ANDRITZ
Pulp & Paper

Low consistency refiner plates

Refiner plate installation instructions

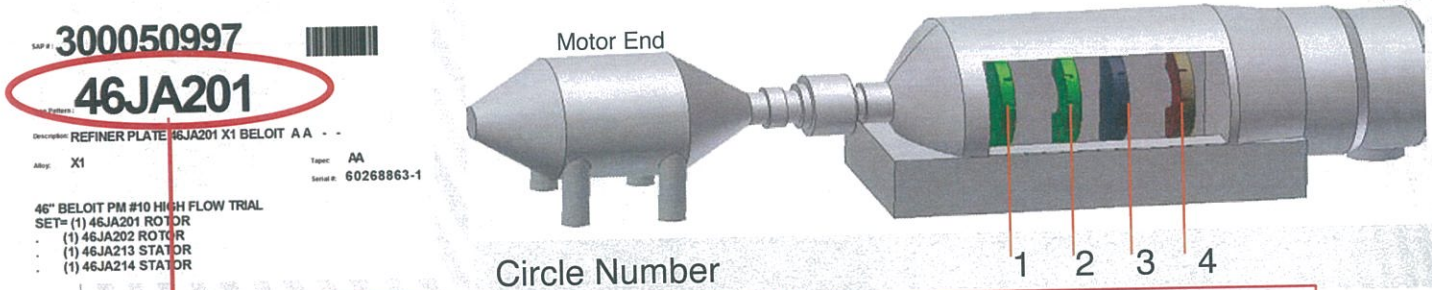
⚠ WARNING: ⚠ Projectile Hazard

To minimize risk of plate fracture and disintegration, always install plates per the original machinery manufacturer's instructions for the correct make and model refiner.

Please note that correct installation is important for proper performance of your refiner plates. Take time to read these instructions. If you have any questions, do not hesitate to contact your ANDRITZ representative.

Thanks for using ANDRITZ plates in your refiner!

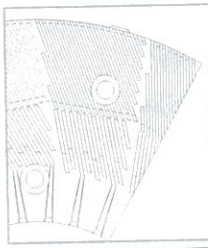
1. Open the refiner housing.
2. Looking at the refiner from the adjustment end (opposite the motor), determine if the shaft rotates clockwise or counterclockwise.
3. Remove all segments.
4. Clean all rotor and stator mounting surfaces thoroughly.
5. Install new refiner plates according to the table below.
6. Durametal refiner plates can be used on either rotor or stator.



If shaft rotates clockwise	
Circle number	Pattern number
1	even
2	even
3	odd
4	odd

If shaft rotates counterclockwise	
Circle number	Pattern number
1	odd
2	odd
3	even
4	even

HOW TO DETERMINE IF THE PLATE IS EVEN OR ODD

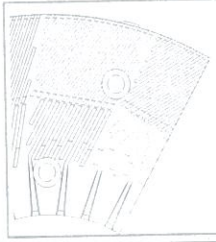


ODD

BARS GO TO LEFT.

PATTERN NUMBER ENDS WITH

1,3,5,7, 9 **(ODD NUMBER)** FOR EXAMPLE 42TA009



EVEN

BARS GO TO RIGHT.

PATTERN NUMBER ENDS WITH 0,2,4,6,8 **(EVEN NUMBER)**

FOR EXAMPLE 42TA010

Contact:
ANDRITZ Inc.
Muncy, PA 17756 USA
Phone +1 570 546 8211
Fax +1 570 546 1256

ANDRITZ Inc.
Tualatin, Oregon 97062 USA
Phone +1 503 692 0850
Fax +1 503 692 1169
Toll free: +1 800 547 6511

durametal@andritz.com

ANDRITZ
Pulp & Paper

Low consistency refiner plates

Refiner plate installation instructions

Bolt torque

RECOMMENDED BOLT TORQUE (lubricated)			
Bolt Size	Material / Grade	Torque	
		[Nm]	[ft-lb]
3/8-inch	316	27	20
1/2-inch	316	55	40
5/8-inch	316	110	80
M12	A4-70/A4-80	54	40
M16	A4-70/A4-80	132	98

ADDITIONAL INSTRUCTIONS

1. **All refiner plates are ground and fit in complete circles.**
   One circle equals one half set, or one quarter set for double disc refiners.
2. **Do not mix segments between circles.**
   Thickness between circles can vary due to manufacturing tolerances, but all segments of a given circle are ground to the same thickness.
3. **Install all segments loosely until all are properly seated and evenly spaced.**
   This procedure minimizes vibration caused by unbalance. Approximately center bolts in the counter bore. This should equally distribute the spaces between all segments. Then apply the final bolt torque.
4. **Use only the correct length bolt.**
   Bolts which are too long may bottom-out in blind holes. If this happens, the bolts will not clamp the segment to the disc. Bolts that are too short may not engage enough threads to hold.