



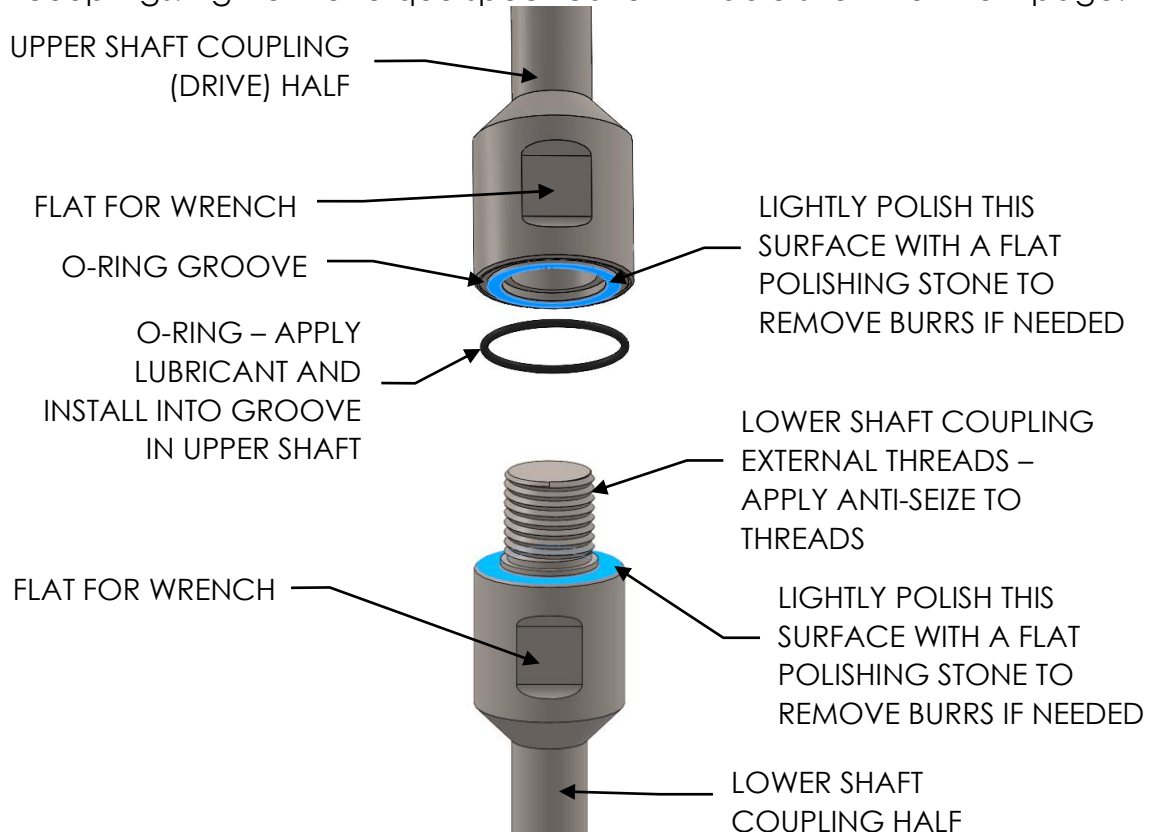
**CAUTION: CHECK MOUNTING FACES FOR BURRS OR ANY OTHER PROTRUSION THAT MAY CAUSE PROBLEMS WITH ASSEMBLY. REMOVE BURRS AS NEEDED TO COMPLETE ASSEMBLY.**

If the upper (drive) half of the sanitary coupling is not attached to the mixer drive, follow the appropriate instructions to attach to the drive.

- Check for burrs and, if needed, lightly polish mounting surfaces with a flat polishing stone to remove burrs. The faces to be polished are highlighted in blue shown below.
- Apply process compatible lubricant to O-ring before inserting into O-ring groove in upper drive half.
- Apply suitable anti-seize to external threads on lower shaft coupling half before assembling.
- Thread the lower shaft coupling half into the upper shaft coupling half.

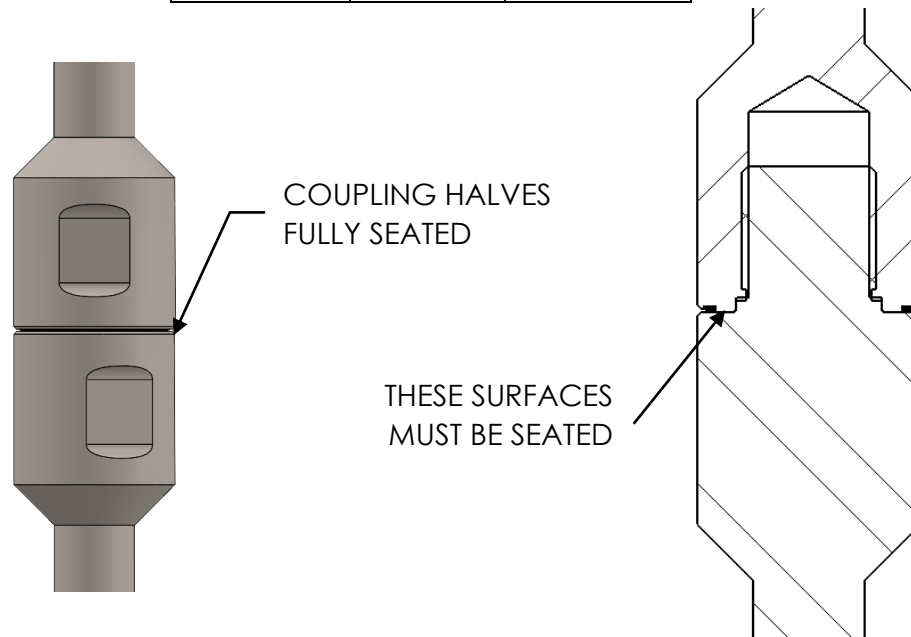
**THE MOST WRENCH JAWS ARE MADE FROM ALLOY STEEL. THE COUPLING MAY SEE SOME CONTAMINATION OR RUST IF JAWS ARE NOT LINED WITH A MATERIAL SUITABLE FOR THE PROCESS. THE SANITARY SHAFT COUPLINGS ARE USUALLY MADE FROM 316 SS.**

- Once the two couplings are hand tight, tighten the rest of the way using two wrenches, one on each coupling flat. Make sure the wrenches are seated on the flats before tightening to prevent damage to the couplings. Tighten to torque specification in table shown on next page.



## TORQUE SPECIFICATIONS

SHAFT DIA.	THREAD	316 STAINLESS
3/4"	1"-8	<b>120 FT-LB.</b>
1"		
1 1/4"	1 1/2" - 6	<b>320 FT-LB.</b>
1 1/2"		
1 3/4"	2" - 8	<b>560 FT-LB.</b>
2"		



**COUPLING HALVES MUST BE FULLY TIGHTENED TO SEAT THE MATING FACES OF THE COUPLING HALVES. IF THE COUPLING IS NOT FULLY SEATED EXCESSIVE RUNOUT AND VIBRATION MAY OCCUR.**

A YouTube Video is also available by following this link -  
[FusionFluidEquipment](#)