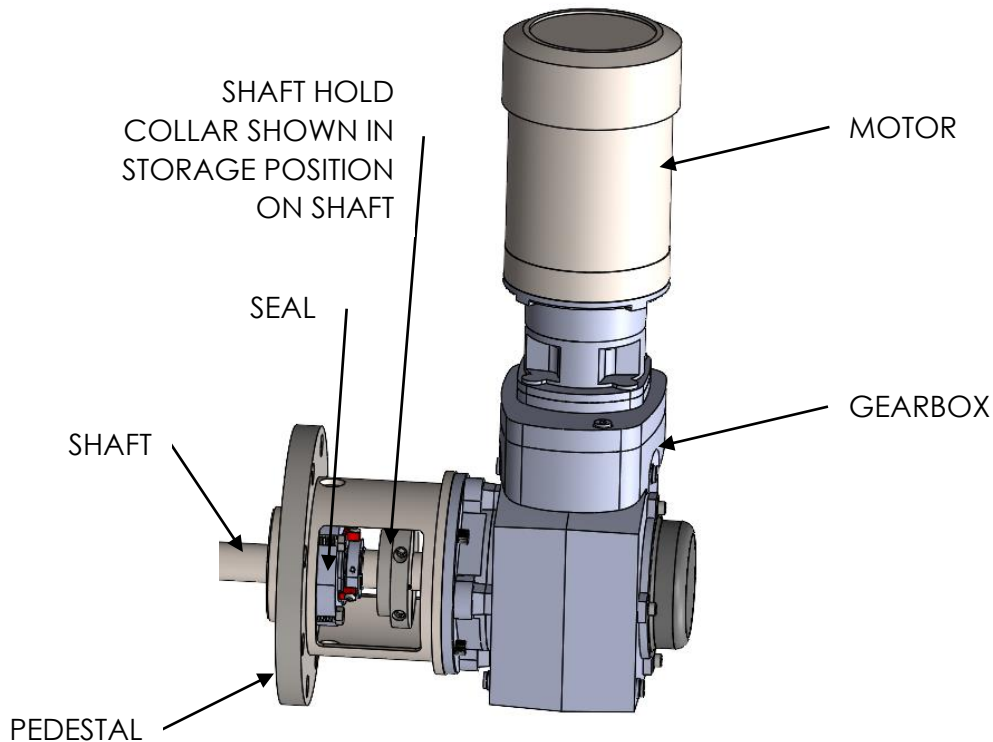
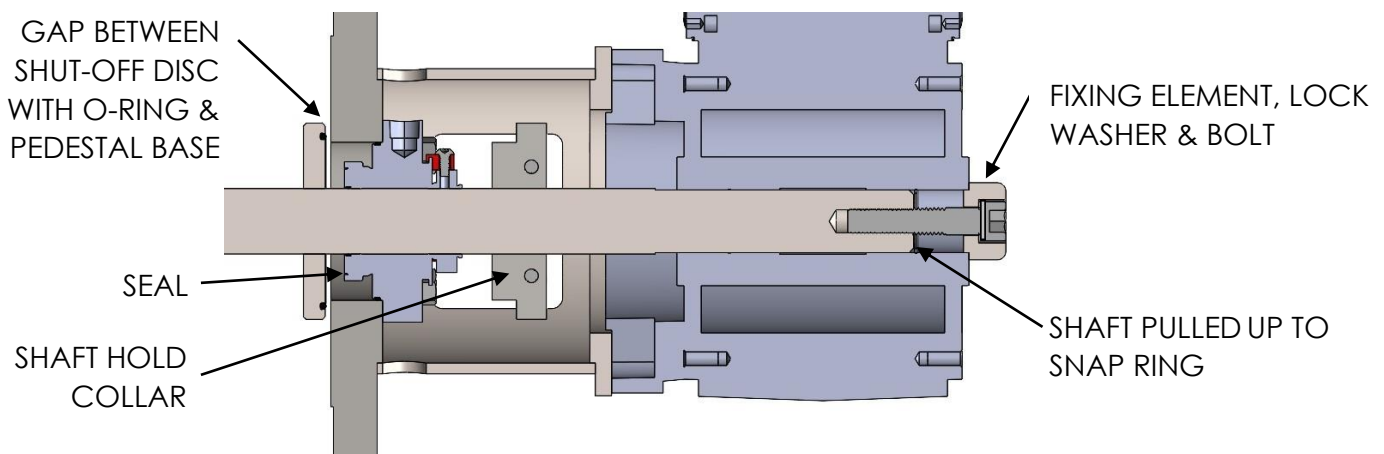



CAUTION:

- **NOT ALL FUSION SIDE ENTRY MIXERS ARE EQUIPPED WITH AN IN TANK SHUT-OFF (ITSO) FEATURE. MAKE SURE YOUR MIXER HAS THIS FEATURE BEFORE BEGINNING THIS PROCEDURE.**
- **DISCONNECT AND LOCK OUT POWER SOURCE BEFORE SERVICING MIXER. MAKE SURE TO FOLLOW LOCK OUT TAG OUT PROCEDURE. FAILURE TO FOLLOW THESE INSTRUCTIONS COULD RESULT IN DEATH, PERSONAL INJURY OR PROPERTY DAMAGE.**
- **HEAVY COMPONENTS. HANDLE PROPERLY.**
- **EXCESSIVE PRESSURE HAZARD: MAKE CERTAIN INTERNAL PRESSURE OF THE MIXING VESSEL IS RELIEVED BEFORE BEGINNING. FAILURE TO FOLLOW THESE INSTRUCTIONS COULD RESULT IN DEATH, SERIOUS PERSONAL INJURY OR PROPERTY DAMAGE.**

TYPICAL ASSEMBLY OF SIDE ENTRY MIXER SHOWN BELOW

TYPICAL CROSS SECTION OF OPERATIONAL MIXER SHOWN BELOW


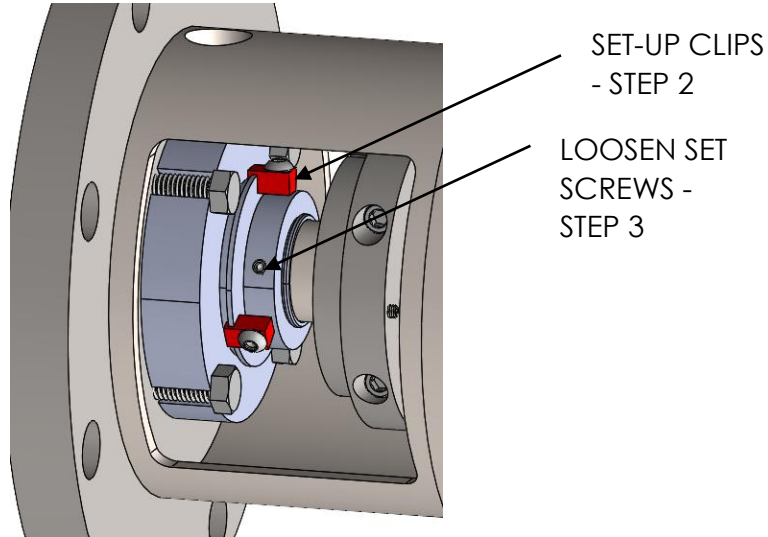
Begin In Tank Shut-Off Engagement



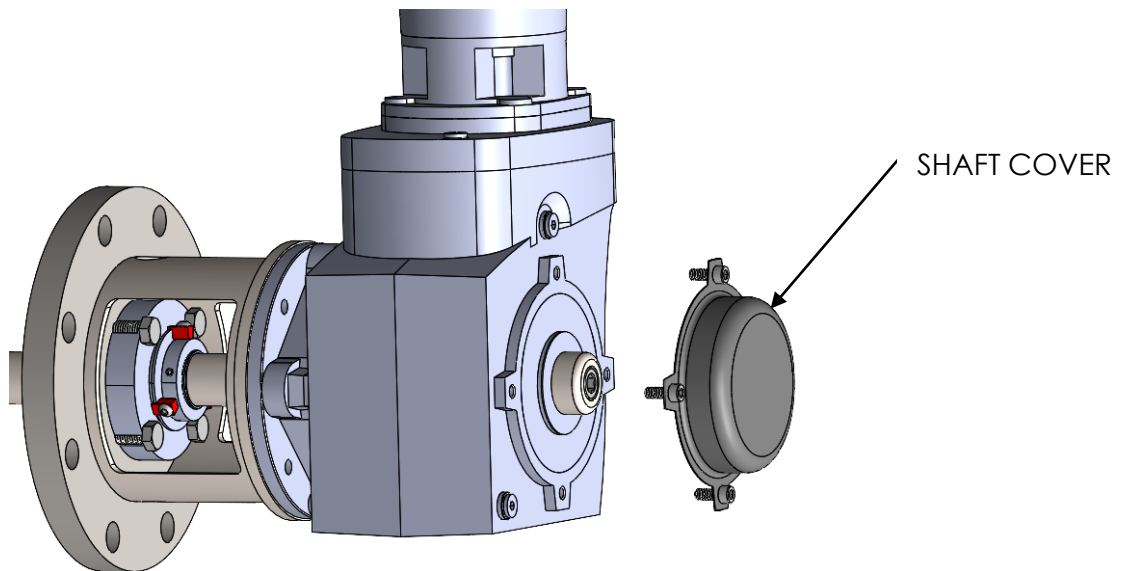
Before beginning any maintenance on your side entry mixer make sure power source is disconnected and make sure to follow Lock Out Tag Out procedure. Make sure mounting flange is secure to tank before beginning. If the o-ring in the shut-off disc is damaged, the shut-off will not effectively seal off the tank, leakage will occur. Check condition of o-ring periodically when the tank is drained.

- 1) Install set-up clips on seal. See image below.
- 2) Loosen seal set screws. See image below.

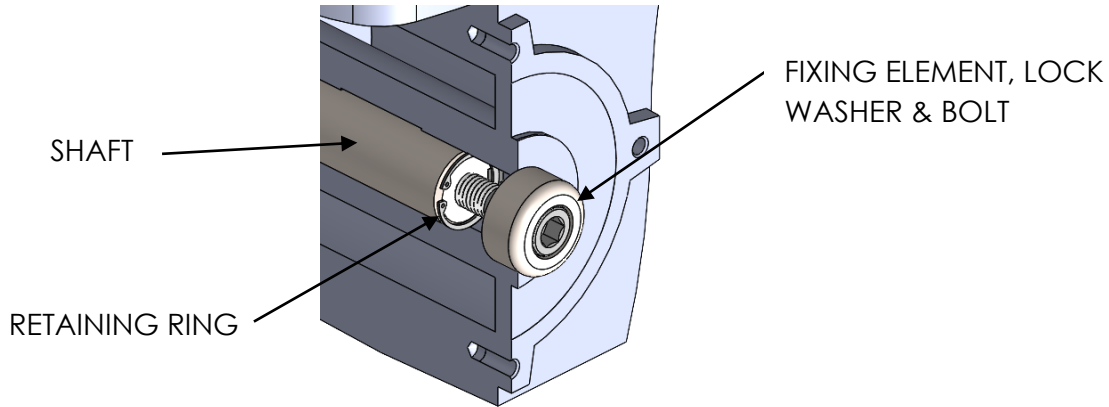
REINSTALL SET-UP CLIPS BEFORE ENGAGING THE ITSO



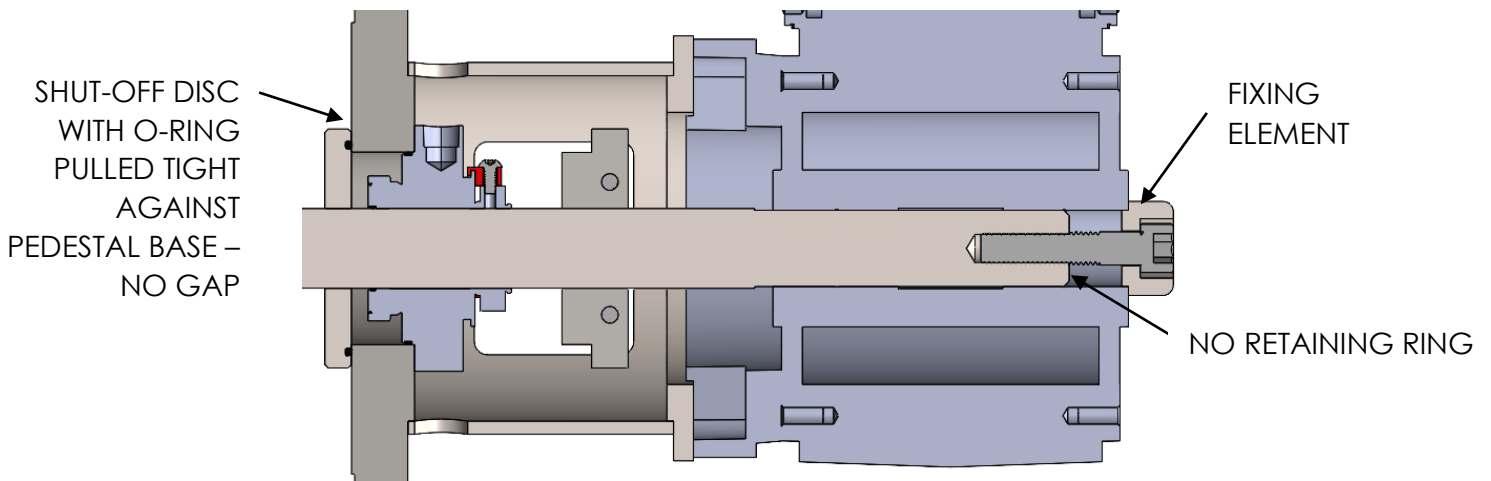
- 3) Remove shaft cover on gearbox by removing bolts & cover. See image below.



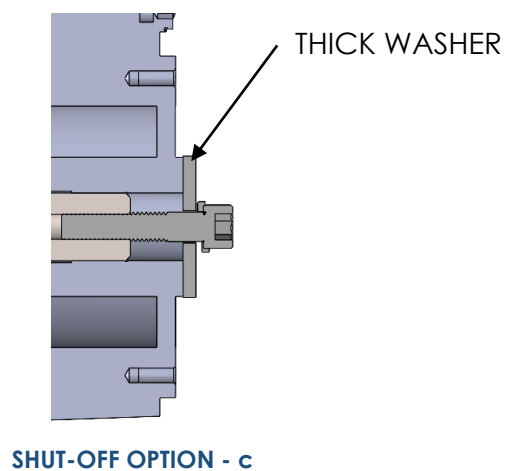
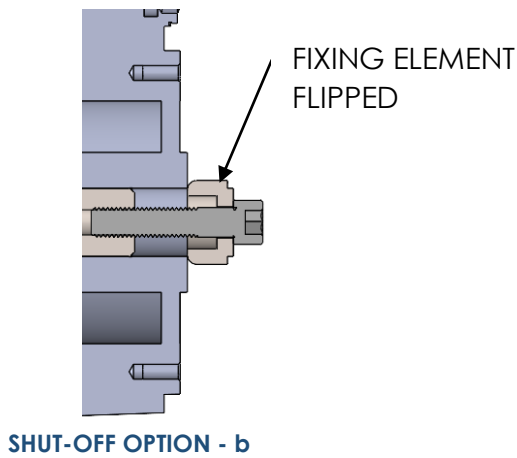
- 4) Remove fixing element, lock washer, bolt & retaining ring. See gearbox cut away assembly image below.



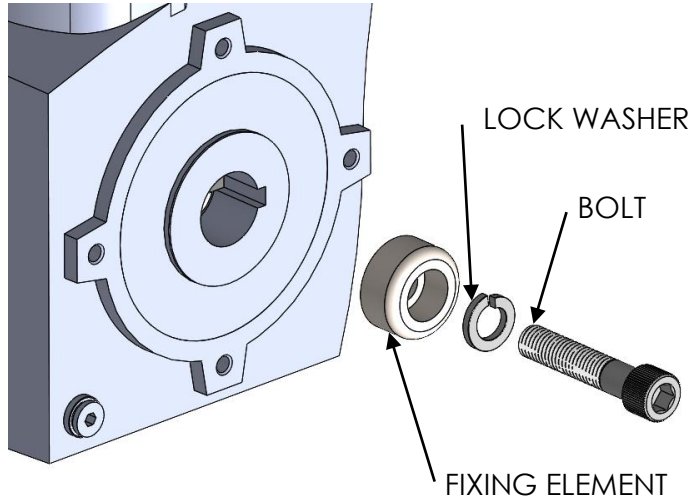
- 5) Depending on your mixer configuration, there are three assembly options listed below - (a, b & c) to draw back shaft to **engage ITS0**.



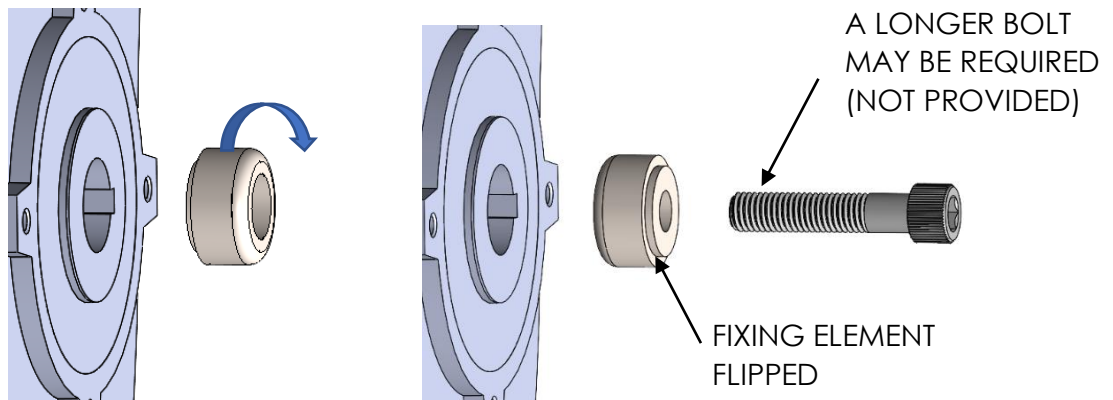
SHUT-OFF OPTION - a



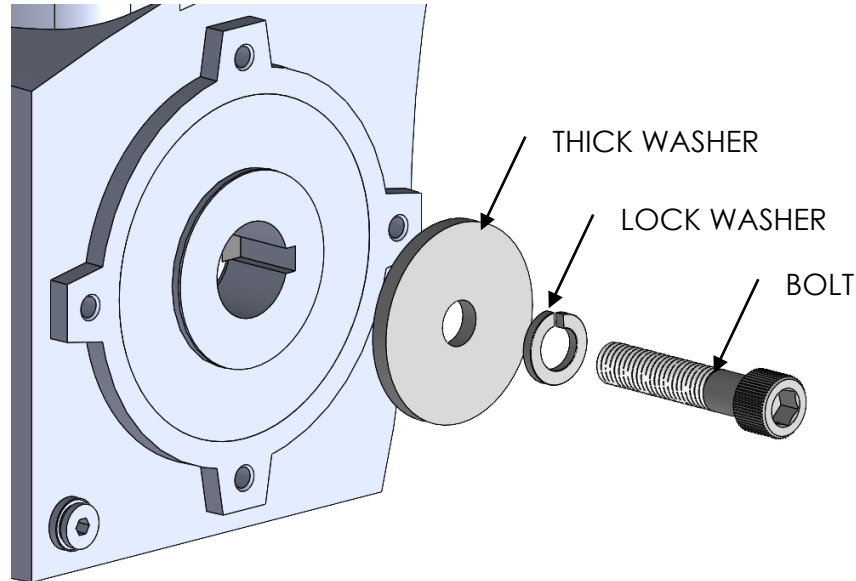
- a) With the retaining ring removed, the fixing element, lock washer and bolt can be reinstated in the same orientation. This will allow the shaft to be pulled further into gearbox hollow bore, thus engaging the ITSO. Tighten bolt to secure the shut-off.



- b) Make sure the retaining ring is removed. Flip the fixing element around so the side with the shoulder is facing away from the gearbox as shown below. A longer bolt may be required to engage the threads in the end of the shaft. Once bolt is engaged to the threads in the shaft tighten to secure the shut-off.



- c) Make sure the retaining ring is removed. For this assembly option a thick washer, lock washer & bolt can be used. Once bolt is engaged to the threads in the shaft, tighten to secure the shut-off.



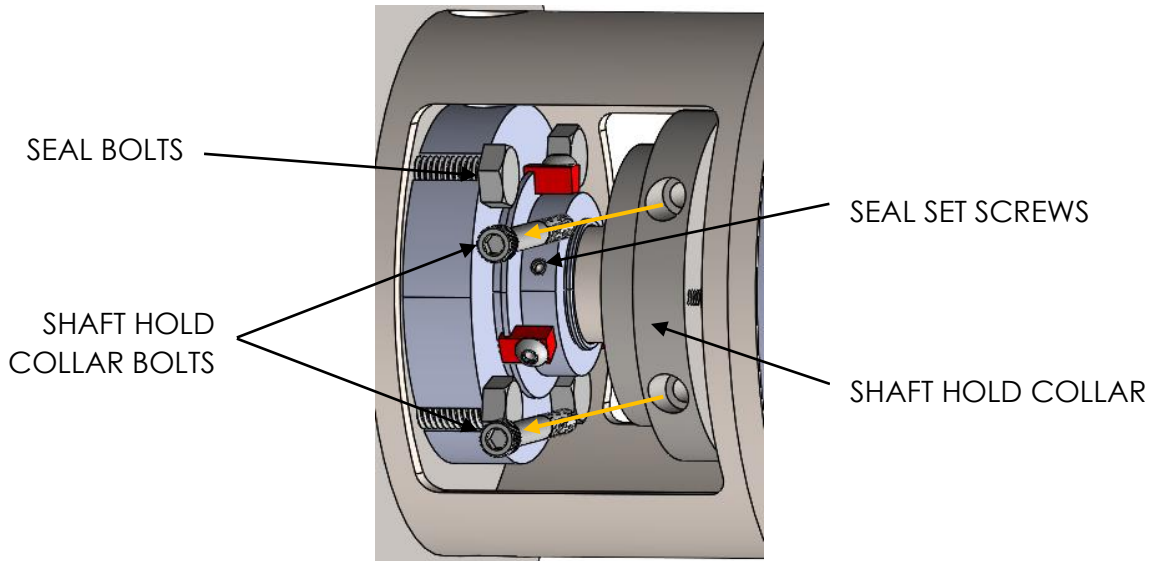
The following instructions will cover removal of a Seal in a side entry configuration with the In Tank Shut-Off (ITSO).



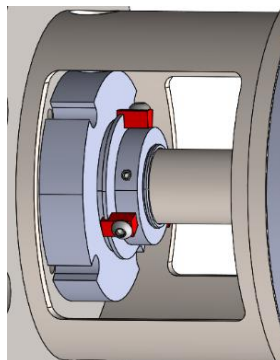
CAUTION:

- **NOT ALL FUSION SIDE ENTRY MIXER PEDESTALS PROVIDE CLEARANCE TO REMOVE THE SEAL. YOUR TANK SHOULD BE EMPTIED IN THAT SITUATION. CONTACT A FUSION REPRESENTATIVE TO FIND OUT THE EXACT CONFIGURATION OF YOUR MIXER ASSEMBLY.**
- **DISCONNECT AND LOCK OUT POWER SOURCE BEFORE SERVICING MIXER. FAILURE TO FOLLOW THESE INSTRUCTIONS COULD RESULT IN DEATH, PERSONAL INJURY OR PROPERTY DAMAGE.**
- **MAKE SURE TO FOLLOW LOCK OUT TAG OUT PROCEDURE.**
- **HEAVY COMPONENTS. HANDLE PROPERLY.**
- **PINCH POINTS & SHARP EDGES MAY BE LOCATED IN THIS AREA.**
- **MAKE SURE THE SET-UP CLIPS ARE INSTALLED ON SEAL – IF EQUIPPED.**
- **MAKE SURE THE IN TANK SHUT-OFF IS ENGAGED OR ENSURE THE TANK IS EMPTY.**

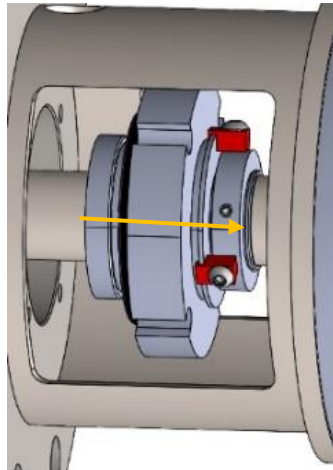
- 1) Ensure that the seal set-up clips are installed (page 2), the shaft is retracted, and the shaft set screws on the seal are loosened. If the shaft hold collar is installed on the shaft as recommended, remove it by removing the two bolts that hold it to the shaft.



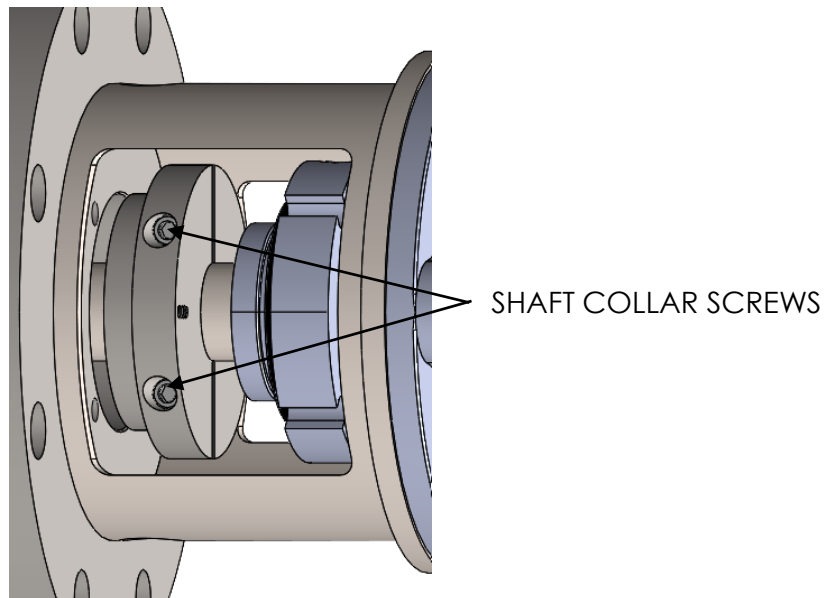
- 2) If your seal is equipped with any plumbing to the flush port, buffer ports or barrier ports, make sure to disconnect and remove. Then remove seal bolts.



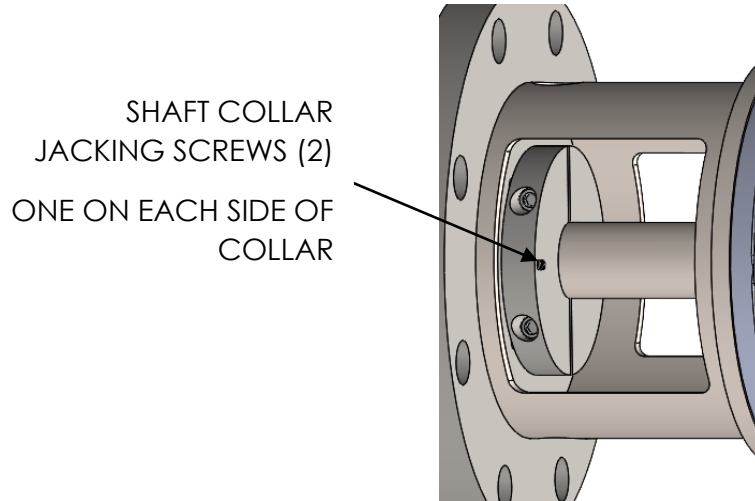
- 3) Slide the seal towards the gearbox.



- 4) Install the shaft hold collar, in the orientation as shown below. The two shaft hold collar screws will have to be removed completely so the two shaft hold collar halves can be placed around the shaft. Reinstall the two shaft hold collar screws, leave them loose so the shaft collar can still slide on the shaft.



- 5) Slide the shaft hold collar towards the tank. Slide the smaller outer diameter of the shaft hold collar into the pedestal bore as shown below. Once in the pedestal bore. Tighten the shaft collar screws. Tighten the two jacking screws evenly. This will keep the ITSO properly sealed against the flange.

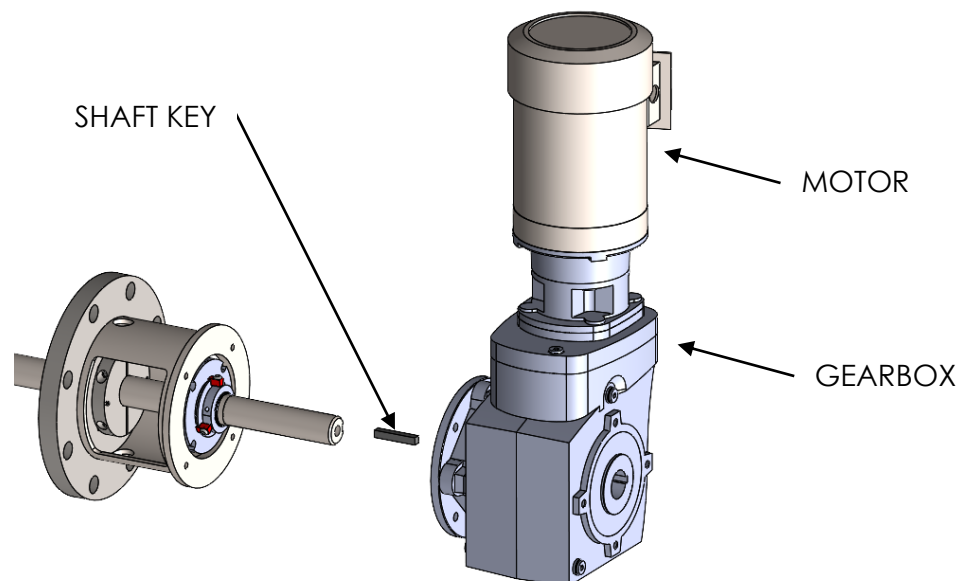


- 6) With the shaft hold collar securely in place, remove the shaft shut-off hardware used per the assembly **option a, b or c**. Continue to the next step.

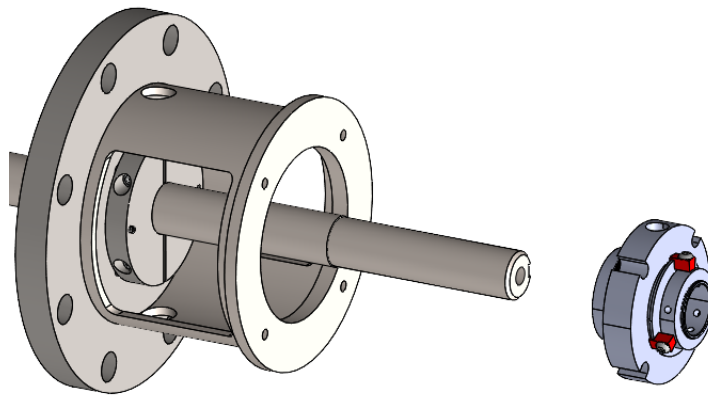


CAUTION:

- **MULTIPLE PERSONS OR USE OF A LIFTING DEVICE MAY BE REQUIRED FOR THE NEXT STEP TO SUPPORT THE ASSEMBLED MOTOR & GEARBOX WHICH CAN BE EXTREMELY HEAVY.**
 - **FOR EASE OF HANDLING THE MOTOR MAY BE REMOVED FROM GEARBOX**
- 7) Gearbox & motor can now be removed by removing the bolts holding the gearbox to the pedestal. The key in the shaft can also be removed. **Use caution as gearbox & motor can be extremely heavy.**



- 8) Slide the seal off the end of the shaft to remove. Follow appropriate instructions if the seal is to be rebuilt or replaced.



Reverse the seal removal steps to install a new or rebuilt seal.