


CAUTION:

- **DISCONNECT AND LOCK OUT POWER SOURCE BEFORE SERVICING MIXER. FAILURE TO FOLLOW THESE INSTRUCTIONS COULD RESULT IN DEATH, PERSONAL INJURY OR PROPERTY DAMAGE.**
- **HEAVY COMPONENTS. HANDLE PROPERLY.**
- **DO NOT ALLOW ROTARY OR STATIONARY SEALING FACES TO CONTACT ANY HARD SURFACES (SEE CROSS SECTION OF SEALING FACES IMAGE ON PAGE 2)**
- **STATIONARY SEALING FACE AND O-RINGS CAN FALL OUT OF GLAND RING. WHEN HANDLING, BE SURE THEY DON'T FALL OUT.**

Begin Seal Installation

If your mixer is equipped with a SDRA or SDRG mechanical seal, follow the Seal Manufacturer's Instructions for Seal Installation and Removal. The following steps are generic and assume use of a piloted seal. Here is the basic process:

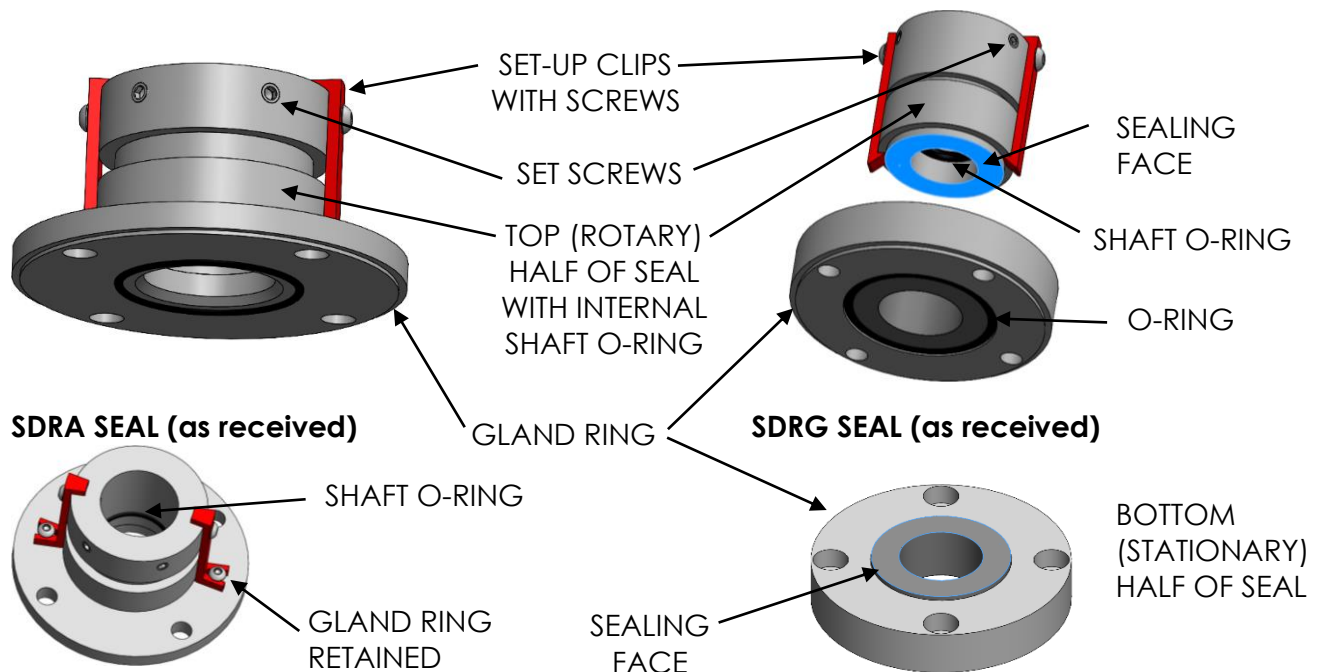
Basic Seal Installation Process

- Float the Seal
- Install the Shaft
- Mount the Seal
- Tighten Set Screws onto Shaft
- Remove Set-up Clips

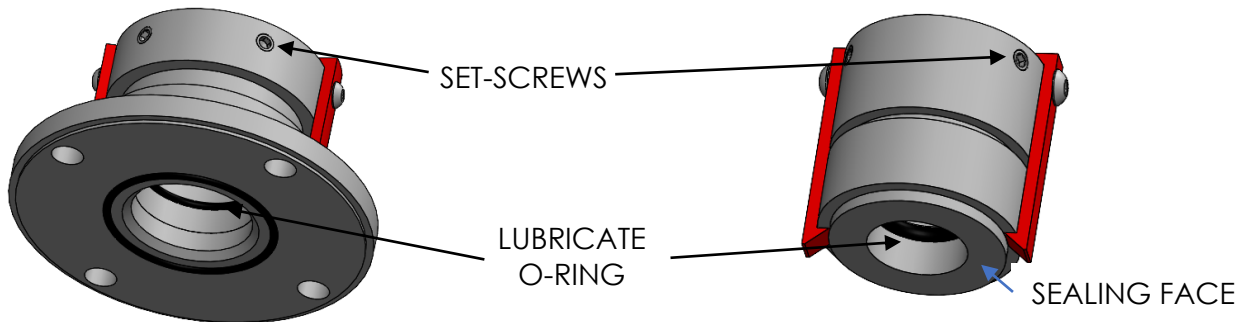
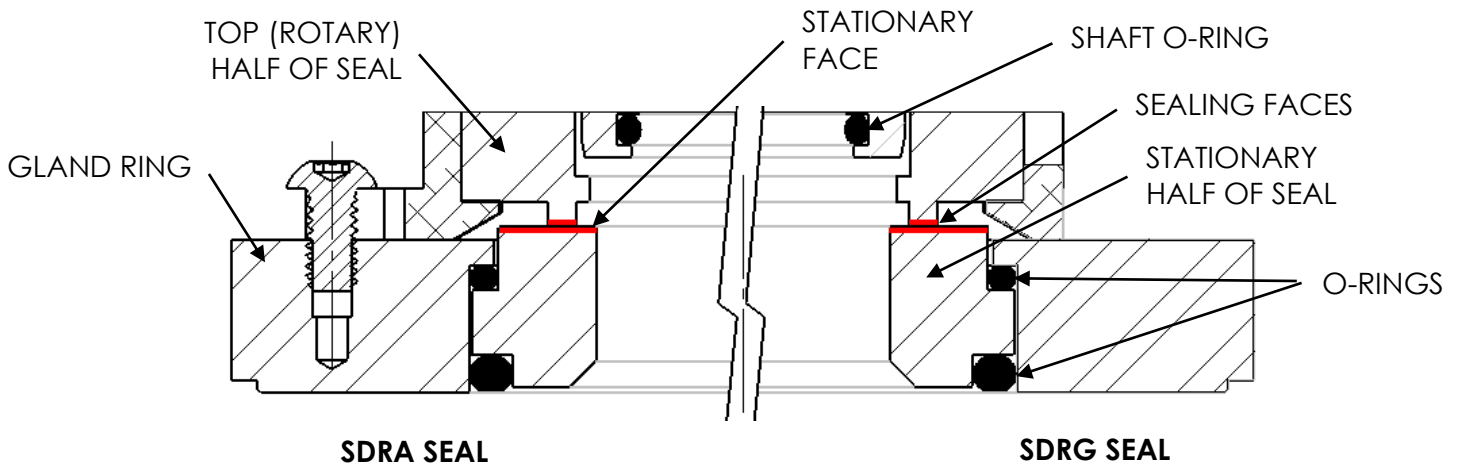


CAUTION: PINCH POINTS & SHARP EDGES MAY BE LOCATED IN THIS AREA

SHOWN BELOW IS THE PROCESS FOR INSTALLING SDRA & SDRG SEALS



CROSS-SECTION OF SEALING FACES



Float the Seal - SDRA

Handle the seal with care to prevent damage to the fragile sealing faces of the seal. Ensure that the stationary face with O-rings does not fall out until the assembly is seated in pedestal.

- Back out the set screws on the rotary half of the seal so they are clear of the bore. Use a process-compatible lubricant on the O-ring located within the bore of the seal as it will help the shaft pass through the O-ring. **Do not apply or allow any grease to contact the mating/sealing faces of the seal.**

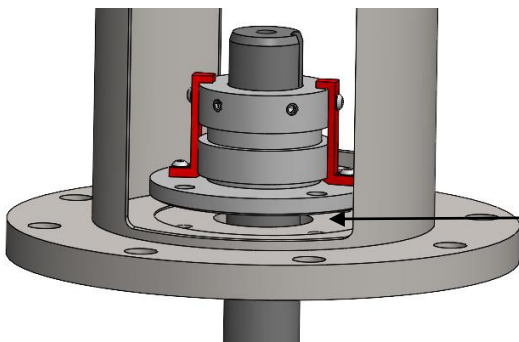
Float the Seal - SDRG

Handle the seal with care to prevent damage to the fragile sealing faces of the seal. Ensure that the stationary face with O-rings does not fall out until the assembly is seated in pedestal.

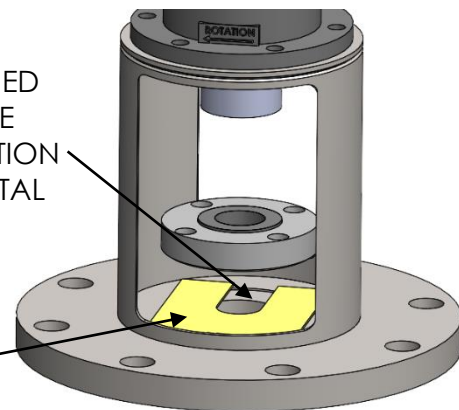
- Back out the set screws on the rotary half of the seal so they are clear of the bore. Use a process-compatible lubricant on the O-ring located within the bore of the seal as it will help the shaft pass through the O-ring. **Do not apply or allow any grease to contact the mating/sealing faces of the seal.**

- To Float the Seal, position the seal in the pedestal and orient with the mounting face toward the base of the pedestal. Insert the shaft through the pedestal then into the mechanical seal bore. Slide the shaft through the bore of the seal.

- FOR SDRG ONLY** - Place a u-shaped piece of cardstock (see last page of this manual section for template) between the stationary half of the seal and the pedestal bore. This prevents the stationary half from sitting in the pedestal female registration.

SDRA SEAL

SDRG SEAL

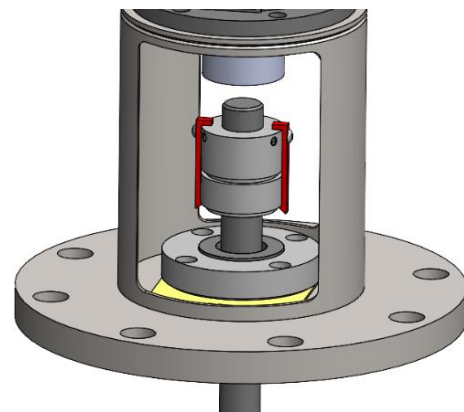
MACHINED
FEMALE
REGISTRATION
IN PEDESTAL
BASE



CARDSTOCK

**CHECK FOR SHARP EDGES OR
BURRS ON SHAFT BEFORE
INSERTING INTO SEAL. DEBURR
AS NECESSARY TO PREVENT
DAMAGE TO O-RINGS.**

Insert the shaft through the bottom of the pedestal, the stationary half of the seal, and the rotary half of the seal. Now the rotary half of the seal is "floated" on the shaft.



Seal installation will resume after the shaft is properly installed.

Install drive end of shaft to mixer drive. See appropriate shaft installation section for your mixer model.

Complete Seal Installation

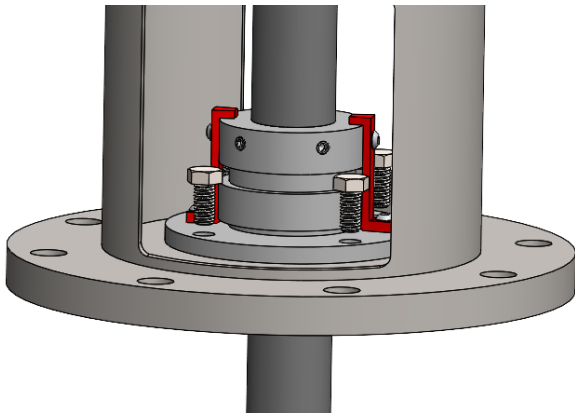
Now that the shaft is properly located and securely affixed, complete the mechanical seal installation. Be sure to follow the manufacturer's instructions. Here is the basic process.



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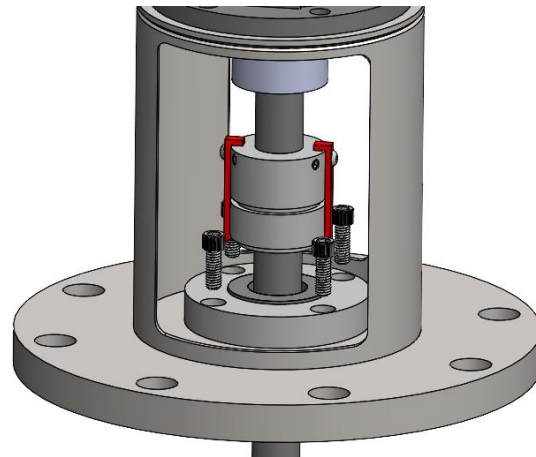
Mount the Seal - SDRA

Slide the seal into the pedestal female registration, aligning the bolt holes in the seal to the holes in the pedestal. Insert and tighten the 4 provided bolts evenly to the appropriate torque value for thread size called out in the table. The installation clips that hold the seal together and set the spring tension should remain in place until the end of the installation process.



Mount the Seal - SDRG

Remove the cardstock and place the stationary half into the pedestal bore, aligning the holes in the seal to the holes in the pedestal. Insert and tighten the 4 provided bolts evenly to the appropriate torque value for thread size called out in the table.

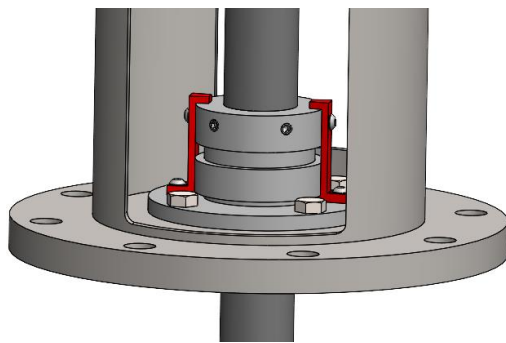


THREAD SIZE	18-8 STAINLESS
5/16"-18	103 in-lb
3/8"-16	16 ft-lb
1/2"-13	36 ft-lb

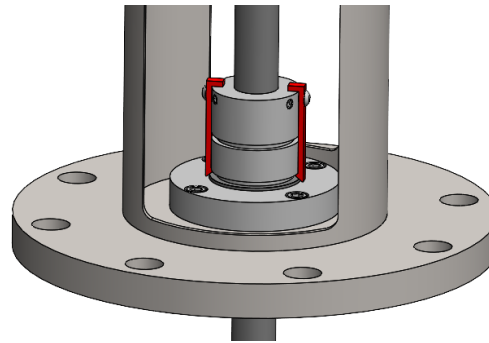
Tighten Set Screws onto Shaft

Use an alternating sequence to tighten and then torque the shaft set screws located on the rotating collar of the seal as required by the seal manufacturer. The goal is to keep the shaft centered within the seal bore, rather than pushed completely to one side. Start by loosely snugging the set screws in the prescribed pattern, then tighten the set screws a little more, and a little more, repeating the same pattern multiple times. Finally, torque the set screws to the appropriate value in table.

HEX SIZE	SET SCREW THREAD SIZE	18-8 STAINLESS
1/8"	1/4"-28	72 in-lb
5/32"	5/16"-24	147 in-lb
3/16"	3/8"-24	22 ft-lb



SDRA SEAL



SDRG SEAL

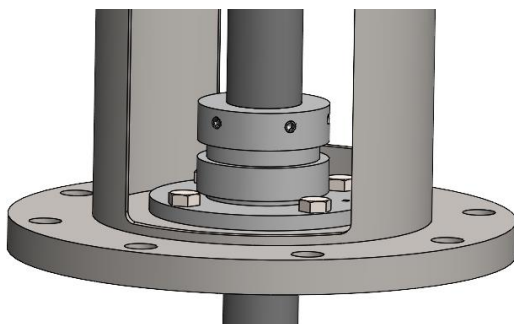
Remove Set-up Clips

A common mistake is **failure to remove the set-up clips** at the end of the seal installation process.

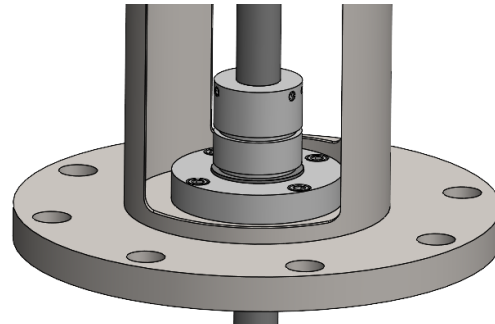


Failure to remove set-up clips before operating mixer can permanently damage seal and equipment.

Remove the set-up clips and be sure to save the seal's set-up clips. They will be essential for future disassembly, shipment, rebuild, and reassembly of the mechanical seal.



SDRA SEAL



SDRG SEAL

USE THIS TEMPLATE TO CUT OUT THE U-SHAPED
CARDSTOCK. DO NOT CUT THIS PIECE OF PAPER. MAY
NEED TO TRIM TO FIT INTO PEDESTAL.

