

KENCO

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Installation of Kenco Bolt-on Uni-Mix for Cedarapids Pugmills

Refer to this chart and verify you have the correct parts for your plant:

OEM Part#	OEM Arm Length	Shaft Dia.	Kenco Shank#	Kenco Tip#	Kenco Shroud#	Tip Notch	Swing Dia. with Tip
5033 G08 04	31.75"	6.75"	US-801-A1	UT-67	SOS-1-338	Middle	35.125"
5033 G08 04	31.75"	7.50"	US-801-B1	UT-67	SOS-1-338	Middle	35.125"
5071 G12 04A	33.00"	6.75"	US-801-A1	UT-67	SOS-1	Outside	36.375"
5071 G12 04A	33.00"	7.50"	US-801-B1	UT-67	SOS-1	Outside	36.375"
5031 G30 04	34.50"	6.75"	US-801-A2	UT-87	SOS-1-338	Middle	38.000"
5031 G30 04	34.50"	7.50"	US-801-B2	UT-87	SOS-1-338	Middle	38.000"
5073 G12 04A	38.75"	7.50"	US-802	UT-8585	SOS-1	Outside	

Main Shaft Preparation:

1. Kenco two piece bolt-on shanks are designed to fit over a 6.75" or a 7.50" diameter main shaft. Verify main shaft diameter before proceeding.
2. If the main shaft has shaft protectors or hardfacing, it must be removed. Kenco shanks require 2.5" of unobstructed surface area on each side of the OEM arm.
3. If the main shaft shows excessive wear it may be necessary to rebuild it to the original diameter. **Kenco shanks must fit securely on the main shaft.**

Cutting OEM Arms:

1. For 6.75" main shaft diameter, measure from the top of the main shaft along the OEM arm 1.5" +/- 1/8". (See Fig. 1, "A" dim.)
2. For 7.50" main shaft diameter, measure from the top of the main shaft along the OEM arm 1.125" +/- 1/8". (See Fig. 1, "A" dim.)
3. Cut OEM arm as measured in previous step. If needed, grind end of arm to remove any material that may keep the Kenco shank from seating properly.

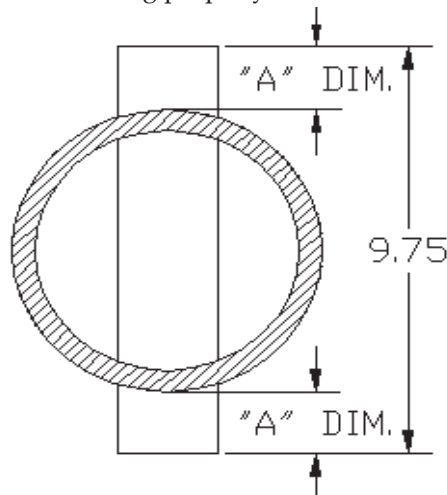


Fig. 1

Assembly of Kenco Shanks and Shrouds:

1. Assemble Kenco shanks over main shaft and OEM arm as shown in Fig. 2. Note that Kenco shanks allow for a 5/8" weld bead around the OEM arm. If weld is present in excess of 5/8", grind to fit.
2. Tighten bolts evenly to assure shanks are in full contact with the main shaft.
3. Heat bolts to approx. 350 deg. F to allow for expansion, and torque to 160-180 foot lbs.
4. Install Kenco Shroud (SOS-1) onto dovetail portion of shank.

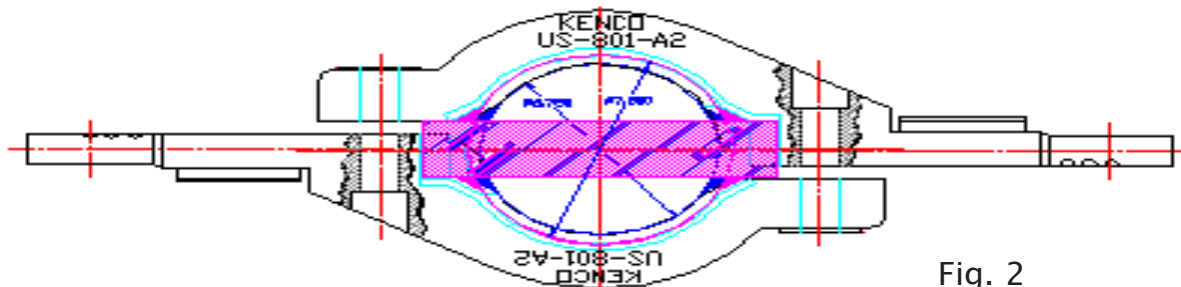
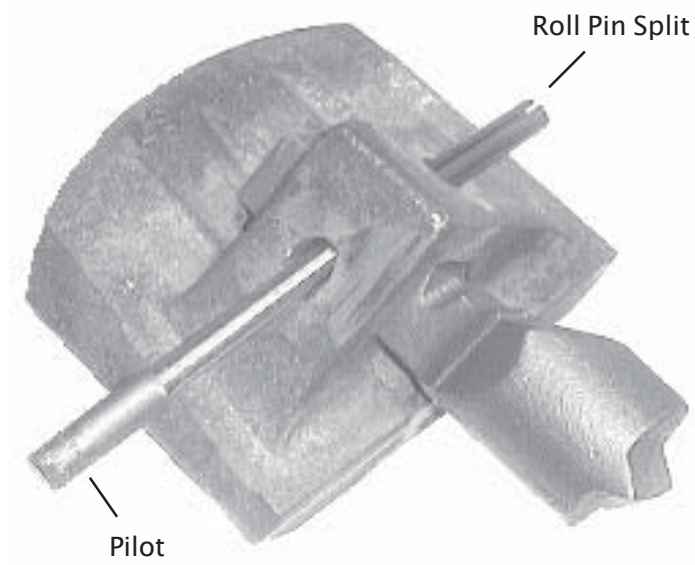


Fig. 2

Installation of Kenco Tips:

1. Slide Uni-Tip onto square end of shank in correct right- or left-hand position.
2. Insert Kenco PP-5 pilot through Uni-Tip hole and shank notch to correctly align the two pieces.
3. From opposite side insert a *new* roll pin into Uni-Tip hole.
4. Check that split in roll pin faces *away* from shank.
5. Drive roll pin through Uni-Tip as it pushes the pilot out opposing side.



Kenco Uni-Tips must be installed using a pilot to correctly align the tip and the shank. This allows proper installation without damaging the Uni-Tip or the shank.

Important:

- Always use a new roll pin when installing Kenco Uni-Tips
- Discard roll pins after a single use
- Always use proper eye protection when installing Kenco Uni-Tips



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