

# **DIXIE GRINDERS INC.**

1324 RAILROAD AVENUE GUNTERSVILLE, AL 35976  
(800) 745-0586 (256) 582-0477 FAX (256) 582-0478

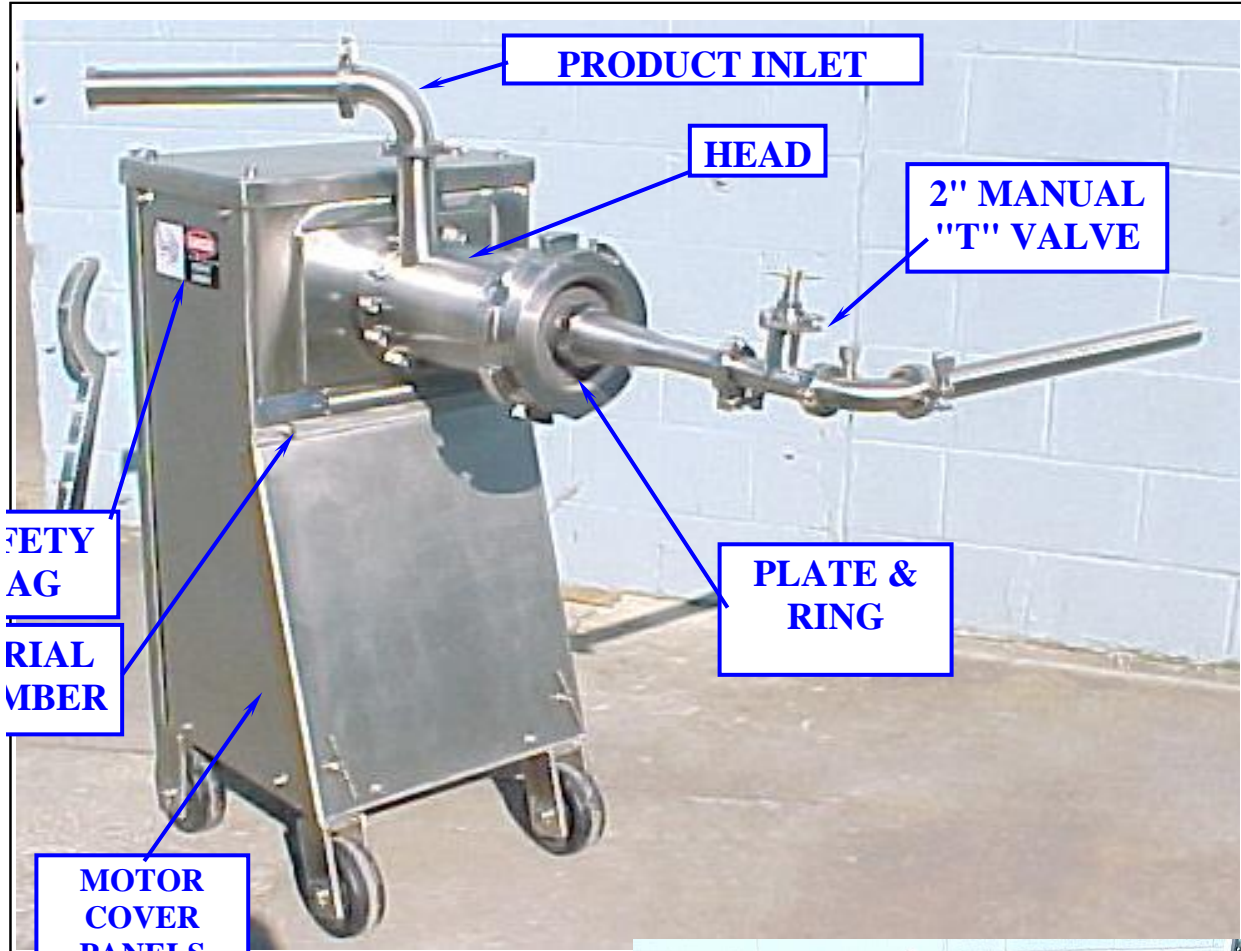
**MODEL 160MM  
GRINDER UNIT**



## **CAUTION**

**THIS MANUAL MUST BE READ TO,  
OR BY EACH PERSON, BEFORE  
THAT PERSON OR DEPARTMENT  
UNCRATES, OPERATES,  
MAINTAINS, OR SUPERVISES USE  
OF THIS MACHINE IN ANY WAY.**

**SAFETY INSTALLATION OPERATION MAINTENANCE**



**TYPICAL DIXIE 160MM GRINDER**

LISTED BELOW IS THE DEFINITION OF THE HAZARD LEVEL USED ON THE SAFETY STICKERS.



**IMMEDIATE HAZARDS WHICH WILL RESULT IN SEVERE PERSONAL INJURY**



### **KNOW YOUR MACHINE**

**READ OPERATING & SERVICE INSTRUCTIONS BEFORE INSTALLING PARTS OR SERVICING MACHINE IN ANY MANNER, BE SURE THAT MACHINE IS STOPPED AND ALL POWER IS OFF AND LOCKED OUT. THIS INCLUDES ELECTRICAL, HYDRAULIC, AIR, STEAM, ETC. FAILURE TO FOLLOW THIS RULE, OR TO PRACTICE SAFE OPERATING PROCEDURES CAN RESULT IN SEVERE PHYSICAL INJURY.**

### **INTRODUCTION**

A Grinder Unit is a type of size reduction machine. Its primary purpose is to grind meat, meat by-products, and other similar products.

The primary grinding components are a plate retaining ring, orifice plate, plate bushing, knifeholder with knife inserts, centering pin, spring or springs, head, and feedscrew. An electric motor drives the grinder unit.

This unit is mounted on a undermount frame (as shown on cover) or sidemount frame.

Standard safety equipment includes a belt guard. This unit uses a C-face motor, but the gearbox and motor are completely enclosed. For this application, a 1/16" diameter hole plate is supplied. Therefore a plate guard is not required, if other diameter holes are used a plate guard may be necessary. Consult Dixie Grinders if other diameter plates are to be used. If a transition funnel is used, the plate guard is also not required.

It is important that your application, and/or installation does not render these guards ineffective. If for any reason you believe these guards are not adequate, do not use the machine and call Dixie Grinders Inc. at once. (256) 582-0477 OR (800) 745-0586.

This machine was sold for a specific application. If you are not familiar with the application that this unit was sold for, check with Dixie Grinders Inc. before using the machine.

All operators and sanitation personnel should read this manual and understand it.



TAG A. 2 EA. (ON SIDES OF CABINET)



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TAG B. 2 EA. (ON BACK & TOP OF CABINET)

## "THE GRINDER HAS ARRIVED"

### **LIFT EQUIPMENT REQUIRED:**

We recommend using a 2,000 pound capacity fork lift with 48" or longer forks. Only authorized and properly trained equipment movers should attempt to unload the grinder unit. Remember to Work Safely!

### **PRE-UNLOADING INSPECTION:**

Before the grinder unit is unloaded, inspect the unit for any damage before unloading. If the machine is damaged consult your management, the trucking company, and Dixie Grinders Inc. before unloading the machine!

### **UNLOADING GRINDER UNIT:**

With the commercial van properly chocked and secured to the loading dock, and using only approved and adequate dock plates should any attempt be made to unload this machine. The forks should be long enough to extend beyond the end of the frame a safe distance. Unload the grinder unit and all parts that have been shipped with the grinder unit. Consult the packing slip to insure that all pieces have been unloaded.

### **UNPACKING:**

When the grinder has been properly unloaded it should be placed in a suitable location for unpacking. The belt guard protector and the shipping skids may be removed. Use appropriate equipment and appropriate personal safety equipment in this process. Remember to Work Safely!

### **SITE CONSIDERATIONS:**

It is important that the permanent position of the grinder unit provides clearance of several feet behind, to either side, and approximately eight feet or more in front of the grinder unit.

If the grinder is set on a stand, or leg extensions are attached, an adequate platform must be provided to provide safe access to the grinder unit. It will be necessary to have an approved platform or device to provide access so the unit can be properly sanitized, disassembled, assembled, and maintained. Consideration must be given to allow for complete service to the grinder unit.

The grinder frame is not to be used as a personal stand, and under no circumstances should anyone be allowed to climb on it or use it as a platform. Remember to Work Safely!

### **HEIGHT ADJUSTMENT:**

The legs on the grinder are adjustable. To adjust the height of the grinder, loosen the set screws, move the legs to the desired height, and retighten the set screws. **Make sure that the set screws are tightened securely! Be sure to tighten the set screws after moving the grinder! After you have adjusted the legs to the desired height, weld the legs in place! Failure to do so may cause the grinder to tip over!**

# **POWER LOCKED OUT!**

## **INSTALLATION:**

The machine can be installed in its permanent position after the skidding has been removed. Use only adequate equipment and properly trained personnel to install the grinder in its permanent position. Use great care in moving this equipment, it is heavy and must not be tipped, tilted, jarred or jammed into position. We recommend a 1° slope to allow water to drain from the grinder unit.



Dixie Grinders Inc. does not supply motor controls, starters, stop/start stations, disconnects, or other related equipment that is required to control the function of the grinder unit.

We recommend serious consideration is given to the location of the start/stop station.

We strongly recommend that additional stop stations are located where deemed appropriate.

Disconnects that can be locked out should be so located that employees that have to operate, service, and sanitize the unit can lock the unit out. Each employee that has to work on this machine should be given a lock and key and trained in proper procedures for LOCK OUT/TAG OUT!

Please consult with your Safety Engineer, your Electrical Engineer, and O.S.H.A. for all regulations related to the controls and wiring for this machine.

We strongly recommend the use of a frequency controller for this machine and it's application. By the use of a frequency controller the grinders capacity can be matched to the expel rate of the bone collector that is feeding this grinder.

It has been proven that if this unit is energized by the primary grinder that the ease of operation is greatly simplified. However precautions must be taken to insure that this machine is not started while it is being worked on. We strongly recommend that this machine is provided with a disconnect or power cord so the operator or persons that are assembling this machine can lock the power out!

# **POWER LOCKED OUT!**

## DISASSEMBLY TOOLS:

If the grinder is not located on floor level make no attempt to disassemble the grinder unit without an adequate platform or provisions provided by the installation contractor, plant engineer, or plant safety officer. The grinder has many parts that have square edges and cutting edges. Adequate safety equipment should be used at all times!

After the grinder has been installed in its permanent position, it can be disassembled.

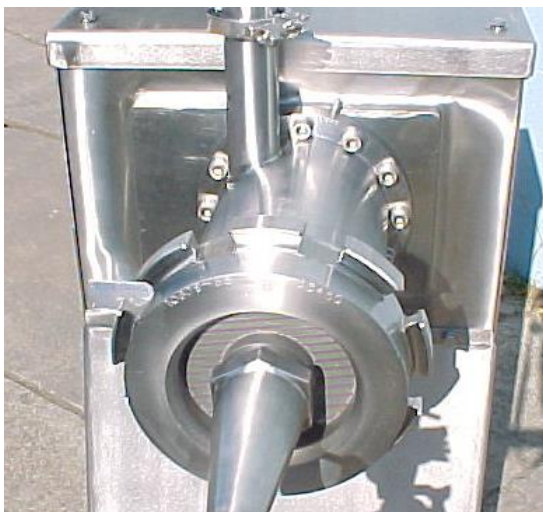
The tools described below are for both disassembly and assembly of the grinder unit.

### Ring Wrench

The Ring Wrench fits over the lugs of ring and is used to loosen the ring (counter clockwise), or tighten the ring (clockwise)



The end of the ring wrench fits into the end of the feedscrew and it can be used to engage the feedscrew to the drive spline.



### Note:

Wear appropriate safety equipment and remember to always "Work Safely".

## GRINDER UNIT DISASSEMBLY:

READ AND UNDERSTAND THE FOLLOWING TAG.

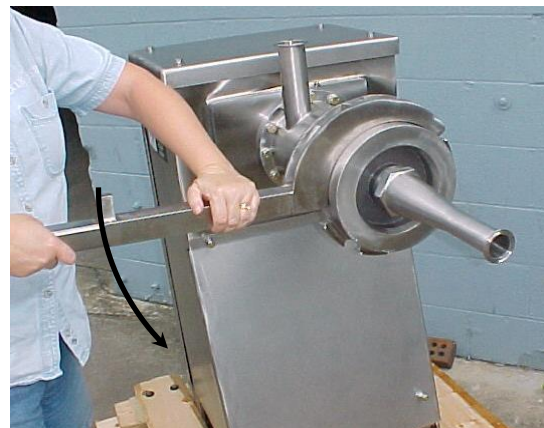


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When the grinder unit has been properly secured, disassembly can begin.

**Step 1.** Using the ring wrench, loosen the ring by exerting downward pressure, as shown, turning the ring counter clockwise.

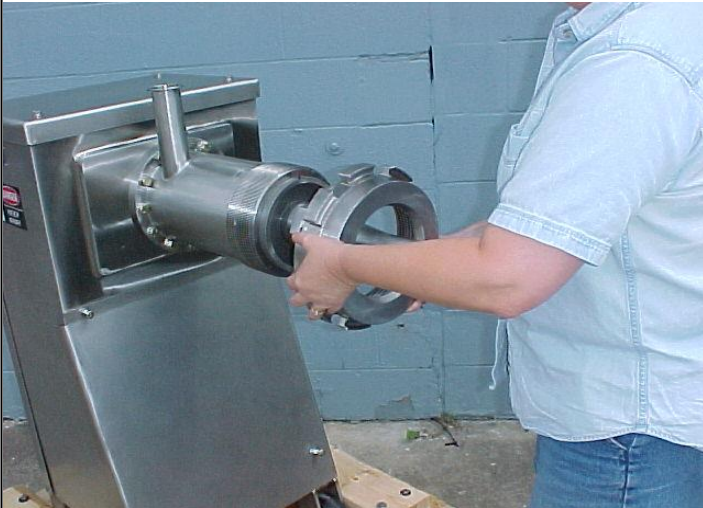


# POWER LOCKED OUT!

**Step 2.** When the ring has been loosened turn it off by hand, and remove it from the grinder.



**Step 2, continued. Remove the ring,**



**POWER LOCKED OUT!**

**Step 3. PLATE REMOVAL:**  
Loosen the Bushing Holder, (counter - clockwise) one turn. It may require a 3" open end wrench to loosen it. Turn it one full

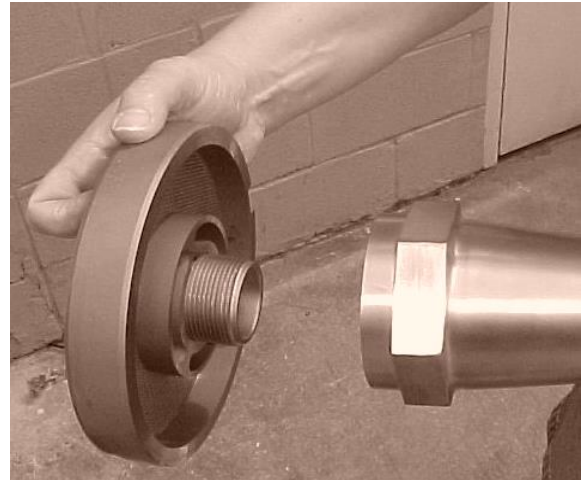


Holding onto the Bushing Holder remove the plate, bushing holder and bushing from the grinder unit.



**POWER LOCKED OUT!**

**Step 4. Remove the Bushing Holder from**



**Step 5. Remove the plate bushing from the grinder plate.**

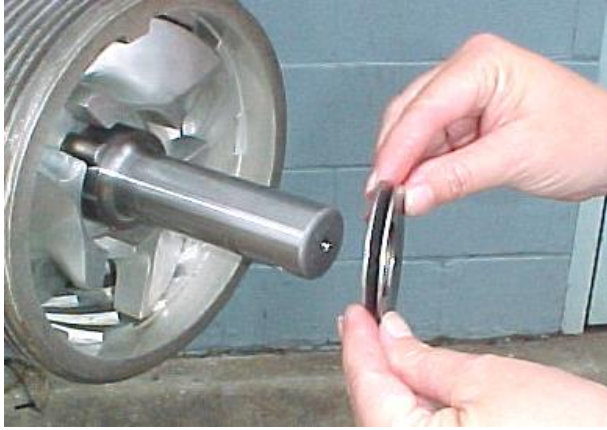


**Step 6. Remove the Knifeholder. It may be sharp, after all it is called a knifeholder.**





**Step 8** Remove the knife tension springs.



**Step 9.** Remove the centering pin. A hole is drilled thru the pin if the pin is slippery or you don't have much of a grip. A 3/8" x 6" dowel pin works nice, or tire iron from some imported car will work.



**Step 9 continued.** Do not loose the pin key!



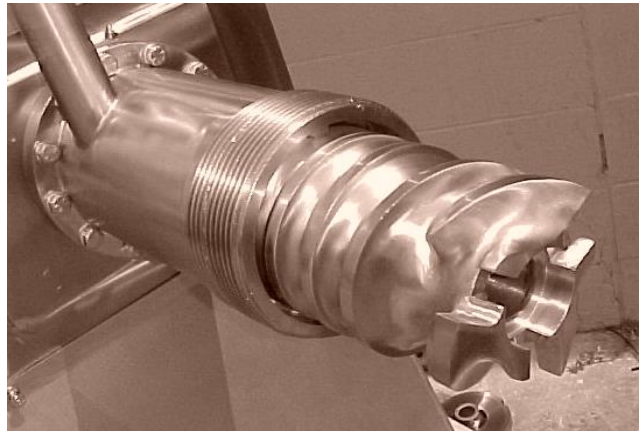
**POWER LOCKED OUT!**

**Pin Key (10010-1)**



**Pin part no. 10536**

**Step 10.** Remove the grinder feedscrew. This feedscrew weighs 58 pounds, if it is too heavy for you, get help.

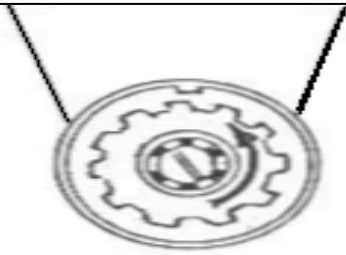


**Step 11.** Remove the excluder seal.



**Step 12** Inspect the adjustment bolt.





**ROTATION:** When the grinder unit has been disassembled, and then wired according to all applicable codes and regulations, rotation can be checked. **Do not turn the unit on until you are positive that no one is in harms way!** The grinder feedscrew should turn counterclockwise! After the rotation has been checked **LOCK OUT THE POWER!**



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**SANITATION:** Appropriate clothing should be worn, and all safety precautions should be taken before cleaning any equipment. The feedscrew, head and ring are stainless steel. The knife inserts, pin and orifice plate high carbon or tool steel. Use appropriate cleaning agents. If acid rince is required, rince with clear water. Do not use high pressure streams of water to clean a grinder unit. It is possible to drive water past the oil seals and damage the gearbox.

The grinder inserts, pin and orifice plate should be placed in mineral oil, or completely dried and kept in a dry place until needed.

If the machine is not going to be used for an extended period, apply a coat of edible grease to all surfaces and wrap the grinder in plastic.

**SANITIZERS:** Iodine sanitizers. Iodine reacts with tin. If the Iodine is in sufficient strength and has been on the tin plated surfaces long enough it will turn anything that touches the surface deep purple. Other sanitizers also may react with tin plated or stainless steel surfaces. Check label instructions before using.

**UNIT ASSEMBLY:** Please study all of the grinder parts shown on the exploded view before you attempt to assemble the grinder unit. The exploded view is at the rear of the maintenance instructions. (These instructions assume that the grinder unit has not been disassembled any further than the instructions already given.)

**MAKE SURE THE POWER IS STILL LOCKED OUT BEFORE ASSEMBLY.**

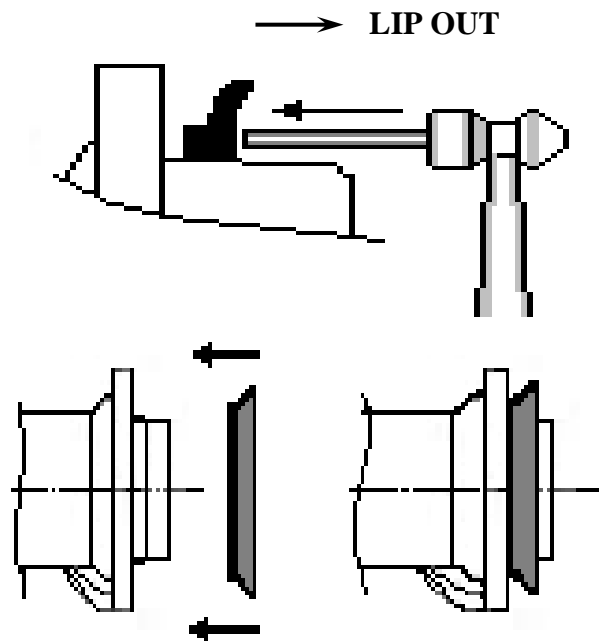
**POWER LOCKED OUT!**

## UNIT ASSEMBLY:

Please study all the grinder parts shown on the exploded view before you attempt to assemble the grinder unit. (The exploded view follows the Maintenance section.) (These instructions assume that the grinder unit has not been disassembled any further than the instructions have already given.)

**Step 1.** Inspect the excluder seal. It should be clean and free of nicks, cracks, or tears. If the excluder seal is damaged it should be replaced.

It may be necessary to tap the excluder seal in position. Use a rounded punch and soft taps to help it in its proper position. Do not use a screw driver or other pointed objects. Push only around the center of the seal, do not push on the soft lip. Apply force at the hub of the seal, as shown. The lip of the excluder seal faces out, and contacts the hopper flange.



Apply a small amount of edible grease, vegetable shortening, tallow, lard, chicken fat, bear fat, or some other lubricant to the face of the seal. (Check with your Quality Control Dept. and your USDA representative for approved material)



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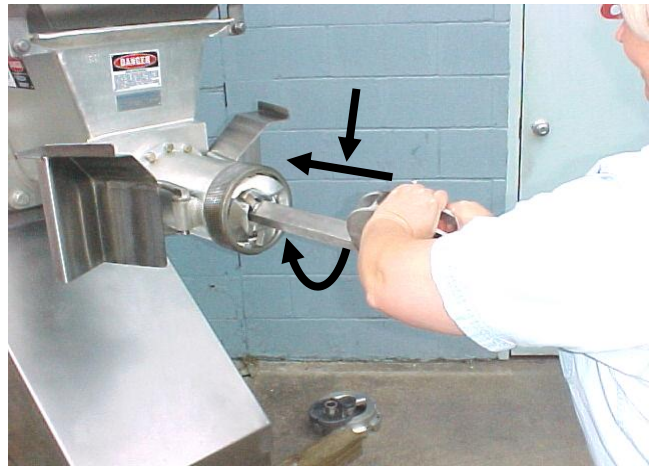


Apply a small amount of the same lubricant to the spline teeth.

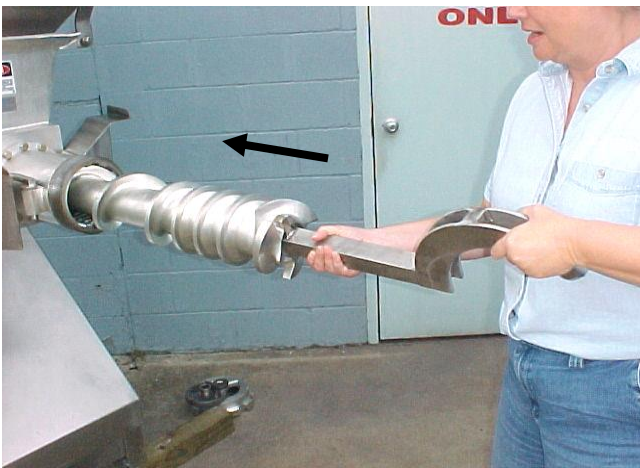
# POWER LOCKED OUT!



Step 2. Place the feedscrew into the grinder head as shown. Using the end of the ring wrench, lift up, and push the feedscrew further into the unit.



The feedscrew may stop before it is engaged on the drive spline. Push down, in, and turn the feedscrew. You will feel the feedscrew slide into place on the drive spline.



Continue to push the feedscrew in while lifting up on the handle.



When the feedscrew is installed properly the feedscrew will be 3/4" (19mm) from the end of the head. If this distance varies, check the thrust screw, add or subtract washers to obtain the 3/4" dimension.



# Power Locked Out!



# Power Locked Out!

# POWER LOCKED OUT!

**Step 3. INSTALL CENTERING PIN.**  
Inspect the pin to make sure it is clean and free of nicks and burrs. Replace the pin when it shows wear grooves, checks, or is worn.



**Step 4.**  
Install the springs, they go in back to back.



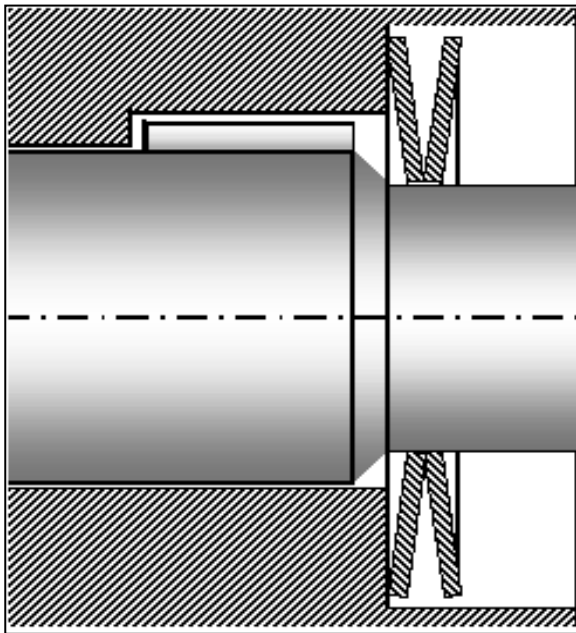
Place the pin key into the slot in the centering pin.



The first spring cup is facing down, the second spring is cup facing out.

Do not tap the pin into place, it should slide in. The key may need to be tilted slightly so that it fits properly, but do not beat the pin into place with a hammer, it will be just about impossible to remove the pin if you do.

# POWER LOCKED OUT!

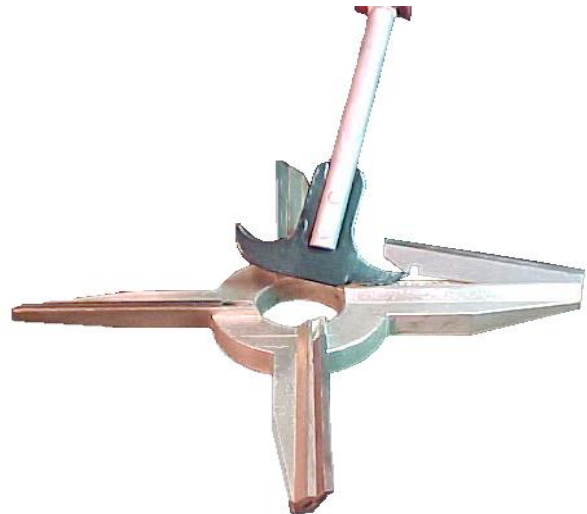


In the above illustration notice that the face at the outer diameter of the first spring is touching the counter bore in the face of the feedscrew. The second spring is opposite and will contact the knife in the same fashion. Do not stack the springs one on top of the other like dishes, this doubles the spring force and will provide too much force against the knife inserts. Do not use more than two springs.

The Belleville springs provide a better power curve than coil type springs, and are designed to provide near uniform power over the life of the knife inserts.

**POWER LOCKED OUT!**

### Step 5. REPLACE INSERTS



Inserting the pointed end of our insert remover into the slot of the knifeholder provides a quick and easy way to remove the knife inserts. Removing them in this manner minimizes damage to the insert locating pins found in the bottom of the insert slots in the knifeholder. We recommend starting with fresh inserts at every plate change! This includes when turning the plate around.

### Step 6. INSTALL KNIFEHOLDER.



The knifeholder with fresh inserts simply slides over the pin and contacts the spring. The inserts face out! Be careful, the inserts are sharp.



**Step 7. INSPECT THE ORIFICE PLATE:**  
(This inspection is performed with the plate out of the machine.)

**Sharp plates may cut you, be careful!**

**MIMIMUM RECOMMEND PLATE THICKNESS IS 3/4".**

Inspect the plate before each use.

Inspect the edge of the holes, they should form sharp corners.

The plate should be clean.

Check for discolored plates, do not use a plate with a deep blue coloring between the holes.

Check for cracks, especially between the holes. If cracks are present, do not use the plate.

Check for grooves, broken holes, and any other defect.

Do not use defective orifice plates.

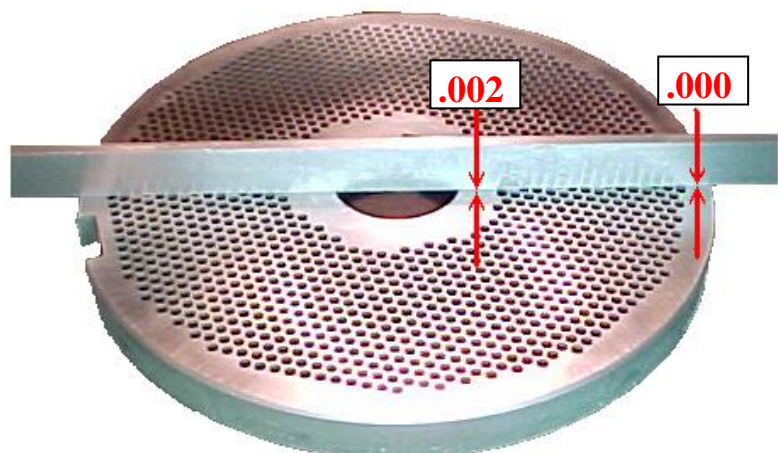
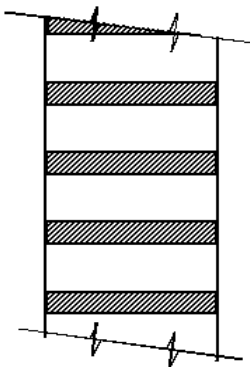
We recommend that a fresh plate surface should be used every 8 hours of operation. Operations that run empty or with hard to grind materials may have to change plate surfaces every 4 hours.

Grinder Plates should be sharpened with a vertical type surface grinder, typically called a "Blanchard Type". With this type of surface grinder the plate should be placed directly over the center of the table. We do not recommend sharpening the plates when they are placed out on the table, not directly over the center of the table.

We recommend using our grinding wheels to sharpen the plate. These specialized grinding wheels produce the correct surface finish to provide clean, cool, cutting. Plates that are not sharpened correctly will not grind even the softest of meats. The plates must be flooded with coolant when they are ground. The horsepower rating of your surface grinder will determine feed rate. The plate should be sharpened enough to restore the edge of the hole, and remove any discoloration from running empty (see Maintenance Instructions, Grinder Plates). Nicks and gouges should be ground out.

The plates should be ground perfectly flat, or slightly concave, .002 per side max.

**SHARP  
CORNER**





**Step 8 INSPECT THE PLATE BUSHING.**

The plate bushing should be clean, and free of nicks and burrs. Inspect the inside diameter, it is common to show wear because the bushing supports the weight of the feedscrew. Replace the bushing when there is .025 wear, or the inside diameter measures 1.280.

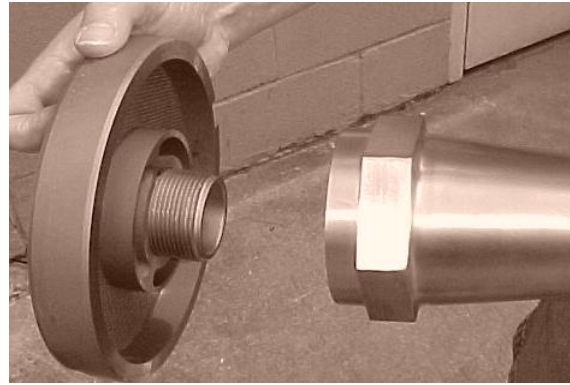
Apply a generous portion of edible grease, vegetable shortening, tallow, lard, chicken fat, goose grease, bear fat, or some other lubricant to the inside diameter of the bushing. (Check with your Quality Control Dept. and your USDA representative for approved materials.)

**Step 9. INSTALL PLATE BUSHING.**

Install plate bushing into orifice plate. Then lubricate the inside surface of the grinder plate. (The side that will be in contact with the knife inserts). Note, the lip of the bushing is to the inside. The knifeholder and inserts will not touch the lip of the bushing.



**Screw the Bushing Holder onto the bushing. Turn the bushing hand tight for now.**



**Step 10. INSTALL PLATE AND BUSHING and BUSHING HOLDER INTO GRINDER UNIT.**



Give the plate a little push up, while lifting on the pin and the plate should slide right into the machine.

**Step 11. Install the Ring.**

Apply a few dabs of bear grease to the threads on the head or ring. Screw the ring on, remember, righty tighty, lefty loosey.



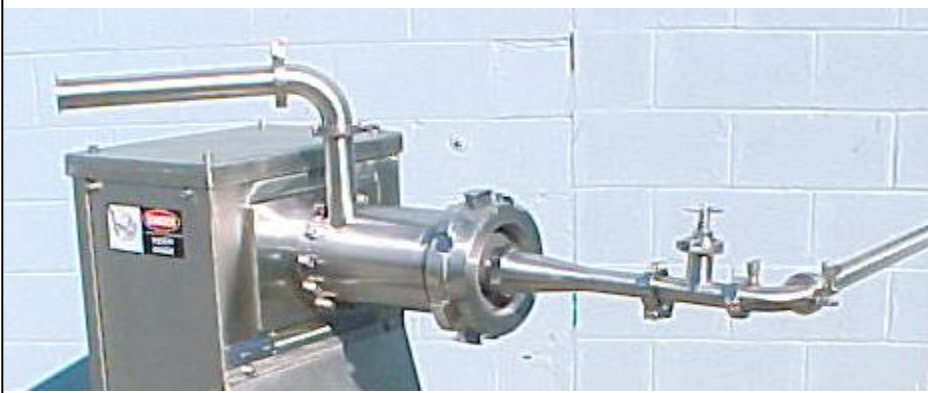




**Beleta is shown backing the ring up!**

**STEP 12. Tighten the ring by hand. Using the ring wrench, fully tighten ring, there is no need to pound on the wrench! Do not tip the machine over while tightening the ring. Back the ring up about one distance of one of the plate lugs. That's it, just back it up a little.**





**Step 13.** Install Inlet pipes and bone collector valve. It is important to use the sanitary gaskets, the fittings will not tighten properly without them.

# POWER LOCKED OUT!

## OPERATING INSTRUCTIONS.

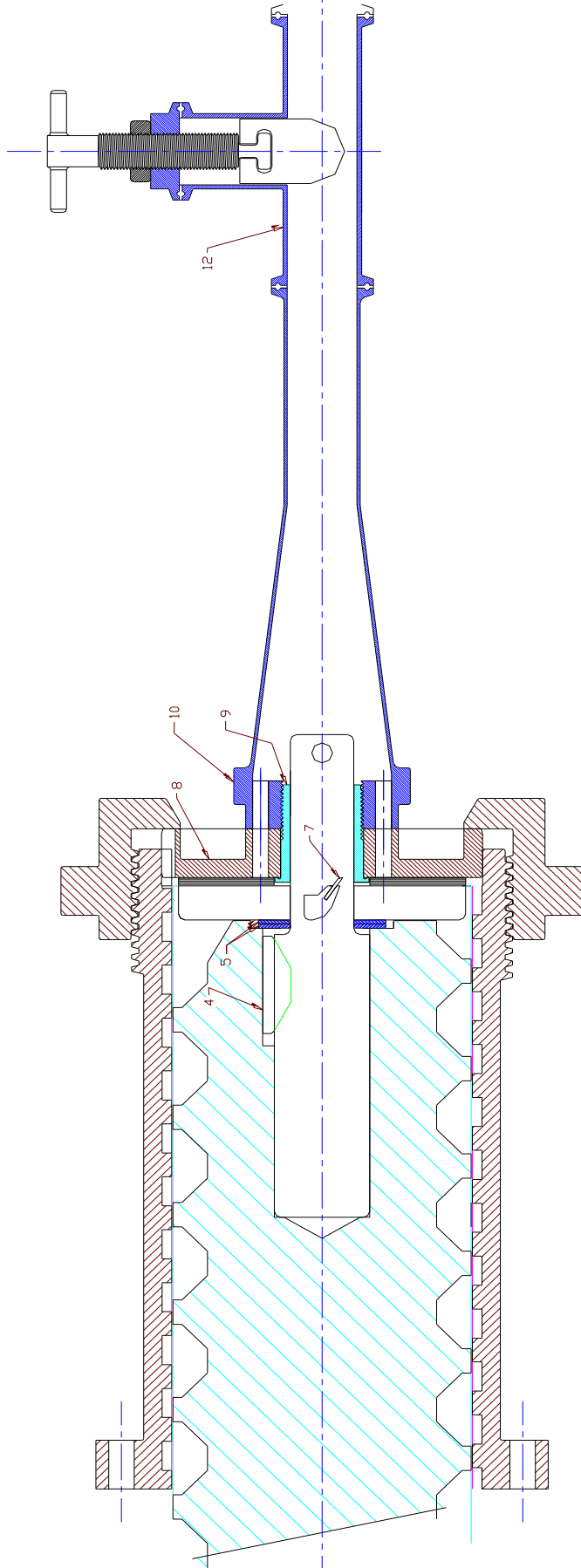
The grinder unit should never be left unattended while running. If you have to be away from your work station, turn the grinder off. If for any reason the grinder has to be taken apart, the **POWER SHOULD BE LOCKED OUT!** We recommend a strict policy that states *"Touching the grinder while the power is not locked out will result in immediate termination!"* This includes a plate change, or even removing the plate guard.

This is a specialized machine, intended to rework product from the bone collection of a larger grinder. If this unit does not resemble the above picture you have the wrong manual or the wrong grinder. The grinder unit should be turned on only when product begins to exit the plate of the larger feeding grinder.

The grinder should be turned off when product stops coming out of the grinder. If the grinder is left running without product, the knife inserts will rapidly dull and generate undesirable heat. The heat generated by the inserts will damage the plate. The pin and bushing rely on the product to supply lubrication and cooling. If the grinder is left running without product, the pin and bushing will also heat up and in some instances they weld together.

Do not grind products that were not intended for this machine. All grinder units are designed for a specific purpose. Do not attempt to feed product by hand into the inlet pipe or use this machine in any manner other than described above.

If you are unsure of what product this grinder was designed for, please call Dixie Grinders Inc. at (800) 745-0586 or (256) 582-0477.

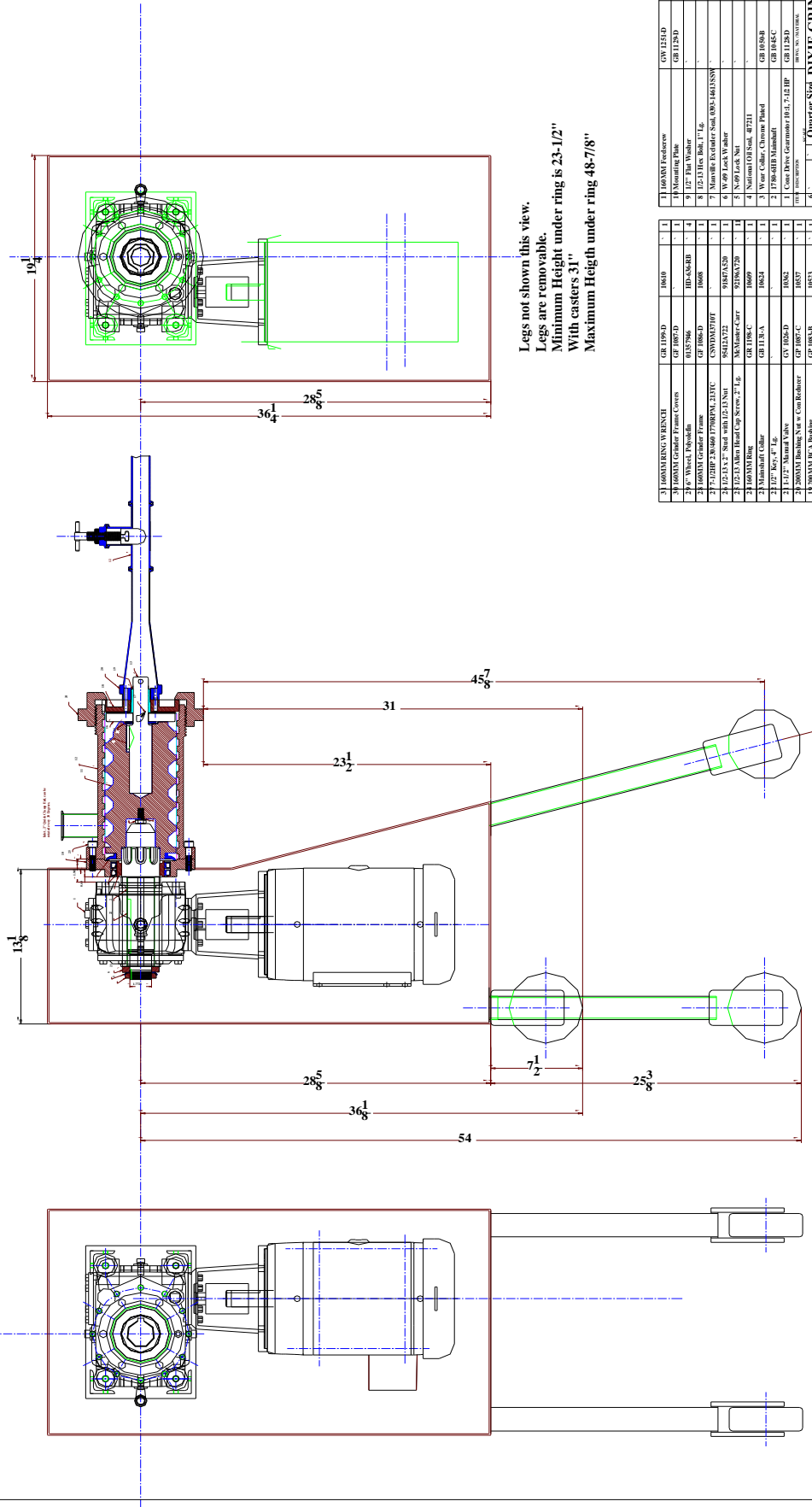


18-1/2" ECA VALVE ASSY.	EQ. 1082-D	1084	1
11.00MM RING	GR. 1072-D	1089	1
10.00MM ECA BUSHING NUT	GP. 1087-C	1093	1
9.00MM ECA PLATE BUSHING	GP. 1083-B	1083	1
8.00MM ECA THIN GRINDER PLATE	GP. 1083-D	1087A-D10A	1
7. PINTE INSERT	US. 1088-B	1098	1
6. 20MM ECA WAFER	US. 1082-C	1090	1
5. 20MM ECA WAFER	GP. 1088-A	1090	1
4. CENTERING PIN KEY	GP. 1088-D	1010-1	2
3. 20MM CENTERING PIN	GP. 1088-D	1083K	1
2. 20MM FEELERSCREW			1
1. 20MM SPIRAL FLUID HEAD	HD. 1145-D	1082	1
THE INFORMATION:			
6.	REV. NO. / MATERIAL	REV. NO.	REV. DT.
5.	REV. NO. / MATERIAL	REV. NO.	REV. DT.
4.	REV. NO. / MATERIAL	REV. NO.	REV. DT.
3.	REV. NO. / MATERIAL	REV. NO.	REV. DT.
2.	REV. NO. / MATERIAL	REV. NO.	REV. DT.
1.	REV. NO. / MATERIAL	REV. NO.	REV. DT.

This drawing was prepared by the design department of the company. It is the property of the company and is not to be reproduced, copied, or used in any way without the written consent of the company. The company is not responsible for any damage or injury caused by the use of this drawing. The company is not responsible for any damage or injury caused by the use of this drawing. The company is not responsible for any damage or injury caused by the use of this drawing.

160 MM SINGLE  
 WFS  
 PLATE ASSEMBLY

DATE: 10/28/08  
 BY: J. J. J.  
 REVISED: 10534  
 GK 1049-D



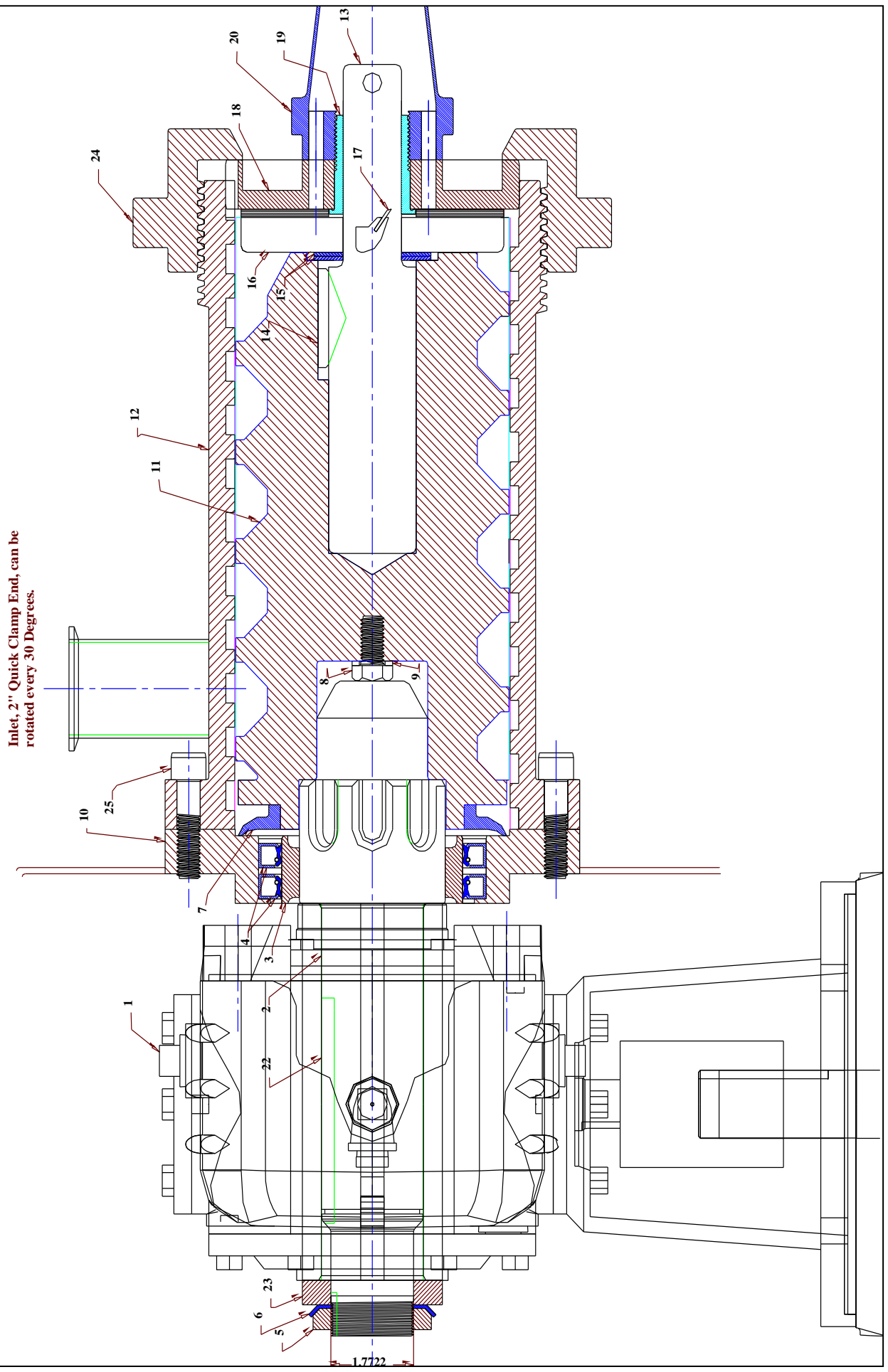
Legs not shown this view.  
 Legs are removable.  
 Minimum Height under ring is 23-1/2"  
 With casters 31"  
 Maximum Height under ring 48-7/8"

3	160MM WRENCH	GR 1096-D	1096-D			1	
3	160MM Grinder Frame Covers	GF 1097-D	1097-D			1	
2	8" Wheel, Polyform	BD-806-RB	10068			4	
2	160MM Grinder Frame	GF 1086-D				1	
2	7-1/2HP 230V 1700RPM 25TC	GMV035101	91874328			1	
2	1/2-13 x 2" Stud with 1/2-13 Nut	SC33888-arr	92708729			4	
2	1/2-13 Allen Head Cap Screw 2 Flt	SC33888-arr	92708729			4	
3	160MM Wheel	GF 1128-A	10067			1	
2	1 1/2" Dia, 4" Lg.	CV 1026-D	10067			1	
2	200MM Binding Nut w/ Con Washer	GF 1097-C	10057			1	
1	200MM B.C.A. Binding	GF 1083-B	10023			1	
1	160MM Grinder Thin B.C.A. Plate	GF 1086-C	10091			1	
1	Rubber Insert	GR 1088-C	10072			1	
1	160MM 3/8 Inset Roundover	GR 1088-C	10065			1	
1	200MM Springs	GF 1088-A	10054			2	
1	200MM Castor Pawl	GF 1086-C	10055			1	
1	160MM Castor Pawl	BD 1176-D	10066			1	

1	160MM Feeders	GV 1251-D	DCW 21154			1	
1	Mounting Plate	GR 1128-D	10097			1	
9	1/2" Dia Washer					1	
8	1/2-13 Hex Bolt 1" Lg.					1	
7	Mounting Exciter Stud (MS-1401558)					1	
6	18-99 Lock Nut		10022			1	
5	8-99 Lock Nut		10021			1	
2	Spring Castor Plate	GR 1088-B	10050			2	
2	1 1/2" Dia, 4" Lg. Castor	GR 1026-D	10028			1	
4	Conc Drive Gearmotor 10.1, 7.12 HP	GR 1128-D	10078			1	
1	160MM In-Line					1	
1	160MM In-Line					1	
1	160MM In-Line					1	
1	160MM In-Line					1	
1	160MM In-Line					1	
1	160MM In-Line					1	

Quarter Size  
 1-5-08  
 DIXIE GRINDERS INC.  
 160MM In-Line  
 Grinder Assembly  
 WFS

Inlet, 2" Quick Clamp End, can be rotated every 30 Degrees.



31	160MM RING WRENCH	GR 1199-D	10610	`	1
30	160MM Grinder Frame Covers	GF 1087-D	`	`	1
29	6" Wheel, Polyolefin	01357946	HD-636-RB	`	4
28	160MM Grinder Frame	GF 1086-D	10608	`	1
27	7-1/2HP 230/460 1770RPM, 213TC	CSWDM3710T	`	`	1
26	1/2-13 x 2" Stud with 1/2-13 Nut	95412A722	91847A520	`	1
25	1/2-13 Allen Head Cap Screw, 2" Lg.	McMaster-Carr	92196A720	`	11
24	160MM Ring	GR 1198-C	10609	`	1
23	Mainshaft Collar	GB 1131-A	10624	`	1
22	1/2" Key, 4" Lg.	`	`	`	1
21	1-1/2" Manual Valve	GV 1026-D	10362	`	1
20	200MM Bushing Nut w Con Reducer	GP 1087-C	10537	`	1
19	200MM BCA Bushing	GP 1083-B	10523	`	1
18	160MM Grinder Thin BCA Plate	OP 1056-C	10601	`	1
17	Knife Insert	GK 1008-B	1972	`	3
16	160MM 3-Bladed Knifeholder	GK 1048-C	10602	`	1
15	200MM Springs	GP 1088-A	10543	`	2
14	Pin Key	`	10010-1	`	1
13	200MM Centering Pin	GP 1086-C	10536	`	1
12	160MM head	HD 1170-D	10606	`	1

11	160MM Feedscrew	GW 1251-D	DGW 2-13-74	`	1
10	Mounting Plate	GB 1129-D	10607	`	1
9	1/2" Flat Washer	`	`	`	1
8	1/2-13 Hex Bolt, 1" Lg.	`	`	`	1
7	Manville Excluder Seal, 0393-14613 SSW	`	10603	`	1
6	W-09 Lock Washer	`	1022	`	1
5	N-09 Lock Nut	`	1021	`	1
4	National Oil Seal, 417211	`	1030	`	2
3	Wear Collar, Chrome Plated	GB 1050-B	1037	`	1
2	1780-6HB Mainshaft	GB 1045-C	2878	`	1
1	Cone Drive Gearmotor 10:1, 7-1/2 HP	GB 1128-D	MSHV30X8B	`	1

ITEM	DESCRIPTION	DRWG. NO. / MATERIAL	PART NO.	WT.	QTY.
6	SCALE <b>Quarter Size</b>	<b>DIXIE GRINDERS INC.</b> GUNTERSVILLE AL 35976 <b>160MM In-Line Grinder Assembly</b>			
5	DATE <b>1-5-08</b>				
4	DRAWN BY <b>WM. F. SELNOW</b>				
3	APPROVED BY <b>WFS</b>				
2	TOLERANCE UNLESS SHOWN				
1	FRACTION +/- 1/32" DEC. .0 +/- .050 DEC. .00 +/- .010 DEC. .000 +/- .003	PART NO.	NET WT.		
<b>NO. DATE BY</b>		<b>DRAWING NUMBER</b>			
<b>REVISION</b>		<b>BD 1066-D</b>			