



Società Italiana Costruzione Macchine a R.L.
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C.C.I.A.A. Perugia 167891 – Iscriz. Tribunale Perugia n. 23197
Cap. Soc. € 26.000,00 int. vers. – C.F. e P.IVA 01923450546
P. IVA CEE IT 01923450546

APPENDIX TO

Duration of wear parts for planetary mixers, turbine mixers and twin shaft compulsory mixers

The following table gives the duration of the wear parts (blades and wall linings). The duration is indicated in cycle numbers, assuming that the average duration of one cycle is of 1.5 minutes. The indicated values are purely indicatory and not mandatory as they may change considerably depending on the specific situation of the various working sites. Among the many factors which affect the duration of the wear parts, we recall the following ones:

- Type of aggregates. If quartz and silex are present, the duration might go down of about 50% respect to the presence of calcareous aggregates; a similar difference is found between crushed gravel and river gravel.
- Correct adjustment of the blades. The distance between the blades and the bottom of the tank must not exceed 3 mm. Experience demonstrates that during the first month of servicing the mixer, the wear of the bottom of the tank is regular and restrained. As soon as the distance of the blades from the bottom of the tank augments, because of the effect of wear, the original adjustment has to be restored as otherwise the gravel jams between the blade and the bottom of the tank which increases the wear of latter.



Planetary mixers		
Blades	Cast-Iron Ny-Hard	60.000 cycles
Bottom	STD STEEL	5000 – 10.000 cycles
	Steel 320 HB	7000 – 15.000 cycles
	Steel 400 HB	10.000 – 20.000 cycles
	Cast-Iron Ny-Hard	100.000 cycles
Walls	STD STEEL	10.000 – 20.000 cycles
	Steel 320 HB	14.000 – 30.000 cycles
	Cast-Iron Ny-Hard	200.000 cycles

Turbine mixers		
Blades	Cast-Iron Ny-Hard	80.000 cycles
Bottom	STD STEEL	10.000 – 20.000 cycles
	Steel 320 HB	15.000 – 30.000 cycles
	Steel 400 HB	20.000 – 40.000 cycles
External Walls	STD STEEL	20.000 – 40.000 cycles
	Steel 320 HB	40.000 - 60.000 cycles
N.B. The internal walls are not replaced		

Twinshaft mixers		
Blades	Cast-Iron Ny-Hard	60.000 cycles
Bottom	Cast-Iron Ny-Hard	100.000 cycles
Walls	Steel 320 HB	100.000 cycles

Rubber for door	Polyuretane 60 SH	30.000-60.000 cycles
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N.B. Referring to the twin shaft mixer, by “bottom” we mean the lining of the omega-shaped tank, while “walls” means the lining of the sides. Because of the minor attrition the walls are subject to, their duration is comparable to the one of the bottom, even if the material with which they are produced is of the CR321 type with a resistance of 320HB.



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