

NPK LLC
13390 Morse Rd. SW
New Albany, OH 43054
614-738-8208 or 614-716-9820

Needles Plates Knives

npkllc@aol.com

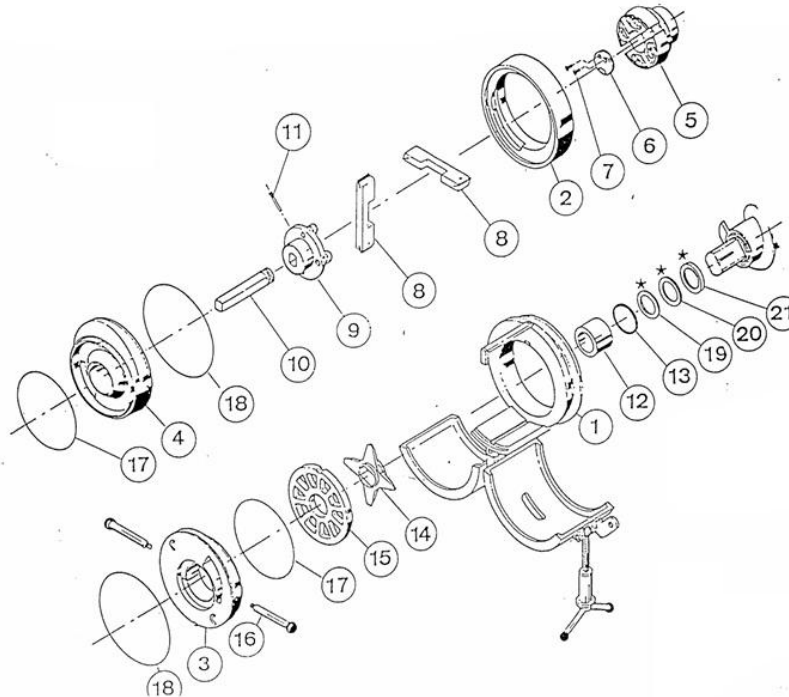
www.npkusa2.com

CFD (Turbo) Parts and Adjustments

Call NPK LLC for assistance with any CFD (Turbo) Adjustments or Replacement Parts

For Parts 614-738-8208

For Service/Questions 614-716-9820



Position	Description	OEM#	Qty
1	Complete Mounting Knife Housing (30442) with Clamping Device (30966)	37247	1
1	Mounting Knife Housing	30442	1
1	Clamping Device	30966	1
2	Pump housing size 16 tn3	32850	1
3	Side gate/suction gate	30355	1
4	Side gate/pressure gate	30354	1
5	Driving hub	30569	1
6	Thrust collar	30622	1
7	Allen M8x12	22342	2
8	Set of pallets	38548	1
9	Part of driving hub	30568	1
10	Worm pin for driving hub	30227	1
11	Tightening screw for CFD worm pin	31890	1
12	Thrust ring	37677	1
13	O-Ring	37678	1
14	Precutter, knife 4-bl.	30168	1

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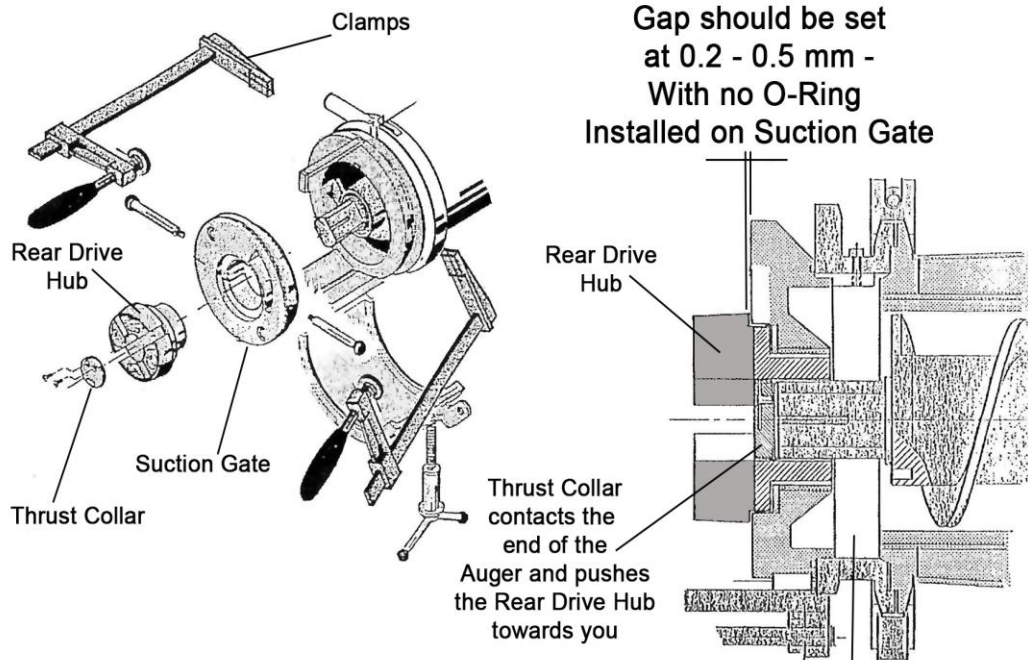
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15	Precutter 10-hole	30143	1
16	Mounting tools	30768	2
17	O-ring 249.3 x 5.7	23348	2
18	O-ring 304.0 x 3.0	40211	2
19	Spacer ring $\varnothing 105/\varnothing 91 \times 1$ mm	31661	1
20	Spacer ring $\varnothing 105/\varnothing 91 \times 2$ mm	31662	1
21	Spacer ring $\varnothing 105/\varnothing 91 \times 4$ mm	31663	1
	Nut for pilot bearing	30005	1
	Screw cap	30897	1
	Precutter - Pressure Symetric	30142	1
	Accessory trolley	33532	1
	BEKA tool box	25661	1
	Nylon hammer	25664	1
	Screw driver	25667	1
	Awl	25695	1
	Crow bar	25697	1
	Allen T-Key	26723	1



Rear Drive Hub Adjustment

Failure to adjust this daily and correctly will result in damage to the Suction and Pressure Gates and can cause metal contamination !

Adjustment made Without Star Knife & Precutter Installed

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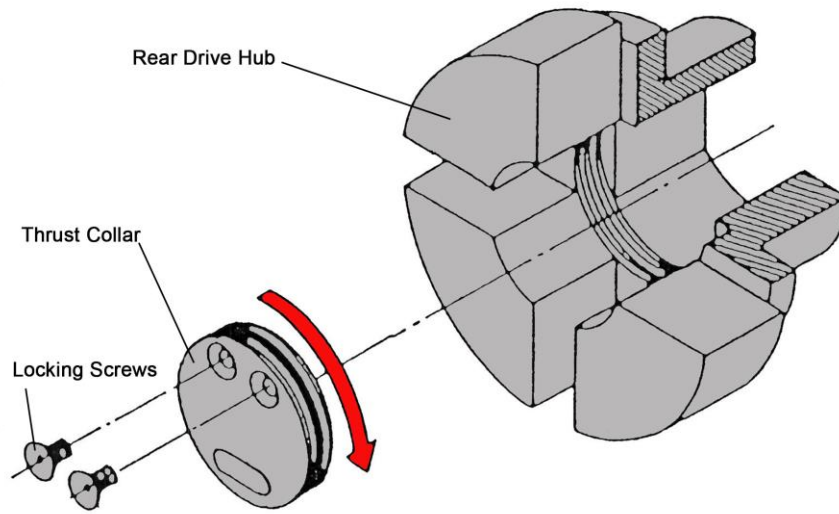
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Tools and items required to adjust the Rear Drive Hub

- Two Clamps
- Set of Handles for gate
- Allen Wrench for Locking Screws
- Food Grade Grease
- 8" Crescent Wrench or other tool that will fit into the opening of the Thrust Collar

Steps to follow:

- Loosen the Locking Screws
- Make sure the Thrust Collar is loose and can freely rotate in and out of the threads of the Rear Drive Hub.
- Remove the Thrust Collar and grease the threads with Food Grade Grease



The Rear Drive adjustment is extremely important to ensure the Pallets are not rubbing against the face of either the Suction or Pressure Gate. If the Pallets are rubbing on the surface of the gates it will result in damage to the Pallets and either the Suction or Pressure Gate. This damage will result in possible metal contamination of the product and will reduce the life of the parts.

Inspect the Gates and Drive Hubs for burrs, remove burrs if any are found.

This Rear Drive Hub adjustment must be performed daily. The following factors is why this adjustment will vary daily.

- The Thrust Collar was removed or Rear Drive Hub replaced
- The Suction Gate was replaced
- The Clamp Housing replaced
- The Auger reworked or replaced
- The gearbox replaced

Adjustment Procedure

- Install the Auger
- Install the Suction Gate (Make sure the black o-ring has been removed)
- Clamp the gate securely to the face of the CFD Clamp Housing
- Adjust the Thrust Collar in until it makes contact with the end of the Auger
- Continue to rotate the Thrust Collar inward until the Rear Drive Hub begins to separate from the face of the Suction Gate
- Once the gap is between 0.2 and 0.5mm stop. You can also use the CFD Tool shown below to help set the gap as well.
- Hold the position of the Thrust Collar and securely tighten up the two Locking Screws
- Insert the Rear Pallet and confirm the Pallet is not touching the face of the Suction Gate. If it is then repeat the steps above until the correct adjustment is obtained.

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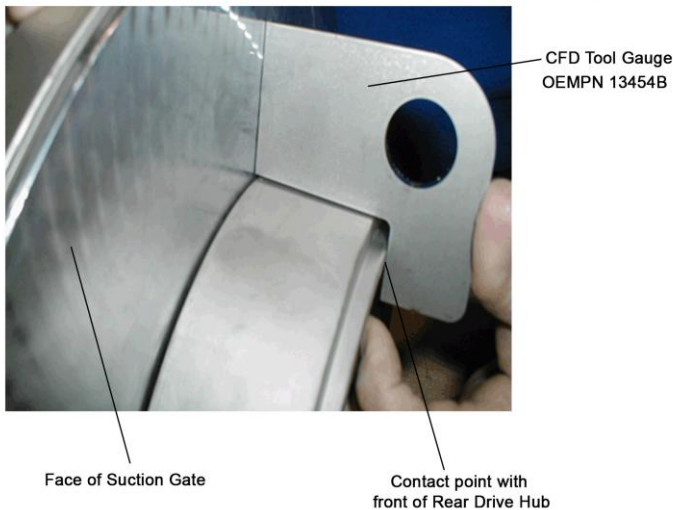
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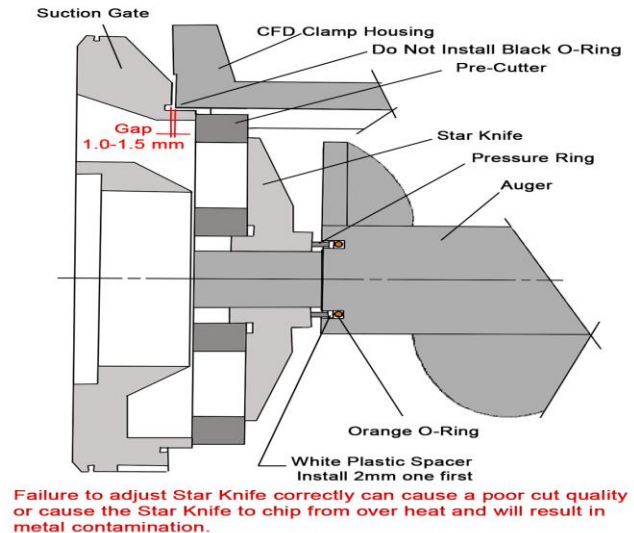
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Rear Drive Hub Adjustment using the CFD Tool Gauge



CFD Star Knife Adjustment



The Star Knife adjustment is very important to ensure the knife is running tight against the Pre-Cutter. However if it's too tight against the Pre-Cutter it will cause damage to the edges of the knife. This will result in metal contamination of the product.

This Star Knife adjustment must be performed daily. The following factors is why this adjustment is required daily.

- Star Blade Sharpening
- Pre-Cutter Sharpening
- Replacement of the Star Knife or Pre-Cutter with a new one
- The Auger reworked or replaced
- The gearbox replaced
- The White Plastic Spacers lost or installed differently

Adjustment Procedure

- Install the Auger
- Install the Orange O-Ring
- Install the 2mm White Plastic Spacer
- Install the Pressure Ring
- Install the Star Blade
- Install the 10 Hole Pre-Cutter
- Install the Suction Gate (The black o-ring must be left off)
- Squeeze the Suction Gate by hand against the face of the CFD Clamp Housing
- Check the gap (See the detail above) The gap should be between 1 and 1.5 mm
- If the gap is below 1mm the knife will not cut correctly
- If the gap is greater than 1.5mm the knife will be too tight, the knife will heat up and cause the edges to chip off. This will result in metal contamination of the product
- Make the adjustment by removing or adding additional White Plastic Spacers. Spacers are available in 1, 2 and 3mm



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