WELD PLATE GAUGE TOOL INSTRUCTIONS

Introduction

The weld plate gauge tool has been developed in order to verify that upon reception and installation of the weld plate they are within acceptable tolerance. By using this tool one can help ensure proper functionality of the mixer.

The weld plate gauge tool is a calibrated instrument. Steridose certifies that it meets or exceeds all specifications and has been calibrated using measurement standards traceable to national measurement institutes. Each component is individually marked with a unique ID (figure 1) verifying all critical dimensions have been verified. The calibration expires yearly and the tool should be recalibrated.

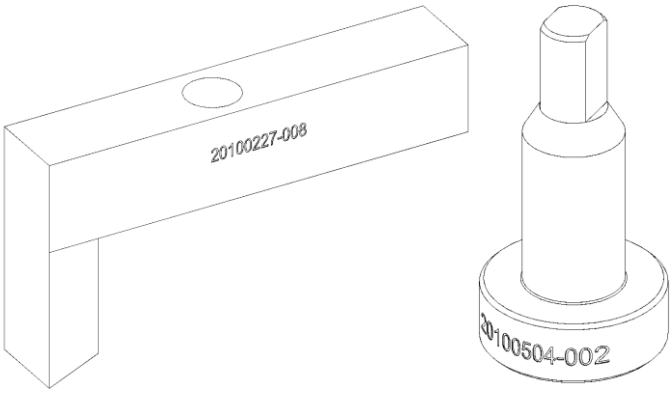

Figure 1: Unique Identification Numbers marked on components

Description

The weld plate gauge tool consists of two parts: an anodized aluminum rotor and a 316L stainless steel bushing (See below).

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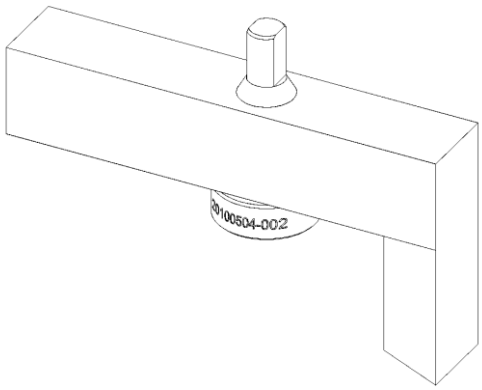

Figure 2: Weld Plate Gauge Tool Assembly

Each size weld plate has its own weld plate gauge tool and corresponding part number (See chart).

Weld Plate Size	Weld Plate Gauge tool Part Number
60	110891
85	110893
120	110896
120H	110899
210	110902

Assembly

To use the weld plate gauge tool the male bearing must be removed from the weld plate (Figure 3). With the male bearing removed, the weld plate gauge tool bushing can be installed (Figure 4). To install, thread the bushing into the weld plate. This should either be done hand tight or very lightly with a wrench. If a wrench is used, caution should be taken to avoid any damage. Any nicks or burrs on the bushing could damage the inner diameter of the rotor, causing the tool to become out of tolerance.

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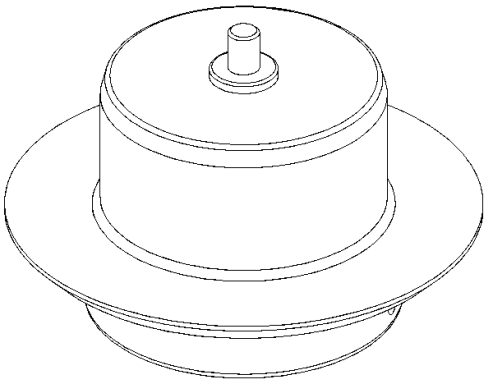

Figure 3: Weld plate with male bearing removed

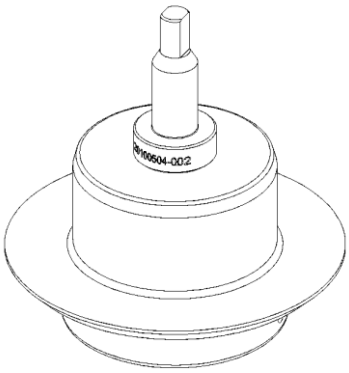

Figure 4: Gauge tool bushing installed

With the gauge tool bushing threaded into the weld plate, the rotor can then be placed into position. The hole in the rotor fits snugly over the gauge tool bushing. Caution must be taken to avoid damage during this process, as any imperfections in either surface are likely to cause damage to the tool. Due to the tight fit and component materials, the two components should not be stored assembled. With the two components together the weld plate is ready to be tested.

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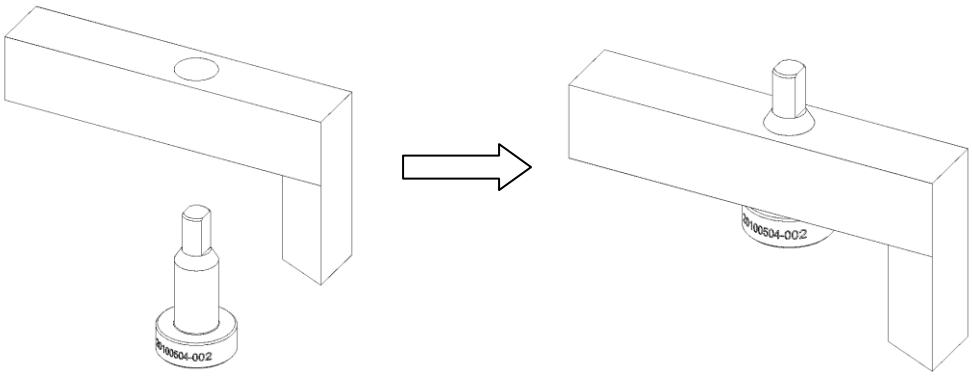

Figure 5: Gauge tool rotor assembly to bushing

Operation

With the weld plate gauge tool in place on the weld plate the rotor can be rotated around the weld plate. If there is any interference between the rotor and the weld plate, the weld plate is out of tolerance and metal to metal interference with the impeller can be expected. Interference could be possible due to warping or distortion that takes place during the welding procedure.

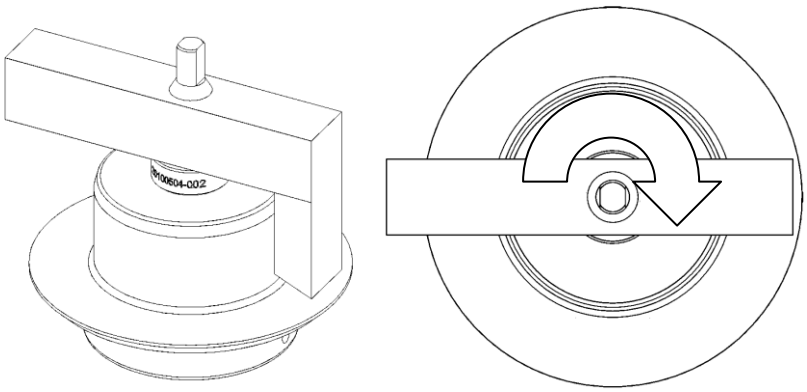

Figure 6: Gauge tool assembled on weld plate

The gap between the rotor and weld plate can be used to check the concentricity of the weld plate. As long there is no contact between the two, normal operation can be expected.

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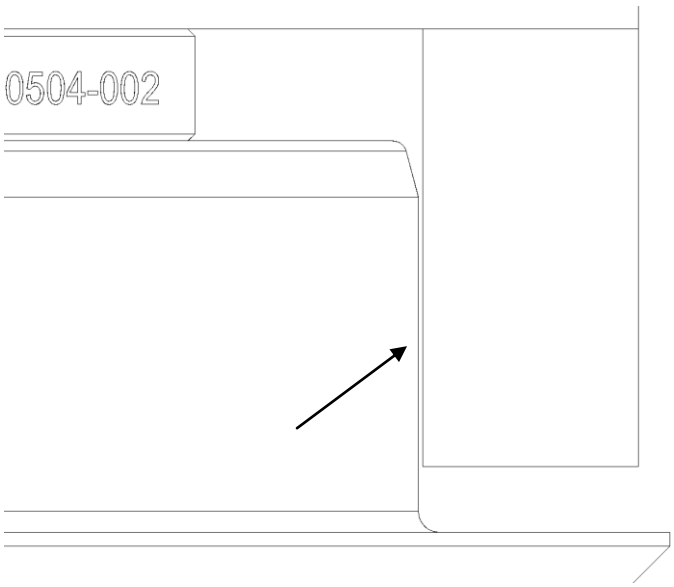

Figure 7: Check Gap between weld plate and gauge tool rotor

Certificate of Calibration

Each weld plate gauge tool is shipped with a certificate of calibration. It is recommended to be maintained with all other calibration records.

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