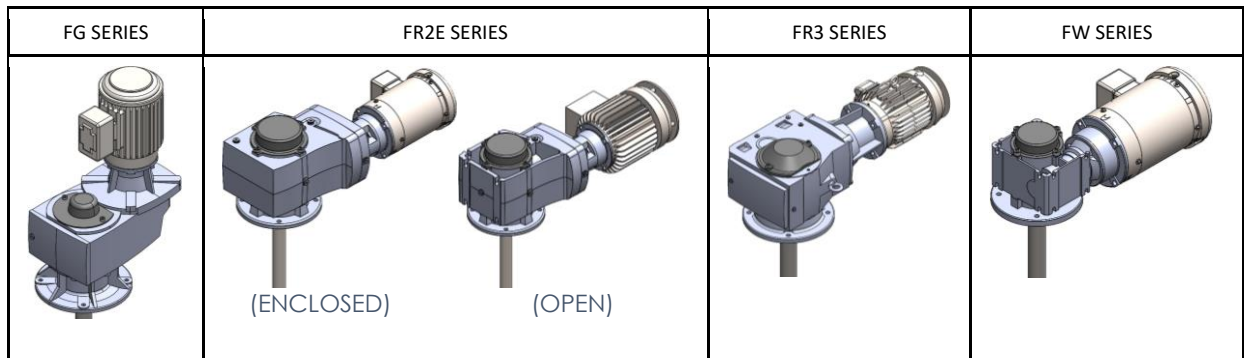


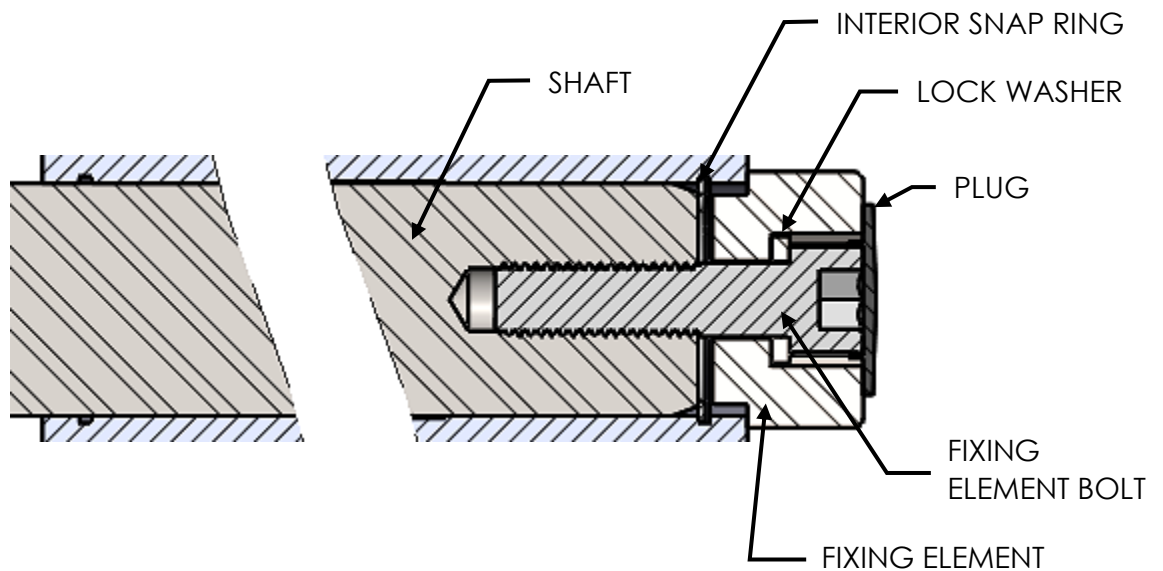

CAUTION:

- **ALWAYS SHUT OFF AND LOCK OUT POWER SUPPLY AND DISCONNECT FROM POWER SUPPLY BEFORE SERVICING MIXER. FAILURE TO FOLLOW THESE INSTRUCTIONS COULD RESULT IN DEATH, PERSONAL INJURY OR PROPERTY DAMAGE.**
- **PINCH POINTS & SHARP EDGES MAY BE LOCATED IN THIS AREA.**

The following Fusion mixer models may use a fixing element to secure the shaft to the Nord gearbox:



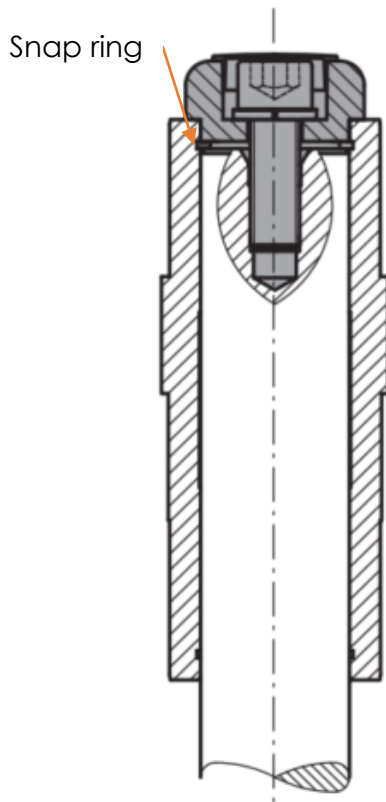
Typical fixing kit components



*Snap Ring is used on Side Entry mixers & when the mixer has a non-stepped shaft.

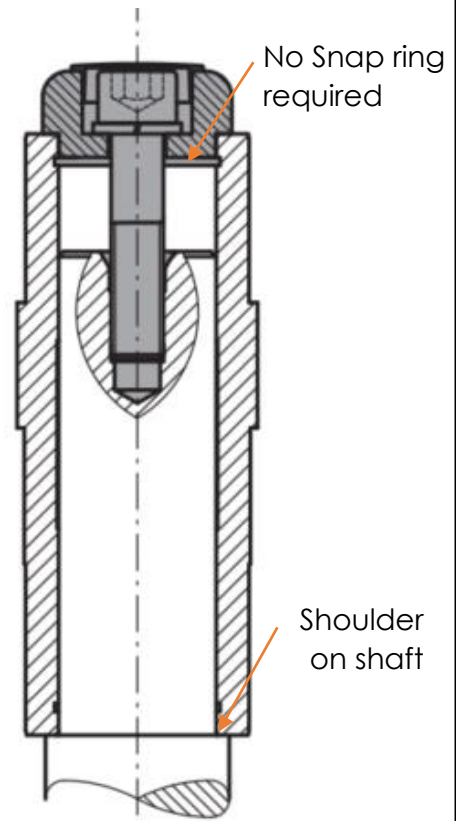
Assembly Type 1 – Fixing Element with Snap Ring

The mixer shaft is located against a fixed snap ring located inside the bore of the gearbox.



Assembly Type 2 – Fixing Element with Stepped (Shouldered) Shaft

The mixer shaft is shouldered and is pulled tight against the hollow bore.



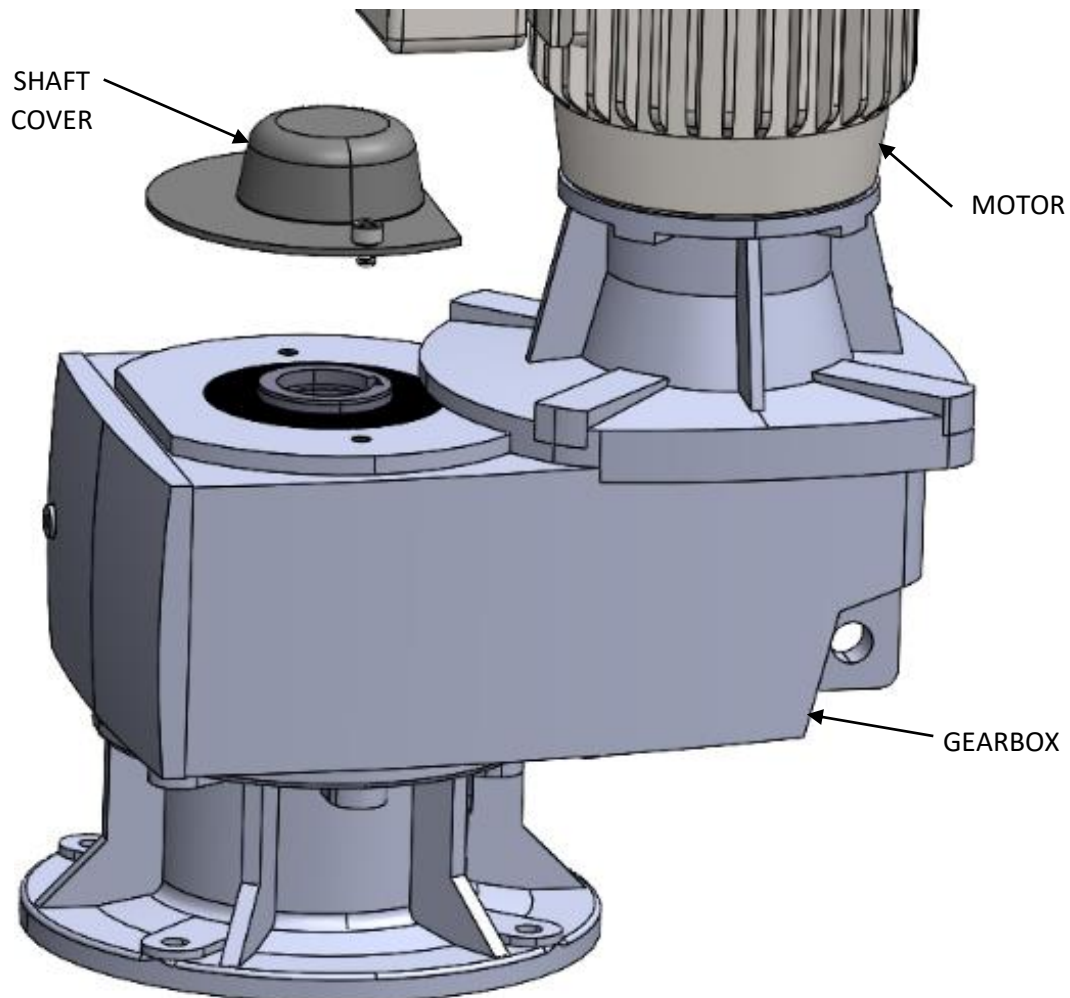
Type 1 Assembly typical shaft sizes: $\varnothing 3/4''$; $\varnothing 1''$; $\varnothing 1-1/4''$ and for Side Entry.

Type 2 Assembly typical shaft sizes: larger than $\varnothing 1-1/4''$. Not used on Side Entry application.

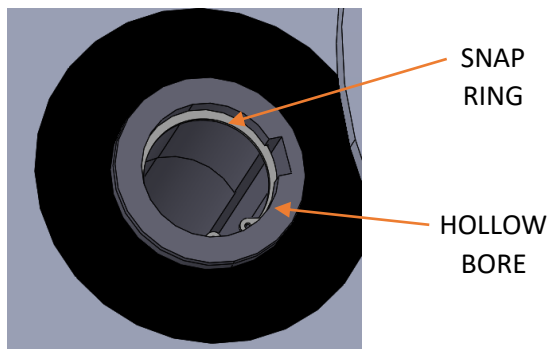
Note: Some of the assembly steps are identical for the fixing element with snap ring and the fixing element with stepped shaft. The steps will note this as you follow the assembly methods below.

| | |
|------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|
| Type 1 - Shaft Installation – Fixing Element with Snap Ring | Type 2 - Shaft Installation – Fixing Element with Stepped (Shouldered) Shaft |
|------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|

- **This assembly step is the same for both Type 1 & 2.** Remove the gearbox's shaft cover by removing the bolts that hold it down. Keep the shaft cover and bolts.

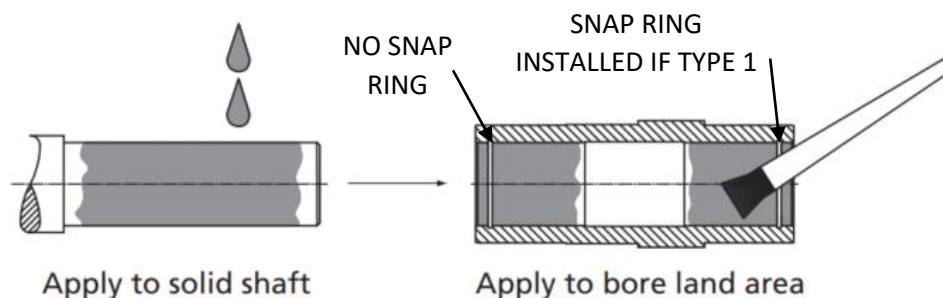


| Type 1 - Shaft Installation – Fixing Element with Snap Ring | Type 2 - Shaft Installation – Fixing Element with Stepped (Shouldered) Shaft |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------|
| <ul style="list-style-type: none"> • Type 1 assembly only. Ensure the snap ring is fully seated in the top groove in the gearbox's hollow bore. Some gearboxes have multiple grooves in hollow bore. | <ul style="list-style-type: none"> • Type 2 assembly only. Remove the snap ring if installed. |



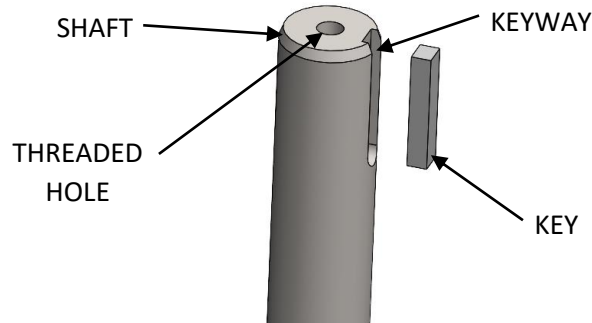
- **Type 1 & 2.** Clean and remove any dirt, grease, or rust-preventative coatings from both the gearbox hollow bore and the mixer shaft. Make sure the edges of both the gearbox hollow bore and mixer shaft are free from any nicks or burrs. If nicks or burrs are present, remove them using an abrasive material such as an emery cloth. Before installing the mixer shaft into the gearbox, apply an anti-seize compound or anti-corrosive lubricant to the mating shafts as shown in Figure 1. Assembly and subsequent disassembly will be aided by the anti-seize agent.

Figure 1 – Application of anti-seize to the mating shafts



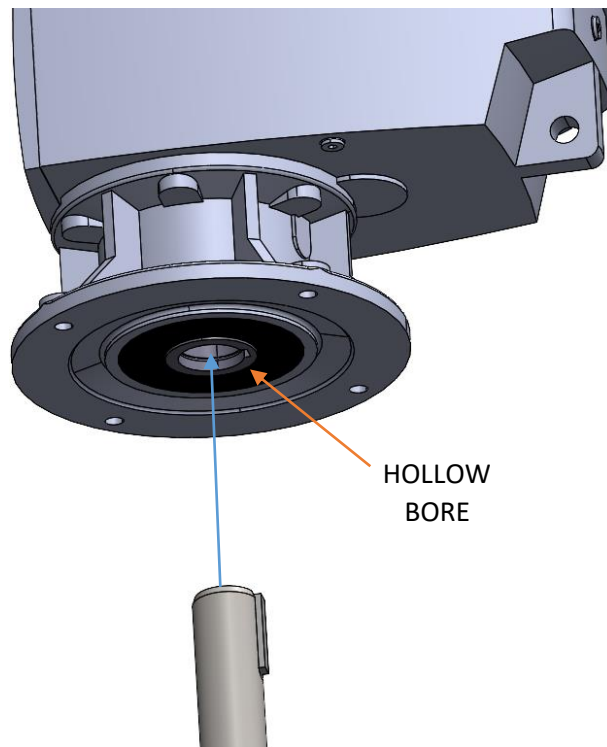
| | |
|------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|
| Type 1 - Shaft Installation – Fixing Element with Snap Ring | Type 2 - Shaft Installation – Fixing Element with Stepped (Shouldered) Shaft |
|------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|

- **Type 1 & 2.** Insert the key into the keyway on the shaft before assembly in hollow bore.



- **Type 1 & 2.** Insert the shaft and key into the gearbox's hollow bore. Ensure that the key in the shaft is aligned with the keyway in the gearbox's hollow bore.

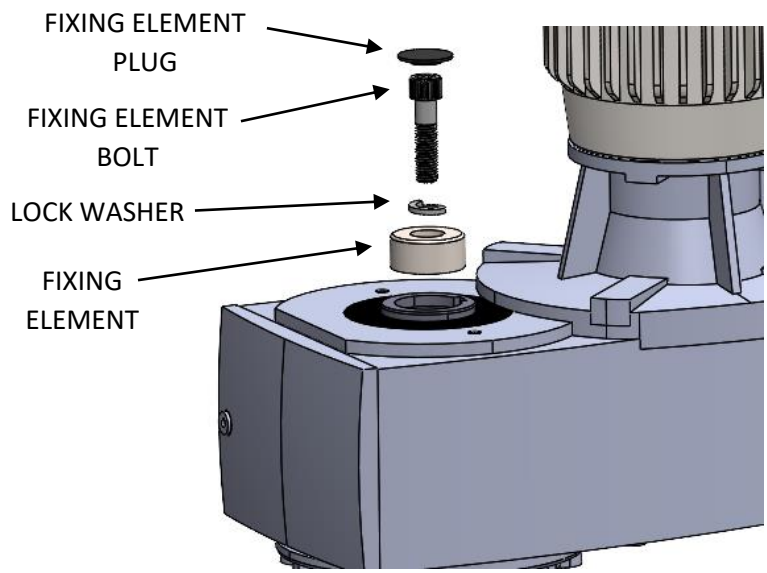
| | |
|----------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------|
| Type 1 only. The shaft needs to be in contact with the snap ring when fully inserted. | Type 2 only. The shaft shoulder should make contact with the bottom of the gearbox hollow bore. |
|----------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------|



| | |
|------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|
| Type 1 - Shaft Installation – Fixing Element with Snap Ring | Type 2 - Shaft Installation – Fixing Element with Stepped (Shouldered) Shaft |
|------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|

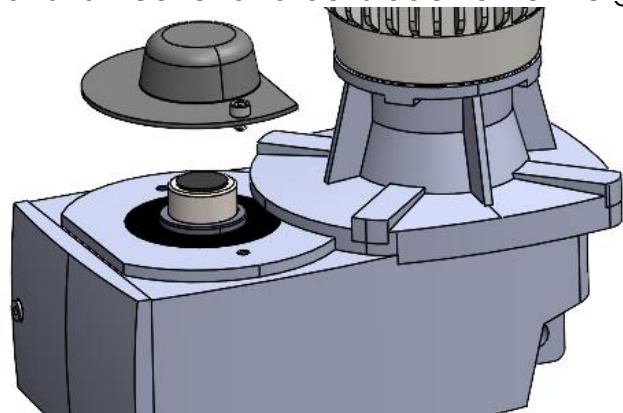
- Type 1 & 2.** Attach the shaft to the gearbox using the fixing element and fixing element bolt (both provided). Apply service removable thread-locking compound to the fixing element bolt before assembling to threaded end of shaft. Tighten the fixing element bolt to the appropriate torque value in the table.

TYPE 1 ONLY. DO NOT OVER TIGHTEN SCREW AS IT COULD CAUSE THE SNAP RING TO PULL OUT!



| TYPE 1 & TYPE 2 | | | |
|-----------------|----------------------|---------------|--------------|
| BOLT SIZE | 18-8 & 304 STAINLESS | 316 STAINLESS | GRADES 5 & 8 |
| 10-32 | 15 in-lb. | 16 in-lb. | 17 in-lb. |
| 1/4-20 | 29 in-lb. | 30 in-lb. | 38 in-lb. |
| 5/16-18 | 52 in-lb. | 54 in-lb. | 84 in-lb. |
| 3/8-16 | 96 in-lb. | 102 in-lb. | 13 ft-lb. |
| 7/16-14 | 13 ft-lb. | 14 ft-lb. | 20 ft-lb. |
| 1/2-13 | 18 ft-lb. | 19 ft-lb. | 31 ft-lb. |
| 5/8-11 | 41 ft-lb. | 42 ft-lb. | 61 ft-lb. |
| 3/4-10 | 57 ft-lb. | 59 ft-lb. | 108 ft-lb. |
| 7/8-9 | 89 ft-lb. | 93 ft-lb. | 126 ft-lb. |
| 1-8 | 135 ft-lb. | 141 ft-lb. | 188 ft-lb. |

- Type 1 & 2.** Install shaft cover and bolts back onto the gearbox.



For additional Shaft Installation with Fixing Element support go to our YouTube Channel - [FusionFluidEquipment](https://www.youtube.com/channel/UCFusionFluidEquipment)