



WESTERN STATES



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Western States Safety Bulletin

RINGLESS BASKET INSPECTION REQUIREMENTS

This bulletin applies to Western States centrifuge baskets in the sugar/sweetener industry using cylindrical shells made from welded 2205 duplex stainless steel without reinforcing rings.

Inspection Method

The basket side sheet must be thoroughly inspected inside and out using liquid dye penetrant by qualified personnel. This is most easily accomplished with the basket removed from the machine outer casing. Cracks are most likely to develop vertically at the edge of basket holes.

Inspection Frequency

A new basket must be visually and dye penetrant inspected after the first 4 years of operation (or 700,000 cycles), as long as the basket has not experienced any severe bumping or hard discharger contact in that first 4 years. Thereafter the basket side sheet must be visually and dye penetrant inspected complete every 2 years (or 350,000 cycles).

Sidesheet Crack Detection/Repair

In the event that a crack(s) is determined in the basket side sheet emanating from the edge of a side sheet perforation, it is possible to affect a repair of the crack as long as the crack length is small. If the discovered crack is less than 0.200" (5mm) in length, and is **NOT** a through-thickness crack, the crack can be blended out by grinding until no crack remains. This needs to be verified by dye penetrant inspection. If the discovered crack is less than 0.200" (5mm) in length, and **IS** a through-thickness crack, the crack can be removed by carefully drilling out the perforation hole until the crack is removed. **No weld repair of cracks is permitted.** Western States should be notified immediately if any cracks are discovered exceeding 0.200" (5mm) in length. **Ringless baskets with detected cracks at or exceeding 0.5" in length should be immediately removed from service.**

Bill Temple

Director of Engineering

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