Installing KC Anvil Rack Assembly

Procedure Notes

Bulletin 57-01-22

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PROCEDURE

1. Secure the rotor assembly into position.

⚠ **USE EXTREME CAUTION AND PROPER LIFTING EQUIPMENT TO SECURE THIS ROTOR.**

⚠ **THIS IS A HIGH INERTIA ROTOR AND CANNOT BE STOPPED EASILY ONCE IN MOTION.**

⚠ **DO NOT TURN ROTOR OVER BY HAND OR POWER WITH ANY PART OF THE BODY BETWEEN THE TEETH AND ANVIL POINTS. EVEN WHEN BARELY MOVING, IT HAS ENOUGH MOMENTUM TO CUT OFF A FINGER.**

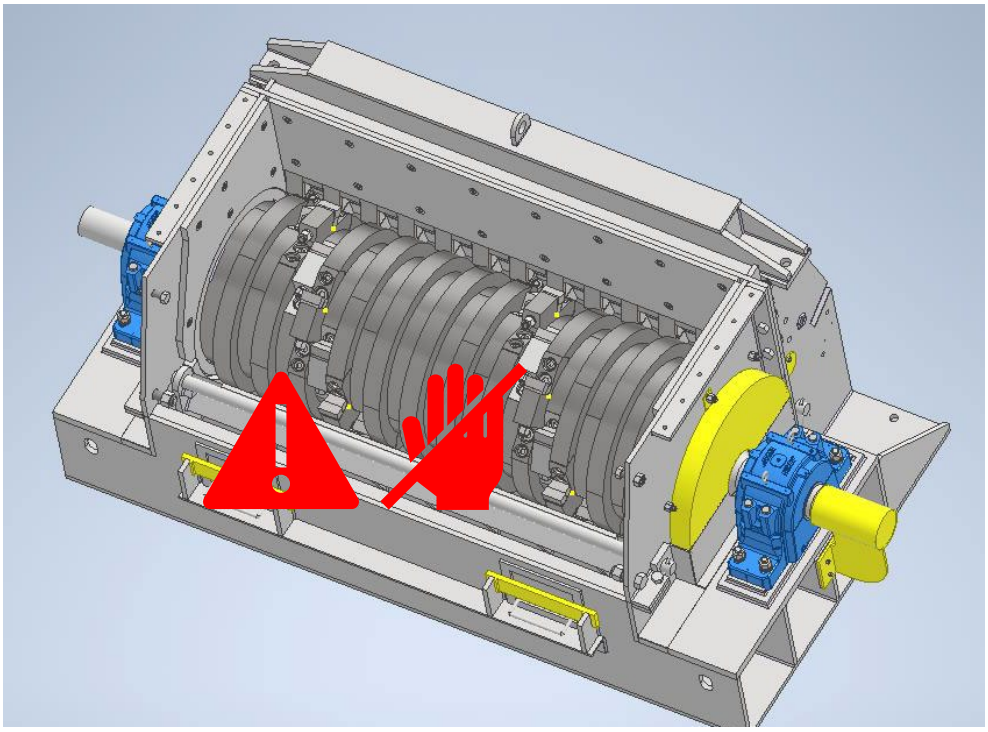

Figure 1: Positioned Rotor Assembly (Rear Door and Hopper Removed for Clarity)

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2. Lift Anvil Rack Assembly and place into position as shown. There should be a 3/16” gap between the inside face of the Anvil Rack and the outside face of the Side Housing.

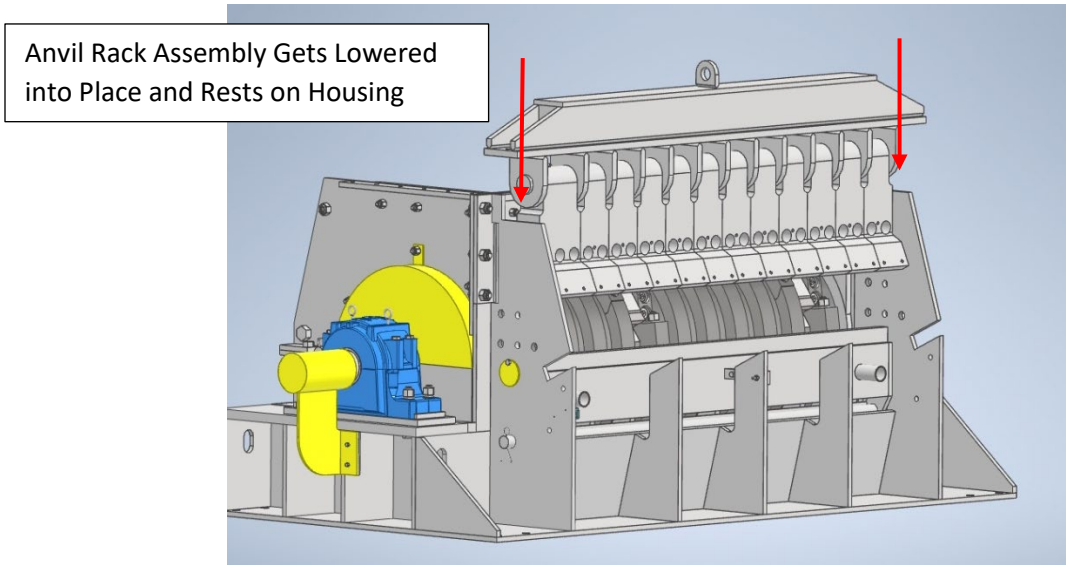

Figure 2: Hog with Anvil Rack Assembly Being Lowered into Place

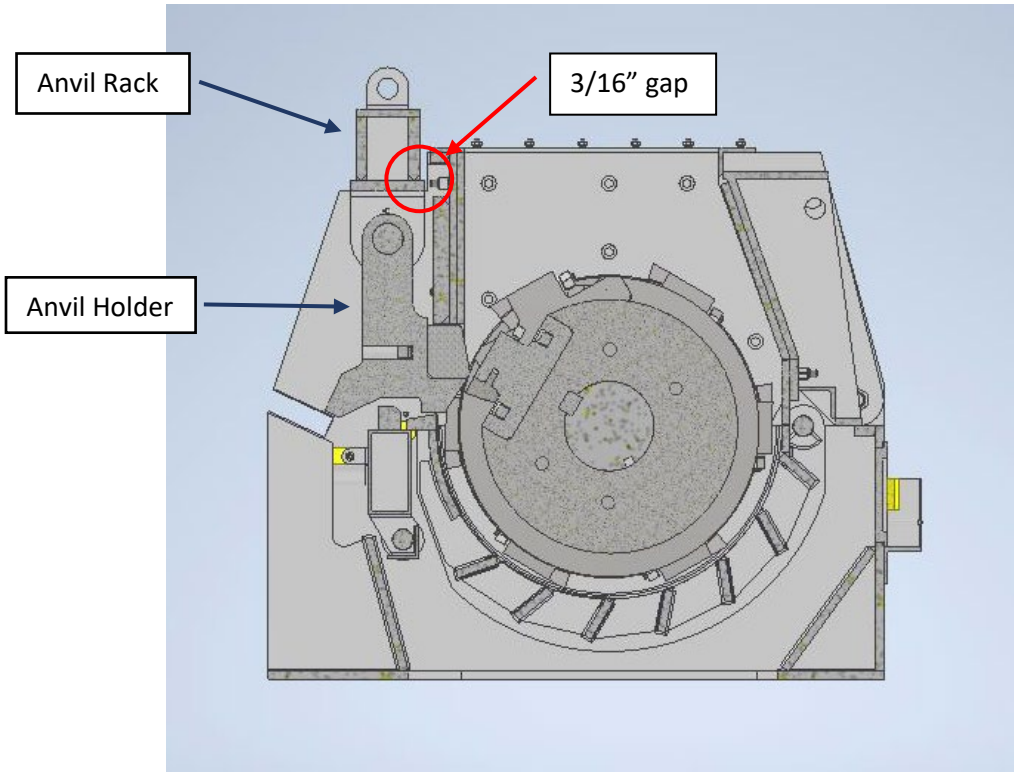

Figure 3: Cross Sectional View of Hog with Anvil Rack Assembly

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3. Connect a Bushing Block to each Anvil Holder and securely tighten.
4. Use machine bolts and nuts in lieu of Shear Bolts during alignment and adjustment. Insert machine bolts into the Anvil Holder Bushing Block Bushings and corresponding Anvil Plate Bushings. Loosely tighten nuts to align Anvil Holders to Anvil Plate.
5. **Do not weld the Anvil Plate to the hog until all alignments have been made.** The Anvil Plate being loose will aid the alignment process.
6. Insert a 1/16” (0.0625”) shim (as needed) between the bottom of the Bushing Block and the Anvil Plate to ensure proper clearance between the Anvil Plate and Anvil Holders.

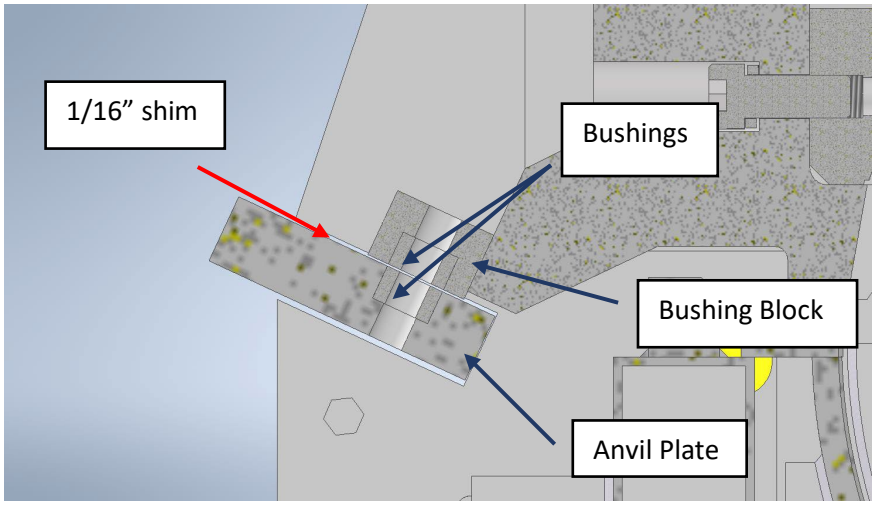

Figure 4: Cross Sectional View of Anvil Plate and Bushing Block (Machine Bolt Removed)

7. Once all the Anvil Holder Bushing Blocks are connected to the Anvil Plate and the shims are in place, tighten bolts to firmly align the Anvil Plate to the Anvil Rack Assembly.
8. By moving/shimming/adjusting the Anvil Rack Assembly, align the Anvil Points with the Teeth on the Rotor Assembly so that there is a 1/16” to 3/16” gap between the Teeth and the Anvil Points. Make sure that the Anvil Rack Assembly remains square to the Rotor Assembly.

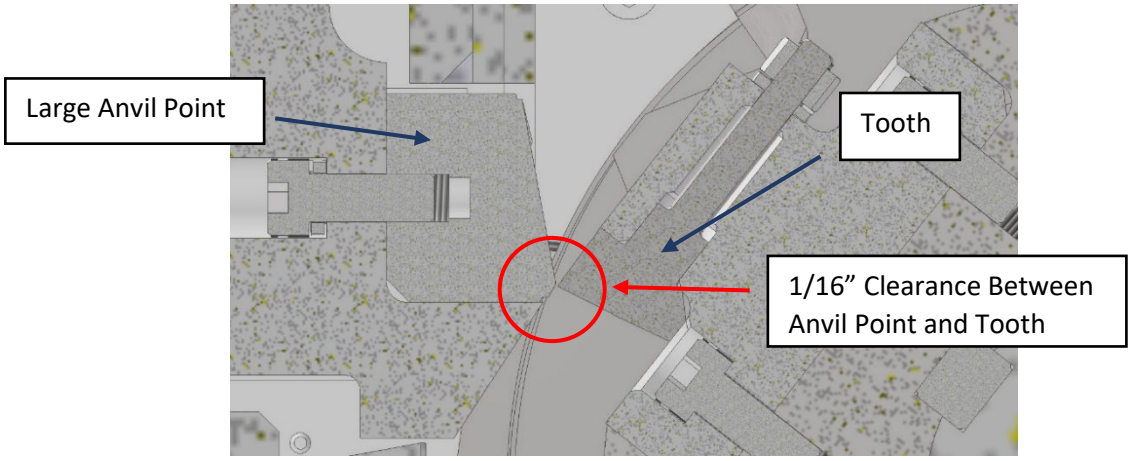

Figure 5: Cross Sectional View of Anvil Points and Teeth

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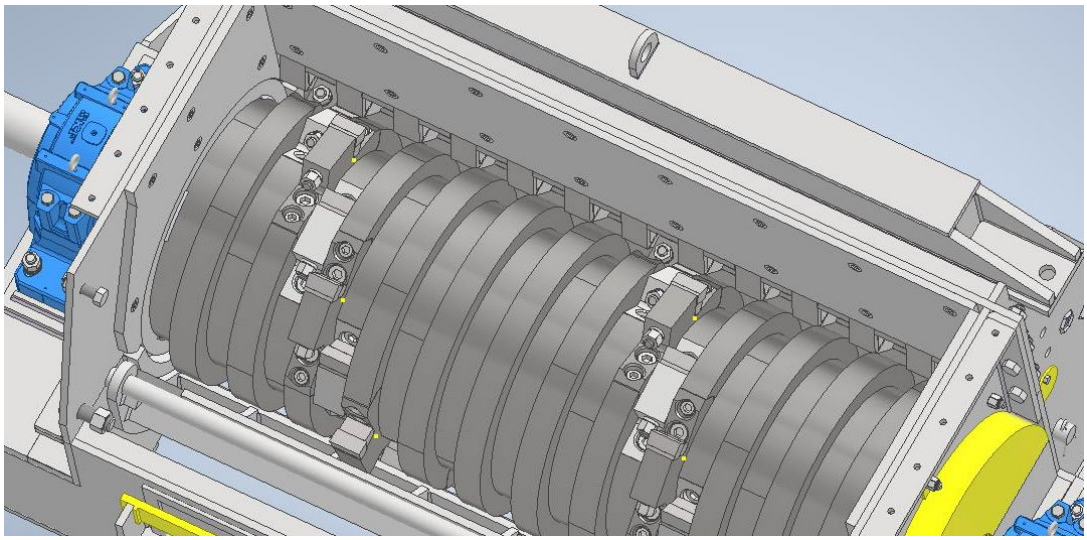
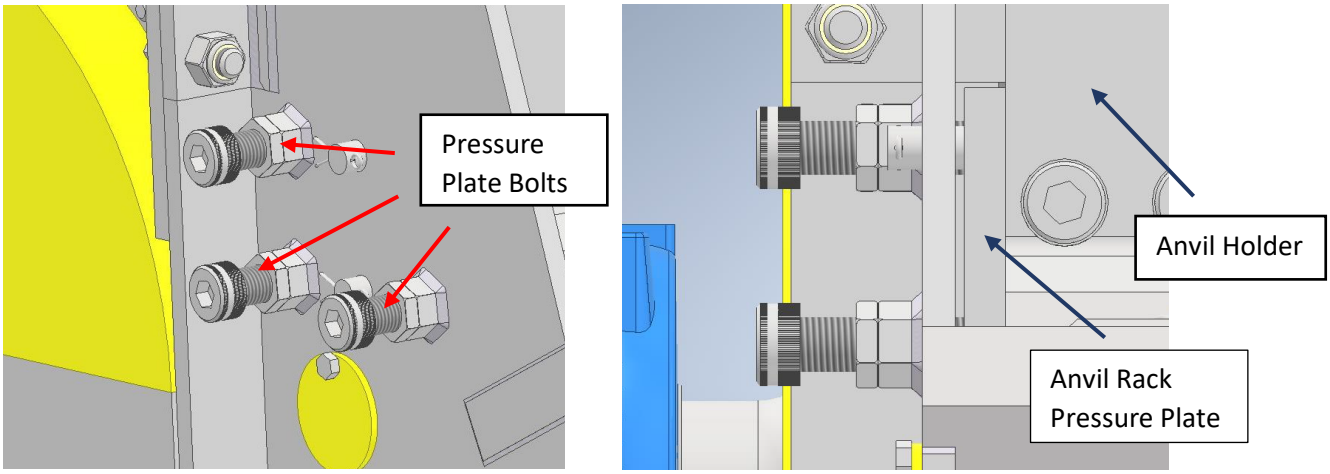


Figure 6: Proper Alignment of Anvil Rack - Anvil Points Align with Teeth, Assembly is Square to Rotor

9. After all aligning and adjusting is complete, tack the Anvil Holder Flanges and the Anvil Plate in place to prevent movement.
10. Tighten the Bolts in the Anvil Rack Pressure Plates to compress the Anvil Holders. Align the centerlines of the pockets formed by the Anvil Points to the centerlines of the teeth on the Rotor.



Figures 7 & 8: Anvil Rack Pressure Plates - End View (L) and Side View (R)

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11. Weld the Anvil Holder Flanges and the Anvil Plate to the Lower Housing.

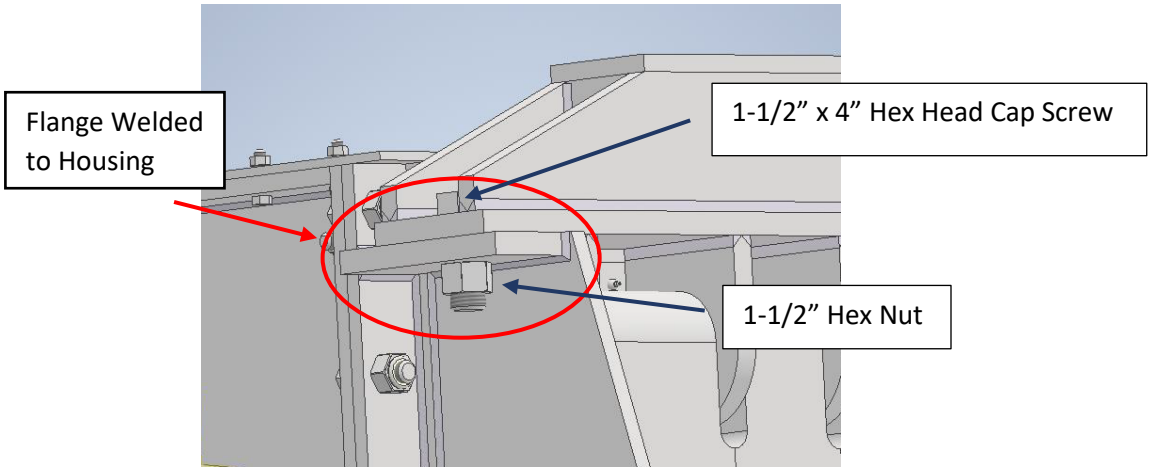
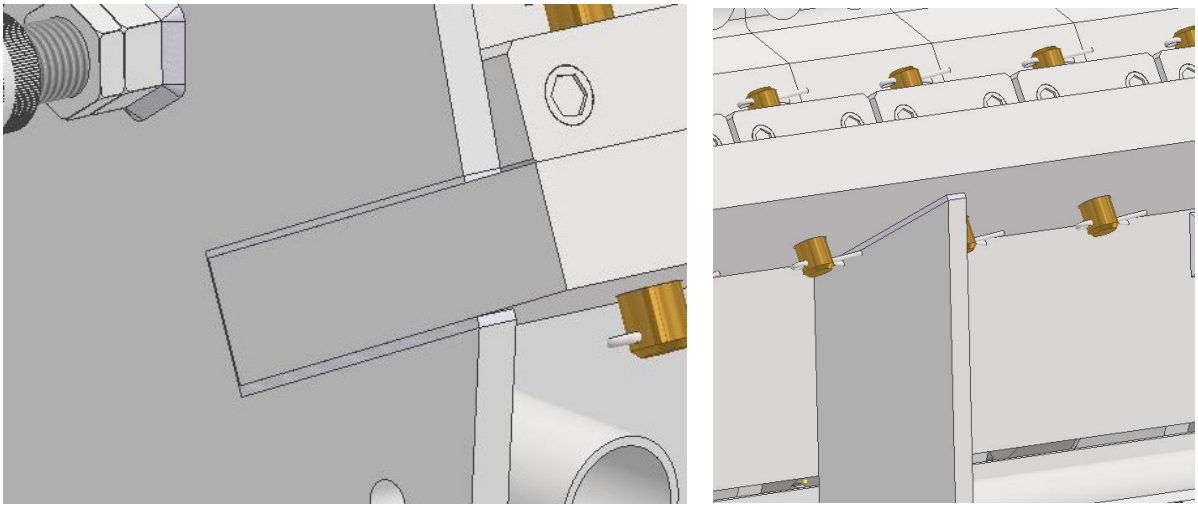


Figure 9: Welded Anvil Holder Flange, Secured to Anvil Rack with Proper Hardware



Figures 10 & 11: Anvil Plate Welded to Lower Housing

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12. Remove machine bolts and shims. Insert Shear Bolts and secure each with (2) Cotter Pins. Install/Tap in Shear Bolts from underneath to hide any hammer galling.

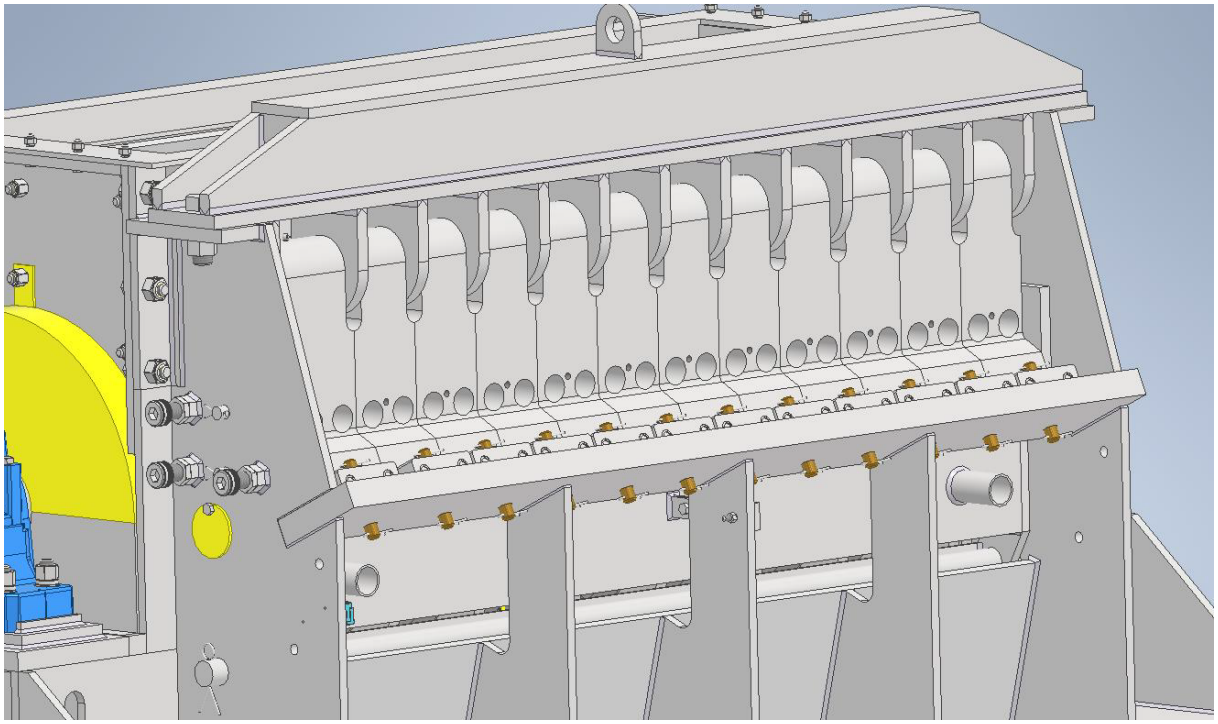

Figure 11: Complete Installation of Anvil Rack Assembly with Shear Bolts and Cotter Pins

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