

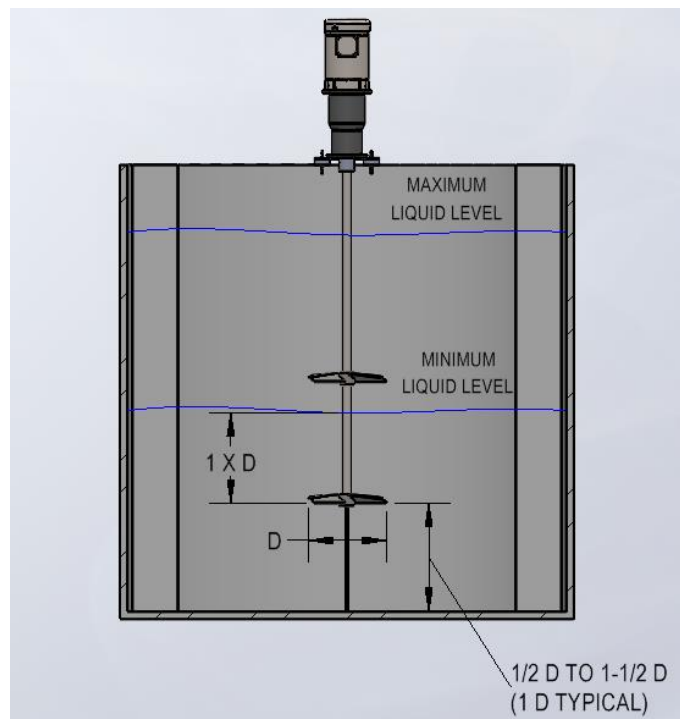


CAUTION: PINCH POINTS & SHARP EDGES MAY BE LOCATED IN THIS AREA

Impeller Installation - Set Screw

If impellers are not permanently mounted to the mixer shaft, then they will need to be installed on the mixer shaft.

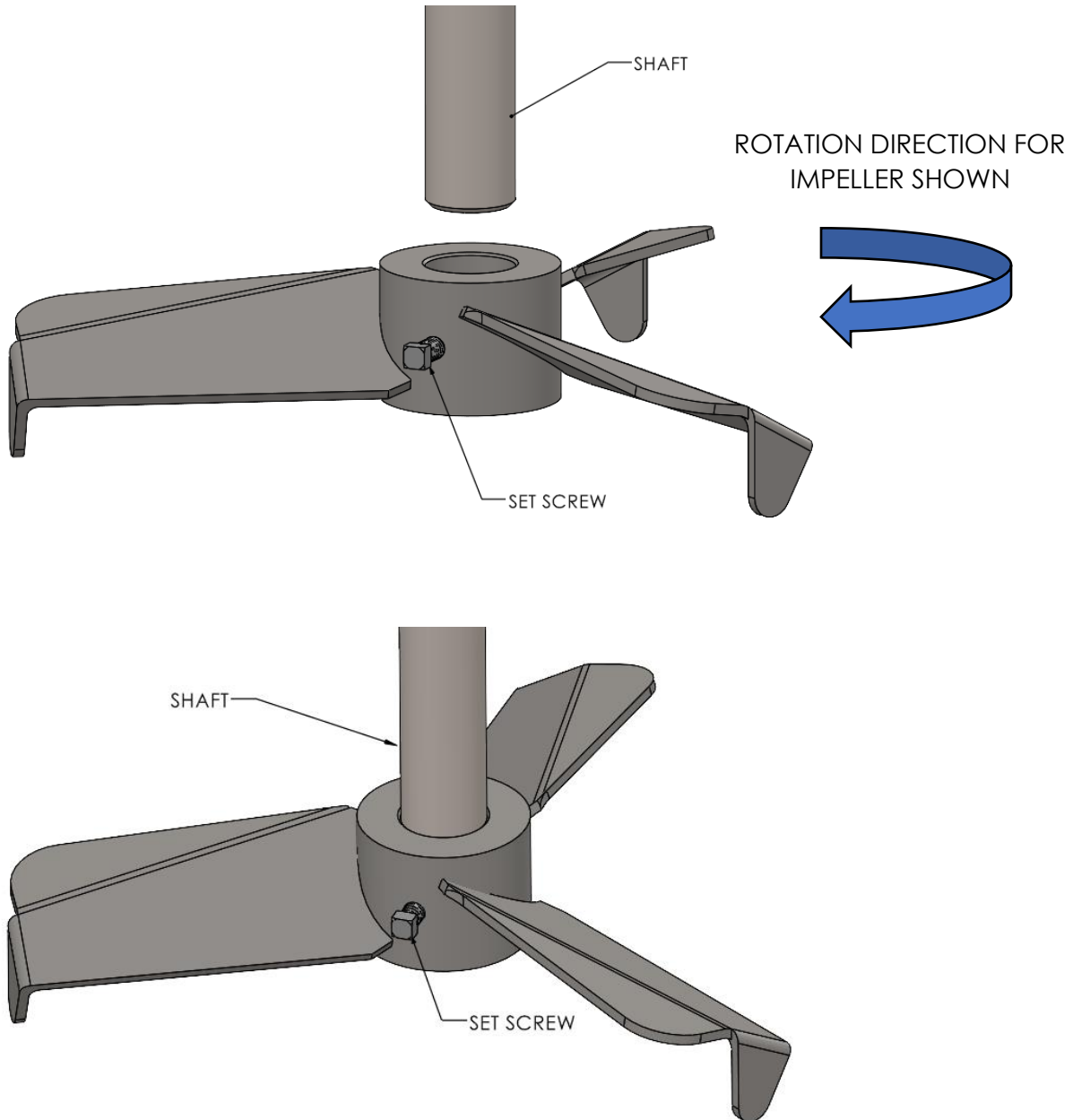
Determine the proper mounting location. In general, the bottom of the shaft should be between 0.5X impeller diameter to 1.5X impeller diameter off the bottom of the tank. For dual impellers, refer back to the quote or Approval Drawing for spacing. As a general rule, in gear drive models, the second impeller should be about 2X impeller diameters from the lower impeller and on direct drive models about 5X impeller diameters from the lower impeller.



Slide the impeller(s) over the shaft until in their proper location(s). Snug the first set screw to locate the impeller. Snug the second set screw (if equipped) securely to the shaft. *The use of a process compatible service removable thread-locking compound is recommended where acceptable.* Remove the first set screw and apply service removable thread-locker (Blue 242 Loctite or similar) to the threads. Reinstall first set screw onto shaft, tighten and torque as required. See **Torque Table – Installation Section** for recommended dry torque settings. Remove the second set screw and apply service removable thread-locker compound to the threads. Reinstall second set screw onto shaft, tighten and torque as required. *NOTE: Some thread-locking compounds act as a lubricant, requiring torque settings to be adjusted. Follow manufacturer's instructions for this adjustment.*

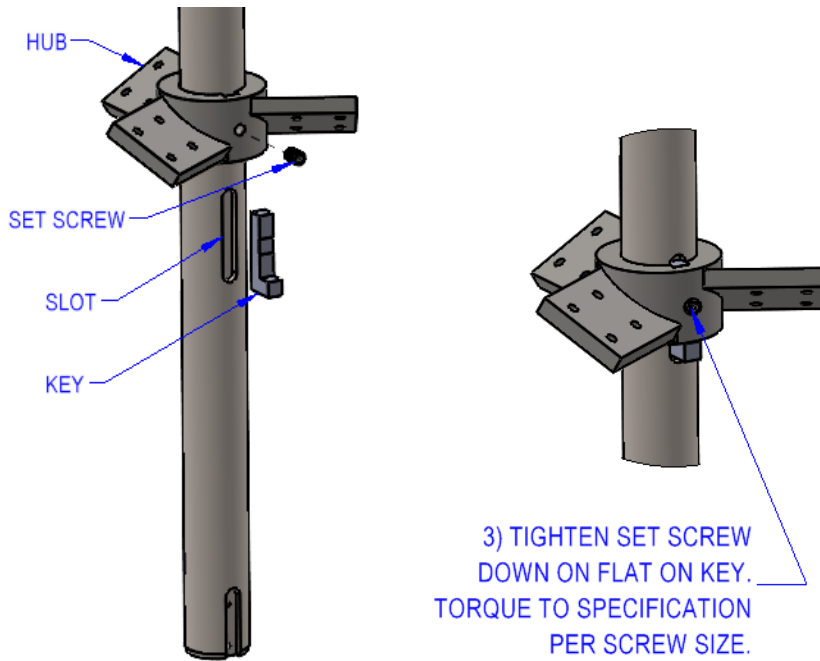
If use of a thread-locking compound is unacceptable, tighten set screws and torque as required. See **Torque Table – Installation Section** for recommended dry torque settings.

Repeat these steps for additional impeller(s) as required.

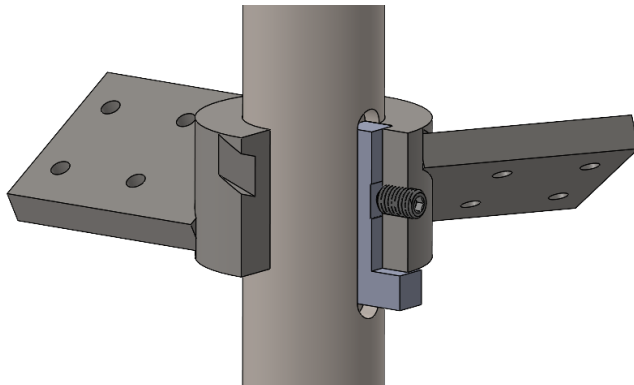


Impeller Installation – Hub & Key

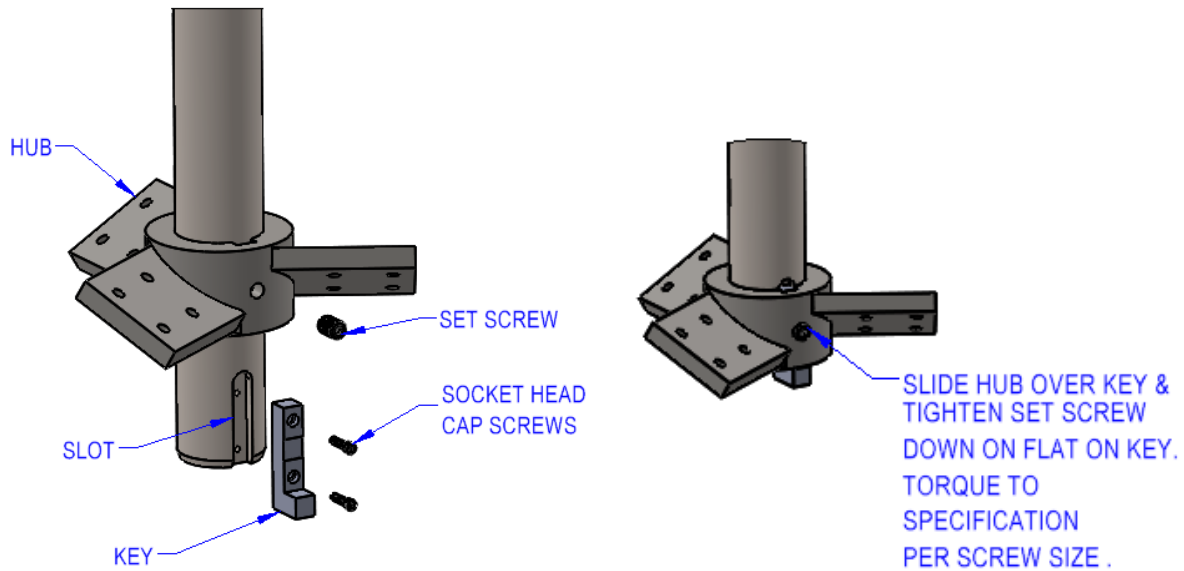
When installing multiple impellers on a shaft, start with the impeller closest to the drive. If your mixer is equipped with a Captured Key, slide impeller hub over the shaft & go past the slot for the key (start with slot closest to drive for multiple impellers) as shown below. Insert key into slot in shaft & slide the hub over key. Align the keyway in hub with the key. Tighten set screw down on flat on key as shown below. Torque screw to specification per screw size see **Torque Table – Installation Section**.



Hub sectioned to show set screw on flat on key in image below



If your mixer is equipped with a Bolted Key, slide impeller hub on the shaft & go past the slot for the key as shown below. Insert key into slot in shaft & attach key with 2-socket head cap screws. Align the keyway in hub with the key & slide hub over key. Tighten set screw down on flat on key as shown below. Torque screw to specification per screw size see **Torque Table – Installation Section**.



Hub sectioned to show set screw on flat on key in image below

