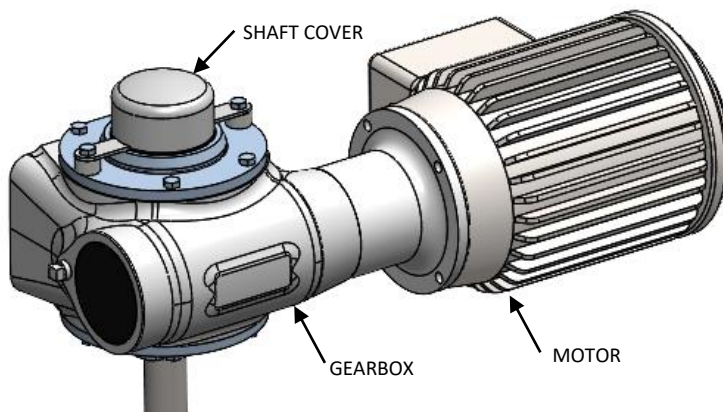
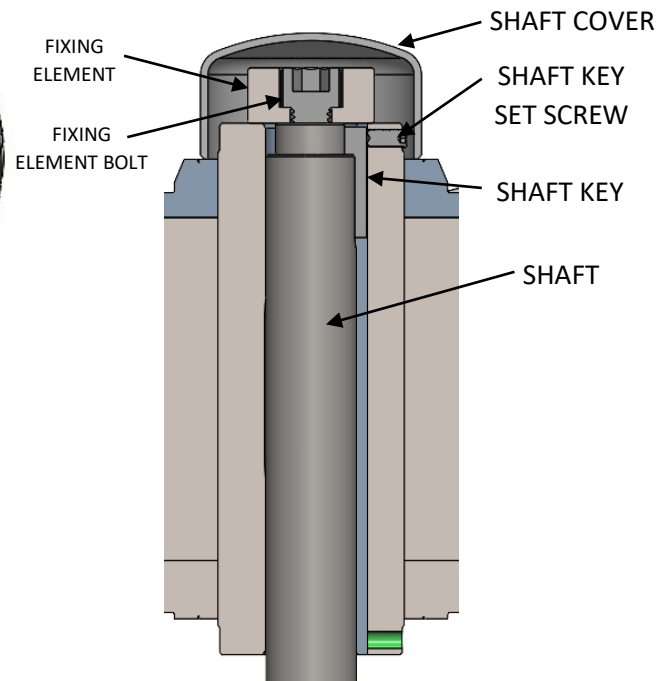



CAUTION:

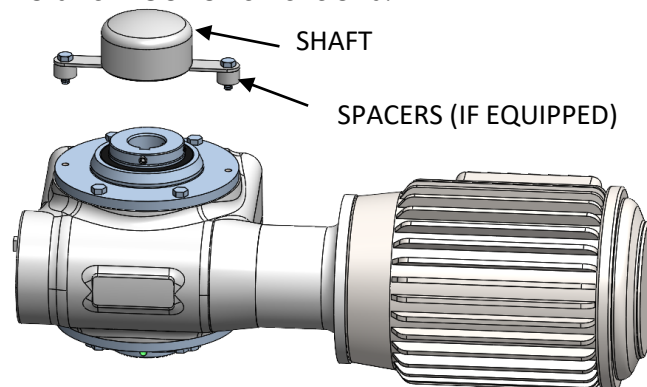
- **ALWAYS SHUT OFF AND LOCK OUT POWER SUPPLY AND DISCONNECT FROM POWER SUPPLY BEFORE SERVICING MIXER. FAILURE TO FOLLOW THESE INSTRUCTIONS COULD RESULT IN DEATH, PERSONAL INJURY OR PROPERTY DAMAGE.**
- **PINCH POINTS & SHARP EDGES MAY BE LOCATED IN THIS AREA**

Shaft Installation – Cone Drive Fixing Element

The following section provides instruction on the installation of a shaft with keyway and fixing element in a hollow bore of a Cone Drive gearbox.

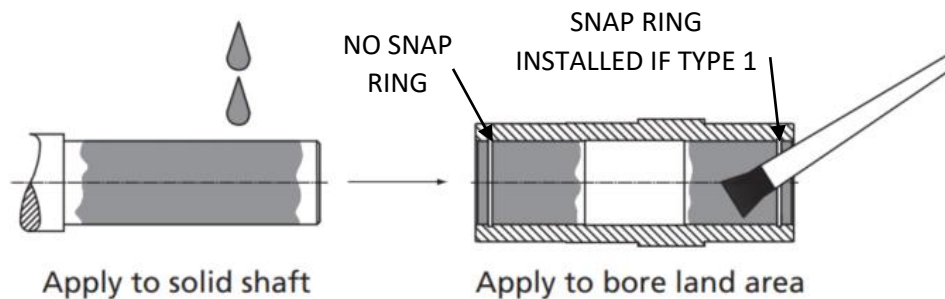
 FINAL ASSEMBLY WITH SHAFT
AND SHAFT COVER INSTALLED

 SECTION VIEW OF
FINAL ASSEMBLY


- 1) Remove the gearbox's shaft cover by removing the bolts that hold it down. Keep the shaft cover and bolts.

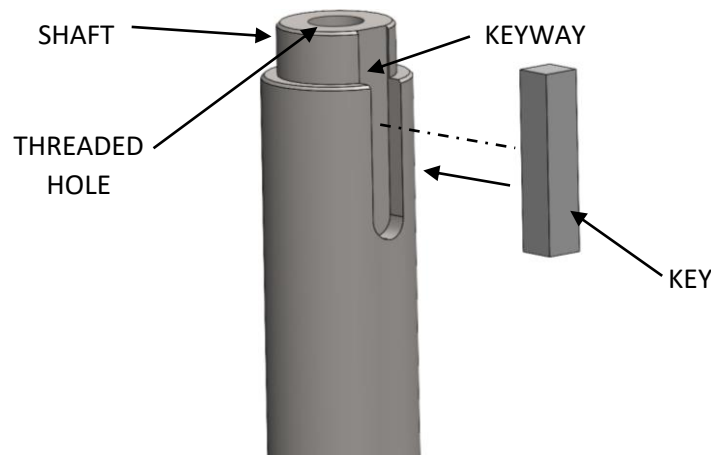


- 2) Clean and remove any dirt, grease, or rust-preventative coatings from both the gearbox hollow bore and the mixer shaft. Make sure the edges of both the gearbox hollow bore and mixer shaft are free from any nicks or burrs. If nicks or burrs are present remove them using an abrasive material such 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.

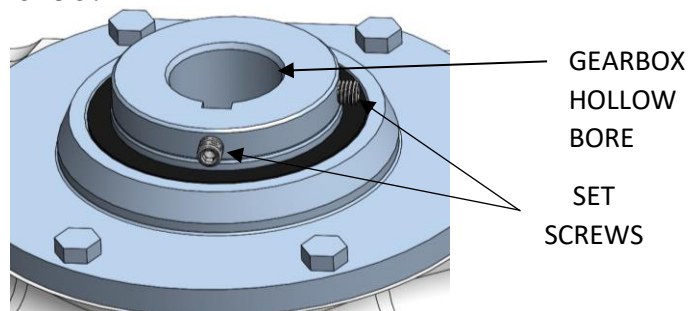
Figure 1 – Application of anti-seize to the mating shafts



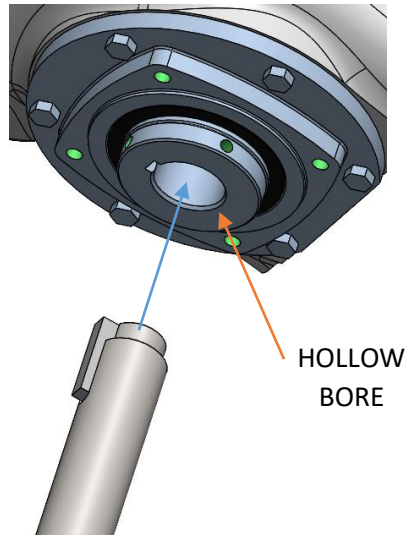
- 3) Insert the key into the keyway on the shaft before assembly in hollow bore.



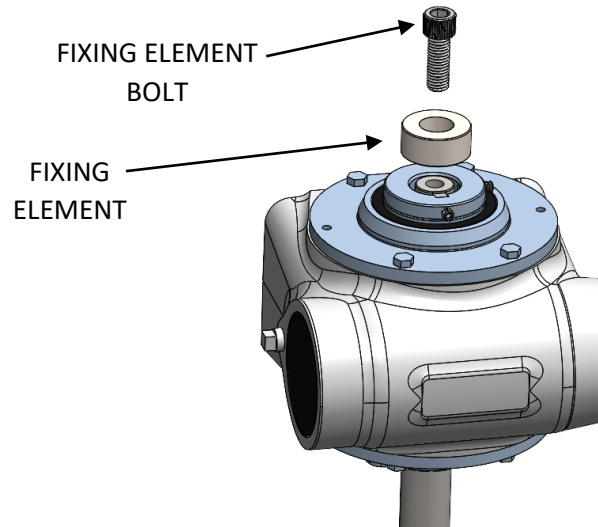
- 4) Ensure the set screws are backed up and clear of the bore to allow for the shaft and key to be installed.



- 5) 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.

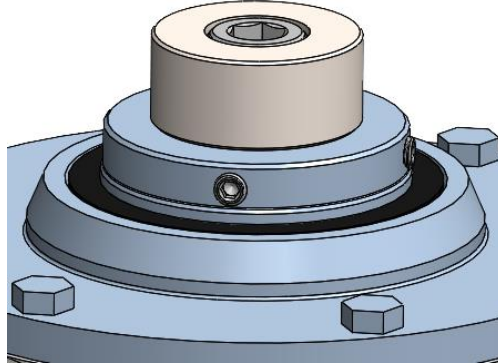


- 6) Attach the shaft to the gearbox using the fixing element and fixing element bolt (both provided). Apply service removable thread-locking compound to the fixing element bolt threads before assembling to tapped end of shaft. Tighten the fixing element bolt to the appropriate value in the table.



BOLT SIZE	18-8 & 304 STAINLESS	316 STAINLESS
5/16-24	71 in-lb.	74 in-lb.
3/8-16	96 in-lb.	102 in-lb.
7/16-14	13 ft-lb.	14 ft-lb.
5/8-11	41 ft-lb.	42 ft-lb.

- 7) Removed set screws & apply service removable thread-locking compound to the set screw threads, reinstall & then tighten the screws to 71 in-lbs.



- 8) Install shaft cover and bolts (and spacers if provided) back onto the gearbox.

