TECHNICAL BULLETIN

Subject:

Clearance Specs for Airlocks

Bulletin #:	Rev:	Created by:	Date:
95277	E	MK	2023-08-14

ECR # 25099

Production: X **Service:** X **Sales:** X

Product Lines: **Transportation Equipment:** X **Agri-vac/Pneumatic Equipment:** X

Tables of airlock specifications can be found below.

Airlock Specification

The following table lists the specifications of new airlocks manufactured by Walinga.

	TIP CASING TOP		TIP CASING BOT		ROTOR END-PLATE	
	Min	**Max**	**Min**	**Max**	**Min**	**Max**
1008 DT	0.003	0.006	N /A		0.004	0.006
1210 DT	0.004	0.007	N/A		0.005	0.007
1314 DT	0.004	0.007	N/A		0.005	0.007
1314 BT	0.005	0.007	0.004	0.007	0.005	0.007
1618 DT	0.004	0.007	N/A		0.007	0.009
1618 BT	0.006	0.008	0.004	0.008	0.007	0.009
2018 BT	0.008	0.010	0.005	0.010	0.007	0.009
2224 DT	0.006	0.010	N/A		0.010	0.013

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Airlock Service Specification

Walinga airlocks with adjustable tips should be checked and adjusted annually or every 100 hours of operation. The following table lists the specifications which should be maintained when performing service on Walinga airlocks.

	Tip / Casing		Rotor / End-plate	
	Set to:	**Reset Spec:**	**Set to:**	**Replace Spec:**
1008 DT	0.003	0.009	0.004	0.009
1210 DT/BT	0.004	0.010	0.005	0.010
1314 DT/BT	0.005	0.010	0.005	0.011
1618 DT	0.004	0.011	0.007	0.014
1618 BT	0.006	0.012	0.007	0.014
2018 BT	0.008	0.015	0.007	0.016
2224 DT	0.008	0.016	0.010	0.020

NOTE: The Tip/Casing clearance should be measured and reset on the side of the airlock opposite to the airlock tip wiper. This is necessary as the side of the airlock that has the tip wiper installed on it will typically experience normal operational wear, and using this side may result in clearances that fall below the minimum clearance and cause scraping between the Tip/Casingn

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