

Before any actual installation, develop a plan for the mounting location. Mounting the mixer in a baffled tank will provide the best mixing performance. There is no equivalent substitute that will provide the level of performance of mixing in a baffled tank. If the installation of baffles in your tank is not a possibility, then angle-offset your mixer. Correct angle-offset mounting will provide acceptable mixing performance where baffles are not an option. If none of these options are a possibility, then contact the factory for a suggested mounting location. Center mounting your mixer in the middle of the tank will cause vortexing, thus resulting in the WORST mixing performance. Center mounting without baffles will also reduce the lifetime and mechanical integrity of the mixer. **DO NOT** center mount the mixer vertically unless authorized by the factory. **See Mounting Guidelines section for more information.**

Confirm that your tank nozzle and mixer support structure are suitable for the weight and dynamic loads from the mixer. Loading information can be found on your approval drawing, by contacting your Fusion representative, or by contacting the factory. Consult the tank fabricator to confirm the tank is capable of supporting these loads. Fusion is not responsible for damage resulting from inadequate tank design or mount design.

Industrial process equipment requires use of caution, care, and common-sense during installation. Take care to preplan all actions after reading the instructions to ensure a successful and safe installation of your Pro Series mixer.



USE CARE. MULTIPLE HAZARDS EXIST

Installation Process Overview

- Mount the Mixer
- Begin Seal Installation (if equipped)
- Shaft Installation
- Complete Seal Installation (if equipped)
- Impeller Installation
- Electrical Installation

Mount the Mixer

Mount the mixer to the desired location. Be careful, as there are several pinch points in the mounting hardware, couplings, hubs, flanges, etc. **Make sure there is adequate clearance between impeller and the side wall of tank to account for shaft deflection.**

Recommended Tightening Torques

Tighten all of the hardware to the torque specifications in the table below. These average torque values should be used as a guide and not as absolute values:

Torque Specifications:						
BOLT SIZE	18-8 & 304 STAINLESS (uncoated/no lube)		316 STAINLESS (uncoated/no lube)		Gr5 / Gr8 STEEL (uncoated/no lube)	
1/4"-20	57	<i>in-lbs</i>	60	<i>in-lbs</i>	75	<i>in-lbs</i>
5/16"-18	103	<i>in-lbs</i>	108	<i>in-lbs</i>	165	<i>in-lbs</i>
3/8"-16	189	<i>in-lbs</i>	198	<i>in-lbs</i>	300	<i>in-lbs</i>
7/16"-14	308	<i>in-lbs</i>	322	<i>in-lbs</i>	480	<i>in-lbs</i>
1/2"-13	36	FT-LBS	38	FT-LBS	61	FT-LBS
9/16"-12	48	FT-LBS	51	FT-LBS	88	FT-LBS
5/8"-11	81	FT-LBS	84	FT-LBS	121	FT-LBS
3/4"-10	114	FT-LBS	118	FT-LBS	215	FT-LBS
7/8"-9	178	FT-LBS	186	FT-LBS	251	FT-LBS
1"-8	269	FT-LBS	281	FT-LBS	375	FT-LBS
1-1/4"-7	492	FT-LBS	513	FT-LBS	750	FT-LBS

Note: These values are provided for reference only. Every torquing situation needs to be evaluated as small differences can have significant impact on torque. These numbers assume clean, uncoated, non-lubricated stainless threads. In general, lubricated threads require less torque, while coated threads may require more or less. Dirty threads will require more torque.

- 1) **ALL BOLTS SHOULD BE TIGHTENED TO TORQUE SPECIFICATIONS AFTER 12 HOURS OF SERVICE AND AT EACH SCHEDULED SHUT DOWN.**
- 2) USE OF SERVICE REMOVEABLE THREAD-LOCKER RECOMMENDED (BLUE 242 LOCTITE OR SIMILAR).
- 3) Use of service removeable thread-locker recommended (Blue 242 Loctite or similar). *NOTE: Some thread-locking compounds act as a lubricant, requiring torque settings to be adjusted. Follow manufacturer's instructions for this adjustment.*
- 4) **CONVERSION FACTOR:**
Torque values are shown as dry values (no lube or thread locker). For a typical lubricated thread torque value multiply by 80%. For use of thread locker follow manufacturer's instructions for torque adjustment.