAN GROOVE WITH OIL FREE SOLVENT AND DRY
B. APPLY ACTIVATOR IN A VERY THIN FILM TO BOTTOM
OF SEAL RING. IF EXCESS ACTIVATOR IS APPLIED, A
PARTIALLY CURED BOND MAY RESULT. (CONT' BELOW)



**SURFACE PREPARATION, CLEANING
AND PAINTING SYMBOLS ACCORDING
TO COMPANY STANDARD 23-01-01**



BILL OF MATERIAL				
ITEM NO.	PART NUMBER	QTY	PART NAME	UNIT BY LASH
	1094280053		MAIN FRAME ASSY.	62137
1	1033781803	1	MAIN FRAME	A0 4200
2	1068863500	1	MAIN SHAFT	A0 634
3	1057605160	1	THRUST BEARING	A1 27
4	1070589780	2	SHIM 3.0	A2 2.5
5	1070589778	2	SHIM 1.7	A2 1.4
6	1070589776	2	SHIM .75	A2 .6
7	1070589774	2	SHIM .40	A2 .3
8	1003063296	6	LOCKPLATE M10	- -
9	1003722550	6	HHCS M10 X 1.5 X 30 LG.	- -
10	1054350820	4	MAIN FRAME PIN	A3 6.5
11	SEE NOTE 1		MAIN FRAME LINER	A2 334
12	1038026500	4	ARM GUARD	A2 3
13	1001558843	1	PIPE PLUG 3/8	- -
14	1001559644	3	PIPE PLUG 3/4	- -
15	1003056028	24	WASHER M10	- -
16	1003010046	12	HEX NUT M10	- -
17	1003801023	8	GREASE FITTING	- -
18	1003801990	8	GREASE FITTING CAP 1/4	- -
19	1063518943	1	SEAL RING	A3 2
20	1004590351	NR	ACTIVATOR	- -
21	1003344282	3	DOWEL PIN Ø20 X 110 LG.	- -
22	1003722571	12	HHCS M10 X 1.5 X 4.5 LG.	- -
23	1004590350	NR	ADHESIVE	-
24	1013301442	4	PIN RETAINER	A4 0.8
25	1003724078	4	HEX HD CAPSCREW M16 x 30	-
26	1003069061	4	LOCKWASHER M16	-

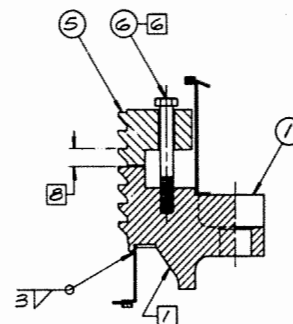
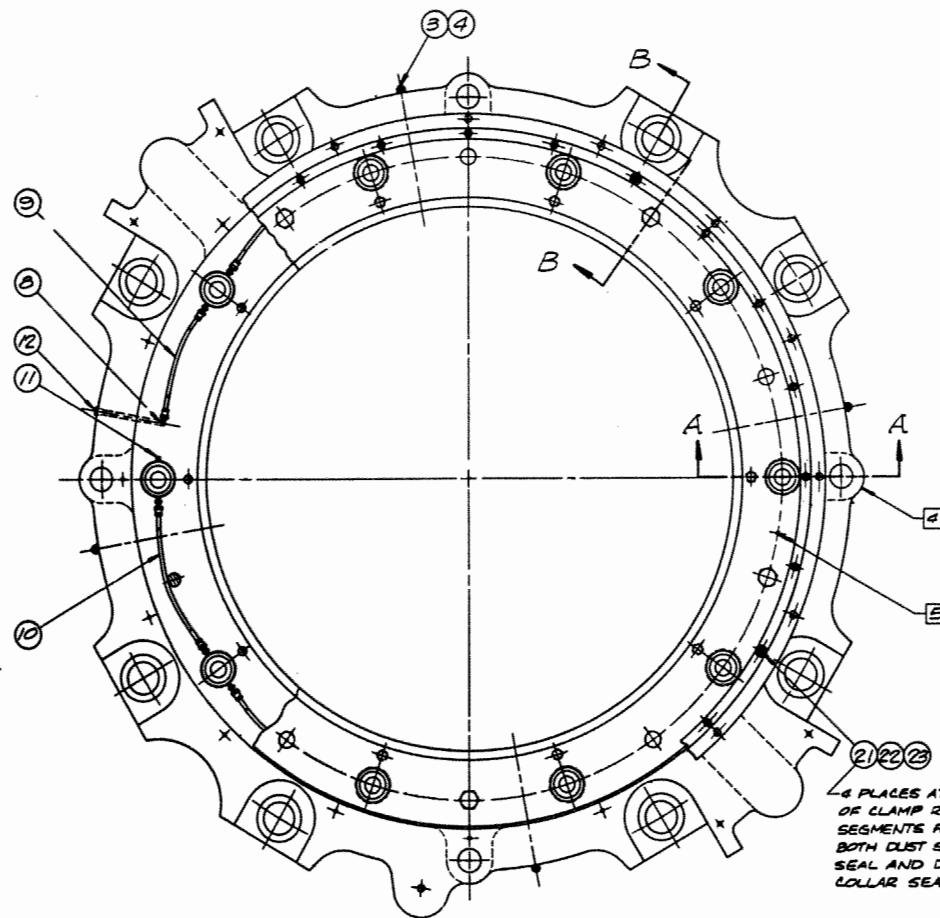
* use 38064710

- C. APPLY ADHESIVE TO BOTTOM OF GROOVE. APPLY ENOUGH ADHESIVE TO ENSURE MINIMAL SQUEEZE OUT.
- D. POSITION SEAL RING INTO GROOVE AS SOON AS POSSIBLE AFTER ADHESIVE APPLICATION. SUFFICIENT PRESSURE TO KEEP THE TWO SURFACES IN CONTACT WITH EACH OTHER SHOULD BE MAINTAINED UNTIL A HANDLING BOND IS ATTAINED. A HANDLING BOND IS ATTAINED IN APPROXIMATELY THREE MINUTES.

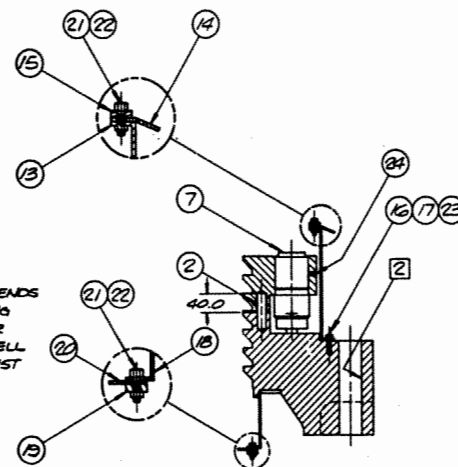
* WHEN ORDERING MAIN SHAFT, ORDER MAIN SHAFT 10-68863503 IN PLACE OF 10-68863500. SOCKET 10-73814251 MUST BE FURNISHED WITH NEW MAIN SHAFT.
DO NOT USE SOCKET SHIM.

PROTOTYPE

METRIC ALL DIMENSIONS IN MILLIMETERS		 Raymond Machinery Division	
IMPULSE TOLERANCES FINISHES DIMENSIONS		DRAWING D-2 DATE 2-16-52	SUPERSEDES _____ ASSEMBLY GR 01
MILLIMETERS		CHECKED C. DAVIS DATE 6 APR 52	SUPERSEDED BY _____ CRUSHER
EXPL. OR C. DAVIS J. J. J. J.		APPROVED _____ DATE _____ DESCRIPTION _____	PRODUCT 1352 OMNICON
R/V <input checked="" type="checkbox"/> DIMENSION FINISH UNLESS OTHERWISE STATED		PART NAME MAIN FRAME ASSY.	
PLACE ANGLE 1 SIDE SHOWN		DRAWING NUMBER _____ REV. _____	
 3rd ANGLE PROJECTION		PART SIZE A1	PARTS 110
SCALE 1:6		QUANTITY 94280053	REV. _____ A



SECTION "B-B"



SECTION "A-A"

BILL OF MATERIAL				
ITEM	ITEM NUMBER	ITEM NAME	ITEM	ITEM NAME
	10942801040	ADJ RING ASSEMBLY		4445
(1)	1061878300	1 ADJUSTMENT RING	AO	3140
(2)	1003344469	1 DOWEL PIN Ø25 X Ø0.6	-	-
(3)	1003001025	4 GREASE FITTING Mx1	-	-
(4)	1003501900	4 GREASE FIT CAP 1/4	-	-
(5)	1061878000	1 CLAMP RING	AI	1093
(6)	10033726246	5 HINCS M26 X 300 LG	-	-
(7)	1004290075	10 CLAMP CYL ASSY	AI	113
(8)	1002082630	1 ELBOW 90°	-	-
(9)	044251280	1 HOSE ASSEMBLY	AB	-
(10)	044251327	3 HOSE ASSEMBLY	AB	-
(11)	010398504	1 CAP	-	-
(12)	0102098750	1 CAP PLUG	-	-
(13)	0169618076	1 DUST SHELL	AI	80
(14)	0169519701	1 ADJ CAP SEAL	AI	-
(15)	0164660524	4 SEGMENT	AB	55
(16)	0103722550	16 HINCS M10 X 30 LG	-	-
(17)	10030269046	16 LOCKWASHER M10	-	-
(18)	0169617020	1 DUST COLLAR	AB	45
(19)	0164667113	4 SEGMENT	AB	28
(20)	0169519158	1 SEAL	AB	-
(21)	0103722557	48 HINCS M10 X 35 LG	-	-
(22)	0103010046	48 HEX NUT M6	-	-
(23)	0103050608	24 WASHER M10	-	-
(24)	0102991657	24 SHSS M10 X 20 LG	-	-

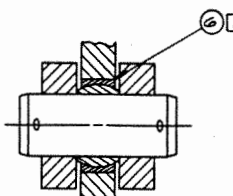
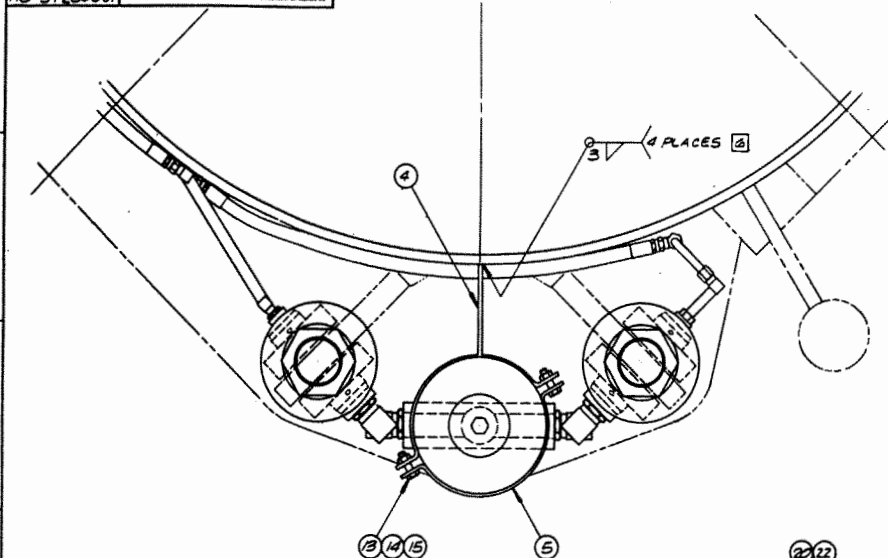
- 1) THE ADJUSTMENT RING SEAT IS TO BE COATED WITH GREASE/LITHIUM BASE NLGI #2 WITH 5-10% MOLYBDENUM DISULFIDE POWDER.
- 2) THE MAIN FRAME PIN HOLE IS TO BE COATED WITH WHITE LEAD & OIL, 60% WHITE LEAD, 40% BOILED LANSSE.
- 3) ALL HYDRAULIC PASSAGES ESPECIALLY DRILLED HOLES SHOULD BE CLEANED THOROUGHLY BEFORE ASSEMBLY.
- 4) WHEN INSTALLING ADJUSTMENT RING ON FRAME, PLACE THIS POINT OVER COUNTERSHAFT BOX.
- 5) WHEN INSTALLING CLAMP RING BE SURE THAT POSITIONING HOLE IN CLAMP RING AND ADJUSTMENT RING MATCH.
- 6) HEX HEAD SCREW ITEM ② IS USED TO PREVENT ACCIDENTAL LIFTING OF CLAMP RING WHEN REMOVING BOWL.
- 7) AFTER ASSEMBLY OF CYLINDERS AND CONNECTIONS, PRESSURIZE SYSTEM TO MAX. OF 34.6 MPa AND HOLD FOR 10 MINUTES TO CHECK CYLINDERS AND FITTINGS FOR LEAKS.
- 8) IMPORTANT - BEFORE INSTALLING BOWL, PRESSURIZE CLAMP CYLINDERS TO 34.5 MPa MIN. AND CHECK PITCH BETWEEN CLAMP RING AND ADJUSTMENT RING THREADS. THE DIMENSION MUST BE 42.1204
- 9) DO NOT INSTALL DUST SHELL ITEM ③ UNTIL PRESSURE TEST IN NOTE # 7 AND PITCH TEST IN NOTE # 8 ARE COMPLETED.

(10 mm)

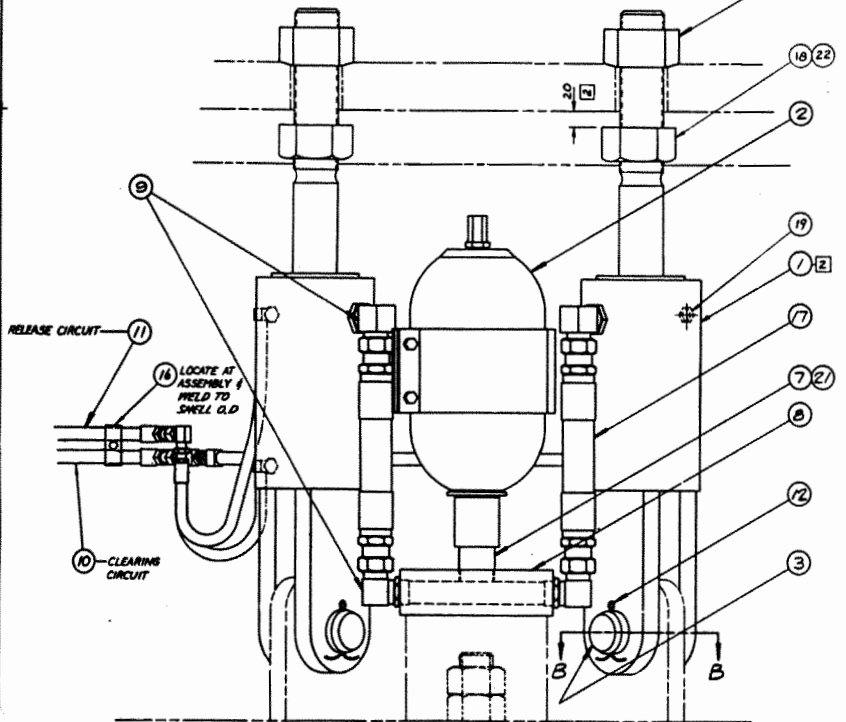
PROTOTYPE

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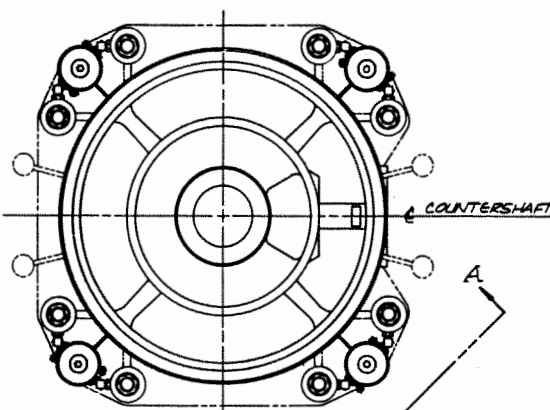
10-94280067



SECTION "B-B"
SCALE 1/2



VIEW "A-A"
SCALE 1/3



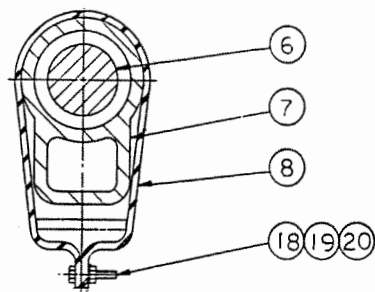
TOP VIEW OF MAIN FRAME SHOWING
ARRANGEMENT OF TRAMP RELEASE
CYLINDERS AND ACCUMULATORS

ITEM	QTY	DESCRIPTION	UNIT	QTY
10-94280067	1	TRAMP RELEASE ASSY		
10-9428 0082	8	RELEASE CYLINDER	A1	-
10-7914 2715	4	ACCUMULATOR	AB	-
10-5426 6498	8	CLEVIS PIN	AB	4.8
10-2456 1408	4	CLAMP BRACKET - HALF	AB	4.8
10-2456 1406	4	CLAMP SEGMENT	AB	8.4
10-0856 8380	8	BEARING	AB	1.6
10-5075 9501	4	NIPPLE (2") X 76.2	-	-
10-5006 1480	4	MANIFOLD	AB	9.8
10-2208 1585	16	ELBOW	-	-
10-9428 0016	1	CLEARING CIRCUIT	A2	-
10-9428 0046	1	RELEASE CIRCUIT	A2	-
10-0907 6693	16	COTTER PIN 8 X 180	-	-
10-0972 3078	16	HHCS M12 X 50 LG.	-	-
10-0906 9061	16	LOCKWASHER M12	-	-
10-0901 0051	16	HEX NUT M12	-	-
10-2470 9137	6	TUBE CLAMP	1	-
10-44 8566 67	8	HOSE ASSEMBLY 3/8" - 1/2"	-	-
10-0301 0106	8	HEX NUT M12	-	-
10-0209 8750	4	PLUG	-	-
10-6149 5225	8	NUT, SPHERICAL	A4	-
10-0482 6347	8	PIPE SEALANT	-	-
10-0482 6357	8	LOCITE	-	-

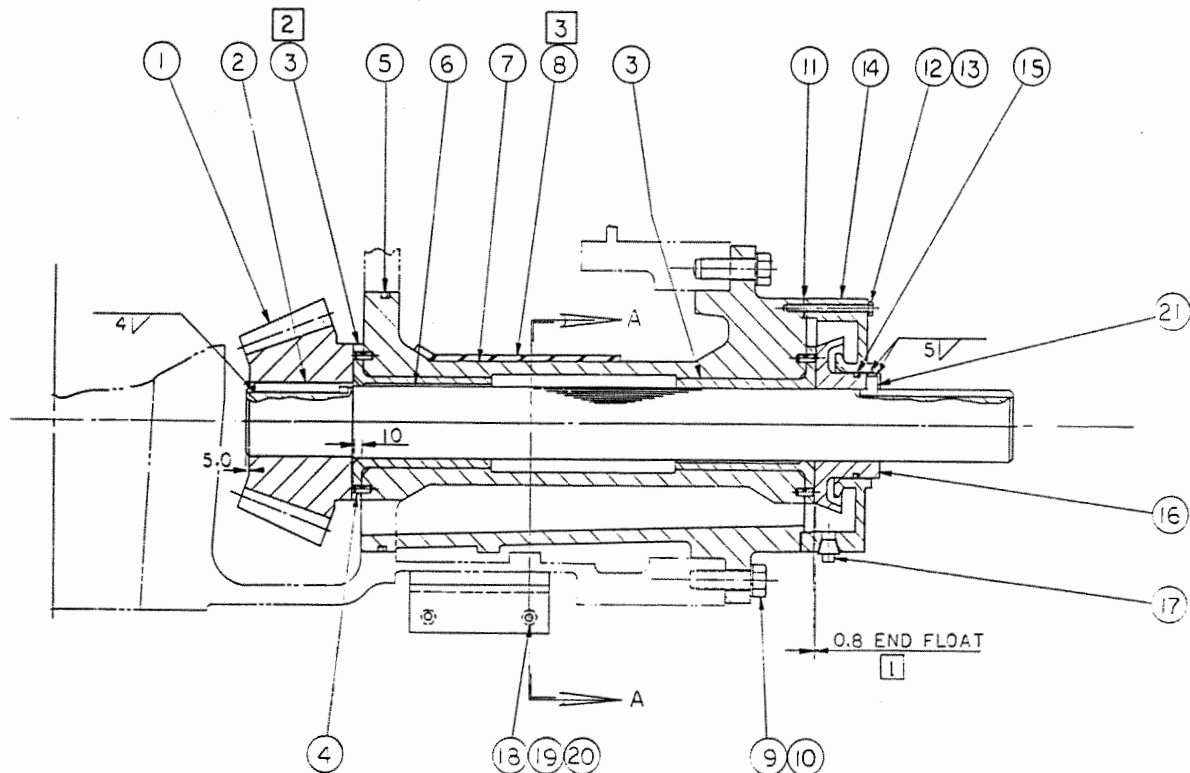
- FOR INSTALLATION OF BEARING ITEM (6) USE MOUNTING TOOL TO AID IN ASSEMBLY. IMPORTANT: WHEN INSTALLING BEARING MAKE SURE SPLIT IN OUTER RING IS POSITIONED IN LINE WITH THE GREASE FITTING LOCATED IN MAIN FRAME BEARING MOUNTING RIB.
- WHEN INSTALLING CYLINDERS, ITEM (1), PROCEED AS FOLLOWS:
 - BEFORE INSTALLING THE CYLINDERS PUSH THE CYLINDER RODS DOWN TO BOTTOM THE PISTONS AGAINST THE LOWER HEADS.
 - TURN NUTS, ITEM (16) ONTO THE CYLINDER RODS, DOWN TO THE END OF THE THREADS.
 - TO INSTALL THE CYLINDERS, SLIDE THE CYLINDER RODS UP THROUGH THE ADJUSTMENT RING HOLES, THEN INSTALL THE CLEVIS PINS, ITEM (3), AND COTTER PINS, ITEM (2).
 - PULL THE RODS OUT OF THE CYLINDERS 25mm. NEXT COAT THE TOPS OF THE RODS WITH LOCITE, ITEM (22), THEN TURN SPHERICAL NUTS, ITEM (20), ONTO THE RODS UNTIL THEY BOTTOM ON THE ADJUSTMENT RING.
 - APPLY LOC-ITE, ITEM (22), TO FOUR CYLINDER ROD THREADS STARTING 20mm FROM THE BOTTOM OF THE ADJUSTMENT RING. THEN TURN NUTS, ITEM (16), UP THE RODS UNTIL THERE IS A 20mm SPACE BETWEEN THE NUT AND UNDERSIDE OF THE ADJUSTMENT RING.

- ALL COMPONENTS IN TRAMP RELEASE ASSEMBLY ARE RATED FOR 20.7 MPa.
- BEFORE PLACING SYSTEM INTO OPERATION, OR AFTER MAINTENANCE ON SYSTEM, BLEED AIR FROM CIRCUIT. LOOSEN ELBOWS, ITEM (6), IN CYLINDER HEADS AND REMOVE BLEEDER PLUG ON ACCUMULATOR TO BLEED CIRCUIT.
- AFTER COMPLETE ASSEMBLY AND BLEEDING, PRESSURE TEST RELEASE AND CLEARING CIRCUITS AT 20.7 MPa.
- AFTER ASSEMBLING PIPING, ASSEMBLE CLAMP SEGMENTS AND CLAMP BRACKETS, POSITION BRACKETS RADIAL TO CENTER OF CRUSHER AND WELD TO SHELL O.D.

METRIC		Raymond Machinery Division	
QUANTITY	1110	DATE	03/05
DESCRIPTION	TRAMP RELEASE ASSY	PROJECT	1982 OMNICON
ISSUED	1110	DATE	03/05
REVISION	1110	DATE	03/05



SECTION AA



BILL OF MATERIAL				
ITEM NO.	PART NUMBER	QTY. REQ.	PART NAME	DWG. SIZE WT. EACH
	10194280091		COUNTERSHAFT ASSEM	500
(1)	10136831191	1	PINION	A1 54
(2)	10147007970	1	KEY. PINION	A3 .3
(3)	10122062080	2	BUSHING	A2 13.5
(4)	10103343189	4	DOWEL ϕ 12x24 LG.	
(5)	10135715373	1	O-RING	A4
(6)	10168749880	1	COUNTERSHAFT	A2 90
(7)	10145375840	1	COUNTERSHAFT BOX	A0 270
(8)	10138048810	1	GUARD	A3 5
(9)	10103725634	6	HEXHD CAPSCRW M30x90	
(10)	10103069076	6	LOCKWASHER M30	
(11)	10135766400	1	GASKET	A2
(12)	10103723162	6	HEXHD CAPSCR. M12x130	
(13)	10103069051	6	LOCKWASHER M12	
(14)	101635d4495	1	FLINGER HOUSING	A2 41
(15)	10163084500	1	PISTON RING SEAL	A4 .2
(16)	10163585150	1	OIL FLINGER	A2 14.5
(17)	10101558846	1	PIPE PLUG 1"	
(18)	10103722571	2	HX. HD. CAPSCRW M10x45	
(19)	10103056028	4	WASHER M10	
(20)	10103010046	2	HEX NUT M10	
(21)	10147009505	1	OIL FLINGER KEY	A4 .1

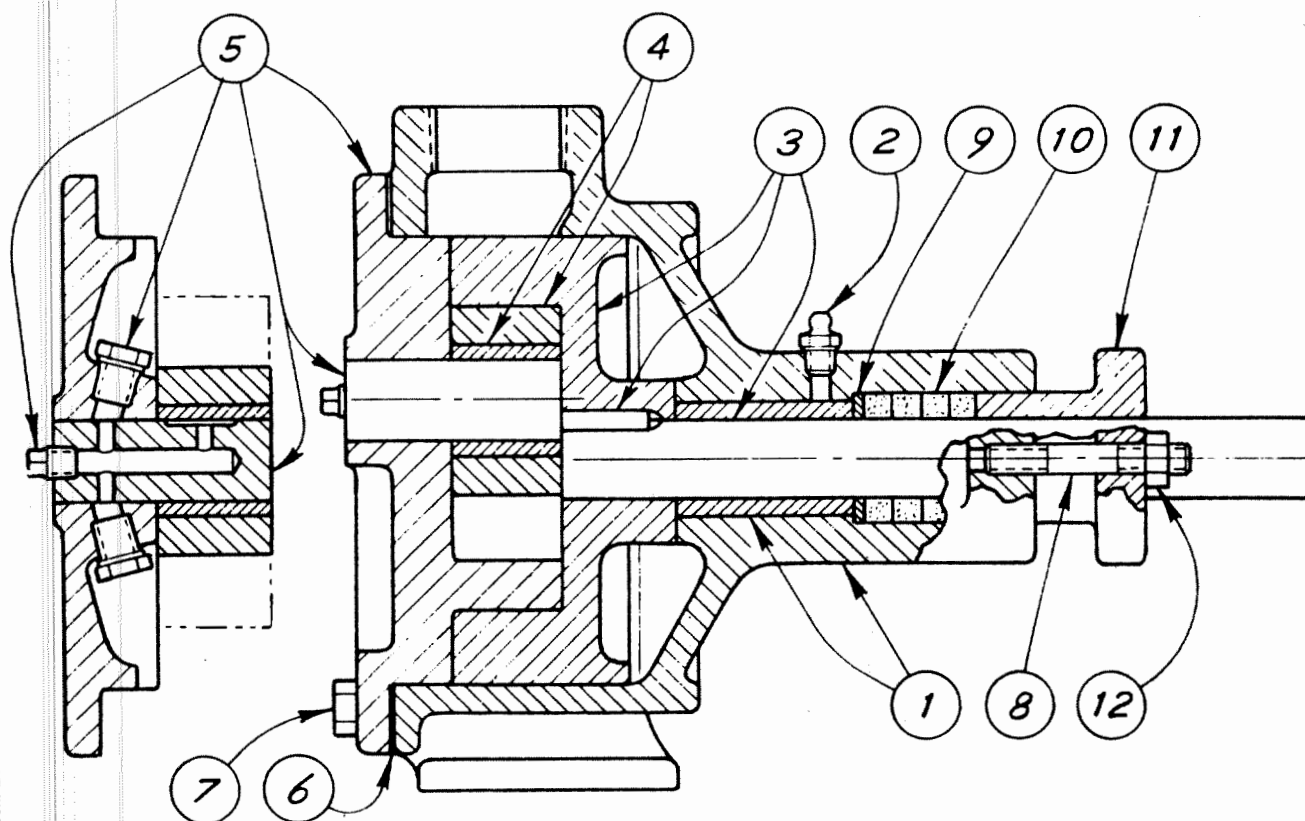
NOTES:

- AN END FLOAT RUNNING CLEARANCE OF 0.8 MUST BE MAINTAINED BETWEEN THE OUTBOARD COUNTERSHAFT BOX BUSHING ITEM 3 AND OIL FLINGER ITEM 16. FAILURE OF THE OUTBOARD BUSHING AND COUNTERSHAFT WILL OCCUR IF THIS CLEARANCE IS NOT MAINTAINED.
- COUNTERSHAFT BUSHING ITEM 3. LONGITUDINAL OIL GROOVE MUST BE ASSEMBLED AS FOLLOWS: 12:00 O'CLOCK FOR BUSHING ON PINION END, 6:00 O'CLOCK FOR BUSHING ON SHEAVE END.
- ARM GUARD IS TO BE INSTALLED AROUND COUNTERSHAFT BOX AND FRAME AFTER COUNTERSHAFT BOX IS INSTALLED INTO FRAME.

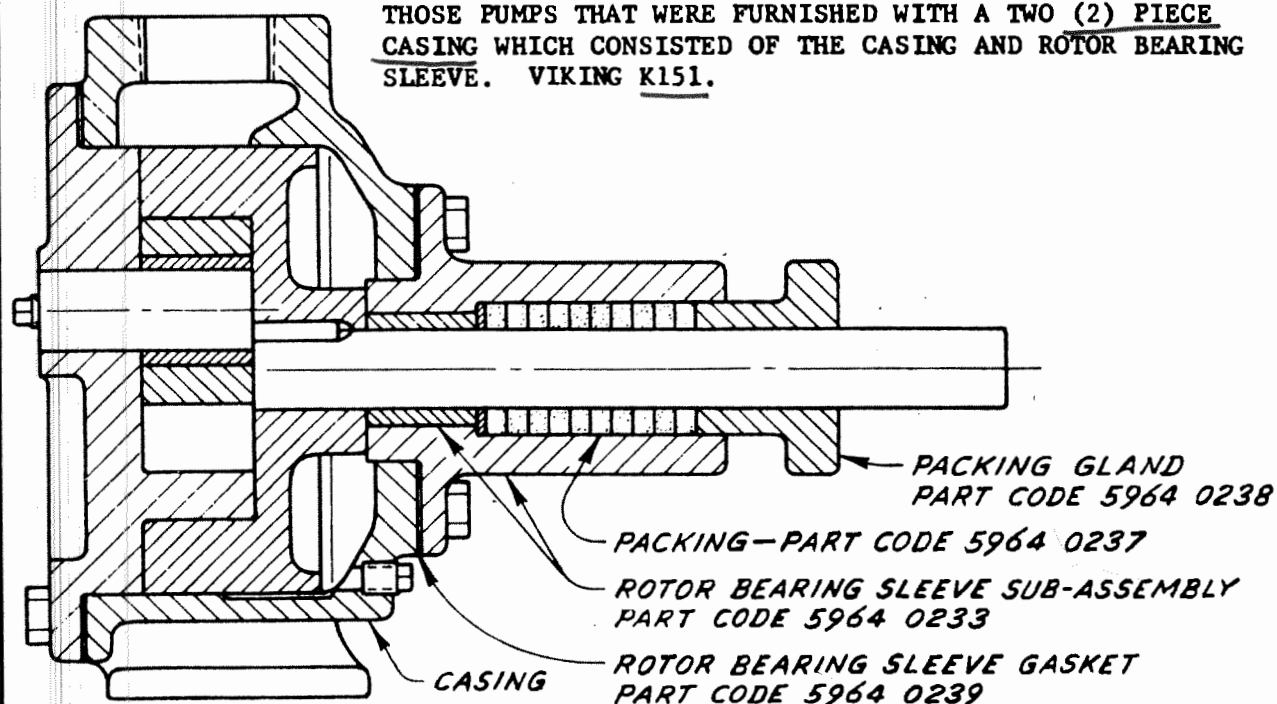
METRIC
ALL DIMENSIONS
IN MILLIMETRES

IMPLIED TOLERANCES		DRAWN R. G. 311		SUPERSEDES		ASSEMBLY GR. 05	
Finished Dimensions		DATE 1 DEC 83		SUPERSEDED BY		CRUSHER	
MILLIMETRES		CHECKED E.S.		DATE 8 DEC 83		PRODUCT 1352 OMNICON	
XXX (P. 500) 1.3		DATE		DATE		DESCRIPTION	
XXX (K. 500) 1.5		APPROVED		DATE		6:00 O'CLOCK GROOVE	
X 0.5		DATE		DATE		PART NAME	
XX 0.13		DATE		DATE		COUNTERSHAFT ASSEM	
NO MACHINE FINISH UNLESS OTHERWISE STATED		DATE		DATE		DOW. SIZE	
PLANE ANGLES 1 ONE DEGREE		DATE		DATE		PREFIX	
3rd ANGLE PROJECTION		DATE		DATE		CODE	
SCALE 1:4		DATE		DATE		SUFFIX	
REV. DESCRIPTION OF CHANGE		DATE		DATE		REV	
ISSUED		R.G.		42922		A1	
LOC. BY		DATE		DATE		11094280091	

SURFACE PREPARATION, CLEANING AND PAINTING SYMBOLS ACCORDING TO COMPANY STANDARD 03-01-01.



USE THIS ILLUSTRATION FOR ORDERING REPLACEMENT PARTS ON THOSE PUMPS THAT WERE FURNISHED WITH A TWO (2) PIECE CASING WHICH CONSISTED OF THE CASING AND ROTOR BEARING SLEEVE. VIKING K151.



OIL PUMP ASSEMBLY

Nordberg
A Nordberg Group Company

S44-C-548

5942 0078

Redrawn/Revised

11-13-79

Rexnord 5/75

W24 120#
VIKING MODEL (K32) KV-1705
1 1/2" PORTS

Nordberg
A Northern Growers Company

2', 3', 4', 4 1/4', 5100 & 36"

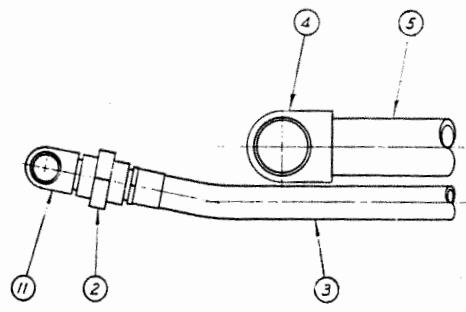
OIL PUMP ASSEMBLY

5942 0078

S44-C-548

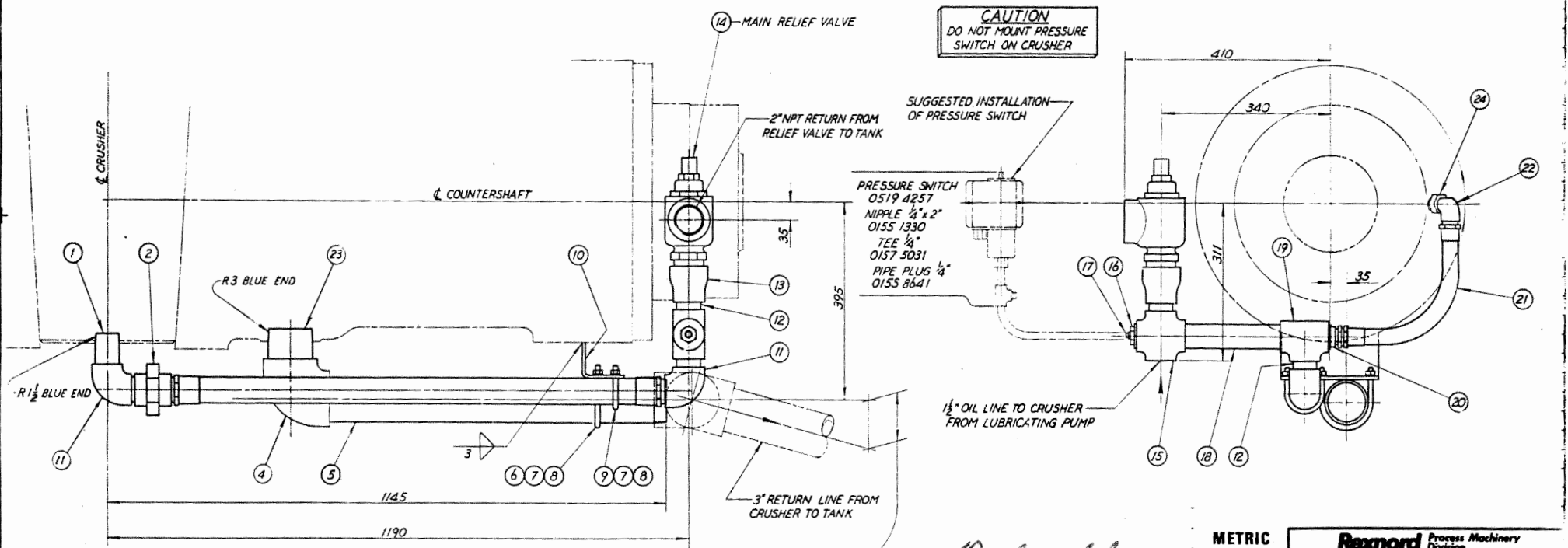
910 9428 0062

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(14)	10	0167 4128	1	RELIEF VALVE 2" (SET @ 172.4 KPa)	
(15)	10	0152 7037	1	CROSS 1 1/2"	
(16)	10	0150 4354	1	REDUCER 1 1/2" x 1/4"	
(17)	10	0155 8641	1	PIPE PLUG 1/4"	
(18)	10	0155 1447	1	NIPPLE 1 1/2" x 9"	0.9
(19)	10	0157 5037	1	TEE 1 1/2"	
(20)	10	0150 4351	1	REDUCER 1 1/2" x 3/4"	
(21)	10	4425 4092	1	HOSE ASSEMBLY 3/4" x 420 mm LG	
(22)	10	0154 0576	1	ELBOW 3/4" x 90°	
(23)	10	5075 9691	1	NIPPLE	A4
(24)	10	0150 2105	1	ADAPTER R 3/4" - 1/2" NPT	-

BILL OF MATERIAL					
ITEM NO.	PART NUMBER	QTY. REQ.	PART NAME	DWEL. RZ.	WT. EACH kg
	10 9428 0062		CRUSHER OIL PIPING		
(1)	10 5075 9185	1	NIPPLE	A4	0.2
(2)	10 0158 6233	1	UNION 1 1/2"		
(3)	10 4425 7978	1	HOSE ASSEMBLY 1 1/2" x 1050 mm LG	A3	
(4)	10 0153 5582	1	ELBOW 3" x 90°	-	
(5)	10 5460 0088	1	PIPE 3" x 710 mm LG	A4	8
(6)	10 1970 3800	1	U-BOLT	A4	0.2
(7)	10 0301 0046	4	HEX NUT M10		
(8)	10 0306 9046	4	LOCKWASHER M10		
(9)	10 1970 3780	1	U-BOLT	A4	0.1
(10)	10 2135 2020	1	BRACKET	A3	
(11)	10 0153 5579	2	ELBOW 90° x 1 1/2"		
(12)	10 0155 1435	2	NIPPLE 1 1/2" x 2" LG		0.2
(13)	10 0156 2357	1	REDUCER 2" x 1 1/2"		



CAUTION
DO NOT MOUNT PRESSURE SWITCH ON CRUSHER

Replaced by
94280145
(4" drain)

SURFACE PREPARATION, CLEANING AND PAINTING SYMBOLS ACCORDING TO COMPANY STANDARD 03-01-01.

REV.	DESCRIPTION OF CHANGE	LOC.	DATE	ENG. ORDER NUMBER
1	REVISED ITEM 14, ADDED 11.23		11.23	45832
2	ITEM 11 2-REQD WAS 1-REQD		11.23	40773
3	ISSUED		11.23	

METRIC ALL DIMENSIONS IN MILLIMETRES		Rexnord Process Machinery Division	
IMPLIED TOLERANCES Fitted Dimensions	DRAWN S.S. DATE 6 OCT 82	SUPERSEDES	ASSEMBLY GR 07
MILLIMETRES XXX.0 - 500.0 ± 0.1 XXX.0 - 500.0 ± 0.15 X ± 0.5 XX ± 0.13	CHECKED S.S. DATE 8 NOV 82	SUPERSEDED BY	CRUSHER
APPROVED DATE	DATE	PRODUCT	1352 OMNICON
DESCRIPTION			
ASSEMBLY			
PART NAME CRUSHER OIL PIPING			
SCALE 1:4	PREFIX A1	CODE 910	SUPPLY 9428 0062

110-9423 0089

ALL INFORMATION CONTAINED ON THIS DRAWING IS CONSIDERED TO BE BOTH CONFIDENTIAL AND PROPRIETARY. IT IS TO BE KEPT IN SECRECY AND NO USE OR REPRODUCTION THEREOF MAY BE MADE WITHOUT THE WRITTEN CONSENT OF Raytheon.

2-12	10 0372 4578	2	HEX HD CAPSCREW M20x50		
2-9	10 5616 7919	1	COUNTERWEIGHT COVER	A3	6.2
2-14	10 0482 8555	A/R	FOAM		

BILL OF MATERIAL

ITEM NO.	PART NUMBER	QTY	PART NAME	UNIT	WT EACH
	1094280089		ECCENTRIC ASSY		1273
(1)	1094285003	1	ECCENTRIC SUB-ASSEMBLY		
(1-1)	1031136170	1	ECCENTRIC	A0	480
(1-2)	1022074063	1	ECCENTRIC BUSHING	A1	89
(1-3)	1057605155	1	THRUST BEARING	A2	23
(1-4)	1003722550	6	HEX HD CAPSCREW M10x30		
(1-5)	1003063296	6	LOCKPLATE M10		
(1-6)	1036803300	1	GEAR	A0	80
(1-7)	1003724641	12	HEX HD CAPSCREW M20x100		
(1-8)	1003344489	1	DOWEL #25x80		
(1-9)	1095059960	A/R	NORDBAK COMPOUND		
(1-10)	1004826354	A/R	LOCTITE		
(2)	1094285002	1	COUNTERWEIGHT SUB-ASSEMBLY		
(2-1)	1086428100	1	COUNTERWEIGHT	A0	470
(2-2)	1063724606	15	HEX HD CAPSCREW M20x70		
(2-3)	1086420473	5	CTWEIGHT SEGMENTS	A2	8
(2-4)	1004826354	A/R	LOCTITE		
(2-5)	1063518947	1	SEAL RING LOWER	A3	2
(2-6)	1063518830	1	SEAL RING UPPER	A3	2
(2-7)	1003724550	2	HEX HD CAPSCREW M20x30		
(2-8)	1004590350	A/R	ADHESIVE		
(2-9)	1004590351	A/R	ACTIVATOR		
(2-10)	1038018170	1	COUNTERWEIGHT LINER	A2	66
(2-11)	1018653803	6	SPACER	A4	1

NOTES:

1. WHEN ASSEMBLING BUSHING IN ECCENTRIC ALIGN HOLE IN BUSHING WITH OIL HOLE IN ECCENTRIC. INSTALL BUSHING WITH BUTTER OF ECCENTRIC AS SHOWN.
2. WHEN ASSEMBLING GEAR TO ECCENTRIC, HEAT GEAR TO GIVE AT LEAST 30°C TEMPERATURE DIFFERENCE. ITEM (1) TO BE TIGHTENED TO 470 N-m.
3. COUNTERWEIGHT IS NOT TO BE ASSEMBLED TO ECCENTRIC UNTIL ECCENTRIC IS POSITIONED WITH THE PROPER GEAR & FINISH BACKLASH.
4. INSTALL ECCENTRIC AFTER COUNTERWEIGHT ASSEMBLY IS IN POSITION. THERE SHOULD BE 5.0 OF BUSHING INSTALLED ON THE MAIN FRAME ASSEMBLY THAT CAN BE INCREASED OR DECREASED TO OBTAIN THE CORRECT GEAR & FINISH BACKLASH OF 0.44 TO 1.11. FINISH BACKLASH WITH FINISH IS BOLLARD CIRCULAR AND BUSH IN CONTACT WITH A GEAR TOOTH.
5. AFTER FINAL FINISHING, BE SURE TO TIGHTEN AND LOCK THIRTY BEARING SCREWS AND LOCKS ON MAIN FRAME ASSEMBLY.
6. SEAL REMOVAL INSTRUCTIONS:
 - a. CLEAN GROOVES WITH OIL FREE RAGS AND WET.
 - b. APPLY ACTIVATOR IN A WET THIN FILM TO SURFACES OF SEAL RINGS. IF EXCESS ACTIVATOR IS APPLIED A PARTIALLY CURED RING MAY RESULT.
 - c. APPLY ADHESIVE TO BOTTOM OF GROOVES, APPLY ENDOR ADHESIVE TO INSURE MAXIMAL SOURCE OF.
 - d. POSITION SEAL RINGS INTO GROOVES AS SOON AS POSSIBLE AFTER ADHESIVE APPLICATION. SUFFICIENT PRESSURE TO KEEP THE TWO SURFACES IN CONTACT WITH EACH OTHER SHOULD BE MAINTAINED UNTIL A HANDED RING IS ATTAINED. A HANDED RING IS ATTAINED IN APPROXIMATELY THREE MINUTES.
7. WHEN WELDING, WELD LINER TIGHTLY TO KEEP GAP BETWEEN LINER AND COUNTERWEIGHT TO A MINIMUM. THIS COUNTERWEIGHT AS SHOWN. AFTER THE LONGITUDINAL JOINT TO THE FULL THICKNESS OF THE LINER.
8. USE AN 8/16 WELD ROD WHEN WELDING COUNTERWEIGHT LINER ITEM 2-10.
9. APPROXIMATELY 0.03 CUBIC METERS OF FOAM ARE REQUIRED TO FILL THE AREA BETWEEN THE COUNTERWEIGHT CHASE AND COUNTERWEIGHT.

METRIC

ALL DIMENSIONS IN MILLIMETERS

Process Machinery Division

Raytheon

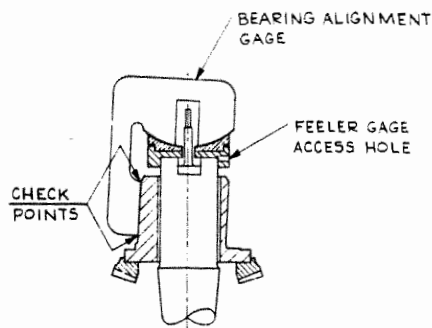
IMPLIED TOLERANCES	DRAWN TO GB	SUPERSEDES	ASSEMBLY
FINISHED DIMENSIONS	DATE 10 OCT 85	DATE 08 OCT 85	CRUSHER
MILLIMETERS	APPROVED	PRODUCT	OMNISCONE 1352
REV. 0-000	DATE	DESCRIPTION	
REV. 1-000			
REV. 2-000			
REV. 3-000			
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REV. 100-000			

PROTOTYPE

ADDED ITEMS 2-7, 2-13 & 2-14 AND NOTE #9	45628
REMOVED ITEM 2-7	43076
CHANGED LINE WELDS	42889
ITEM 2-10 10-9428 5002 WAS 10-1622 5002	42858
ISSUED	
REV.	DESCRIPTION OF CHANGE
LOC	DATE
BY	END ORDER NUMBER

SECTION A-A

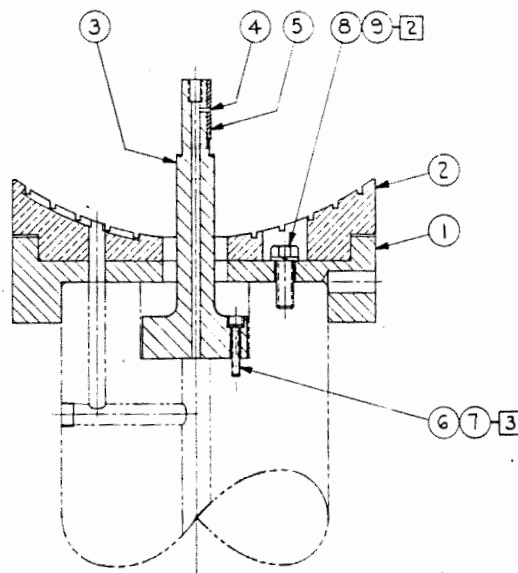
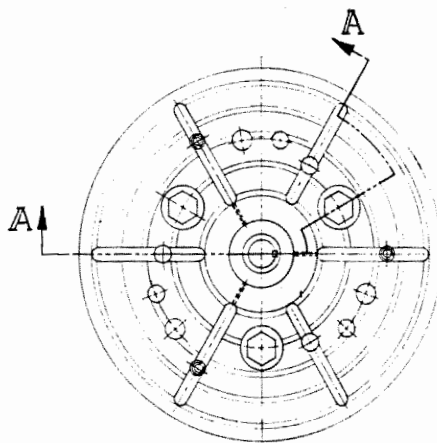
SURFACE PREPARATION, CLEANING AND PAINTING SYMBOLS ACCORDING TO COMPANY STANDARD 89-01-01.



BEARING ALIGNMENT PROCEDURE

TO CHECK BEARING ALIGNMENT PROCEED AS FOLLOWS:

- 1 AFTER SOCKET HAS BEEN INSTALLED ONTO THE MAINSHAFT, CHECK WITH A FEELER GAGE THRU THE 3 ACCESS HOLES IN THE O.D. OF THE SOCKET TO MAKE SURE THE SOCKET IS SEATED FLAT ON THE MAINSHAFT. SEE THE SKETCH ABOVE.
- 2 PUSH THE ECCENTRIC OVER UNTIL THE THICK SIDE CONTACTS THE MAINSHAFT.
- 3 PLACE THE BEARING ALIGNMENT GAGE ON THE SOCKET LINER WITH THE VERTICAL LEG OF THE GAGE AGAINST THE THICK SIDE OF THE ECCENTRIC.
- 4 WITH A FEELER GAGE, CHECK FOR CLEARANCE BETWEEN THE ALIGNMENT GAGE AND ECCENTRIC AT CHECK POINTS SHOWN ON THE SKETCH ABOVE. THE ALLOWABLE CLEARANCE AT EITHER CHECK POINT IS 0.00 TO 0.18. IF CLEARANCE IS GREATER, CONTACT ENGINEERING.



SECTION A A

BILL OF MATERIAL				
ITEM NO.	PART NUMBER	QTY. REQ.	PART NAME	DRWG. SIZE
1	1094280098	1	SOCKET ASSEMBLY	180
1	1073814251	1	SOCKET	A2 63
2	1048722900	1	SOCKET LINER	A1 111
3	1074620041	1	SPINDLE	A2 7.5
4	1003395469	1	SPRING PIN M3.5x12	A2
5	1047002700	1	KEY	A4
6	1003069046	6	LOCKWASHER M10	-
7	1003766336	6	SOC CAP SCR M10x1.5x70	-
8	1003069066	3	LOCKWASHER M20	-
9	1003724592	3	HEX CAP SCR M20x2.5x60	-

NOTES:

- 1 WHEN INSTALLING SOCKET LINER, ITEM ②, IN SOCKET, ITEM ①, COOL THE SOCKET LINER 55°C OR HEAT THE SOCKET TO GIVE 80°C TEMPERATURE DIFFERENCE.
- 2 WHEN INSTALLING SOCKET ON MAINSHAFT HEAT SOCKET TO GIVE AT LEAST 65°C TEMPERATURE DIFFERENTIAL. AFTER SOCKET HAS BEEN INSTALLED ON MAINSHAFT, CAPSCREWS, ITEM ⑦, ARE TO BE TIGHTENED TO 470 N·m.
- 3 SOCKET CAPSCREWS, ITEM ⑦, ARE TO BE TIGHTENED TO 60 N·m.

*If replacing socket & socket liner
remove dowel from main shaft
& furnish*

3-86046070 washers

3-3724606 cap screws

*Replaced by
94280150*

** STILL using original Socket &
Socket Liner*

SURFACE PREPARATION, CLEANING AND PAINTING SYMBOLS ACCORDING TO COMPANY STANDARD 03-01-01.

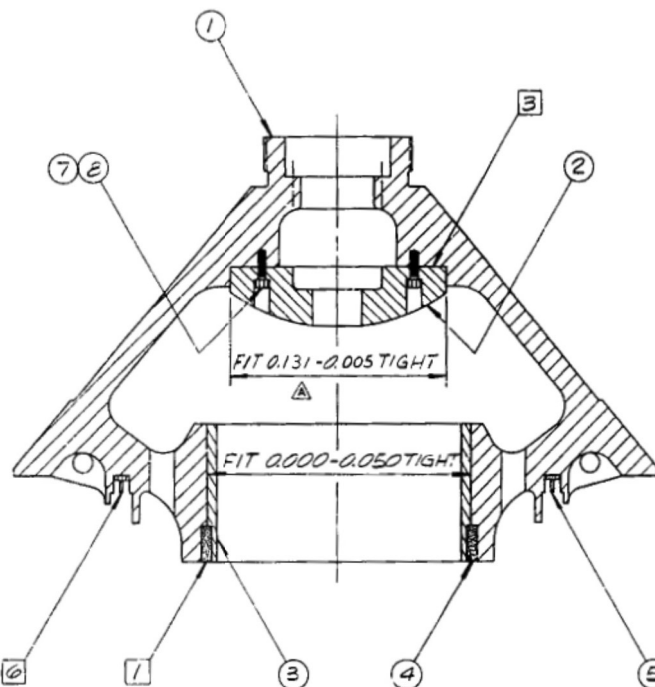
METRIC
ALL DIMENSIONS
IN MILLIMETRES

IMPLIED TOLERANCES Finished Dimensions		DRAWN: TGB DATE: 20 JUL 84		SUPERSEDES		ASSEMBLY GROUP-10	
MILLIMETRES XXX (D 500) : 3 XXX (C 500) : 1.5 X : 0.5 XX : 0.13		CHECKED: CCB DATE: 21 JUL 84		SUPERSEDED BY			
NO MACHINE FINISH UNLESS OTHERWISE STATED		APPROVED		PRODUCT		1352 OMNICON	
PLANE ANGLES 1 ONE DEGREE		DATE		DESCRIPTION			
3rd ANGLE PROJECTION		PART NAME		SOCKET ASSEMBLY			
SCALE: 1:3		PREFIX		CODE		SUFFIX	
REV. 1		11094280098					

ISSUED	21 JUL 84	42607
REV.	DESCRIPTION OF CHANGE	LOC. BY DATE

NO 110-94280001

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CONFIDENTIAL AND PROPRIETARY OF RAYMOR. NO USE OR REPRODUCTION
HEREOF MAY BE MADE WITHOUT THE EXPRESS WRITTEN CONSENT OF RAYMOR.



1) WHEN ASSEMBLING BUSHING
IN HEAD, COOL THE BUSHING
TO GIVE ATLEAST 11 °C TEM-
PERATURE DIFFERENCE. ALIGN
POCKETS IN BUSHING WITH
POCKETS IN HEAD. INSTALL
BUSHING FLUSH WITH BOTTOM
OF HEAD.

2) WHEN ASSEMBLING HEAD BALL
TO HEAD, COOL THE HEAD BALL
TO GIVE ATLEAST 56 °C TEM-
PERATURE DIFFERENCE.

3) HEAD BALL SHOULD CONTACT
HEAD ALL AROUND ON SURFACE
INDICATED.

4) THOROUGHLY CLEAN CORED
HEAD CAVITY.

5) EXERCISE CAUTION WHEN
LOWERING THE HEAD ASSEMBLY
INTO POSITION DUE TO THE
SMALL CLEARANCE BETWEEN
HEAD BUSHING AND SOCKET.
USE SPECIAL LIFTING EYE
TO HOLD HEAD AT THE PROPER
ANGLE DURING ASSEMBLY.

SEAL CEMENTING INSTRUCTIONS

A. CLEAN GROOVE WITH OIL FREE SOLVENT
AND DRY.

B. APPLY ACTIVATOR IN A VERY THIN FILM TO
BOTTOM OF SEAL RING. IF EXCESS
ACTIVATOR IS APPLIED, A PARTIALLY CURED
BOND MAY RESULT.

BILL OF MATERIAL					
ITEM NO.	PART NUMBER	QTY REQD	PART NAME	REV	BY DATE
1	1094280001		HEAD ASSEMBLY	1765	
2	1042464002	1	HEAD	A01592	
3	1057605153	1	HEAD BALL	F2 51	
4	1022147100	1	HEAD BUSHING	A1 20	
5	1095059960	AR	NORDBAK LOCKING COMPOUND	-	
6	1063518832	1	SEAL RING	A3 2	
7	1004590350	AR	ADHESIVE	-	
8	1003724078	3	HHCS M16X50 LG.	-	
9	1004826353	AR	LOC-TITE	-	
10	1004590351	AR	ACTIVATOR	-	

*Head Ball REPLACED by
57605157 and add
3ea 74880767 WASHERS
3ea 3786092 Paperseal

C. APPLY ADHESIVE TO BOTTOM OF GROOVE.
APPLY ENOUGH ADHESIVE TO INSURE
MINIMAL SQUEEZE OUT

D. POSITION SEAL RING INTO GROOVE AS SOON AS
POSSIBLE AFTER ADHESIVE APPLICATION.
SUFFICIENT PRESSURE TO KEEP THE TWO
SURFACES IN CONTACT WITH EACH OTHER
SHOULD BE MAINTAINED UNTIL A HANDLING BOND
IS ATTAINED. A HANDLING BOND IS
ATTAINED IN APPROXIMATELY THREE
MINUTES.

***NOTE: IF CUSTOMER NEEDS A NEW HEAD
ASSY SUPPLY 1094280170 SR 05/02/2019

PROTOTYPE

METRIC
ALL DIMENSIONS
IN MILLIMETERS

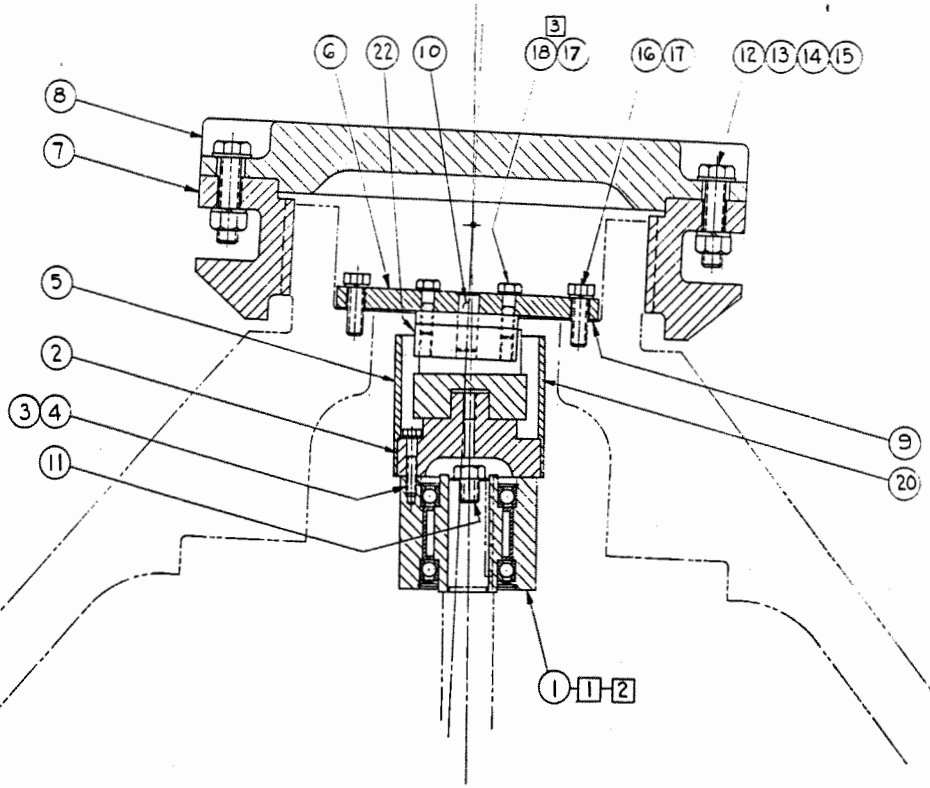
Raymord Process Machinery Division	
DRAWN: J. J. J. DATE: 2/1/80 CHECKED: C. DAVIS DATE: 4 DEC 80	SUPP. CODE: _____ ASSEMBLY: GR 1. SUPERSEDED BY: CRJSHR PRODUCT: 1352 OMNICON DESCRIPTION:
APPROVED: _____ DATE: _____	PART NAME: HEAD ASSEMBLY
MACHINE FROM: _____ VALUED OTHERWISE: _____ PLANT: _____ J. J. J.	DRAWING NUMBER: 11094280001 REV: 3

1	ITEM(1) WAS 9428 0047	C. DAVIS	29210
2	ADDED ITEM(2)	S. BAKER	29297
3	ITEM(3) WAS 3787 0047	P. J.	29297
4	ISSUED	S. BAKER	29297
5	DESCRIPTION OF CHANGES	LOG	DATE
6	REV.	BY	DATE
7	DESCRIPTION OF CHANGES	LOG	DATE
8	REV.	BY	DATE
9	DESCRIPTION OF CHANGES	LOG	DATE
10	REV.	BY	DATE

SURFACE PREPARATION, CLEANING
AND PAINTING SYMBOLS ACCORDING
TO COMPANY STANDARD 03101.

110-9428 0097

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BILL OF MATERIAL					
ITEM NO.	PART NUMBER	QTY. REQ.	PART NAME	DWG. SIZE	WT. EACH kg
	1094280097		FEED PLATE ASSEM		116
(1)	1006530138	1	BACKSTOP CLUTCH	A3	4.8
(2)	1027020140	1	COUPLING ADAPTER	A2	2.4
(3)	1002778561	4	HEX CAP SCR 5/16-24x1 3/4	-	-
(4)	1003069041	4	LOCKWASHER M8	-	-
(5)	1010140059	1	COUPLING SLIDER	A2	1.5
(6)	1027438403	1	HEAD PLATE	A3	4.2
(7)	1062731720	1	LOCKING NUT	A2	52
(8)	1055981200	1	FEED PLATE	A2	50
(9)	1035857425	1	GASKET	A3	-
(10)	1003343680	1	DOWEL #16x45	-	-
(11)	1057954650	1	ORFICE	A4	-
(12)	1003724106	4	HEX CAP SCR M16x2x70	-	-
(13)	10103056037	4	WASHER M16	-	-
(14)	10103069061	4	LOCKWASHER M16	-	-
(15)	10103010061	4	HEX NUT M16	-	-
(16)	10103723064	6	HEX CAP SCR M12x1.75x40	-	-
(17)	1003069051	8	LOCKWASHER M12	-	-
(18)	1003723057	2	HEX CAP SCR M12x35	-	-
(19)				-	-
(20)	1038011450	1	SHIELD	A2	1.4
(21)				-	-
(22)	1014060092	1	LOCKING BAR	A3	7

NOTES:

- BACKSTOP CLUTCH ITEM (1) ALLOWS THE HEAD TO TURN CLOCKWISE WHILE CRUSHING, BUT PREVENTS IT FROM SPINNING COUNTER-CLOCKWISE WHEN RUNNING EMPTY.
- WHEN ASSEMBLING CLUTCH TO SPINDLE, MOUNT WITH SEAL END DOWN. THEN CHECK TO SEE THAT OUTER RACE TURNS CLOCKWISE WHEN VIEWED FROM TOP OF CRUSHER.
- LOCKING BAR IS INSTALLED WITH BREAK-AWAY SCREWS ITEM (18) WHICH PREVENTS OVERLOAD DAMAGE TO THE CLUTCH, SPINDLE, ETC. IF SCREWS BREAK FIND AND CORRECT THE OVERLOAD. THEN REPLACE THE BROKEN SCREWS. TORQUE SCREWS IT (18) TO 105 N.m.

PROTOTYPE

SURFACE PREPARATION, CLEANING AND PAINTING SYMBOLS ACCORDING TO COMPANY STANDARD 03-01-01.

ISSUED	13443	ENG. ORDER NUMBER
DESCRIPTION OF CHANGE	LOC. BY DATE	

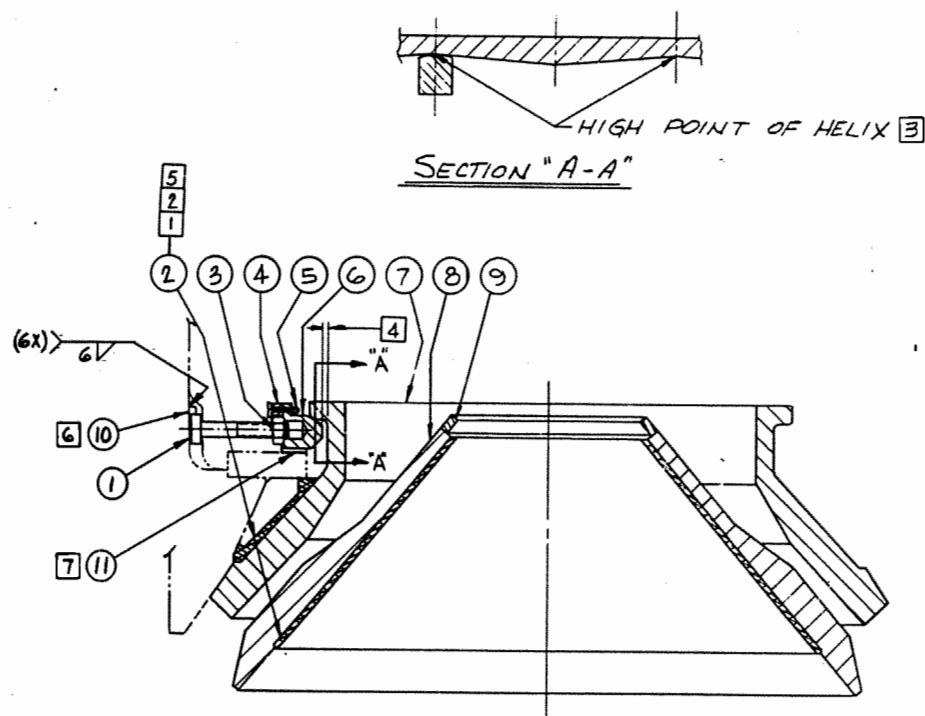
METRIC ALL DIMENSIONS IN MILLIMETRES		Rexnord Process Machinery Division	
IMPLIES TOLERANCES FRACTIONAL DIMENSIONS	DRAWN C 3/4/85 DATE 17 APR 84	SUPERSEDES	ASSEMBLY GROUP - 12
MILLIMETRES	CHECKED C 3/4/85 DATE 17 APR 84	SUPERSEDED BY	
XXXL (500) ± 3 XXXL (500) ± 1.5 XX ± 0.5 X ± 0.13	APPROVED DATE	PRODUCT	1352 OMNICON
NO MACHINE FINISH UNLESS OTHERWISE STATED	PART NAME FEED PLATE ASSEM		
PLANE ANGLES 1 ONE DEGREE	DWG. NO. PREFIX CODE SUFFIX		
3rd ANGLE PROJECTION	A1 11094280097		
SCALE 1:2			

110-9428 0045

ALL DIMENSIONS SHOWN ON THIS DRAWING TO BE IN MILLIMETERS, UNLESS OTHERWISE NOTED. ALL DIMENSIONS TO BE TAKEN TO THE CENTER OF THE PART UNLESS OTHERWISE NOTED. ALL DIMENSIONS TO BE TAKEN TO THE CENTER OF THE PART UNLESS OTHERWISE NOTED.

NOTES CONT.:

- 7 TACK WELD WEDGE SHIM, ITEM 11, TO BOWL IF REQUIRED.



SECTION "A-A"

BILL OF MATERIAL				
ITEM NO.	PART NUMBER	QTY	PART NAME	UNIT
	10194280045		LINER ASS'Y	1844
(1)	10119577700	6	WEDGE BOLT	A3
(2)	10195059901	9	NORDBAK 22* KIT	—
(3)	10151483199	6	SPHERICAL NUT	A4
(4)	10156839390	6	LOCKPLATE	A3
(5)	10103075440	6	COTTER PIN 6x80	—
(6)	10186342845	6	WEDGE	A3
(7)	10148294807	1	BOWL LINER	A1
(8)	10150133981	1	MANTLE	A1
(9)	10163915607	1	TORCH RING	A2
(10)	1018780302	6	BOLT STOP	A4
(11)	10170516700	6	WEDGE SHIM	A4

NOTE: For XT500 liners see
94280191

NOTES:

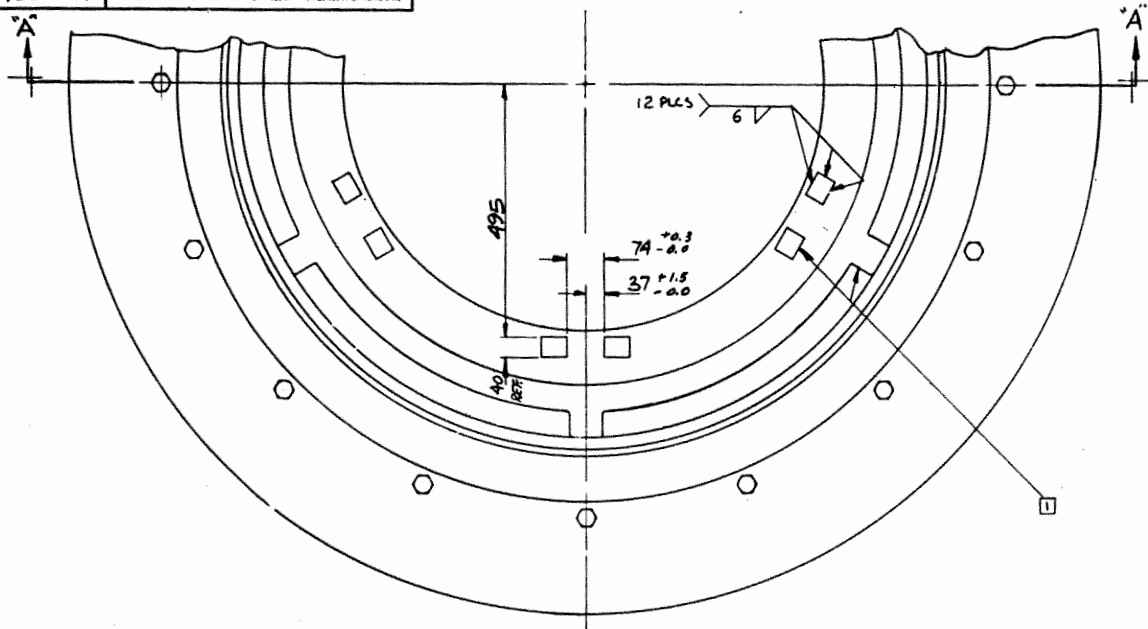
- FOR NORDBAK BACKING INSTRUCTIONS REFER TO OMNICON CRUSHER INSTRUCTION MANUAL.
- APPROXIMATE QUANTITY TO BACK BOTH LINER AND MANTLE.
- TO INSURE SELF TIGHTENING, LOCATE BOWL LINER IN BOWL SO THAT WEDGE ITEM 6 WILL CONTACT HIGHEST POINT OF HELIX ON BOWL LINER. AFTER WEDGES AND SQUARE HEAD BOLTS ARE LOCATED, TURN SPHERICAL NUTS UNTIL HAND TIGHT, THEN ALTERNATE NUTS WITH WRENCH TO PULL UP BOWL LINER EVENLY. DROP LOCKPLATES ITEM 4 OVER SPHERICAL NUTS AND INSERT COTTER PINS ITEM 5.
- CLEARANCE MUST BE MAINTAINED BETWEEN WEDGE AND LINER AT THIS POINT. WEDGE SHOULD BE SHIMMED UP IF REQUIRED TO OBTAIN CLEARANCE.
- ONLY 6 NORDBAK 22* KITS ARE REQUIRED WHEN FILLER PIECES ARE USED IN THE BOWL.
- AFTER WEDGE BOLTS HAVE BEEN TIGHTENED, WELD ITEM 11 ABOVE EACH WEDGE BOLT AS SHOWN.

METRIC
ALL DIMENSIONS
IN MILLIMETERSProcess Machinery
Division

REPLY TOLERANCES FINISHED DIMENSIONS MILLIMETERS DEC. 0.001 1.3 DEC. 0.002 1.2 DEC. 0.003 1.0 DEC. 0.004 0.8 DEC. 0.005 0.6 DEC. 0.006 0.5 DEC. 0.007 0.4 DEC. 0.008 0.3 DEC. 0.009 0.2 DEC. 0.010 0.1		DRAWN: S.S. DATE: 1 MAR 82 CHECKED: C. BAYB DATE: 2 MAR 82 APPROVED: [Signature] DATE: [Blank] MACHINE FROM: [Blank] UNLESS OTHERWISE STATED: [Blank]		SUPERSEDES: [Blank] ASSEMBLY: GR. 13 SUPERSEDED BY: CRUSHER PRODUCT: 1352 OMNICON DESCRIPTION: SH HD MEDIUM PART NAME: LINER ASSEMBLY	
ADDITIONAL NOTES: 1. ADDED ITEM 11 & NOTE 7 2. ADDED ITEM 10 3. IT 5-REQ WAS 5-REQ 4. ADDED NOTE 5 5. ISSUED		51765 47917 43370 38191		SCALE: 1:4 A1 110 9428 0045	

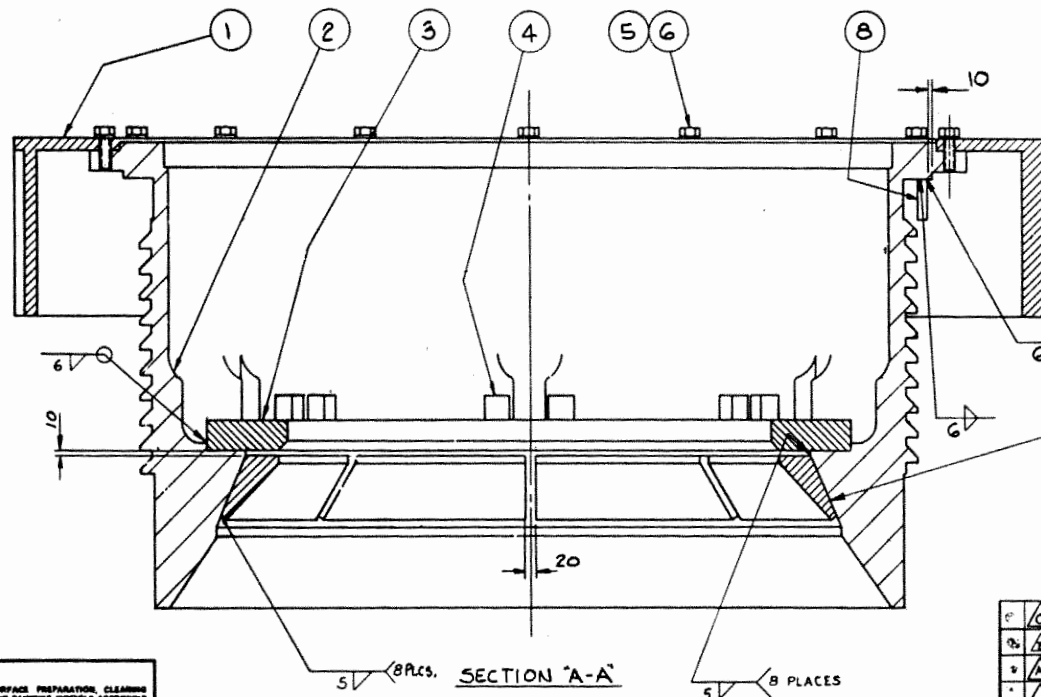
SURFACE PREPARATION, CLEANING
AND FINISHING SYMBOLS ACCORDING
TO COMPANY STANDARD IS-41-01.

110-94280039

ALL INFORMATION CONTAINED ON THIS DRAWING IS CONSIDERED TO BE BOTH
1. CONFIDENTIAL AND PROPRIETARY BY RECORD INC. NO USE OR REPRODUCTION
THEREOF MAY BE MADE WITHOUT THE WRITTEN CONSENT OF RECORD INC.

BILL OF MATERIAL				
ITEM NO.	PART NUMBER	QTY REQ.	PART NAME	REV. DATE
	10194280039		BOWL ASSEMBLY	3615
1	10122816801	1	ADJUSTMENT CAP	A1 778
2	10120052801	1	BOWL	A1 2559
3	10163487397	1	ADAPTER RING	A2 266
4	1018780257	12	STOP BLOCK	A4 .9
5	10103725106	16	CAP SCREW 24X70 L6	- -
6	10103069071	16	LOCK WASHER 24	- -
7				
8	1018780256	1	STOP BLOCK	A3 1

1 POSITION STOP BLOCKS IN RELATION TO CORED POCKETS AND DIMENSIONS SHOWN.



FILLER PIECE: IF FILLER PIECES ARE DESIRED TO REDUCE THE AMOUNT OF NORDBAK BACKING REQUIRED WHEN MAKING FREQUENT "LINER" CHANGES, ORDER FILLER PIECE, 1808 0114, 8 REQUIRED.

PROTOTYPE

HYDRAULIC

METRIC
ALL DIMENSIONS
IN MILLIMETERS

APPROVED TOLERANCES		DRAFT C.Y.H.		SUPERSEDES		ASSEMBLY	
FINISHED DIMENSIONS		DATE 14 DEC 81		CHECKED C. DAVIS		SUPERSEDED BY	
MILLIMETERS		DATE 15 DEC 81		APPROVED		PRODUCT	
EXL. DIM.		DATE		DESCRIPTION		PART NAME	
EXL. F. DIM.		DATE		STD FINE		SH HD FINE, MEDIUM, COARSE	
A		DATE		BOWL ASSEMBLY			
B		DATE		SCALE		1:5	
C		DATE		REV.		C	
D		DATE		REV.		C	
E		DATE		REV.		C	
F		DATE		REV.		C	
G		DATE		REV.		C	
H		DATE		REV.		C	
I		DATE		REV.		C	
J		DATE		REV.		C	
K		DATE		REV.		C	
L		DATE		REV.		C	
M		DATE		REV.		C	
N		DATE		REV.		C	
O		DATE		REV.		C	
P		DATE		REV.		C	
Q		DATE		REV.		C	
R		DATE		REV.		C	
S		DATE		REV.		C	
T		DATE		REV.		C	
U		DATE		REV.		C	
V		DATE		REV.		C	
W		DATE		REV.		C	
X		DATE		REV.		C	
Y		DATE		REV.		C	
Z		DATE		REV.		C	

SURFACE PREPARATION, CLEANING
AND PAINTING SYMBOLS ACCORDING
TO COMPANY STANDARD 02-01-01

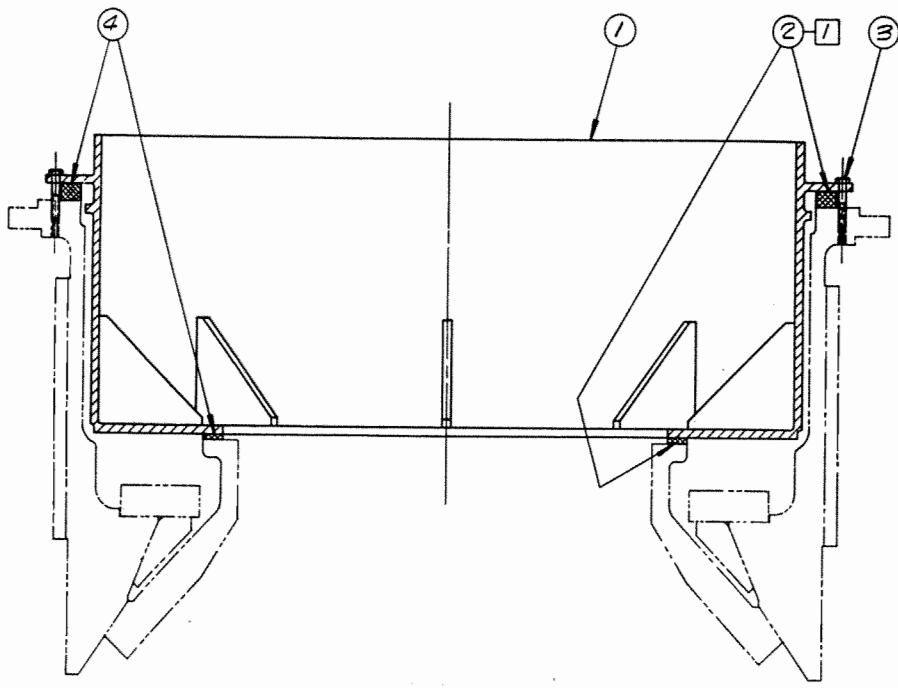
REMOVED 1101808 0114	REMOVED 1101808 0114	REMOVED 1101808 0114	REMOVED 1101808 0114
ADDED DIM 10, ADDED WELD SYMBOL	ADDED DIM 10, ADDED WELD SYMBOL	ADDED DIM 10, ADDED WELD SYMBOL	ADDED DIM 10, ADDED WELD SYMBOL
CHANGED TO SHOW CHAMFER ON ADAPTER RING	CHANGED TO SHOW CHAMFER ON ADAPTER RING	CHANGED TO SHOW CHAMFER ON ADAPTER RING	CHANGED TO SHOW CHAMFER ON ADAPTER RING
ISSUED	ISSUED	ISSUED	ISSUED
REV.	REV.	REV.	REV.
DESCRIPTION OF CHANGE	DESCRIPTION OF CHANGE	DESCRIPTION OF CHANGE	DESCRIPTION OF CHANGE
LOC.	LOC.	LOC.	LOC.
DATE	DATE	DATE	DATE
BY	BY	BY	BY
DATE	DATE	DATE	DATE
BY	BY	BY	BY
DATE	DATE	DATE	DATE

710-94280007

ALL INFORMATION CONTAINED ON THIS DRAWING IS CONSIDERED TO BE BOTH CONFIDENTIAL AND PROPRIETARY BY REMCOR INC. NO USE OR REPRODUCTION THEREOF MAY BE MADE WITHOUT THE EXPRESS WRITTEN CONSENT OF REMCOR INC.

BILL OF MATERIAL

ITEM NO.	PART NUMBER	QTY REQ	PART NAME	SIZE	WT EACH
	1094280007		HOPPER ASSEMBLY		522
①	1044180123	1	HOPPER	A3	518
②	1076340069	4	SEAL STRIP	A3	.8
③	1003723606	12	HHCS M14 X 2 X 70 LG		-
④	1004590250	AR	ADHESIVE		-



① WHEN ASSEMBLING ITEM ② CUT LENGTHS TO SUIT TO MAKE A COMPLETE RING AND THEN CEMENT TO HOPPER WITH ADHESIVE ITEM ④.

PROTOTYPE

METRIC
ALL DIMENSIONS
IN MILLIMETERS

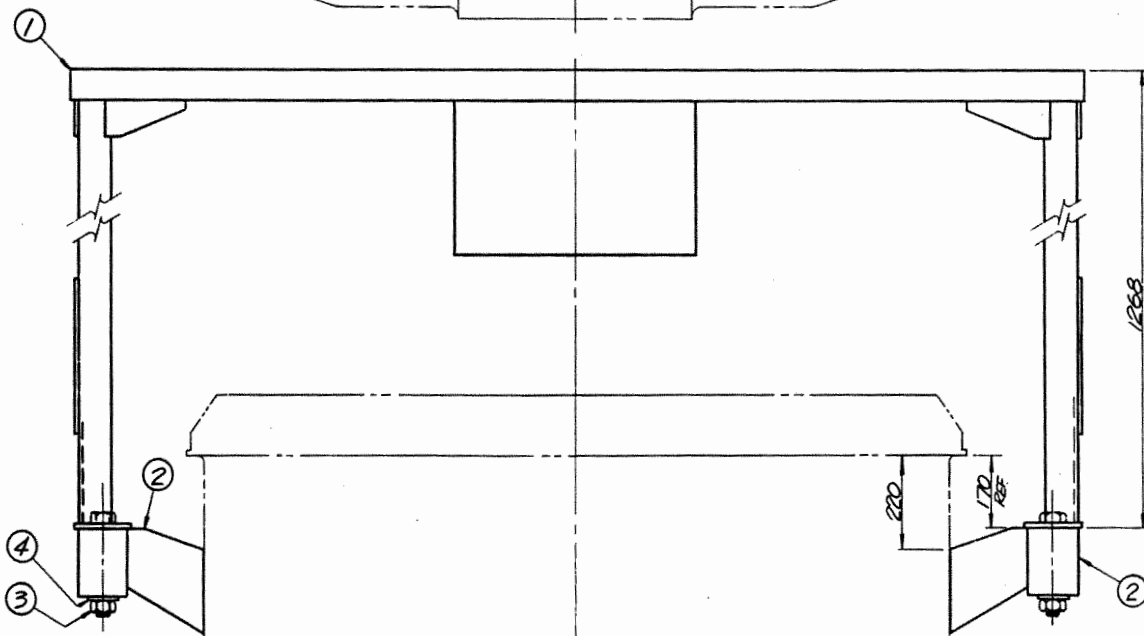
Remcor Process Machinery
Division

IMPLIED TOLERANCES FINISHED DIMENSIONS MILLIMETERS XXX.0 MIN 3.2 XXX.0 MAX 3.2 .X 1.0 .XX 0.5 .XXX 0.25		DRAFTSMAN DATE 12/20/80 CHECKED C. DAVIS DATE 4 DEC 80 APPROVED DATE AS Y MACHINE FINISH UNLESS OTHERWISE STATED PLANE ANGLES 1 DIA. DEGREE 3/4 ANGLE PROJECTION SCALE 1:5	SUPERSEDES ASSEMBLY GR 15 CRUSHER PRODUCT 1352 OMNICON DESCRIPTION PART NAME HOPPER ASSEMBLY DRAWING NUMBER 110 94280007 REV
--	--	---	---

SURFACE PREPARATION, CLEANING
AND PAINTING SYMBOLS ACCORDING
TO COMPANY STANDARD 82-01-01

ISSUED	BY R. GURAN	DATE 12/20/80	29023
DESCRIPTION OF CHANGE	LOC	DATE	REV

ALL INFORMATION CONTAINED ON THIS DRAWING IS CONSIDERED TO BE BOTH CONFIDENTIAL AND PROPRIETARY BY *Merck & Co., Inc.* NO USE OR REPRODUCTION THEREOF MAY BE MADE WITHOUT THE EXPRESS WRITTEN CONSENT OF *Merck & Co., Inc.*



**SURFACE PREPARATION, CLEANING
AND PAINTING SYMBOLS ACCORDING
TO COMPANY STANDARD 03-01-01.**

BILL OF MATERIAL					
ITEM NO.	PART NUMBER	QTY. REQ.	PART NAME	QWLT. SIZE	WT. EACH IN
10	9428 0031		FEED PLATFORM ASSY		323
10	5781 5200	1	FEED PLATFORM	A0	255
10	7810 0084	4	SUPPORT	A3	17
10	0301 0081	4	HEX NUT M36		
10	0305 6061	4	WASHER M36		

1. ASSEMBLE SUPPORT ITEM ② TO FEED PLATFORM ITEM ①.
2. POSITION ASSEMBLY AS SHOWN AND WELD SUPPORT ITEM ② TO FRAME SHELL.

METRIC
ALL DIMENSIONS
IN MILLIMETRES

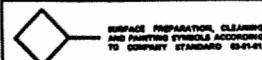
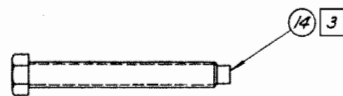
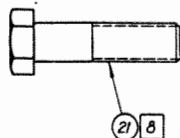
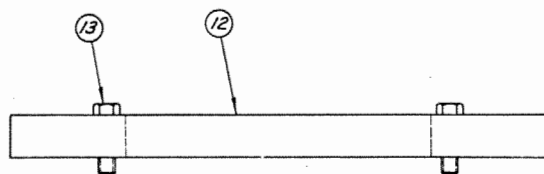
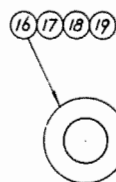
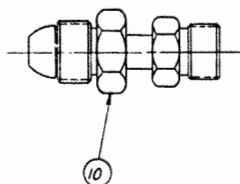
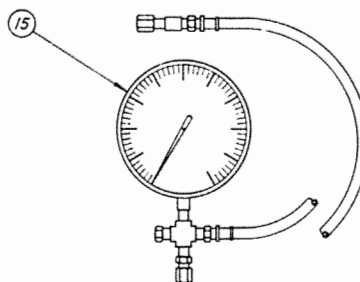
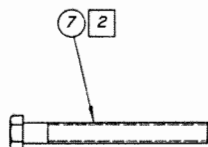
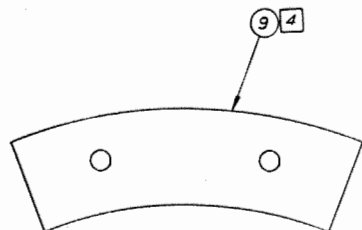
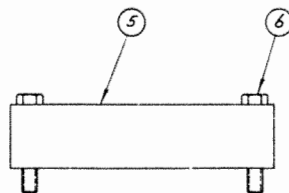
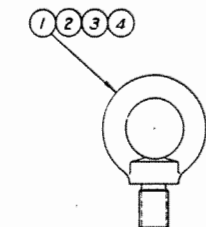
Nordberg

Nordberg Inc.
P.O. Box 383
Milwaukee, WI 53201

IMPLIED TOLERANCES Finished Dimensions		DRAWN <i>24</i> DATE <i>11/28/82</i>		SUPERSEDES		ASSEMBLY <i>GR8</i>	
MILLIMETRES		CHECKED <i>E S</i>		SUPERSEDED BY		<i>CRUISER</i>	
XXX.X.D BOOI + 1.5 XXX.X BOOI + 1.5 X + 0.5 .XX + 0.13		DATE <i>8 JAN 90</i>		PRODUCT <i>1352 CANNIKONE</i>			
<input checked="" type="checkbox"/> MACHINE FINISH UNLESS OTHERWISE NOTED		APPROVED DATE		DESCRIPTION			
PART NAME							
<i>FEED PLATFORM ASSY</i>							
<input checked="" type="checkbox"/> 3rd ANGLE PROJECTION		DWG. SIZE		DRAWING NUMBER		REV.	
SCALE <i>1:6</i>		A1		PREFIX <i>110</i>		CODE <i>942800031</i>	
				SUFFIX			

110 94280032

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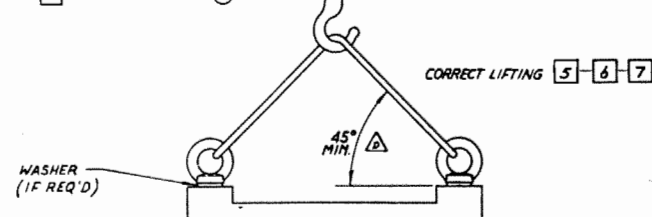



SURFACE PREPARATION, CLEANING AND PAINTING SYMBOLS ACCORDING TO COMPANY STANDARD 80-01-01.

BILL OF MATERIAL

ITEM NO.	PART NUMBER	QTY	PART NAME	REV	REV DATE
10	9428 0032		TOOLS ASSEMBLY		220
1	10 03183910	3	RING BOLT M10		0.1
2	10 03183920	4	RING BOLT M20		0.5
3	10 03183930	2	RING BOLT M30		1.7
4	10 03183936	3	RING BOLT M36		2.7
5	10 8096 0054	1	HEAD LIFTING PLATE	A3	13
6	10 0372 3106	6	HEX HEAD CAPSCREW M12x70		0.1
7	10 1918 3750	3	BACKING OUT BOLT	A3	0.2
8					
9	10 8642 0473	3	COUNTERWEIGHT SEGMENT	A2	7
10	10 1028 1790	1	ADAPTOR	A4	
11					
12	10 3096 0056	1	ECCENTRIC LIFTING RING	A3	85
13	10 0372 4606	3	HEX HEAD CAPSCREW M20x70		0.2
14	10 6726 9101	3	JACKSCREW	A4	.5
15	10 9429 0022	1	CHARGING ASSEMBLY	A4	
16	10 03056 028	3	WASHER M10		
17	10 03056 043	4	WASHER M20		
18	10 03056 055	2	WASHER M30		
19	10 03056 061	3	WASHER M36		
20					
21	10 0372 5655	3	HEX HD CAPSCREW M30x120		

- 2 ITEM 7 BACKING OUT BOLT IS TO BE USED TO DISASSEMBLE SOCKET LINER AND HEAD BALL
- 3 ITEM 14 JACKSCREW IS TO BE USED TO DISASSEMBLE SOCKET
- 4 USE CTRWEIGHT SEGMENT ITEM 9 IF ADDITIONAL WEIGHT IS NEEDED FOR BALANCING.
- 5 LIFTING RING BOLTS MUST ALWAYS BE SCREWED TIGHT IN SUCH A WAY THAT THEY FIT FLUSH AGAINST THE BEARING FACE
- 6 ANY LOADING AT RIGHT ANGLES TO THE PLANE OF THE EYE IS NOT PERMISSIBLE
- 7 WASHERS ITEMS 16 17 18 AND 19 SHALL BE INSERTED IF NECESSARY TO EXCLUDE THE POSSIBILITY OF INCORRECT LOADING
- 8 HEX HD CAPSCREW ITEM 21 IS TO BE USED FOR PULLING COUNTERSHAFT BOX INTO FRAME.

METRIC
ALL DIMENSIONS
IN MILLIMETERSReconord Process Machinery
Division

IMPLIES TOLERANCES FINISHED DIMENSIONS MILLIMETERS		DRAWN S.S. DATE 20 MAR 81		SUPERSEDES		ASSEMBLY GR 20	
REEL: 01 001 XREF: K 000 J.E.		CHECKED C. Davis DATE 25 MAR 81		SUPERSEDED BY		CRUSHER	
APPROVED DATE		PRODUCT		1352 OMNICON			
DESCRIPTION		PART NAME					
N/S ✓ IMAGING FINISH UNLESS OTHERWISE NOTED FLAME ANGLE 1 ONE DEGREE		TOOLS ASSEMBLY					
 3rd ANGLE PROJECTION		SHEET SIZE		DRAWING NUMBER		SUFFIX	
SCALE NONE		PREFIX A1		CODE 110		9428 0032	

1	CHANGED ITEM 9 NOTE REMOVED ITEM 8	TOR 19 AUG 81	45773
2	ADDED 'MIN' TO 45° LIFTING ANGLE.	R.G. 26 MAR 81	40806
3	ITEM 10 1028 1790 WAS PULLING PL. IT IS 4.20 DELATED	S.S. 17 MAR 81	38 849
4	ITEM 11 HEX HD CAPSCREW WAS SAFETY BLOCK, ADDED NOTE 21	S.S. 22 MAR 81	29439
5	ADDED ITEM 21	S.S. 22 MAR 81	29295
6	ISSUED	S.S. 22 MAR 81	29225
REV.	DESCRIPTION OF CHANGE	LOC	DATE

110-94280056

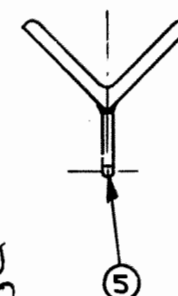
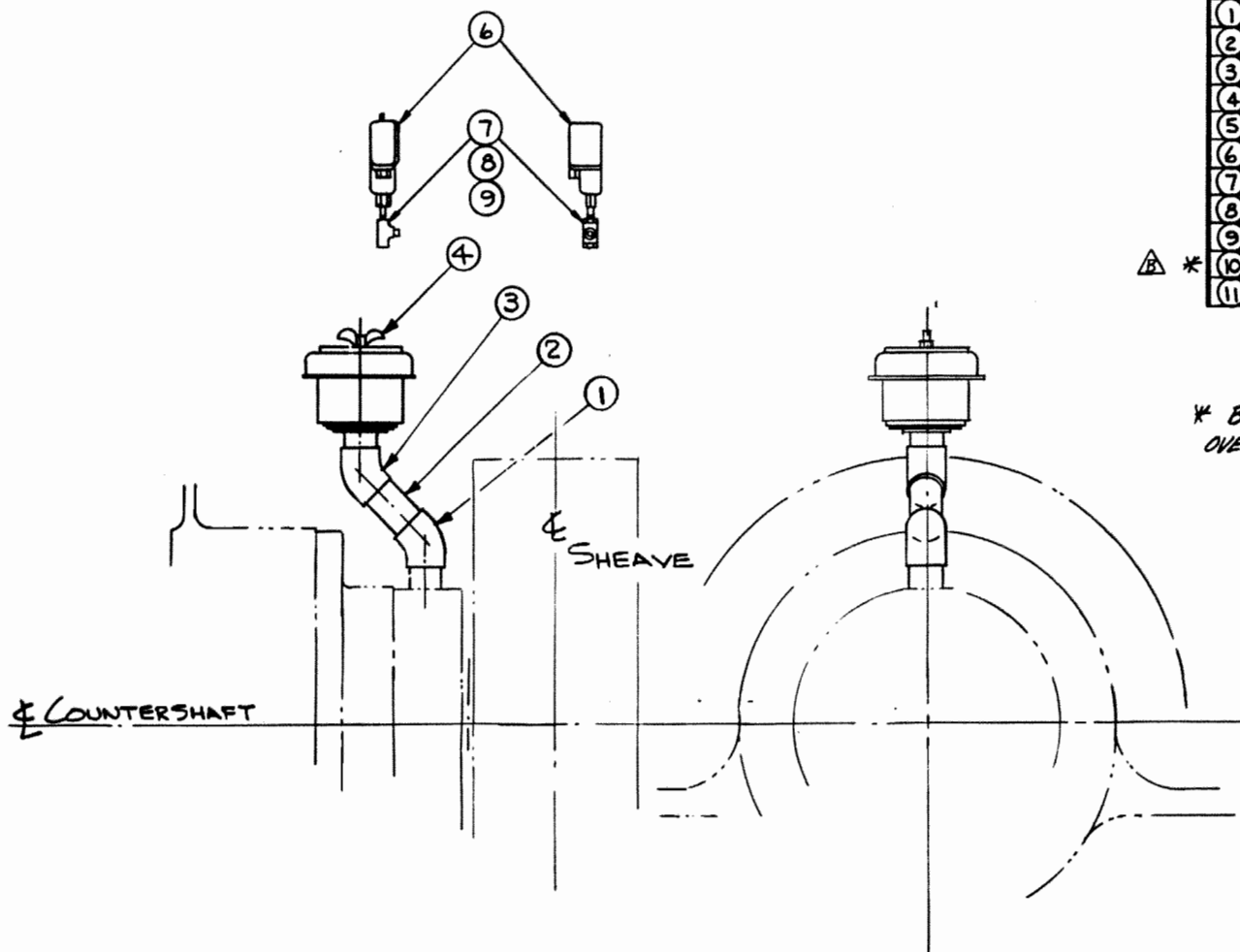
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BILL OF MATERIAL

ITEM NO.	PART NUMBER	QTY REQ	PART NAME	SIZE	WT EACH
	1094280056		ACCESSORIES ASSY.		
(1)	1031334249	1	ELBOW ASSEMBLY	A3	5
(2)	1001551440	1	NIPPLE 1 1/2 x 4		.4
(3)	1001535081	1	ELBOW 1 1/2 x 45°		
(4)	1021880021	1	AIR BREATHER	A4	
(5)	1018780275	4	SAFETY BLOCK	A3	2
(6)	1005194257	1	PRESSURE SWITCH	A4	
(7)	1001551330	1	NIPPLE 1/4 x 2		
(8)	1001575031	1	TEE 1/4		
(9)	1001558641	1	PIPE PLUG 1/4		
(10)	1003722557	6	CAPSCREW M10x35		
(11)					

△ *

* BREAK-AWAY SCREWS (SHEAR BOLTS) FOR PREVENTING OVERLOAD DAMAGE TO THE CLUTCH, SPINDLE, ETC...




Replaced by
9429 0280

METRIC
ALL DIMENSIONS
IN MILLIMETERS

Ramrod Process Machinery Division	
DATE 12-25-80	ASSEMBLY GR. 21
DATE 2 SEPT 82	CRUSHER
DATE	PRODUCT 1352 OMNICON
DESCRIPTION	
PART NAME	
ACCESSORIES ASSY.	
SIZE	QTY
A2	11094280056
B	


REV.	DESCRIPTION OF CHANGE	LOC.	DATE	REV. ORDER NUMBER
1	ADDED IT (10) 03722557		28 JUN 84	47860
2	REMOVED IT (10) 7007 305	C-6	28 JUN 84	43615
3	ISSUED		3 SEPT 82	40654


SURFACE PREPARATION, CLEANING AND PAINTING SYMBOLS ACCORDING TO COMPANY STANDARD 82-01-01.



H	G	F	E	D	C	B	A		
ALL INFORMATION CONTAINED ON THIS DRAWING IS CONSIDERED TO BE BOTH CONFIDENTIAL AND PROPRIETARY BY METSO MINERALS (MILWAUKEE) INC. NO USE OR REPRODUCTION THEREOF MAY BE MADE WITHOUT THE EXPRESS WRITTEN CONSENT OF METSO MINERALS (MILWAUKEE) INC.				BILL OF MATERIAL					
 SURFACE PREPARATION, CLEANING AND PAINTING SYMBOLS ACCORDING TO COMPANY STANDARD 03-01-01.				ITEM NO.	PART NUMBER	QTY REQ.	PART NAME	DWG. SIZE	WT. EACH KG
					1094280033		ID PLATE ASSEMBLY		

ITEM NO.	PART NAME	NO. REQ'D	PART CODE NO.	DWG. SIZE
1	CRUSHER NAME PLATE. TO BE FASTENED TO MAIN FRAME SHELL, 180° FROM COUNTER-SHAFT BOX. BOTTOM OF PLATE TO BE POSITIONED 100 mm ABOVE THE LOWER MAIN FRAME FLANGE.	1	56371174	3
2	DANGER PLATE. TO BE FASTENED TO MAIN FRAME SHELL 50 mm FROM THE CRUSHER NAME PLATE AND AT THE SAME ELEVATION.	1	56372886	3
3	COUNTERSHAFT ROTATION INSTRUCTION DECAL. TO BE APPLIED TO THE END OF THE COUNTERSHAFT. MAKE SURE THE ARROW IS POINTING IN THE CORRECT DIRECTION.	1	56372827	1
4	RED ACCENT STRIPE. DECAL OR PAINT - 152 mm HIGH STRIPE TO BE APPLIED OR PAINTED ON THE DUST SHELL.	4	29300110	
5	NORDBERG DECAL. DECAL - 152 mm HIGH, TO BE APPLIED BETWEEN THE RED ACCENT STRIPE ON THE OUTSIDE DIAMETER OF THE DUST SHELL. DECALS TO BE LOCATED 180° APART WITH 76 mm SPACING BETWEEN DECAL AND RED ACCENT STRIPE.	2	29300107	3
6	DANGER DECAL. TO BE APPLIED TO THE ACCUMULATOR BRACKETS. BOTTOM OF DECAL TO BE POSITIONED 10 mm ABOVE THE BOTTOM OF THE BRACKET.	4	56372887	3
7	DANGER PLATE. TO BE FASTENED TO THE MAIN FRAME SHELL. TO BE CENTERED BETWEEN TWO TRAMP RELEASE CYLINDERS 75 mm BELOW THE UPPER FLANGE AND AT ALL FOUR CORNERS.	4	56373095	3

ITEM NO.	PART NAME	NO. REQ'D	PART CODE NO.	DWG. SIZE
8	DANGER PLATE. TO BE FASTENED TO THE TOP OF THE ADJUSTMENT CAP, 90° FROM LIFTING DECALS.	4	56372892	3
9	DRIVE SCREWS. FOR ITEMS 1, 3, 8, 9 AND 12.	44	3130566	
10	LIFTING DECAL. TO BE APPLIED TO THE TOP OF THE ADJUSTMENT CAP, 50 mm FROM THE ADJUSTMENT CAP LIFTING LUGS. DECALS TO BE LOCATED 180° APART.	2	56372888	3
11	PATENT PLATE. TO BE FASTENED TO MAIN FRAME SHELL, CENTERED & LOCATED 12 mm BENEATH CRUSHER NAME PLATE, 56371174.	1	56372942	A3

DUAL DIMENSION	mm	N9 250 MACHINE FINISH UNLESS OTHERWISE STATED
IMPLIED TOLERANCES FINISHED DIMENSIONS	inches"	
MILLIMETRES		ANGLE TOLERANCE COMPANY STD 02-02-13
XXX. (≥500)	± 3	 3RD ANGLE PROJECTION
XXX. (<500)	± 1.5	
.X	± 0.5	
.XX	± 0.13	
INCHES		SCALE
.XX (≥19.68)	± 1.2	NONE
.XX (<19.68)	± 0.6	
.XXX	± 0.020	
.XXXX	± 0.005	

		Metso Minerals Inc. 3073 S. Chase Ave. Milwaukee, WI 53207		DESCRIPTION	
DRAWN	MMM	SUPERSEDES	ASSEMBLY	PART NAME	
DATE	03FEB94		GR 22	ID PLATE ASSEMBLY	
CHKD	MMM	SUPERSEDED BY	CRUSHER		
DATE	03FEB94				
APPD		PRODUCT	1144 & 1352 OMNICON		
DATE					
				DWG. SIZE	REV.
				A3	H
				PREFIX	SUFFIX
				110	
				DRAWING NUMBER	
				CODE	
				94280033	

1		REDRAWN & REVISED	LOC	BY	DATE	ENG. ORDER NUMBER
				MMM	03FEB94	56435
MF	REV.	DESCRIPTION OF CHANGE				

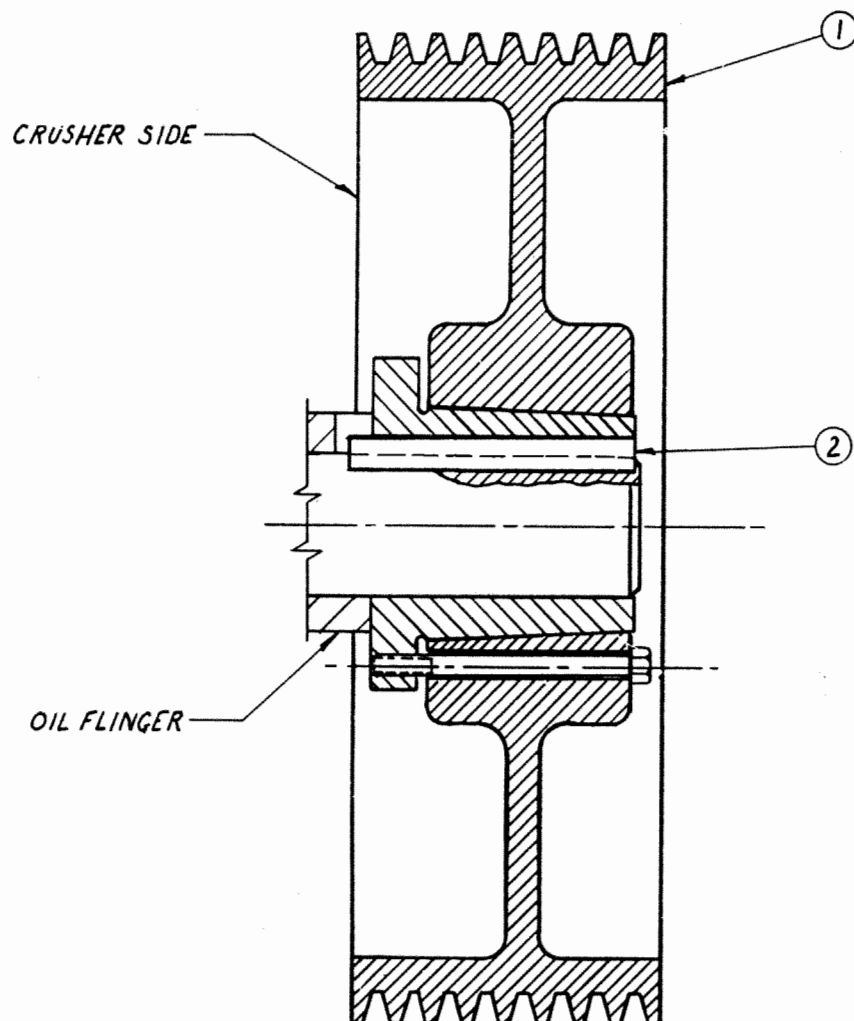
CAD 03/01

NO. 942800

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BILL OF MATERIAL

ITEM NO.	PART NUMBER	QTY REQ.	PART NAME	DWG. SIZE	WT. EACH LBS. EAG.
1	094280076	1	DRIVE ASSEMBLY		357
(1)	59238770	1	CRUSHER SHEAVE	2	355
(2)	1047007975	1	KEY	A3	2



IMPLIED TOLERANCES Finished Dimensions DECIMAL INCH .X ± .120 .XX ± .080 .XXX ± .020 .XXXX ± .008 MILLIMETRES XXX. > 900 ± .3 XXX. < 900 ± 1.5 .X ± 0.8 .XX ± 0.13		Rexnord Process Machinery Division DRAWN <i>F.S.</i> DATE <i>6-29-83</i> CHECKED <i>[Signature]</i> DATE <i>6-29-83</i> APPROVED <i>[Signature]</i> DATE <i>6-29-83</i> DESCRIPTION PART NAME DRIVE ASSEMBLY	
MACHINE FINISH UNLESS OTHERWISE STATED (M)		ASSEMBLY <i>CR. 23</i> PRODUCT <i>1352</i> DWG. SIZE 310 94280076	

SURFACE PREPARATION, CLEANING AND PAINTING SYMBOLS ACCORDING TO COMPANY STANDARD 03-01-01.

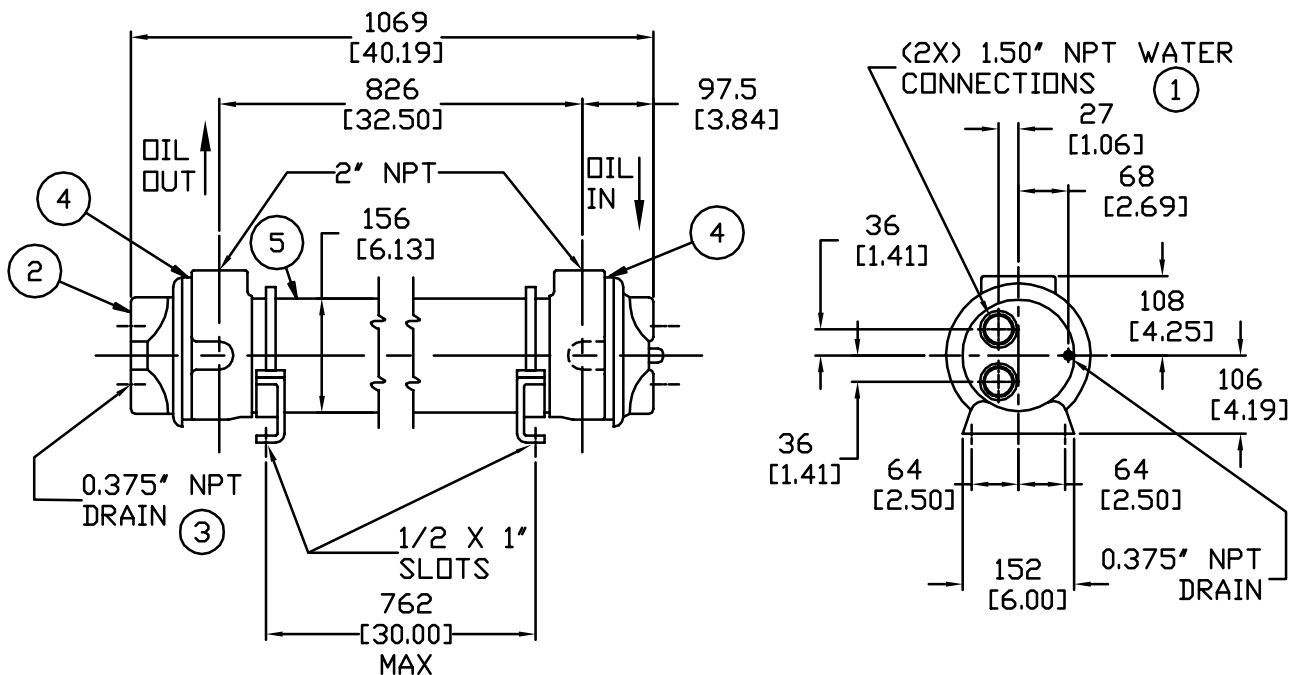
ISSUED	BY <i>F.S.</i>	ENG. ORDER	42380
ME	REV	DESCRIPTION OF CHANGE	SCALE

BILL OF MATERIAL

ITEM NO.	PART NAME	QTY REQ	PART CODE	DWG SIZE
	HEAT EXCHANGER (COOLER) WHITLOCK - AMETEK HEAT TRANSFER EQUIPMENT DIV, MODEL No. 6-Y-36. TYPE MHT-4-B-C1, 4 PASS APPROXIMATE WEIGHT 100 LBS. [45.36 Kg] (WITH SPECIAL DRAIN HOLES IN BONNET, AND 90-10 COPPER NICKEL CORE ASSEMBLY).	1	2674 0073 (A-26517)	A4

REPLACEMENT PARTS

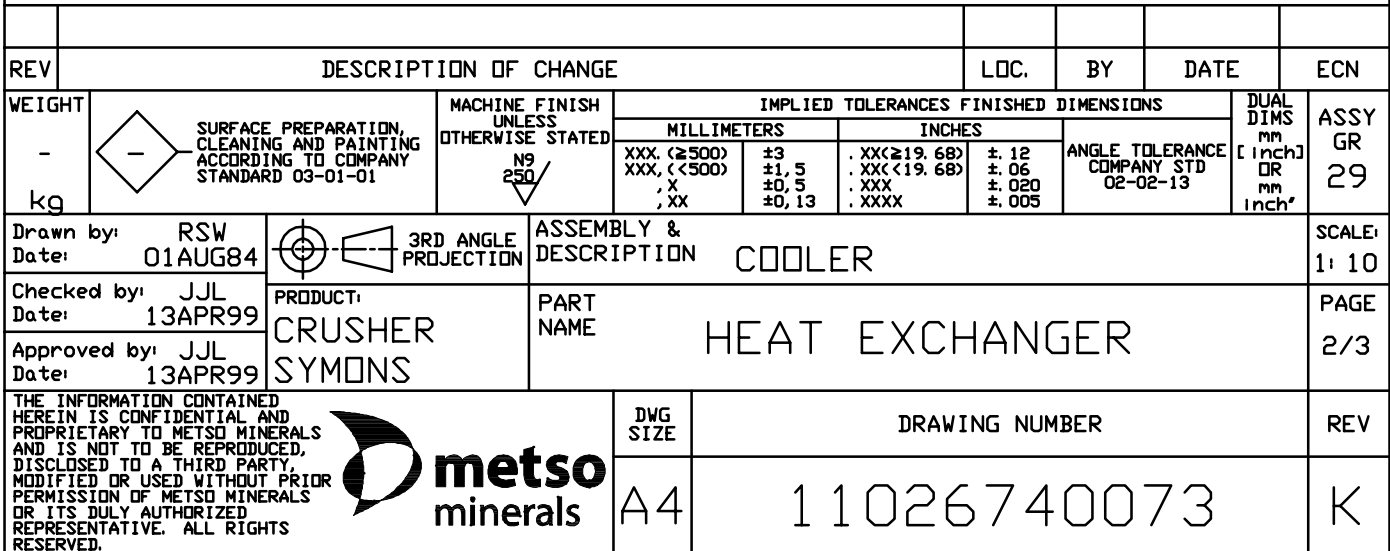
1	FRONT BONNET, 4 PASS 1 1/2" NPT	1	1027453620 (3058-07-306-0026)	-
2	REAR BONNET, 4 PASS	1	2745 3621 (01BBOOF6)	-
3	ZINC ANODE	2	1052 0001 (ZIZ11Y)	-
4	GASKET, 4 PASS	2	3525 6450 (01C141B)	-
5	CORE ASSEMBLY	1	NOT AVAILABLE AS REPLACEMENT PART	-



K	REVISED VENDOR PART NUMBER, (3058-07-306-002) WAS (01B600F6).		MMM	26JUN15	114888																	
REV	DESCRIPTION OF CHANGE		LOC.	BY	DATE																	
WEIGHT	SURFACE PREPARATION, CLEANING AND PAINTING ACCORDING TO COMPANY STANDARD 03-01-01	MACHINE FINISH UNLESS OTHERWISE STATED N9 250	IMPLIED TOLERANCES FINISHED DIMENSIONS		DUAL DIMS mm [inch] OR mm inch																	
- kg			<table border="1"> <tr> <th colspan="2">MILLIMETERS</th> <th colspan="2">INCHES</th> </tr> <tr> <td>XXX, (>500)</td> <td>±3</td> <td>.XX(>19.68)</td> <td>±.12</td> </tr> <tr> <td>XXX, (<500)</td> <td>±1, 5</td> <td>.XX(<19.68)</td> <td>±.06</td> </tr> <tr> <td>.X</td> <td>±0, 5</td> <td>.XXX</td> <td>±.020</td> </tr> <tr> <td>.XX</td> <td>±0, 13</td> <td>.XXXX</td> <td>±.005</td> </tr> </table>			MILLIMETERS		INCHES		XXX, (>500)	±3	.XX(>19.68)	±.12	XXX, (<500)	±1, 5	.XX(<19.68)	±.06	.X	±0, 5	.XXX	±.020	.XX
MILLIMETERS		INCHES																				
XXX, (>500)	±3	.XX(>19.68)	±.12																			
XXX, (<500)	±1, 5	.XX(<19.68)	±.06																			
.X	±0, 5	.XXX	±.020																			
.XX	±0, 13	.XXXX	±.005																			
Drawn by: RSW Date: 01AUG84		3RD ANGLE PROJECTION		ASSEMBLY & DESCRIPTION COOLER																		
Checked by: JJL Date: 13APR99		PRODUCT: CRUSHER SYMONS		PART NAME HEAT EXCHANGER																		
Approved by: JJL Date: 13APR99				SCALE: 1: 10																		
THE INFORMATION CONTAINED HEREIN IS CONFIDENTIAL AND PROPRIETARY TO METSO MINERALS AND IS NOT TO BE REPRODUCED, DISCLOSED TO A THIRD PARTY, MODIFIED OR USED WITHOUT PRIOR PERMISSION OF METSO MINERALS OR ITS DULY AUTHORIZED REPRESENTATIVE. ALL RIGHTS RESERVED.		DWG SIZE A4		DRAWING NUMBER 11026740073																		
				REV K																		

BILL OF MATERIAL				
ITEM NO.	PART NAME	QTY REQ	PART CODE	DWG SIZE
	HEAT EXCHANGER (COOLER) AMERICAN STANDARD HEAT TRANSFER DIVISION, MODEL 06036 HCF, 4 PASS APPROXIMATE WEIGHT 90 LBS. [40.82 Kg] (WITH SPECIAL DRAIN HOLES IN BONNET AND 90-10 COPPER NICKEL CORE ASSEMBLY).	1	2674 0073 (5-142-06-036-146)	A4

1	IN-OUT BONNET	1	2745 3622	-
2	REVERSING BONNET	1	2745 3623	-
3	ZINC ANODE	2	1052 0003	-
4	IN-OUT GASKET	1	3525 6500	-
5	REVERSING GASKET	1	3525 6501	-
6	CORE ASSEMBLY	1	NOT AVAILABLE AS REPLACEMENT PART	-

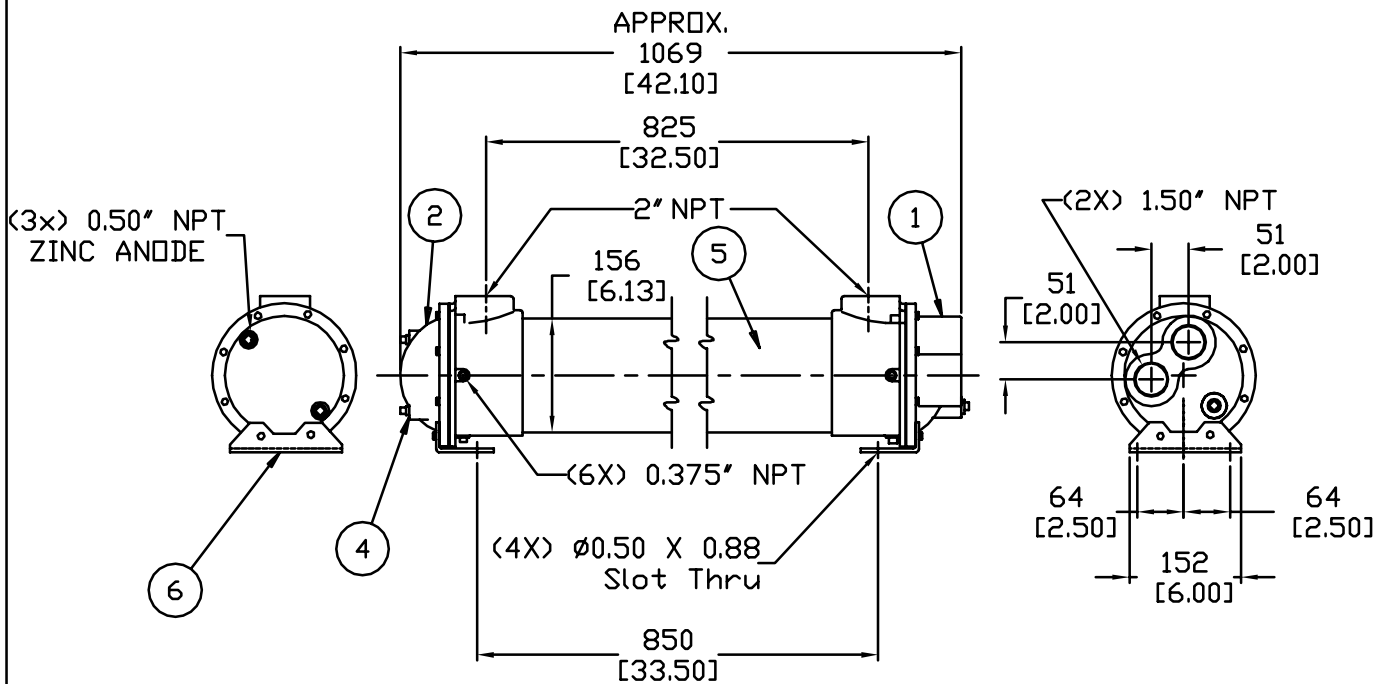


BILL OF MATERIAL

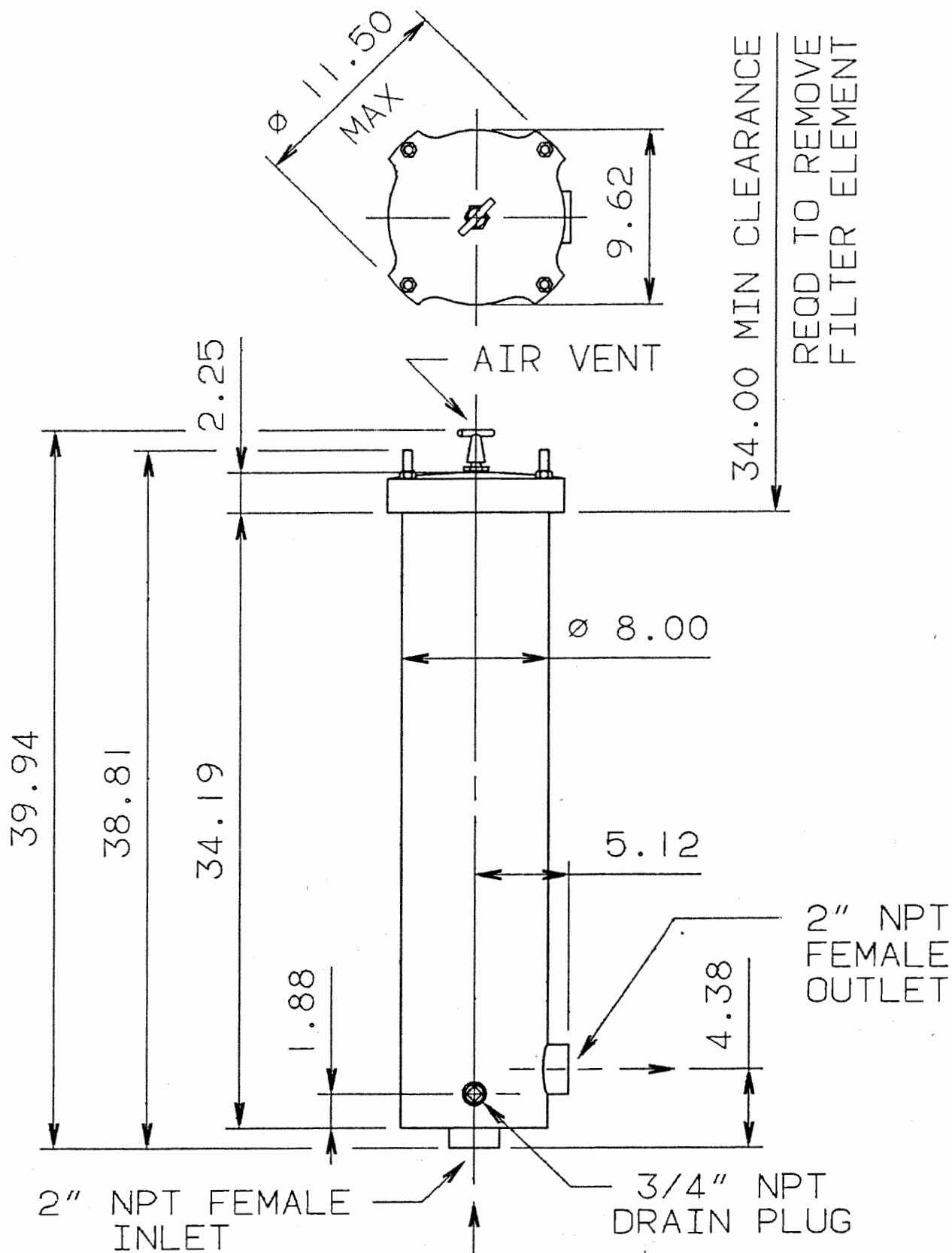
ITEM NO.	PART NAME	QTY REQ	PART CODE	DWG SIZE
	HEAT EXCHANGER (COOLER) AMERICAN INDUSTRIAL HEAT TRANSFER INC. MODEL No. AA1236-19269, 4 PASS APPROX. WEIGHT 120 LBS. [54.43 Kg] 90/10 Cu. Ni. CORE ASSEMBLY	1	2674 0073 (AA1236-19269)	A4

REPLACEMENT PARTS

1	BONNET (IN/OUT)	1	N02154762 (204-0005)	-
2	BONNET (RETURN)	1	N02154763 (204-0006)	-
3	GASKET (BOTH)	2	N02154764 (302-1004)	-
4	ZINC ANODE	3	N02154765 (301-0003)	-
5	BUNDLE (90/10 Cu. Ni.)	1	N02154766 (221-3517)	-
6	KIT FOOT BRACKET, ASSEMBLY	1	N02154767 (204-0076)	-



REV	DESCRIPTION OF CHANGE				LOC.	BY	DATE	ECN
WEIGHT	SURFACE PREPARATION, CLEANING AND PAINTING ACCORDING TO COMPANY STANDARD 03-01-01	MACHINE FINISH UNLESS OTHERWISE STATED N9 250	IMPLIED TOLERANCES FINISHED DIMENSIONS				DUAL DIMS mm [inch] OR mm inch	ASSY GR 29
- kg			MILLIMETERS		INCHES			
			XXX, (>500) XXX, (<500) , X , XX	±3 ±1, 5 ±0, 5 ±0, 13	. XX (>19. 68) . XX (<19. 68) . XXX . XXXX	±. 12 ±. 06 ±. 020 ±. 005	COMPANY STD 02-02-13	
Drawn by: RSW Date: 01AUG84	3RD ANGLE PROJECTION		ASSEMBLY & DESCRIPTION COOLER					SCALE: 1: 10
Checked by: JJL Date: 13APR99	PRODUCT: CRUSHER SYMONS		PART NAME HEAT EXCHANGER					PAGE 3/3
Approved by: JJL Date: 13APR99								
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metso minerals			A4	11026740073				K



OIL FILTER
ASSEMBLY

94361000

SLU-506

Nordberg[®]

Nordberg Inc.
P O. Box 383
Milwaukee, WI 53201

G	E.O. 58044	23JUN95

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"S" SHEET		PAGE 2 OF 4	94361000	
ITEM NO.	PART NAME	QTY REQ'D	PART CODE	DWG SIZE
1	OIL FILTER: CONTAINS ONE THROWAWAY, SIZE 4L, FILTER ELEMENT WITH 50 MICRON COTTON FLANNEL MATERIAL. ELEMENT HAS A TOTAL FILTERING AREA OF 1092 SQUARE INCHES. FILTER IS EQUIPPED WITH 3/4" HEX BUSHING, 1/4" AIR VENT VALVE AND 3/4" DRAIN PLUG. FILTER IS NOT EQUIPPED WITH INTERNAL BYPASS RELIEF VALVE. INLET & OUTLET CONNECTIONS ARE FEMALE, 2" NPT. APPROXIMATE WEIGHT - 90 lbs.	1	3877 080	1
<u>WHEN ORDERING REPLACEMENT FILTER ELEMENTS, ORDER:</u>				
1.	FILTER ELEMENT: THROWAWAY, 50 MICRON COTTON FLANNEL MATERIAL. APPROXIMATE WEIGHT - 10 lbs.	1	3894 081	
2.	"O" RING: FOR USE BETWEEN COVER & SHELL ASSEMBLY.	1	3571 3051	
	OR			
	FLAT GASKET: FOR USE BETWEEN COVER & SHELL ASSEMBLY.	1	3586 1790	1
(SPECIFY WHICH STYLE OF SEAL THE FILTER WAS FURNISHED WITH)				

THROWAWAY ELEMENT
50 MICRON
45 GPM @ 8 PSI DROP

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OIL FILTER ASSEMBLY	
SLU-506	94361000

INSTRUCTIONS FOR OPERATING OIL FILTER WITH THROWAWAY ELEMENTS

GOOD PERFORMANCE IS DEPENDENT UPON PROPER INSTALLATION,
GOOD MAINTENANCE AND ADHERANCE TO THESE INSTRUCTIONS.

INLET AND OUTLET ARE MARKED ON THE FILTER, BE SURE TO
CONNECT THEM PROPERLY.

THE MAXIMUM WORKING PRESSURE OF THIS FILTER IS 150 PSI.

WHEN TO CLEAN FILTER

A PRESSURE GAUGE SHOULD BE INSTALLED IN BOTH THE INLET AND
OUTLET PIPING CLOSE TO THE FILTER TO INDICATE DIFFERENTIAL
PRESSURE. IF THE DIFFERENCE BETWEEN INLET AND OUTLET
PRESSURE IS 25 LBS., THE ELEMENT IS CLOGGED (PROVIDED
RUNNING TEMPERATURE AND VISCOSITY ARE NORMAL) AND SHOULD
BE REPLACED.

CLEANING THE FILTER

OBSERVE CAREFULLY HOW THE FILTER IS ASSEMBLED WHEN IT IS
TAKEN APART THE FIRST TIME.

1. OPEN AIR VENT VALVE AT TOP OF FILTER, THEN OPEN THE
DRAIN VALVE AT THE BOTTOM OF THE FILTER PIPING AND
COMPLETELY DRAIN THE UNIT.
2. REMOVE THE FILTER COVER, THEN THE PRESSURE PLATE
ASSEMBLY AND LIFT OUT THE DIRTY ELEMENT. USE THE
PLASTIC BAG THE REPLACEMENT ELEMENT IS SHIPPED IN
FOR DISPOSAL OF THE DIRTY ELEMENT.
3. PLACE THE NEW ELEMENT IN THE FILTER SHELL, MAKING SURE
IT IS PROPERLY SEATED ON THE INLET SEAT AT THE BOTTOM
OF THE SHELL.
4. POSITION THE PRESSURE PLATE ASSEMBLY ON TOP OF THE
ELEMENT, BEING CAREFUL THAT THE TUBE ON THE PRESSURE
PLATE SLIDES INTO THE HOLE IN THE TOP OF THE ELEMENT.
5. PLACE THE FILTER COVER OVER THE FILTER ITSELF. THE
LARGE SPRING ON THE PRESSURE PLATE WILL COMPRESS AS
THE NUTS ON THE TWO LONG SWING BOLTS ARE TURNED DOWN.
TIGHTEN ALL THE COVER BOLTS EVENLY AND NO TIGHTER
THAN NECESSARY.

OIL FILTER
ASSEMBLY



Nordberg Inc.
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Milwaukee, WI 53201

94361000

SLU-506

E

E.O. 58044

23JUN95

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VENTING:

PERIODICALLY BLEED THE AIR FROM WITHIN THE FILTERS BY OPENING THE VALVE AT THE TOP OF THE FILTERS. IF AIR IS CONTINUOUSLY FORCED INTO THE FILTERS WITH THE OIL, UNSCREW THE VALVE AND CONNECT A SMALL TUBE FROM THERE TO THE OIL TANK. THIS WILL BREAK THE TRAP AND ALLOW THE OIL TO FLOW THROUGH THE ENTIRE FILTERING SURFACE. A LITTLE OIL WILL BLEED OUT WITH THE AIR, SO OBSERVE THE OPERATION CAREFULLY AT FIRST.

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OIL FILTER ASSEMBLY	
SLU-506	94361000

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PARTS LIST Cone Crusher		PAGE 1 OF 4	SLU-736	
ITEM NO.	PART NAME	NO. REQ'D	PART CODE NO.	DWG SIZE
1	OIL TANK ASSEMBLY	1	9446 3796	1
1-1	OIL TANK	1	7915 3228	4
1-2	OIL TANK COVER	1	2736 1079	3
1-3	OIL STRAINER	1	7608 4935	2
1-5	LOCKWASHER .25"	2	0306 4464	
1-6	HEX NUT .25"	2	0302 5011	
1-7	OIL TANK INSPECTION COVER	1	2746 6355	2
1-8	INSPECTION COVER GASKET	1	3568 9349	1
1-9	ADHESIVE	A/R	0459 0280	
1-10	OIL TANK COVER GASKET	2	7640 2080	1
1-11	OIL TANK COVER GASKET	2	7641 4093	1
1-12	PIPE PLUG 1.5"	3	0155 8647	
1-13	PIPE PLUG 2.5"	1	0155 8649	
1-14	NIPPLE 1.5" X 6"	1	0155 1444	
1-15	ELBOW 45° X 1.5"	1	0153 5081	
1-16	NIPPLE 4" X 4.5"	1	0155 1514	
1-17	PIPE PLUG 1"	1	0155 8645	
1-19	RED ACCENT STRIPE. DECAL 6" HIGH STRIPE TO BE APPLIED TO THE SIDE OF THE OIL TANK WHICH HAS THE LARGE DRAIN LINE COUPLING. STRIPE TO BE POSITIONED JUST BELOW THE COUPLING WELD.	3	2930 0110	
1-20	NORDBERG DECAL. DECAL 6" HIGH, TO BE APPLIED BETWEEN THE RED ACCENT STRIPE AND THE RIGHT EDGE OF THE OIL TANK WITH 3" SPACING BETWEEN DECAL AND RED ACCENT STRIPE.	1	2930 0107	3
1-21	LUBRICATION INSTRUCTION DECAL. TO BE APPLIED TO THE SIDE OF THE OIL TANK DIRECTLY BELOW THE NORDBERG DECAL.	1	5687 3096	3
2	SKID WELDMENT	1	7282 0082	3
3	PIPE 1.5" X 14"	1	5458 4002	1
4	OIL LEVEL GAUGE	1	0703 0862	1
5	IMMERSION HEATER	1	3151 2290	1

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PARTS LIST
Cone Crusher

PAGE 2 OF 4

SLU-736

ITEM NO.	PART NAME	NO. REQ'D	PART CODE NO.	DWG SIZE
6	AIR BREATHER	1	2188 0021	1
8	OIL FILTER	1	0387 7080	1
9	OIL COOLER	1	2674 0073	1
10	PUMP & MOTOR ASSEMBLY	1	9436 0114	1
11	TEMPERATURE CONTROL VALVE	1	0169 9170	1
12	BALLCENTRIC VALVE 1.5"	2	0161 1390	1
13	GATE VALVE 1.5"	1	0160 8032	1
14	FILTER & COOLER SUPPORT	2	1289 7950	2
15	SUPPORT CLAMP	2	2470 9835	1
16	HOSE ASSEMBLY .25" X 36"	2	4425 1594	1
17	DIFFERENTIAL PRESSURE GAUGE 0-60 PSI	1	0700 6516	1
18	GAUGE MOUNTING BRACKET	1	2144 0620	2
19	CHECK VALVE 1.5"	1	0160 4582	1
20	PRESSURE GAUGE 0-100 PSI	2	0700 7305	1
21	BALLCENTRIC VALVE 1"	1	0161 1380	1
22	FLOW SWITCH	1	0512 8105	1
23	OIL TANK SUPPORT	2	1569 6855	1
24	OIL PIPE SUPPORT	1	7802 0112	2
25	U-BOLT .25"	1	1970 1150	1
26	COOLER PIPING SUPPORT	3	7802 0096	2
27	U-BOLT .25"	3	1970 0710	1
28	CONTACTOR BRACKET	1	1289 7850	1
29	MAGNETIC CONTACTOR	1	0519 3804	1
30	DIAL THERMOMETER 0° - 200° F	3	0705 1008	1
31	TEMPERATURE SWITCH	1	0519 4645	1
32	FEMALE UNION ELBOW 90° X 1.5"	6	0158 9312	1
34	RELIEF VALVE (SET @ 50 PSI)	2	0167 3992	1
35	PIPE PLUG 1"	2	0155 8645	1
36	STRAIGHT CONNECTOR 1"	1	0510 5778	1
37	HEX BUSHING 1.5" X 1"	3	0150 4350	1
38	ELBOW CONNECTOR 90° X 1"	1	0510 5858	1
39	PIPE NIPPLE 1.5" X 5.5"	3	0155 1443	1
40	HOSE ASSEMBLY 1.5" X 9"	1	4425 7400	1
41	HOSE ASSEMBLY 1.5" X 19"	2	4425 7733	1

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Nordberg Inc.
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Milwaukee, WI 53201

PACKAGE LUBE SYSTEM
MODEL "B"

30-35 G.P.M. - 460 VOLT

9820 0210

SLU-736

E REDRAWN-E.O. 57327 15DEC94

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PARTS LIST
Cone Crusher

PAGE 3 OF 4

SLU-736

ITEM NO.	PART NAME	NO. REQ'D	PART CODE NO.	DWG SIZE
42	TEMPERATURE PIPE	1	5460 2399	2
43	ELBOW 90° X 4"	1	0153 5584	
44	PIPE NIPPLE 4" X 2.88"	1	0155 0042	
45	UNION FEMALE 1.5"	3	0158 5037	
46	ELBOW 90° X 1.5"	8	0153 5579	
48	HEX BUSHING 2" X 1.5"	4	0150 4357	
49	PIPE CROSS 1.5"	4	0152 7037	
50	TEE 1.5"	3	0157 5037	
51	TEE 1"	2	0157 5035	
52	PIPE COUPLING 1"	1	0152 0065	
53	ELBOW 90° X .25"	4	0153 5573	
54	HEX BUSHING 1.5" X .25"	4	0150 4354	
55	PIPE NIPPLE .25" X 1.5"	6	0155 1328	
56	HEX BUSHING 1.5" X .5"	2	0150 4352	
57	WASHER .62"	2	0306 0043	
58	REDUCING TEE 1.5" X 1.5" X 1"	1	0157 8241	
59	FEMALE UNION ELBOW 90° X 1"	2	0158 9035	
60	REDUCER 1.5" X .75"	1	0156 2351	
61	PIPE NIPPLE 1.5" X 2.5"	18	0155 1436	
62	ELBOW 90° X 1"	1	0153 5577	
63	PIPE NIPPLE 1.5" X 3"	1	0155 1438	
64	PIPE NIPPLE 1.5" X 12"	1	0155 1450	
65	PIPE NIPPLE 1.5" X 4"	1	0155 1440	
66	PIPE NIPPLE 1.5" X 7"	4	0155 1445	
67	PIPE NIPPLE 1.5" X 4.5"	2	0155 1441	
68	PIPE NIPPLE 1.5" X 5"	1	0155 1442	
69	PIPE NIPPLE 1" X 3"	2	0155 1404	
70	PIPE NIPPLE 1" X 4.5"	2	0155 1407	
71	PIPE NIPPLE 1" X 5.5"	1	0155 1409	
72	PIPE NIPPLE 1" X 7"	2	0155 1411	
73	PIPE 1" X 15"	1	5457 9312	1
74	ROUND HEAD MACHINE SCREW .25" X .62"	2	0283 7841	
75	LOCKWASHER .25"	10	0306 4464	
76	HEX NUT .25"	8	0302 5011	

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Nordberg Inc.
P.O. Box 383
Milwaukee, WI 53201

PACKAGE LUBE SYSTEM
MODEL "B"

30-35 G.P.M. - 460 VOLT

9820 0210

SLU-736

D	E.O. 58446	13MAR96
C	REDRAWN-E.O. 57327	15DEC94

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PARTS LIST
Cone Crusher

PAGE 4 OF 4

SLU-736

ITEM NO.	PART NAME	NO. REQ'D	PART CODE NO.	DWG SIZE
81	ELECTRICAL FITTINGS & WIRING DIAGRAM	1	9820 0066	3
FOR PROPER LOCATION OF THESE ITEMS REFER TO PACKAGE LUBE SYSTEM MODEL "B" GENERAL ARRANGEMENT PART CODE NO. 9820 1015, DRAWING NO. LU 1465 A.				

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Nordberg

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Nordberg Inc.
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Milwaukee, WI 53201

PACKAGE LUBE SYSTEM
MODEL "B"

30-35 G.P.M. - 460 VOLT

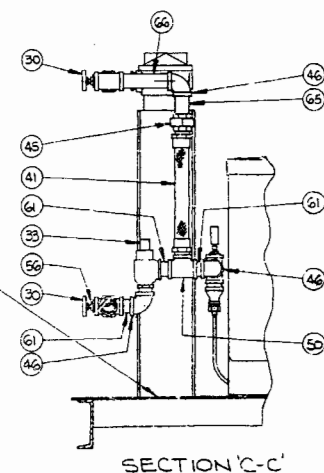
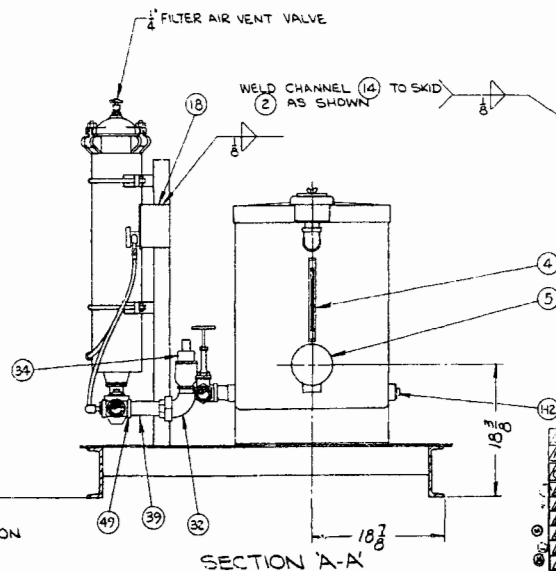
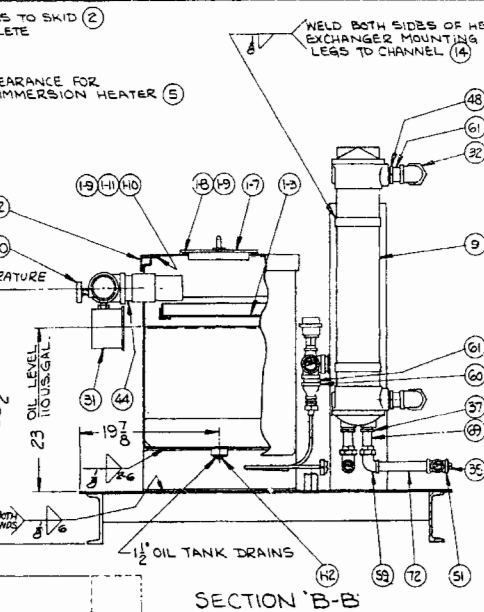
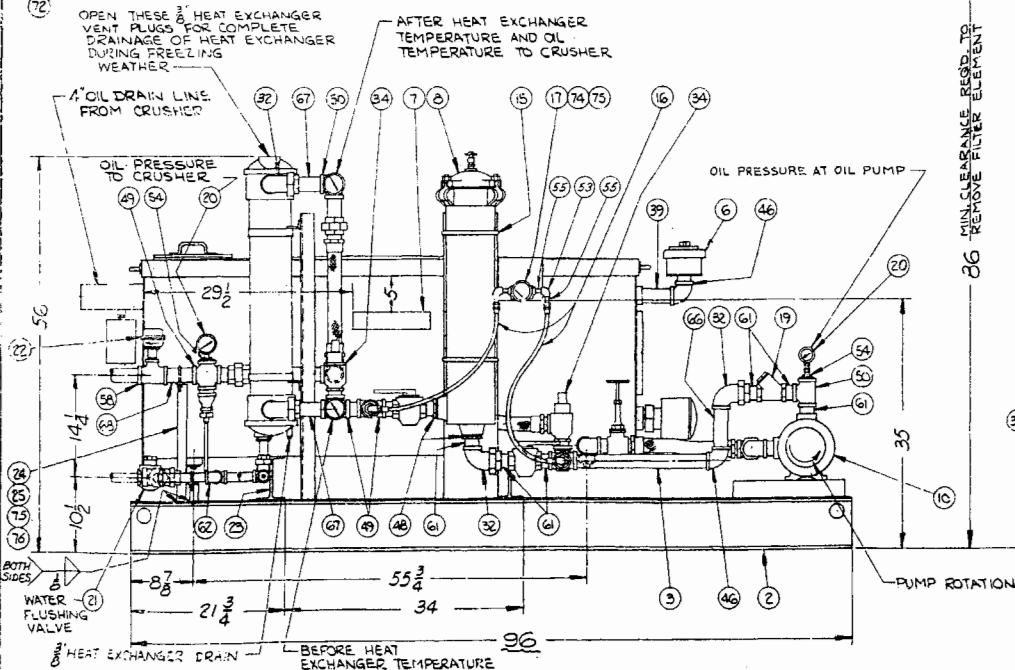
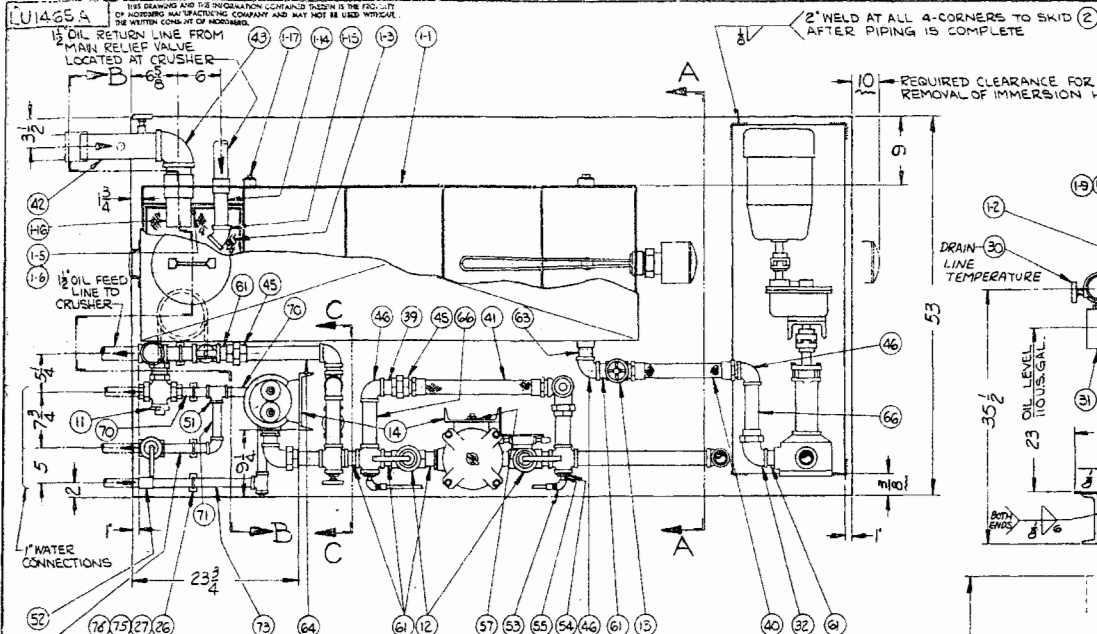
9820 0210

SLU-736

D	E.O. 58446	13MAR96
C	REDRAWN-E.O. 57327	15DEC94

LUI465A

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- ASSEMBLY INSTRUCTIONS:**
1. USING ADHESIVE (9), CEMENT GASKET (10), TO COVER (12) AND GASKETS (11) & (11) TO COVER (12) AS SHOWN.
 2. USE LOCTITE PIPE COMPOUND, MATERIAL CODE 4B2634B, ON ALL JOINTS.
 3. FILTER SHUT OFF VALVE (12), MUST BE INSTALLED WITH THE 'SEAT' OR ARROW ON THE SIDE OF THE VALVE BODY POINTING TOWARD THE FILTER.
 4. WATER FLUSHING VALVE (21), MUST BE INSTALLED WITH THE 'SEAT' OR ARROW ON THE SIDE OF THE VALVE BODY POINTING IN THE SAME DIRECTION AS THE WATER FLOW.
 5. FOR WIRING MAGNETIC CONTACTOR (29) TO IMMERSION HEATER (5) SEE SCHEMATIC LUI351C, CODE N158200066 FOR 480 VOLT OPERATION OR LUI352C, CODE N158200067 FOR 575 VOLT OPERATION.
 6. INSTALL 2 1/2" LONG BRONZE PADDLE ON FLOW SWITCH (22), THEN MOUNT SWITCH IN TEE (23) SO THAT PADDLE IS AT RIGHT ANGLES TO THE OIL FLOW. CHECK THAT THE ARROW ON THE SIDE OF THE SWITCH IS IN THE SAME DIRECTION AS THE OIL FLOW.
 7. LUBE SYSTEM IS TO BE TESTED AT 80 PSI FOR ONE (1) HOUR FOR OIL LEAKS. PRESSURE READING IS TO BE TAKEN AT GAUGE AT OIL PUMP.
 8. ALL PIPE LOCATING DIMENSIONS ARE APPROXIMATE.
 9. REFER TO PACKAGE LUBE SYSTEM 'SLU' DRAWING FOR THE LIST OF ITEMS.

SPECIFICATION FOR 1 SET		REVISIONS		DATE	
NO.	DESCRIPTION	DATE	BY	DATE	BY
1	PACKAGE LUBE SYSTEM	LUI465A	98201015		

12-45 GPM	11 1/2" H
HOBASCO MFG. CO. MILWAUKEE, WIS.	
REVISIONS	
1. DELETED MAGNETIC CONTACTOR AND ASSOCIATING WIRING	
2. ADDED 1" OIL FEED LINE	
3. DELETED 1" OIL FEED LINE	
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110-94280026

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BILL OF MATERIAL									
ITEM NO.	PART NAME	QTY REQ.	PART NUMBER	ENG. DESIG.	MATERIAL CODE NUMBER	PATTERN NO.	REMARKS OR REFERENCE NO.	MT. EACH	LTG. NO.
1	HYDRAULIC CIRCUIT	1	110-94280026	A1					
1	HOSE ASSY. 9150mm LG	6	10-44252787	A3					
2	ELBOW 90°	4	10-01983550						

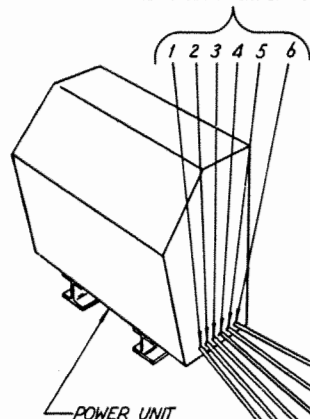
SUPPORT WELDED TO SIDE OF ADJUSTMENT RING

ADJUSTMENT RING

HOSE CONNECTIONS AT POWER UNIT REFER TO POWER UNIT GENERAL ARRANGEMENT DRAWING

REFER TO RELEASE CIRCUIT DRAWING 9428 0017 FOR HOSES AND FITTINGS IN THE RELEASE CIRCUIT.

REFER TO CLEARING CIRCUIT DRAWING 9428 0016 FOR HOSES AND FITTINGS IN THE CLEARING CIRCUIT



UNCLAMP
RAM EXTEND-OPEN SETTING
RAM EXTEND-CLOSE SETTING
RAM RETRACT
RELEASE CIRCUIT
CLEARING CIRCUIT

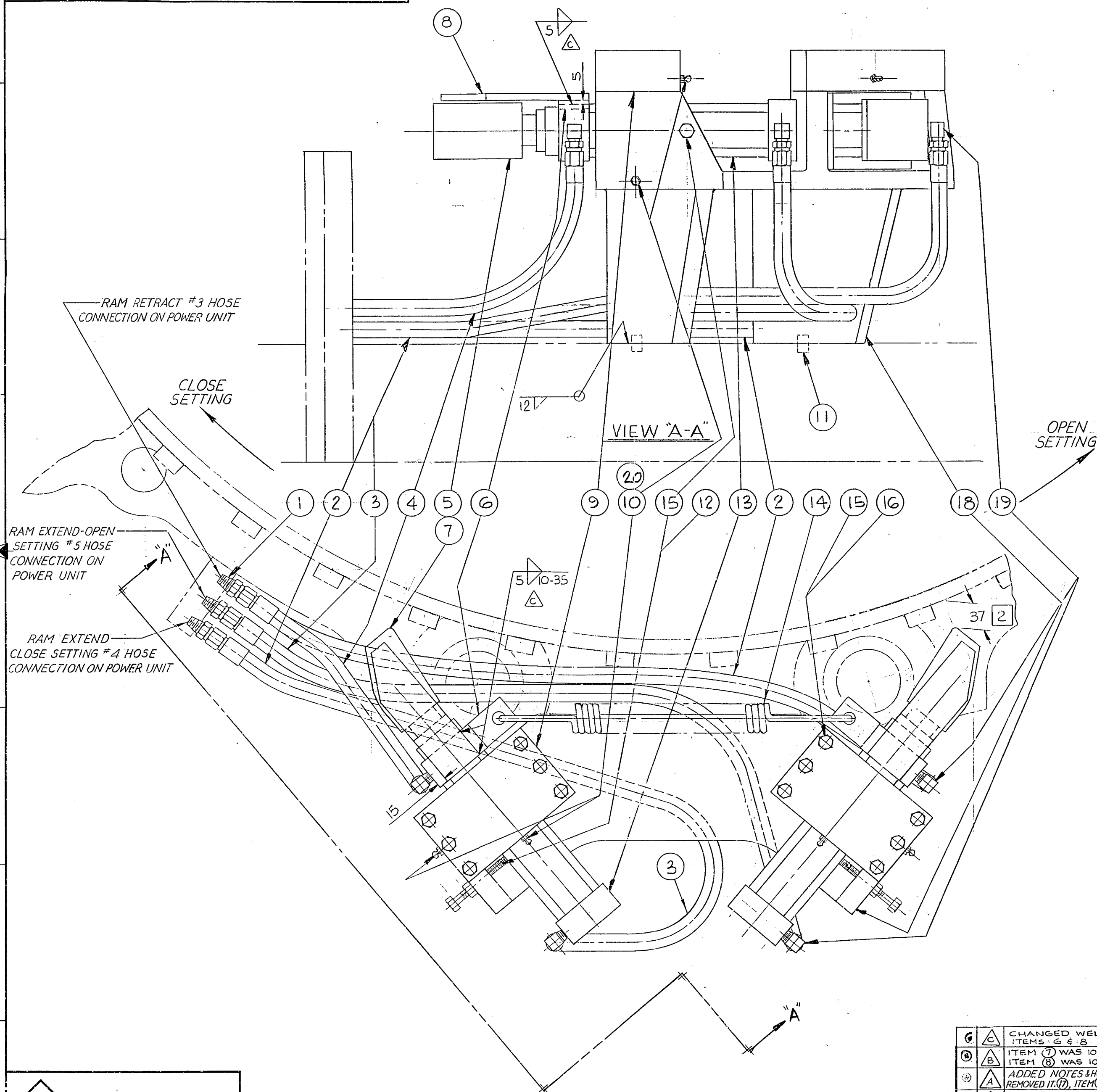
METRIC
ALL DIMENSIONS
IN MILLIMETERS

Raymord Process Machinery
Division

DRAWN J.A. CASH DATE 29 JAN 81		SUPERVISOR		ASSEMBLY GR.32	
CHECKED C. DAVIS DATE 30 JAN 81		SUPERVISOR BY			
APPROVED		PRODUCT		1352 OMNICON	
DATE		ADDITIONAL DESCRIPTION			
PART NAME HYDRAULIC CIRCUIT					
DWS DES.		PART NUMBER		REV.	
SCALE A1		910		94280026	

ITEM 1 ELBOW 90° WAS 5280 AND 411 & DELATED ITEM 3 ADAPTER	52872
ITEM 2 ELBOW 10-02080450 WAS 10-02081050	43571
ADDED NOTES & ITEM 3	39699
HOSES WERE INCORRECTLY LOCATED AT POWER UNIT	38192
ITEM 1 6 REQ'D WAS 5	29436
ISSUED	29163
REV.	DESCRIPTION OF CHANGE
DATE	BY

SURFACE PREPARATION, CLEANING AND PAINTING SPECIFICATIONS TO COMPANY STANDARD 100-01.



BILL OF MATERIAL				
ITEM NO.	PART NUMBER	QTY REQ	PART NAME	WT EACH kg
	1034280011		ADJ. RAM ASS'Y	103
1	10102076250	4	STRAIGHT	
2	1044253749	2	HOSE ASS'Y 1325 mm LG	A3
3	1044253761	1	HOSE ASS'Y 1550 mm LG	A3
4	1044253335	1	HOSE ASS'Y 570 mm LG	A3
5	106606955	2	ROD END	A3 4
6	1021456409	2	SPRING RETAINER	A2 1.5
7	1004826359	1	LOCTITE	
8	1013177409	2	GUIDE PLATE	A4 1.1
9	1018850272	2	RAM RETAINER PLATE	A2 11
10	1003801023	4	GREASE FITTING	
11	1003342890	2	DOWEL Ø10x30 LG	
12	1003010051	2	HEX NUT M12	
13	1028552387	2	RAM CYLINDER	A3 13
14	1003664500	1	RAM SPRING	A3 .8
15	1003723126	14	HHCS M12x80	
16	1003069051	12	LOCKWASHER M12	
17				
18	1077661880	1	RAM RETAINER	A1 55
19	1001982251	4	ELBOW 90°	
20	1003801990	4	CAP 1/4	

NOTE:

- REFER TO HYDRAULIC CIRCUIT DRAWING 9428 0026 FOR CONNECTING ADJUSTMENT RAM HOSES TO POWER UNIT.
- AFTER INSTALLING RAM SPRING ITEM (14) ADJUST BOTH RAMS TO DIMENSION SHOWN WITH ADJUSTING SCREW ITEM (15).

PROTOTYPE

METRIC
ALL DIMENSIONS
IN MILLIMETERS

IMPLIED TOLERANCES	
FINISHED DIMENSIONS	
MILLIMETERS	
XXX (1-500)	± .3
XXX (1-500)	± .5
X	± .5
XX	± .13

N 9 MACHINE FINISH
UNLESS OTHERWISE
STATED

PLANE ANGLES
± ONE DEGREE

3/4 ANGLE
PROJECTION

SCALE
1:3

CHANGED WELDING OF ITEMS 6 & 8	K-5 16 AUG 85	43769
ITEM (7) WAS 10-02775791 ITEM (8) WAS 10-03064492	TGB 9 APR 84	43448
ADDED NOTES & HOSE LENGTHS REMOVED IT (7), ITEM (6) 2-ROD WAS 1	S.S.F.S. 16 SEPT 82	39699
ISSUED	P.G. 8 JAN 81	29061
MF REV.	DESCRIPTION OF CHANGE	LOC. BY DATE ENG. ORDER NUMBER

Rexnord Process Machinery Division	
DRAWN JAV 8/80	SUPERSEDES
CHECKED C DAVIS	SUPERSEDED BY
DATE 8 JAN 81	ASSEMBLY GR. 34
APPROVED	PRODUCT 1352 OMNICON
DATE	DESCRIPTION
PART NAME	
ADJ. RAM ASS'Y	
DWG. SIZE A1	DRAWING NUMBER 910 9428 0011
PREFIX	CODE
SUFFIX	REV. C

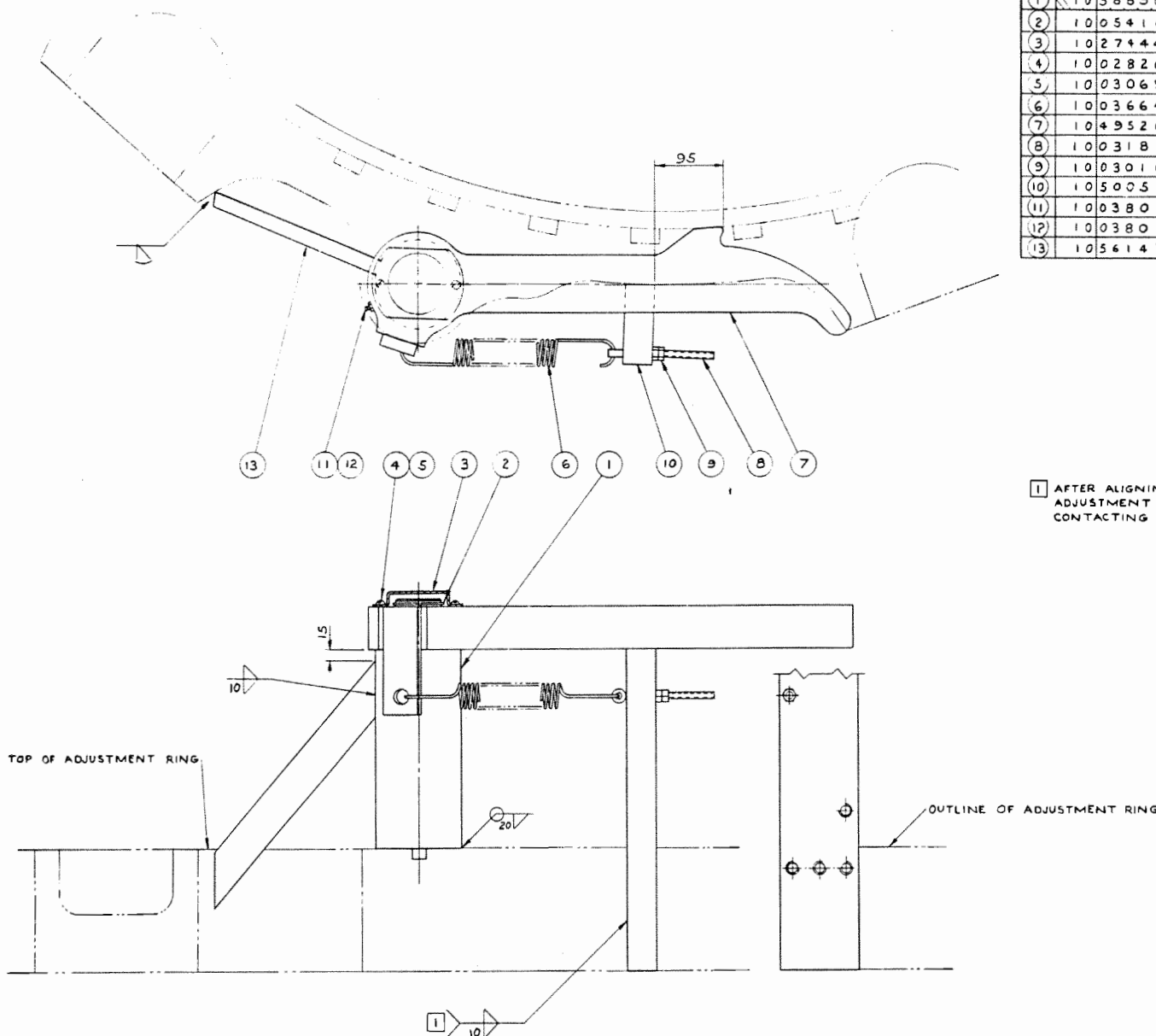
SURFACE PREPARATION, CLEANING
AND PAINTING SYMBOLS ACCORDING
TO COMPANY STANDARD 03-01-01.

NO 110-9428 0012

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BILL OF MATERIAL

ITEM NO.	PART NUMBER	QTY. REQ.	PART NAME	DWG. SIZE	WT. EACH kg
	1094280012		BOWL LOCK ASS'Y		70
(1)	1058850082	1	BOWL LOCK POST	A2	26
(2)	1005416065	1	RETAINING RING	-	
(3)	1027444600	1	DUST COVER	A3	.8
(4)	1002820241	2	RD HD SCR M6x16		
(5)	1003069036	2	LOCKWASHER M6		
(6)	1003664490	1	BOWL LOCK SPRING	A3	
(7)	1049520018	1	LOCK ARM ASS'Y	A1	27.8
(8)	1003181095	1	EYE BOLT M10x30		
(9)	1003010046	2	NUT M10		
(10)	1050051500	1	MANIFOLD	A2	15
(11)	1003801023	1	GREASE FITTING		
(12)	1003801990	1	GREASE FITTING CAP		
(13)	1056147655	1	GUSSET	A3	3



1 AFTER ALIGNING BOWL LOCK ARM (7) PARALLEL TO TOP OF ADJUSTMENT RING, MANIFOLD (10) TO BE WELDED IN POSITION CONTACTING UNDER SIDE OF BOWL LOCK ARM (7) FOR SUPPORT

METRIC

ALL DIMENSIONS IN MILLIMETRES

IMPLIED TOLERANCES
FRACTIONAL DIMENSIONS

MILLIMETRES
XXX (X 500) ± .3
XXX (X 500) ± .5
X ± .05
XX ± .013

NO MACHINE FINISH UNLESS OTHERWISE STATED

PLANE ANGLES ± ONE DEGREE

3rd ANGLE PROJECTION

Rexnord Process Machinery Division

DRAWN C. DAVIS
DATE 9 FEB. 83
CHECKED C. DAVIS
DATE 9 FEB. 83

SUPERSEDES
REV. 2-20-80
SUPERSEDED BY
DATE 9 FEB. 83

ASSEMBLY GR 35
CRUSHER

APPROVED
DATE
PRODUCT 1352 OMNISCONE
DESCRIPTION

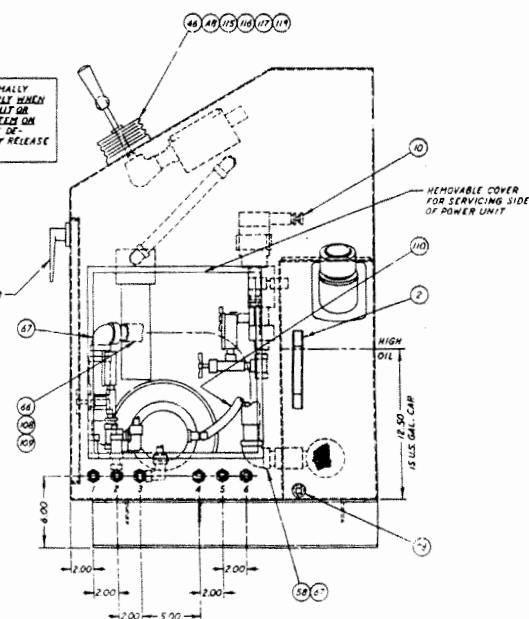
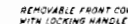
PART NAME
BOWL LOCK ASSEMBLY

DWG. NO. A1
PREFIX 110
CODE 9428
SUFFIX 0012
REV. D

SURFACE PREPARATION, CLEANING AND PAINTING SYMBOLS ACCORDING TO COMPANY STANDARD 03-01-01.

REV.	DESCRIPTION OF CHANGE	LOC.	DATE	BY	END ORDER NUMBER
1	REDRAWN & REVISED			C. DAVIS	40915

SCALE 1:3



	HOSE CONNECTION WORDING REVISED	D9	1.3.81 12:00 PM	3970
1.	START-STOP LOC REVISED	H-9	1.3.81 12:00 PM	3882
	START-STOP LOC REVISED	C-6	1.3.81 12:00 PM	3872
	START-STOP LOC REVISED	C-9	1.3.81 12:00 PM	3142
	ISSUED		1.3.81	3142