



Batch Plant Service, LLC

P.O. Box 701787
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www.bpstx.com
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Rebuild procedure for a mixer star bearing at Batch Plant Service, LLC
Type: Complete mixer star bearing for a 375 ltr. - 4500 ltr. Wiggert planetary pan mixer.

Note

We do recommend to remove as much as possible old and cured concrete to reduce the shipping weight. The weight limit for ground shipping is 150 lbs, which is almost the weight of a clean HPGM 2250 - HPGM 3750 mixer star bearing with our customized and re-usable shipping container. If you do not have our shipping container, use a heavy duty cardboard box with thin plywood sheets inside the box, to prevent damage to the threaded and keyed side of the shaft, use also one sheet on the bottom of the box for safe handling. A piece of fabric wrapped around each end of the shaft is highly recommended.

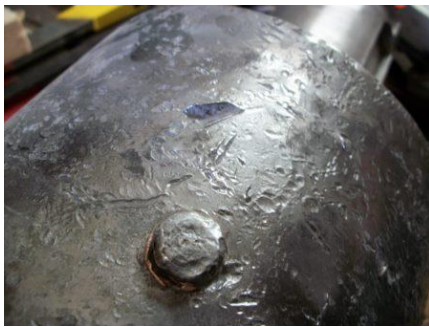
What we do at BPS - step by step



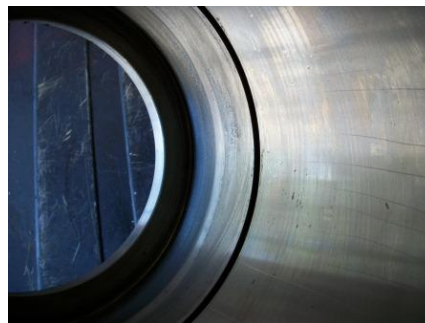
The picture on the left is showing a complete mixer star bearing after unpacking, shipped from a customer.

1. All concrete gets brushed off and residue from old sealant and anti-seize will be cleaned off.
2. We remove both shaft keys, the o-ring, nut and snap ring.
3. The whole unit gets inspected for severe damage on both shaft ends and the mounting flange. Both key-ways are getting tested with a new shaft key to assure that the shaft is still usable.

4. We remove all chisel marks, sand the whole housing surface and break all edges for safer handling.



5. The whole unit gets taken apart, the old bearings pressed out and completely washed, then inspected and fine sanded to remove the markings from the old bearing. The shaft too, gets fine sanded and the thread cleaned up with a metric thread file. All threaded holes (for grease nipple and coverplate) are re-tapped.





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To guarantee quality, good workmanship and longevity, we only use brands like FAG and/or SKF for bearings and seals from a trusted wholesaler.



6. Before assembly, all parts will be treated with anti-seize to assure smooth assembly and future disassembly.



7. We use customized shaft keys, which contain one or two set screws for easy removal. Those set screws are secured with medium strength threadlocker to prevent movement. To remove the key, just turn the set screw clockwise and the key will pop out the shaft groove without getting damaged.



Note:
Use medium threadlocker each time the set screw was used.

8. The complete shaft is treated with anti-seize which does not need to be removed. Other bare metal surfaces are covered with grease to prevent rusting and should be cleaned before assembly, at least the flange surface before applying the sealant. **Note: The unit comes completely filled with grease.**

9. The whole housing is painted with a rust inhibitor primer. The shaft ends are wrapped with fabric and the whole unit is covered with clear foil wrap. Our inhouse build transportation box is re-usable and ensures no movement during transport.



Our gift to you

10. For easy and safe assembly, we will include three M12 threaded rods, six M12 nuts and washers. Also, two metric grease nipples and six new mounting bolts M12 with washers.