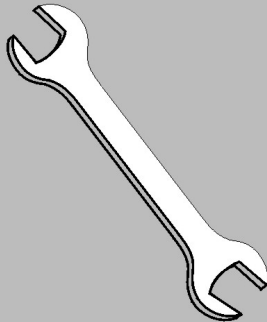


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- Access date: 2/7/01
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# Kit Instruction— KQEXTT1301



# Please Read

## About the Manual Identifying Information on the Cover

The front cover displays pertinent identifying information for this manual. Most important, are the published manual number (part number) /ECN (date code). Generally, when a replacement manual is furnished, it will have the same published manual number, but the latest available ECN. This provides the user with the latest information applicable to his machine. Similarly all documents comprising the manual will be the latest available as of the date the manual was printed, **even though older ECN dates for those documents may be listed in the table of contents.**

When communicating with the Milnor factory regarding this manual, please also provide the other identifying information shown on the cover, including the publishing system, access date, and whether the document ECN's are the latest available or exact.

## References to Yellow Troubleshooting Pages

This manual may contain references to "yellow pages." Although the pages containing troubleshooting procedures are no longer printed on yellow paper, troubleshooting instructions, if any, will be contained in the easily located "Troubleshooting" chapter or section. See the table of contents.

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## Comments and Suggestions

Help us to improve this manual by sending your comments to:

Pellerin Milnor Corporation  
Attn: Technical Publications  
P. O. Box 400  
Kenner, LA 70063-0400

Fax: (504) 469-1849

## **M7E42 & M9E42 Centrifugal Extractor Inner House Channel = Doubler and Gussets**

The purpose of this retrofit is to increase the strength of the rear of the inner house of the M7E42 and M9E42 Centrifugal Extractor. Prior to beginning the retrofit, it is necessary to familiarize yourself with all safety precautions in the Centrifugal Extractor's manual; please observe all safety precautions. It is also imperative that these instructions are read prior to beginning the retrofit. While working on the Miltron, lockout and tag the power in the off position. Also, inventory the parts received with the kit.

Tools required for this retrofit are: welding equipment and material capable of welding 1/4" carbon steel, 6011 stick rod, 5 ton come along, standard hand tools and welding preparation tools.

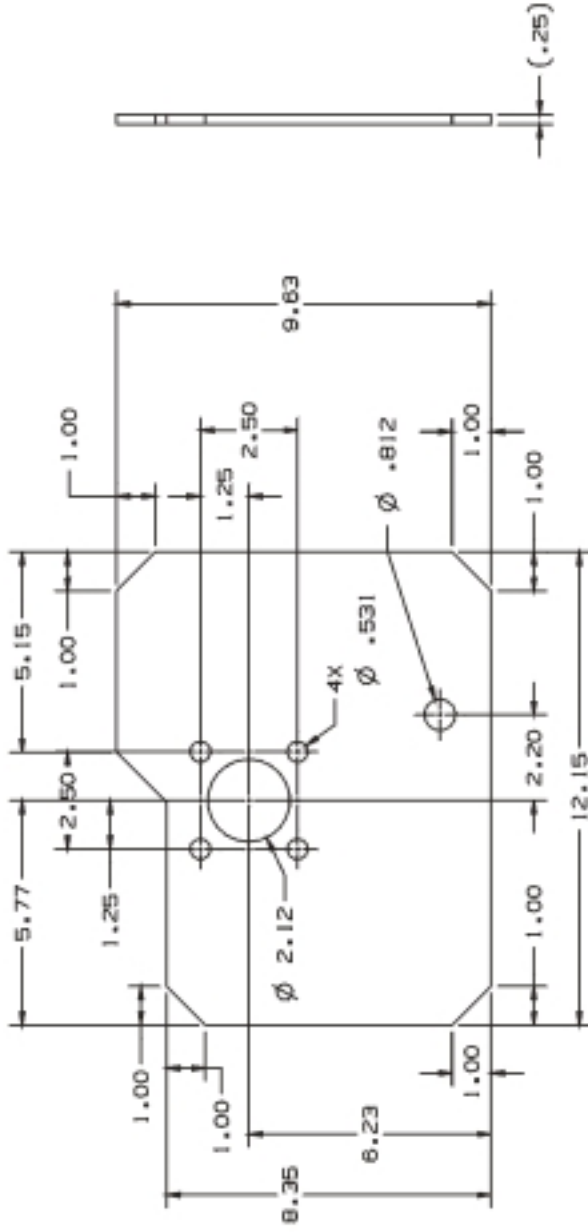
Prepare all surfaces to be welded. The CHANNEL = DOUBLER (part number 03-16222A), item 25 on drawing WELDMENT = INNER HOUSE 42M7E (part number W3 16204) is to be welded in place. Weld all copings with 3/16" fillet welds. In addition, weld all edges with 3/16" fillet welds intermittently for one inch skip three inches.

The GUSSET (part number 03-16222B), item 26 on drawing WELDMENT = INNER HOUSE 42M7E (part number W3 16204) is to be welded in place. Weld all edges with 3/16" fillet welds intermittently for one inch skip three inches.

Inspect WELDMENT = INNER HOUSE 42M7E (part number W3 16204) in the location of item 23. If this area has fatigued, then install item 23. If there is no visible fatigue then skip this step. Mark the location of the nuts on the upper portion of the hydrocushion. Using the 5 ton come along remove all the tension from the hydrocushion and support the extractor shell. Remove the upper portion of the hydrocushion. The HYD DBLR = IN HSE FRNT x CHNL (part number 03-16221B), item 23 on drawing WELDMENT = INNER HOUSE 42M7E (part number W3 16204) is to be welded in place. Weld all edges with 3/16" fillet welds intermittently for one inch skip three inches.

After welding is complete, clean and paint all exposed surfaces. If you should have any questions, please call Milnor Technical Support at (504) 467-9591 extension 276.

Attachments: drawings W3 16204, 03-16222A, 03-16221B and 03-16222B

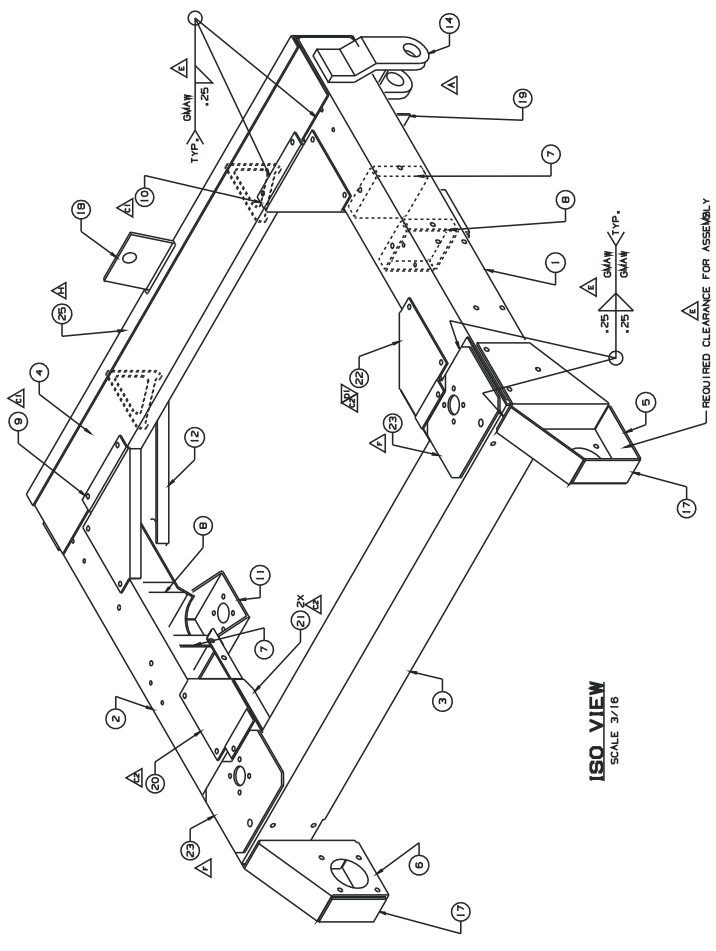
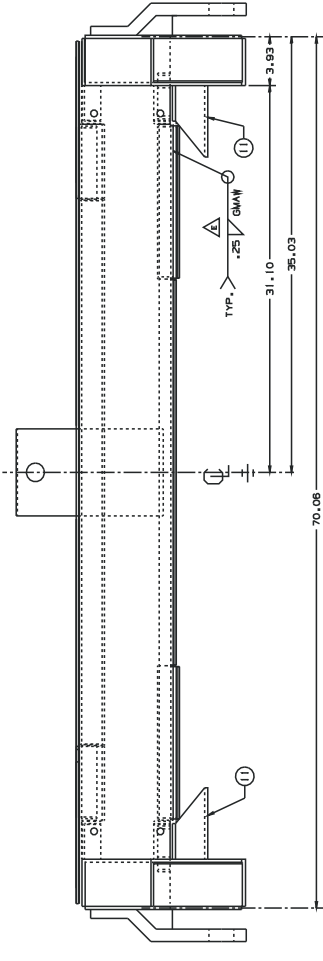
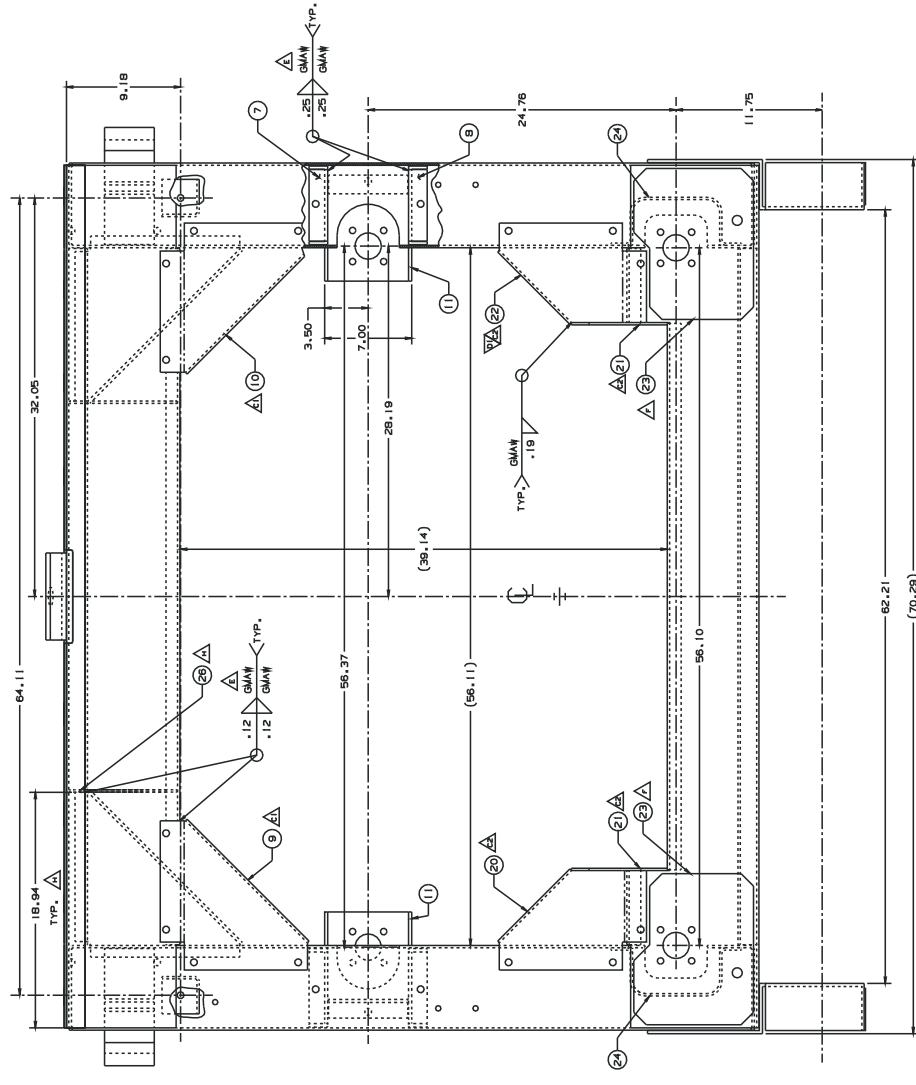
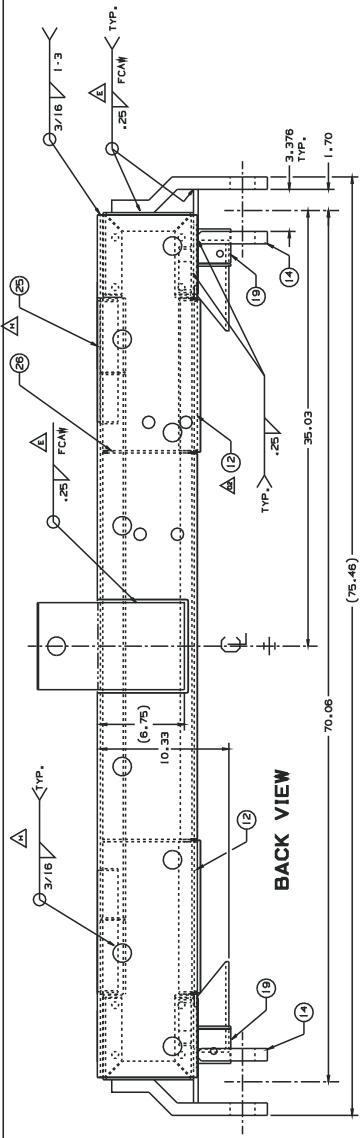


**DRAWING NOT FOR OUTSIDE VENDOR'S USE**

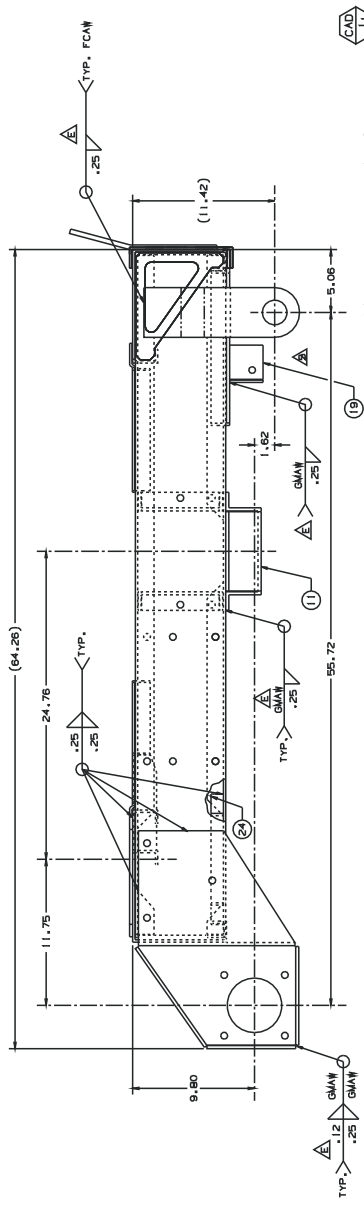
EON		LET BY	KMH	RELPRO	MATERIAL MADE FROM DESCRIPTION		MILNOR MATL P/N	HYD DBLR: IN HSE FRNT X CHNL		PART NO.	03-16221B
ACTION		1/4 CRB HR		1/4 CRB HR		MILNOR MATL P/N		DATE: 4-30-97		P.O. BOX 400-CHAMPLA, 70003-0400 MILNOR MFG CORP	
								SCALE: .39		DRAWN BY: KMH	
								DATE: 4-30-97		PELLERIN MILNOR CORPORATION	
								TOLERANCE: ANGLES ± 1° INCHES ± .005 2-X ± .03 2-X ± .01 2-X ± .02		P.O. BOX 400-CHAMPLA, 70003-0400 MILNOR MFG CORP	
								UNLESS OTHERWISE SPECIFIED			
								DIMENSIONS SHOWN UNLESS OTHERWISE SPECIFIED			







ISO VIEW  
SCALE 3/16



DRAWINGS NOT FOR OTHERS VENDORS USE

REV	DATE	DESCRIPTION	BY	CHK
01	03/15/21	ISSUE FOR PRODUCTION	WILSON	WILSON
02	03/15/21	REVISED TO ADD DIMENSIONS	WILSON	WILSON
03	03/15/21	REVISED TO ADD DIMENSIONS	WILSON	WILSON
04	03/15/21	REVISED TO ADD DIMENSIONS	WILSON	WILSON
05	03/15/21	REVISED TO ADD DIMENSIONS	WILSON	WILSON
06	03/15/21	REVISED TO ADD DIMENSIONS	WILSON	WILSON
07	03/15/21	REVISED TO ADD DIMENSIONS	WILSON	WILSON
08	03/15/21	REVISED TO ADD DIMENSIONS	WILSON	WILSON
09	03/15/21	REVISED TO ADD DIMENSIONS	WILSON	WILSON
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11	03/15/21	REVISED TO ADD DIMENSIONS	WILSON	WILSON
12	03/15/21	REVISED TO ADD DIMENSIONS	WILSON	WILSON
13	03/15/21	REVISED TO ADD DIMENSIONS	WILSON	WILSON
14	03/15/21	REVISED TO ADD DIMENSIONS	WILSON	WILSON
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16	03/15/21	REVISED TO ADD DIMENSIONS	WILSON	WILSON
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23	03/15/21	REVISED TO ADD DIMENSIONS	WILSON	WILSON
24	03/15/21	REVISED TO ADD DIMENSIONS	WILSON	WILSON
25	03/15/21	REVISED TO ADD DIMENSIONS	WILSON	WILSON
26	03/15/21	REVISED TO ADD DIMENSIONS	WILSON	WILSON

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 WELLSVILLE, NY 16801  
 716.835.3333  
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MATERIAL USE FROM DESCRIPTION: WILSON MILNOR, P/N: 11111111  
 ACTION: