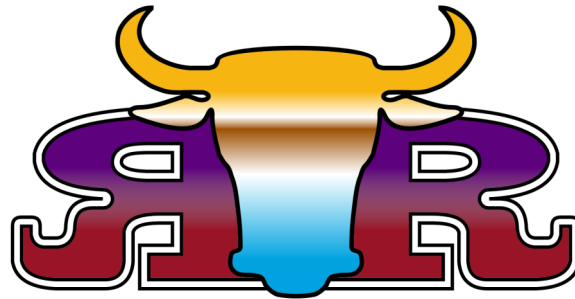


R & R Machine Works Inc.



We really appreciate you making this purchase from us and we hope it meets your expectations. We strive to sell equipment that will make your business as well as ours, prosper. When you have future equipment or service needs please think of us first!

If we can be of further services to you or your company, please call us at
(806) 244-5686.

Sincerely,

Owners and Management
Dalhart R&R Machine Works, Inc.



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INTRODUCTION

Your new cracker is a quality mill that will give you many years of low cost operation if given the proper amount of care and maintenance.

Your mill has been engineered and designed with simplicity of operation in mind, but first and foremost to give the best quality product at maximum operating capacity.

Your cracker manufacturer stands ready to serve you at any time with service, whether it is in the form of maintenance and operating instructions, or on location with help performed by a qualified factory representative.

Your cracker manufacturer has, on hand at all times, any replacement part for your mill that you will need, and a supply of rolls corrugated and journaled to fit your mill and your operation.





GENERAL SAFE PRACTICES

ALWAYS OBSERVE SAFE OPERATING PRACTICES AROUND MACHINERY. MOST ACCIDENTS ARE THE RESULT OF CARELESSNESS OR NEGLIGENCE. ALL ROTATING MACHINERY IS POTENTIALLY DANGEROUS.

OPERATION

READ OWNERS MANUAL BEFORE OPERATING.

MAINTENANCE

SHUT OFF AND LOCK OUT MAIN POWER SOURCE. DO NOT DO MAINTENANCE UNTIL ALL MOVING PARTS HAVE STOPPED.

DO NOT USE CRACKER MILL WITHOUT GUARDS IN PLACE.

FAILURE TO COMPLY WITH SAFETY INSTRUCTIONS CAN RESULT IN INJURY OR DEATH.



INSTALLATION

The installation of your cracker mill should be carefully planned and well engineered.

The following points should be followed to get the most out of your mill, both in capacity and quality:

1. There should be sufficient space around the machine for adjustments, repairs, and removal of rolls for recorrugation.
2. The mill should be installed on a level surface capable of withstanding the weight of the mill.
3. If the surface is not level, shims or grout should be used to avoid warping or binding the frame.
4. Install motor and drive as recommended by the factory. If the motor base or rails are not mounted, the motor must be fastened securely and the V-Belts aligned with the available space to tighten belts at a later time.
5. Provisions should be made to adequately feed the Mill.
6. Provisions must be adequate to take the product from the Mill. This is usually done by any of several methods.
7. Rolls must be kept in TRAM at all times. It is especially important when rolls are changed.



TIPS ON OPERATING YOUR MILL

R&R Machine Works Mills are designed to efficiently produce a high quality of commercial grade product.

The capacity of your mill will be dependent on the following conditions either singly or in combination.

1. Size of product
2. Toughness or Friableness of product
Friable-easily crumbled or pulverized
3. Moisture content
4. Amount of conditioning
5. Size of desire product
6. Foreign material present
7. Corrugation on rolls

The capacity can be increased somewhat if the quality of the final product is not critical.

The rolls are usually set further apart when grinding larger size particles. It may be necessary to adjust the spring tension to obtain your desired final product. This adjustment is explained in this manual.

As the corrugation begins to wear off, you will not notice the decrease in capacity at first, but as the corrugation becomes duller, the capacity will be greatly reduced from the original corrugation. Also, it will be hard to meet grind specs. When this occurs, the rolls should be re-corrugated.

NOTE: Be careful when making adjustments. Do not allow the rolls to run together. This will cause the corrugation to become dull very rapidly.



ADJUSTMENTS

Your R&R Machine Works Mill was shipped assembled and adjusted, but to meet your requirements, certain re-adjustments may be made as necessary to control rate of production and quality of product.

The following section will aid you with these adjustments to meet your requirements.

TO SET FEED RATE

CAUTION: CARE SHOULD BE TAKEN TO KEEP FINGERS AWAY FROM MOVING PARTS.

To increase feed rate:

1. Release lock and move feed gate upward to desire feed rate and set lock.

To decrease feed rate:

1. Release lock and move feed gate downward to desired feed rate. Reset lock.



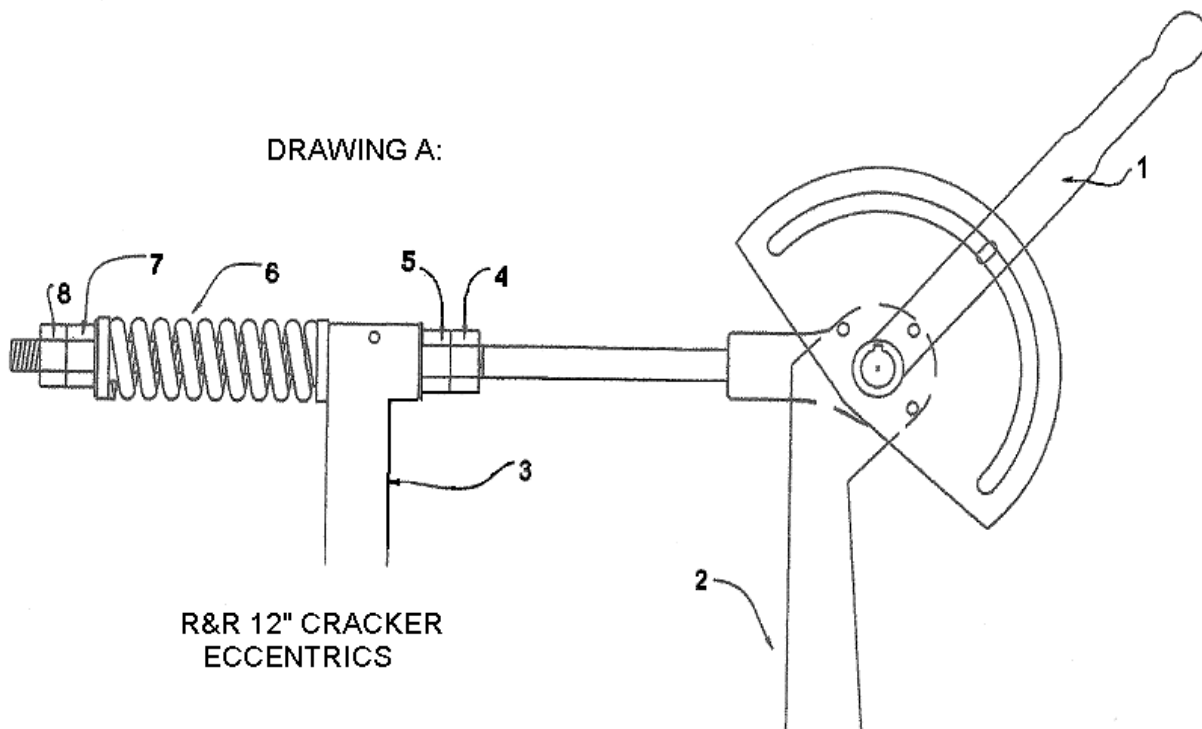
TO SET ROLL CLEARANCE

Refer to Drawing A:

1. Assure power to the mill is shut off.
2. Pull adjustment handle #1 down until rolls come together. This clearance has been preset upon leaving factory at .016”.
3. Place feeder gauge of desired clearance between rolls. Loosen jam nuts #4 and #8. Adjust nut #5 according to gauge-turn toward swivel housing #3 to increase roll clearance; turn away from housing #3 to decrease roll clearance.
4. Adjust nut #7 equal to nut #5 to retain spring tension. Normally the spring preload (difference in spring free length and compressed length) should never be greater than one inch. If more spring tension is needed to maintain product consistency, tighten nut #7 towards housing #3 until desired product is achieved. Tighten jam nut #8 up against nut #7.

Note: Be sure to adjust nuts equal amounts on each side of machine.

5. When desire setting is obtained; tighten jam nuts, #4 and #8 to lock roll setting.
Desire settings for each type of grain will be determined by experimentation depending on conditions.



HOW TO START YOUR MILL

BEFORE STARTING:

1. Check feed control gate – it should be closed.
2. Move roll adjustment to open position (this moves rolls apart).

TO START MILL:

1. Start motor.
2. Move roll adjustment to closed position (this moves rolls together).
3. When mill comes up to speed, adjust feed rate to desired amount.

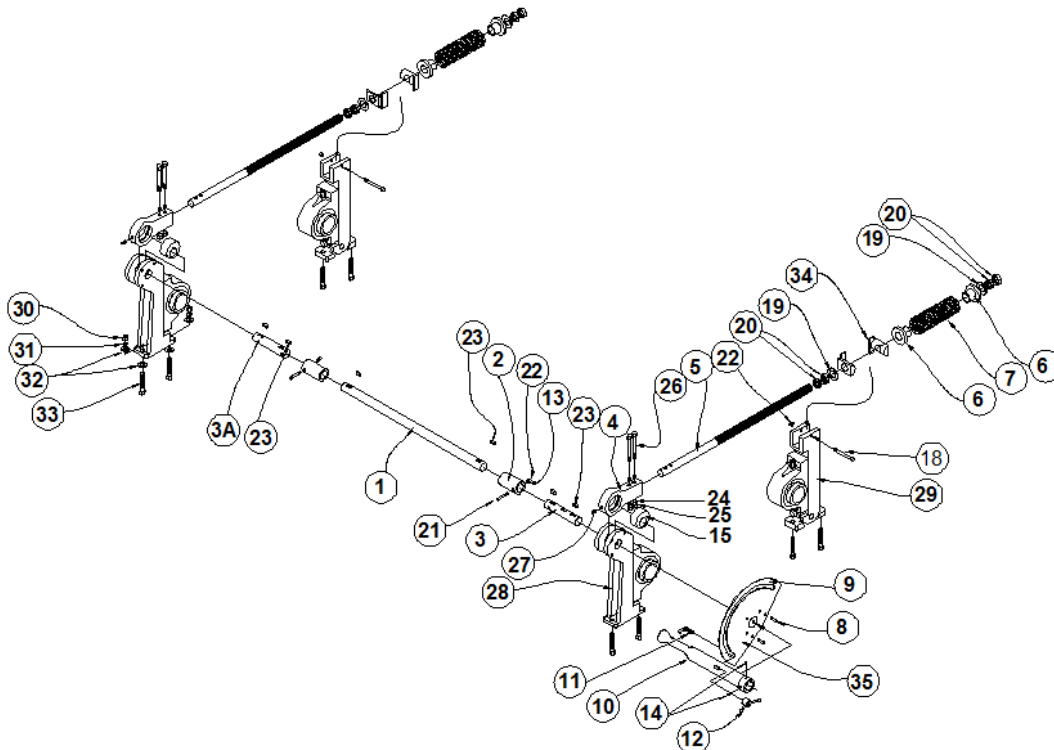
TO STOP MILL:

1. Shut feed off above mill.
2. Close feed gate.
3. Open rolls – move roll adjustment to open position.
4. Stop motor.



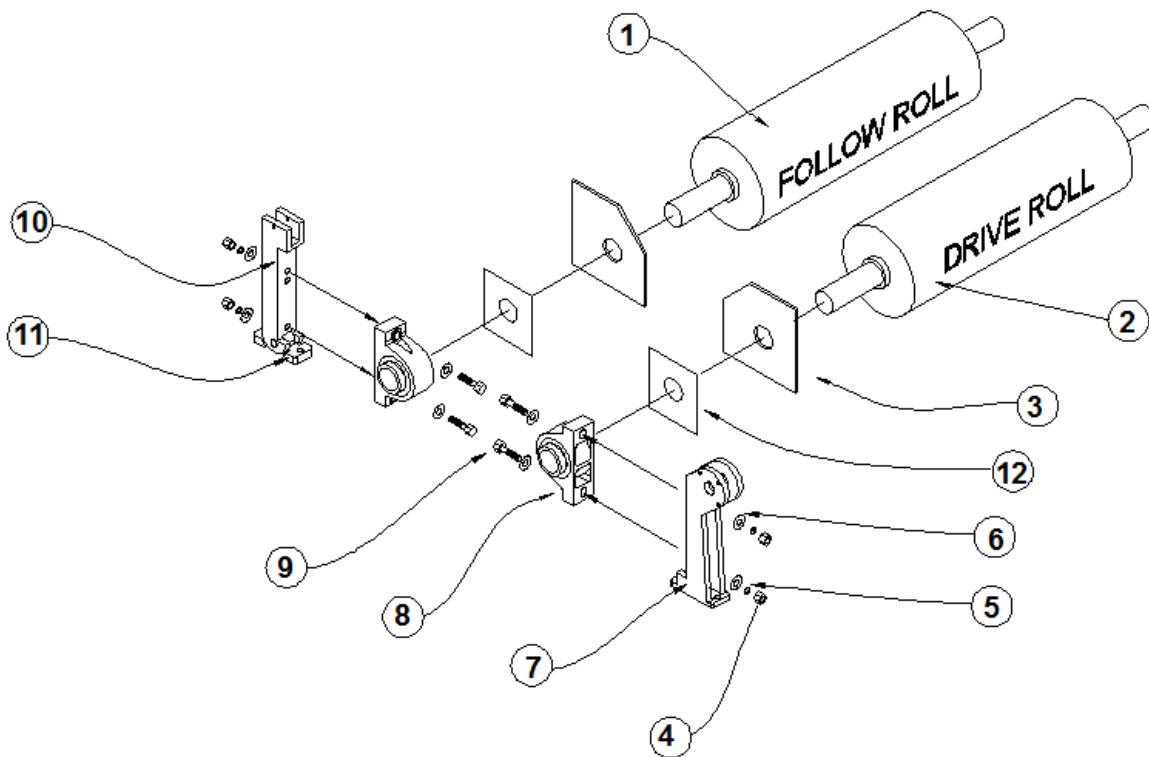
12" CRACKER ECCENTRIC ASSEMBLY

| # | PART# | DESCRIPTION | # | PART# | DESCRIPTION |
|----|------------|----------------------------|----|------------|----------------------|
| 1 | ECC0012A36 | ECCENTRIC CONNECTING SHAFT | 19 | WF114 | 1 1/4 FLAT WASHER |
| 2 | ECC0818 | CONNECTING SHAFT COUPLING | 20 | N114CT | 1-1/4 NUT |
| 3 | ECC0518 | ECC. LONG SHAFT | 21 | BOL38X3 | 3/8 X 3 BOLT |
| 3A | ECC0418 | ECC. SHORT SHAFT | 22 | N38 | 3/8 NUT |
| 4 | ECC0312 | ECCENTRIC HOUSING | 23 | KY38 | 3/8 X 1 KEY |
| 5 | ECC0712 | ECCENTRIC TENSION ROD | 24 | WL716 | 7/16 LOCKWASHER |
| 6 | ECC08SPW | SPRING WASHER | 25 | N716 | 7/16 NUT |
| 7 | ECC08S97 | TENSION SPRING | 26 | BOL716X312 | 7/16 X 3-1/2 BOLT |
| 8 | BOL38X1 | 3/8"X1 BOLT | 27 | GRSZK | 1/8 GREASE ZERK |
| 9 | ECC0012B | BRACKET | 28 | HSGR5 | STATIONARY HOUSING |
| 10 | ECC0012L | LEVER | 29 | HSGR6A | SWIVEL HOUSING |
| 11 | ECC0012BS | T BOLT | 30 | N58 | 5/8 NUT |
| 12 | ECC0012BSL | WING NUT | 31 | WL58 | 5/8 LOCKWASHER |
| 13 | WL38 | 3/8 LOCKWASHER | 32 | WF58 | 5/8 FLATWASHER |
| 14 | BOL38X1ST | 3/8X1 SET SCREW | 33 | BOL58X212 | 5/8 X 2 1/2 BOLT |
| 15 | ECC0218 | ECCENTRIC | 34 | ECCO8SPB | 12" SPRING PIVOT PAD |
| 18 | BOL38X312 | 3/8 X 3-1/2 BOLT | 35 | ECC0012S | OPEN/CLOSE STICKER |



BEARING ASSEMBLY LIST

| # | PART # | DESCRIPTION |
|----|-------------|--------------------------------|
| 1 | R1236 | 12 X 36 FOLLOW ROLL W/JOURNALS |
| 2 | R1236D | 12 X 36 DRIVE ROLL W/JOURNALS |
| 3 | DS12x38 | 3/8 FELT |
| 4 | N58CT | 5/8 NUT |
| 5 | WL58 | 5/8 LOCK WASHER |
| 6 | WF58 | 5/8 FLAT WASHER |
| 7 | HSGR5 | STATIONARY BEARING ARM |
| 8 | BRGZA6215ND | 2-15/16 PILLOW BLOCK BEARING |
| 9 | BOL58X4 | 5/8 X 4" BOLT |
| 10 | HSGR6 | SWIVEL BEARING ARM |
| 11 | HSGR7 | SWIVEL ARM BASE |
| 12 | DS8X8 | 8 x 8 x 1/8 POLY DUST SHIELD |

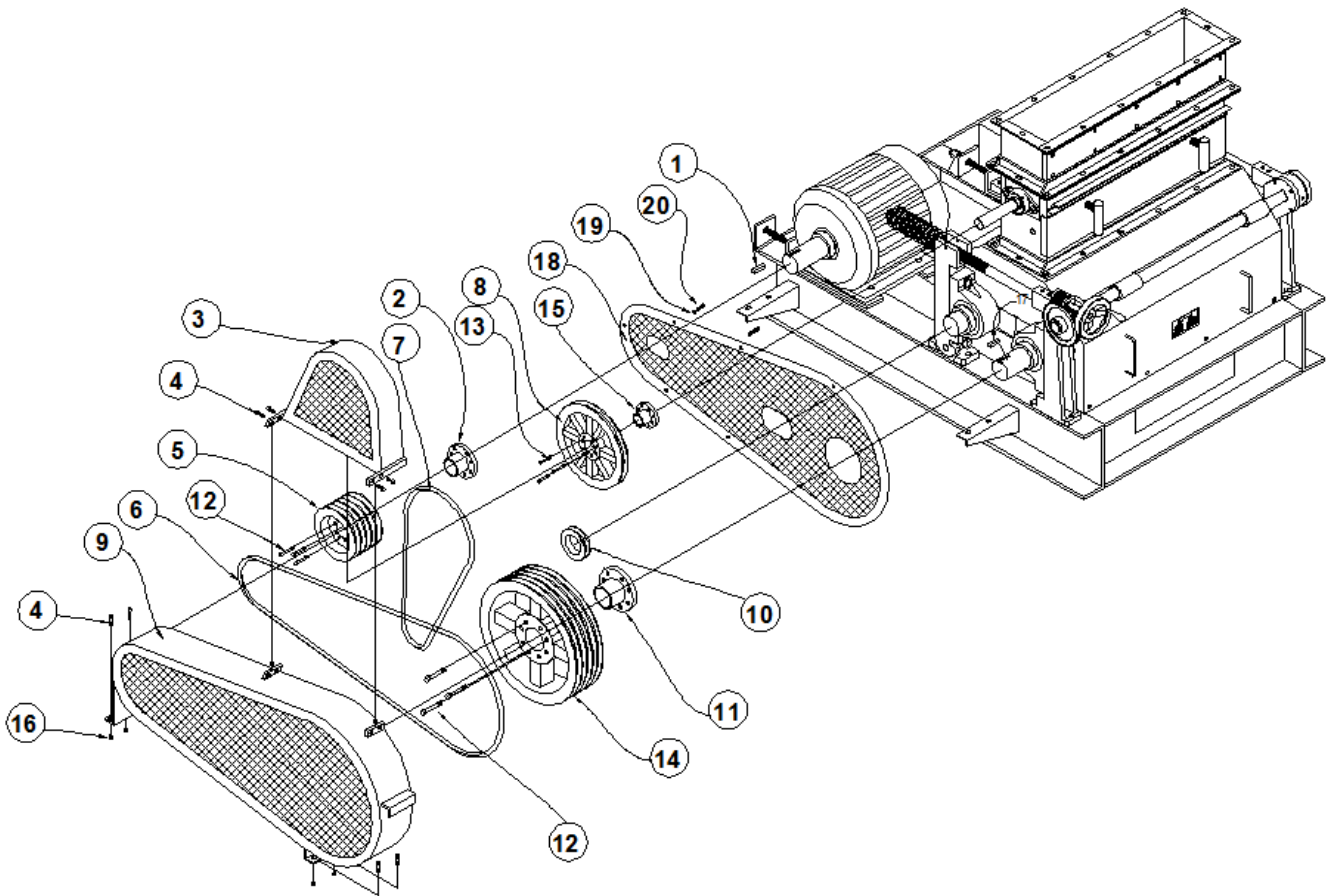


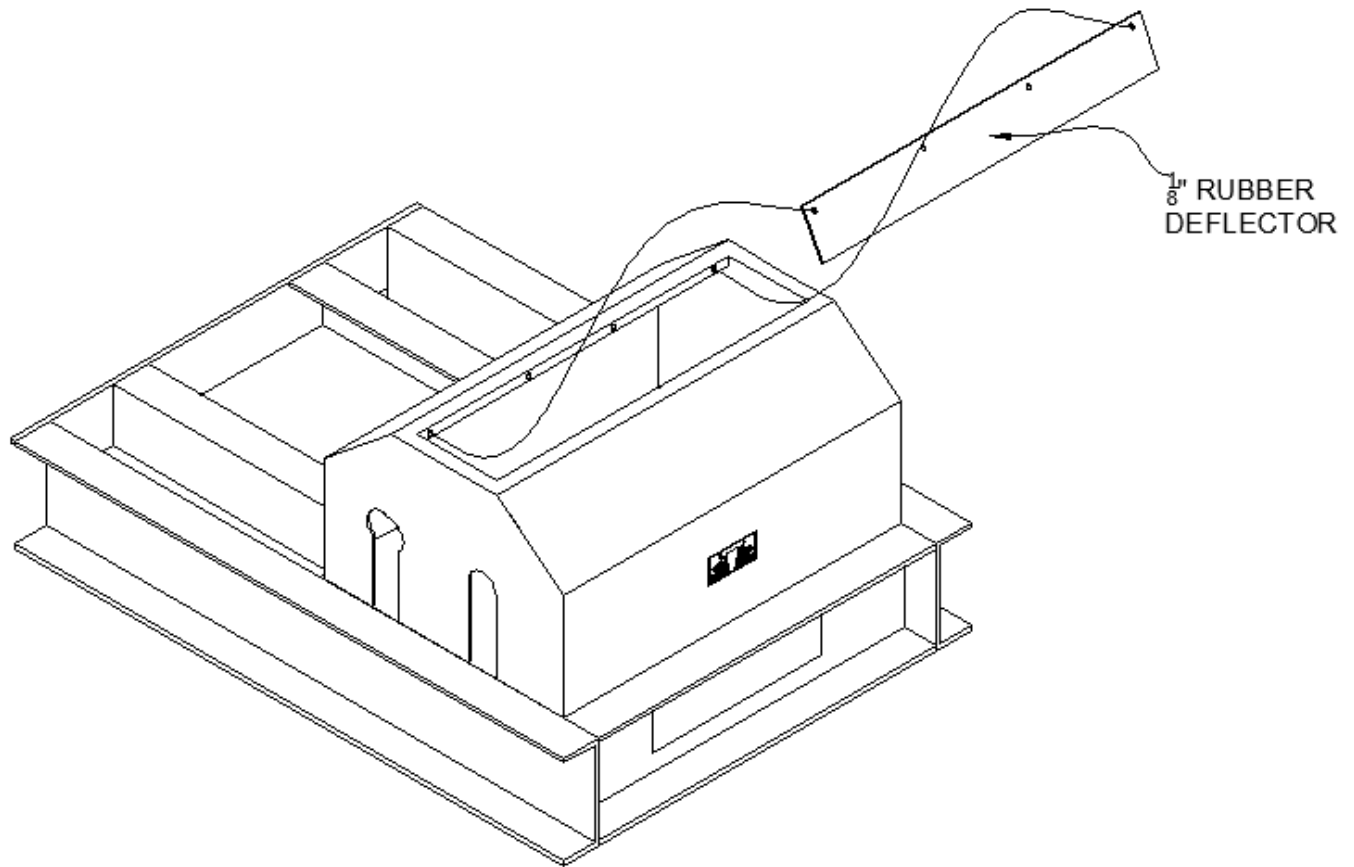
Y



DRIVE SHEAVE, HUB AND BELT ASSEMBLY

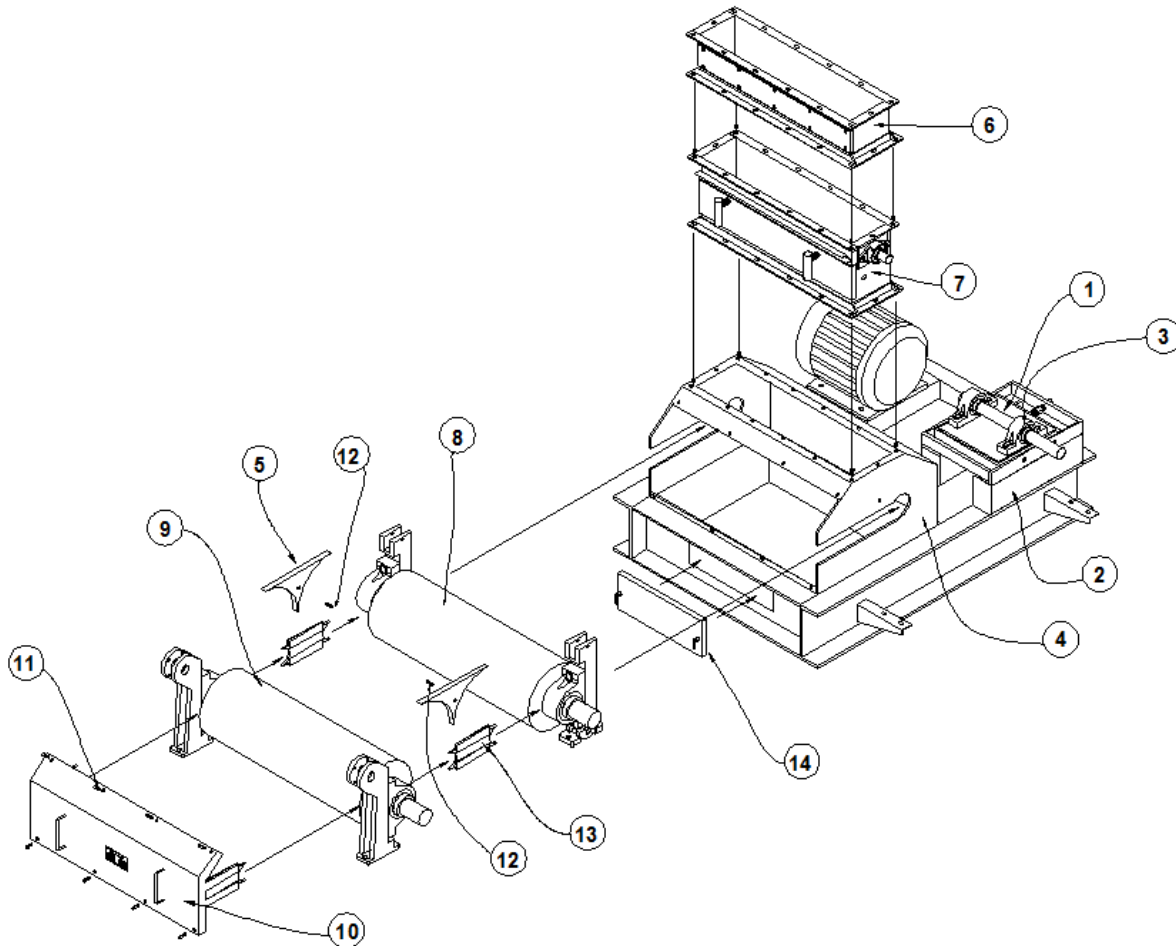
| # | PART# | DESCRIPTION | # | PART# | DESCRIPTION |
|----|-----------|------------------------|-----|-----------|-------------------|
| 1 | KY58 | 5/8" KEYSTOCK | 11 | HBF21516 | F 2 15/16 HUB |
| 2 | HBE218 | 2 1/8 HUB | 12 | BOLHF | F HUB BOLTS |
| 3 | GARPF12 | AGITATOR BELT GUARD | 12B | BOLHE | E HUB BOLTS |
| 4 | BOL12X112 | 1/2 X 1 BOLT | 13 | BOLHSD | SDS HUB BOLTS |
| 5 | SH6CE8 | 6 C8.0 E SHEAVES | 14 | SH6C18 | 6 C18.0 F SHEAVES |
| 6 | BLTC120 | (6) C120 BELT | 15 | HBSDS1716 | SDS 1 7/16 |
| 7 | BLTBGRP | 66 1/2 TWIST LINK BELT | 16 | N12CT | 1/2 CT NUT |
| 8 | SH1B124 | 1B 12.4 SHEAVE | 17 | KY75X6 | 3/4 KEYSTOCK |
| 9 | GAR12DRL | DRIVE GUARD | 19 | WL38 | 3/8 LOCKWASHER |
| 10 | SH1B46 | 1B 4.6 SHEAVE BORED | 20 | BOL38X1 | 3/8 X 1 BOLT |





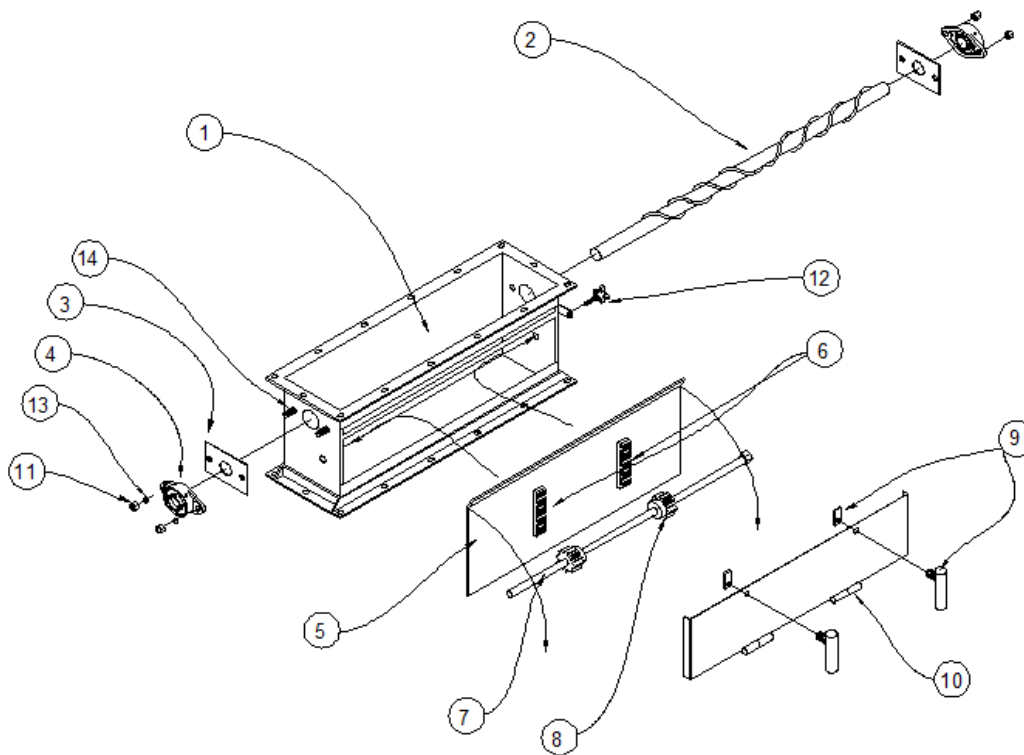
ROLL AND CABINET ASSEMBLY LIST

| # | PART # | DESCRIPTION |
|----|---------|----------------------------|
| 1 | IDL12M | IDLER MOUNT |
| 4 | FR12 | ROLL CABINET |
| 5 | SAD12VU | 12 SADDLE |
| 6 | PFAG12M | MAGNET CABINET |
| 7 | PFAG12 | AGITATOR CABINET |
| 8 | R1236 | FOLLOW ROLL |
| 9 | R1236D | DRIVE ROLL |
| 11 | BOL38X1 | 3/8 X 1 BOLT |
| 12 | BOL38X2 | 3/8 X 2 BOLT |
| 13 | FR12CS | 12" CRACKER CENTER SECTION |
| 14 | DOR0012 | CRACKER INSPECTION DOOR |



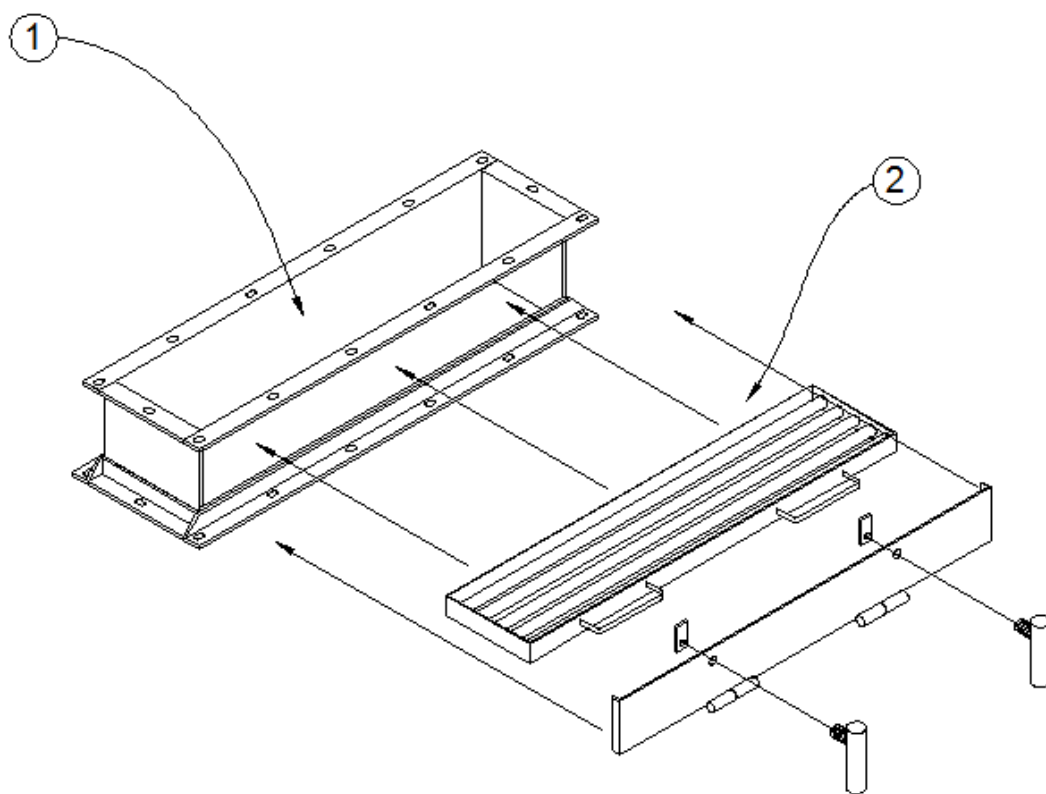
AGITATOR FEEDER CABINET ASSEMBLY

| # | Part # | Description |
|----|-----------|--------------------------|
| 1 | PFAG12M | AGITATOR CABINET |
| 2 | PFAGB | AGITATOR BAR |
| 3 | PFAGF | BEARING FLANGE |
| 4 | BRG1716FB | 1-7/16 FLANGE BEARING |
| 6 | PFCABRK | R8 X 6 FT STEEL RACK |
| 7 | MCRR34 | 3/4 CRR SHAFT |
| 8 | PFCABPN | 3/4 BAR PINION GEAR |
| 9 | DOR0018H | DOOR HANDLE |
| 10 | DORMD18 | M/S DOOR HINGE |
| 11 | N12CT | 1/2 NUT |
| 12 | PFKNB38 | DOG POINTSTAR KNOB |
| 13 | WL12 | 1/2 LOCK WASHER |
| 14 | BOL12X2 | 1/2 X 2 BOLT (WELDED ON) |



MAGNET CABINET ASSEMBLY

| # | PART # | DISCRIPTION |
|---|---------|----------------|
| 1 | PFAG12M | MAGNET CABINET |
| 2 | MAG8333 | MAGNET |



Limited Warranty

The manufacturer warrants this equipment to the original user against defective material or workmanship for a period of 30 days from the date of purchase on repair parts and labor. The manufacturer's responsibility under this warranty is limited to the repair or replacement of defective part or parts.

The manufacturer reserves the right to determine whether the part or parts failed because of defective material, workmanship, or other causes. Failure caused by accident, alteration, or misuse is not covered by this warranty.

A DALHART R & R MACHINE WORKS INC representative must do all warranty repairs. Any repair to the equipment other than by this authorized facility voids this warranty. The rights under this warranty are limited to the original users and may not be transferred to subsequent owners.

The warranty is in lieu of all other warranties, expressed or implied including warranties for a particular purpose.

Dalhart R & R Machine Works, Inc.
P.O. Box 1330, 1006 Liberal St.
Dalhart, TX 79022

