

Grinder DXG 25-11 & DXGM 25-11

Assembly of

Tools needed: Screwdriver; Allen keys (5 mm & 6 mm), torque wrench, hexagon bit adapters (5 mm & 6 mm)



Assemble the upper Impeller washer



Assemble the impeller onto the shaft



Assemble the impeller screw and the lower impeller washer



Tighten the impeller screw.
Tightening torque 25 Nm



Assemble the Suction Cover. Tightening
torque 9,3 Nm



Assemble the Cutter Plate.
Tightening torque 9,3 Nm



TRIMMING OF CUTTER WHEEL:

1. Turn the Cutter Wheel onto the threaded part of the Impeller Screw until the Cutter Wheel touch the Cutter Plate



TRIMMING OF CUTTER WHEEL

2.

Assemble the stop screw into the threaded center of the Cutter Wheel



TRIMMING OF CUTTER WHEEL

3.

Lock the Cutter Wheel from rotating with a Screwdriver and fix the Cutter Wheel by tapping on the Allen key.

After this moment, check that the Cutter Wheel rotates freely and check that the maximum distance between the Cutter Plate and at least one of the Cutter blades is approximately 0,1-0,2 mm



TRIMMING OF CUTTER WHEEL

4.

Fix the Cutter Wheel with a tightening torque of 25 Nm.

Check that the Cutter Wheel rotates freely

Disassembly of

Tools needed: Screwdriver; Allen keys (5 mm & 6 mm), hammer, mandrel, multiple pliers



Lock the Cutter Wheel from rotating by a Screw Driver

Loosen the Stop Screw (one turn around is enough)



Knock carefully with a mandrel on one of the cutter blades to loosen the Cutter Wheel.

Unscrew the Cutter Wheel



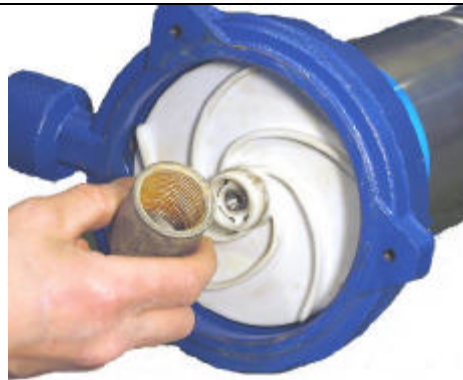
Unscrew the three Cutter Plate screws and dismantle the Cutter Plate



Unscrew the three Suction Cover screws and dismantle the Suction Cover



Unscrew the impeller Screw



Dismantle the Impeller by using a 1 inch socket and a screw driver.

Screw the socket onto the impeller hub and loosen the impeller by bending with a screw driver



Dismantle the upper Impeller washer

