

This manual section will cover the Installation of the Threaded Sanitary Shaft Coupling & the Bolted Sanitary Shaft Coupling.

**Note:** Your mixer configuration and mounting orientation will help determine the assembly sequence for when to assemble the shaft of the sanitary coupling to the mixer drive, follow the appropriate instructions to attach to the drive.

## Threaded Sanitary Shaft Coupling Instructions

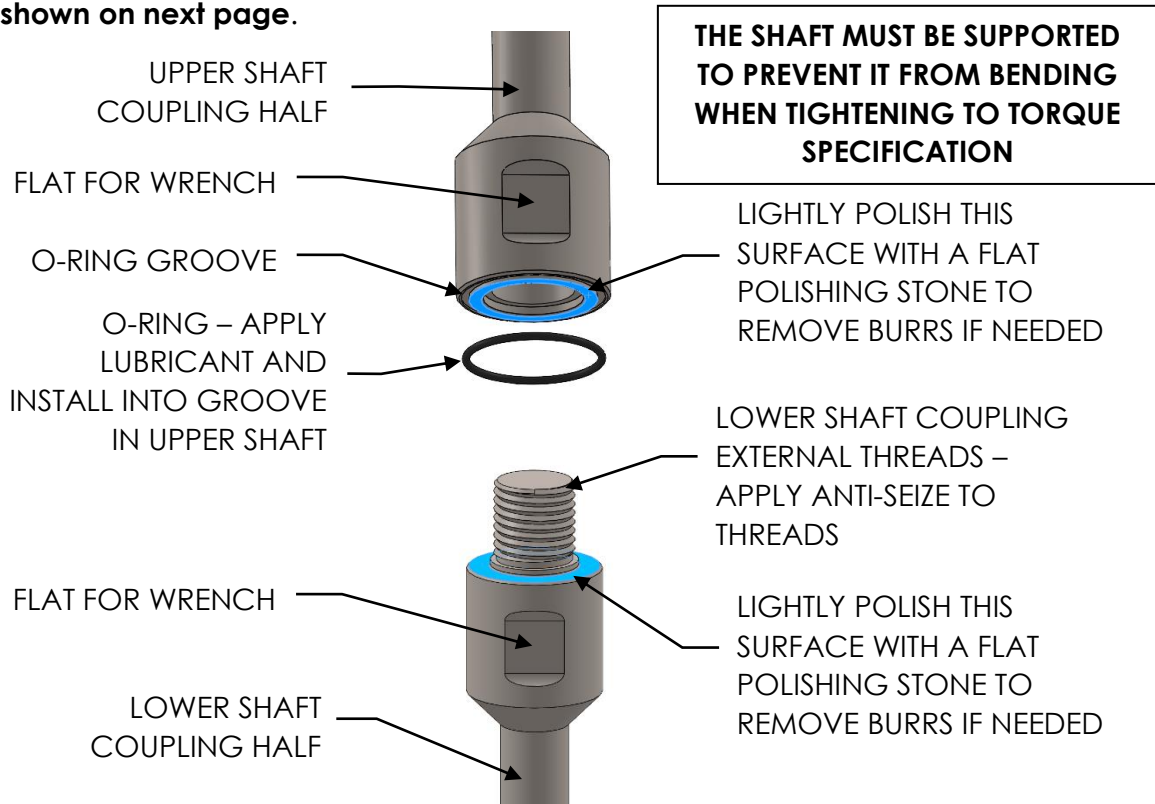


**CAUTION: CHECK MOUNTING FACES FOR BURRS OR ANY OTHER PROTRUSION THAT MAY CAUSE PROBLEMS WITH ASSEMBLY. REMOVE BURRS AS NEEDED TO COMPLETE ASSEMBLY.**

- 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.

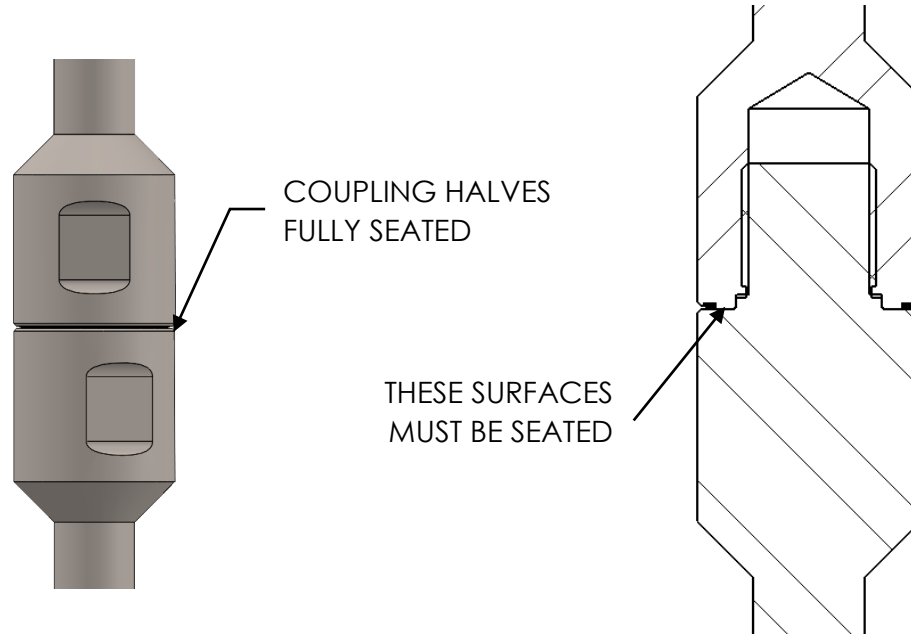
**MOST WRENCH JAWS ARE MADE FROM ALLOY STEEL. THE COUPLING MAY SEE SOME CONTAMINATION OR RUST IF JAWS ARE NOT LINED WITH A MATERIAL SUITABLE FOR THE PROCESS. THE SANITARY SHAFT COUPLINGS ARE USUALLY MADE FROM 316.**

- Once the two couplings are hand tight, tighten the rest of the way using two wrenches, one on each coupling flat. The shaft must be supported to prevent it from bending. 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
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](#)

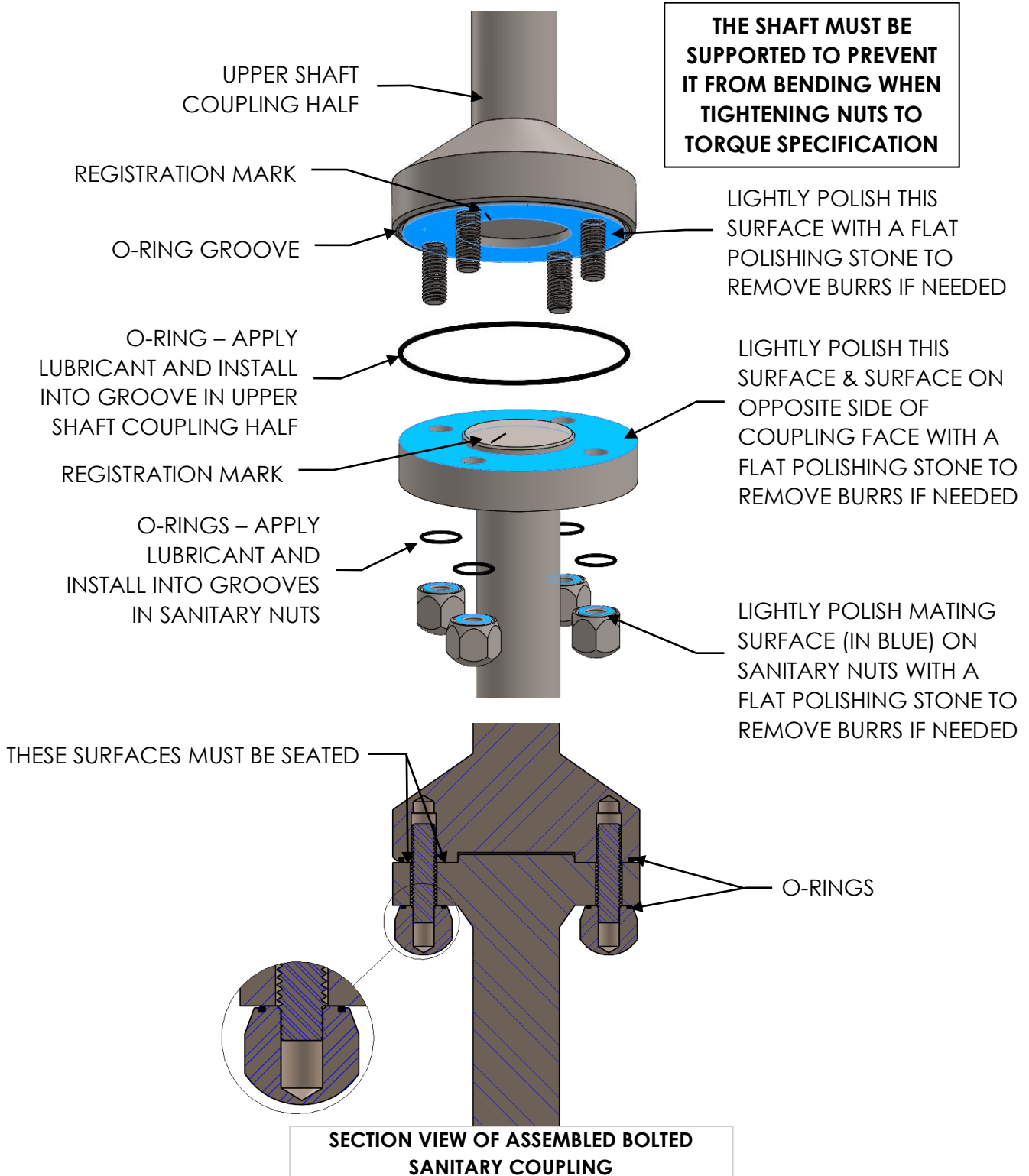
## Bolted Sanitary Shaft Coupling Instructions



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

- 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 on next page.
- Apply process compatible lubricant to O-rings before inserting O-ring into groove in upper drive half & before inserting O-rings into grooves in Sanitary Acorn nuts.
- Once O-rings are installed into the coupling half & the sanitary nuts, then the coupling halves can be assembled together. **Make sure the registration marks on the coupling halves are aligned when assembling coupling halves.**

- Apply process compatible/service removable thread-locker to threads on studs. Thread nuts onto studs and tighten in a crisscross pattern. There may be 4-10 bolts depending on the size of the coupling. **Tighten nuts to Torque Specification chart found on Page 2 of FM-1004 or FM-1006 Installation Sections.**



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