



# MD81 Depositor Feeds Refurbishment Program

## Purpose of the Program

The Moline MD81 Depositor Continuous Feed Refurbishment Program allows existing continuous feeds to be refitted with new rotors.

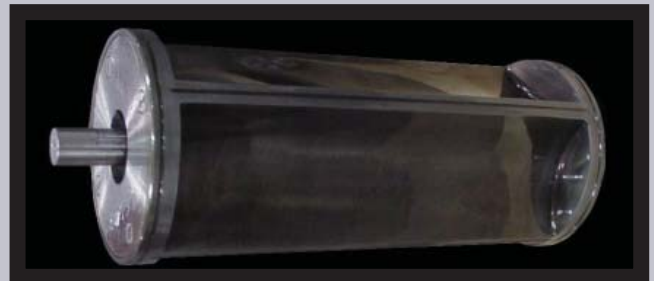
During refitting, the continuous feeds are cleaned and inspected. Moline will contact the customer prior to refurbishment with a quote.



MD81 Depositor

## Benefits of New Rotors

- **Optimally Maintains Existing Continuous Feeds For Extended Wear**
- **Returns Continuous Feeds to OEM Specifications**
- **Maintaining OEM Tolerances Provides Greater Weight Control**
- **Improves Depositor Performance**
- **Cost Effective Maintenance**

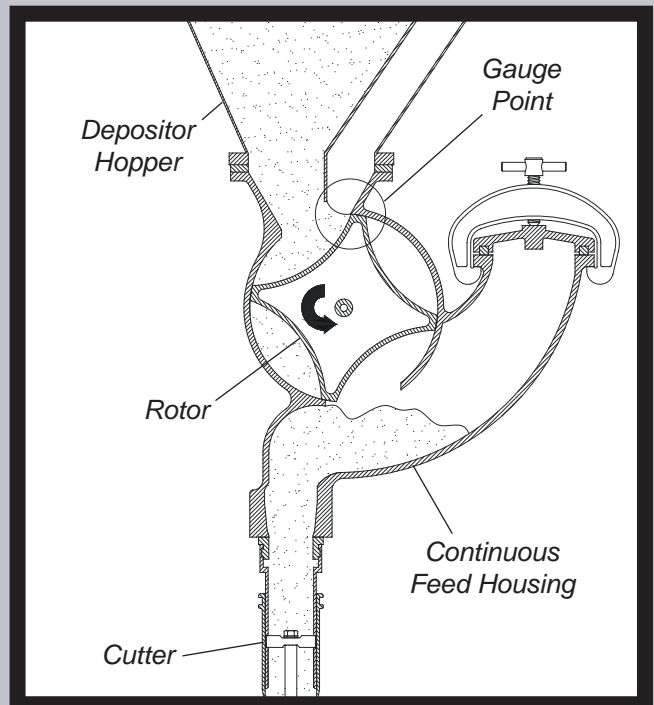


Continuous Feed Rotor

## Refurbish Continuous Feeds...

When manufacturing tolerances are no longer to factory specification (.0015" - .0025" at the gauge point – see drawing at right). Continuous feed tolerances of .007" - .009" indicate that the feed must be refurbished or replaced.

When air pressure fluctuates at the gauge. A worn feed will typically cut several rows of good product, then become erratic. When product weights can no longer be controlled, the continuous feed should be refurbished/replaced.



Cross Section - Hopper, Continuous Feed and Cutter

**Extend Continuous Feed Life by Refurbishing**



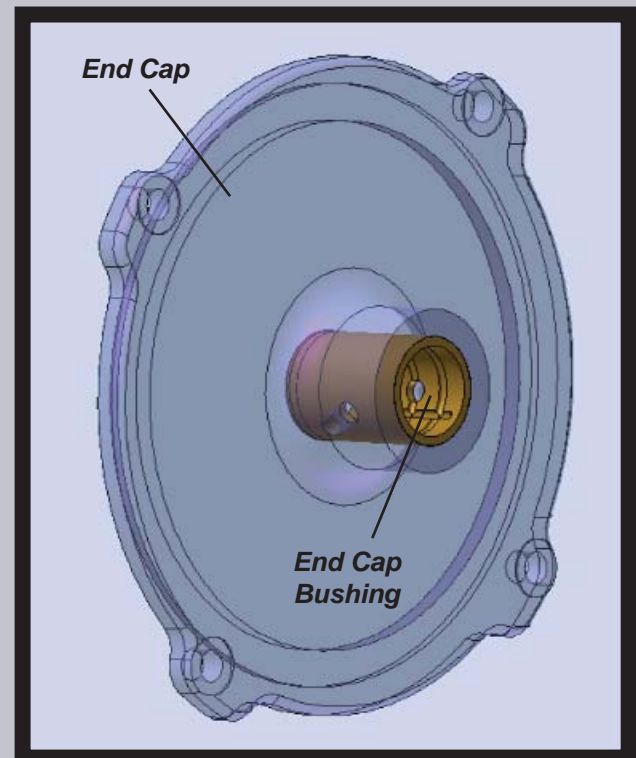
# MD81 Depositor Feeds Refurbishment Program

## The Refurbishment Process:

- 1) Submit Continuous Feeds For Moline Evaluation**  
Moline will evaluate your continuous feeds to determine whether they are a good candidate for refurbishment. Feeds must be sent to Moline for evaluation. Units that are very worn or damaged cannot be accepted. The housing must have an air chamber guard to be eligible for refurbishment (see photo at right).
- 2) Continuous Feeds are Dimensionally Checked**  
The submitted continuous feed is disassembled, cleaned and dimensionally checked. End caps are fixture-checked for "run out" as well as concentricity. If necessary, end caps are re-machined or new ones manufactured. The feed housing bore is fixture-checked for concentricity and parallelism. Once dimensions are checked, the customer is notified as to whether the feed is a candidate for refurbishment. If so, a quote is supplied.
- 3) New Rotor Installed in Feed Housing**  
The feed housing is line-bored for the new rotor. A new rotor is manufactured to the appropriate tolerance and installed in the continuous feed. Rotor end cap bushings are replaced. Tolerances are appropriate for optimal operation. The continuous feed is then reassembled. It is both dimensionally and pressure verified to over 20 key dimensions.
- 4) Refurbished Continuous Feed is Returned**  
Once the continuous feed has been refurbished, it is returned to the customer ready for installation on the depositor. Shipping is via freight carrier and is paid for by the customer.
- 5) Cost for Refurbishment**  
Cost for continuous feed refurbishment will be determined upon inspection and a quotation submitted. Moline standard Terms apply.



Continuous Feed Housing Air Chamber



Typical Rotor End Cap

Contact Moline Customer Service for further details.  
Please have the continuous feed serial numbers available.

**Extend Continuous  
Feed Life by  
Refurbishing**

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