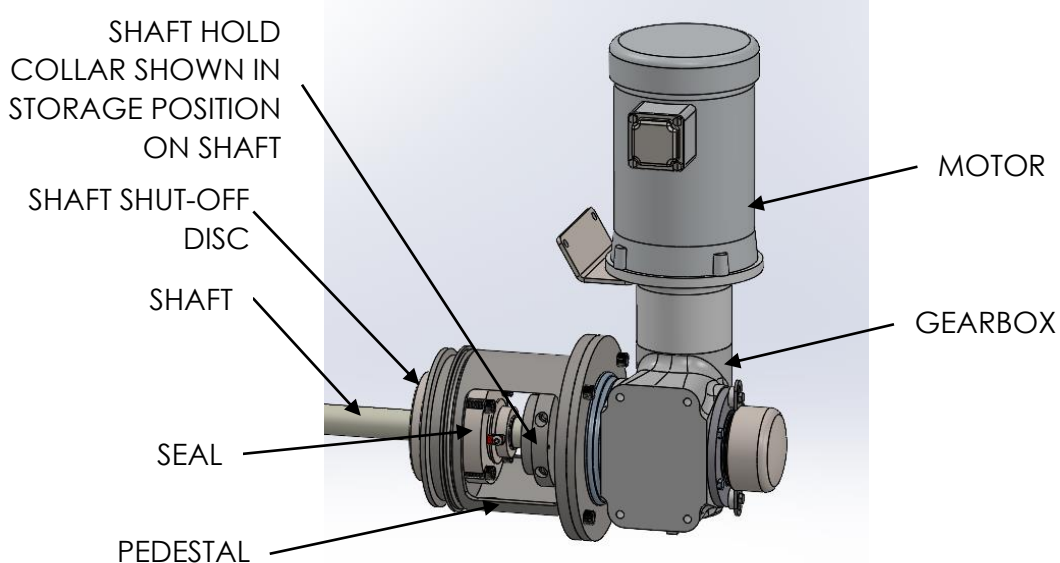
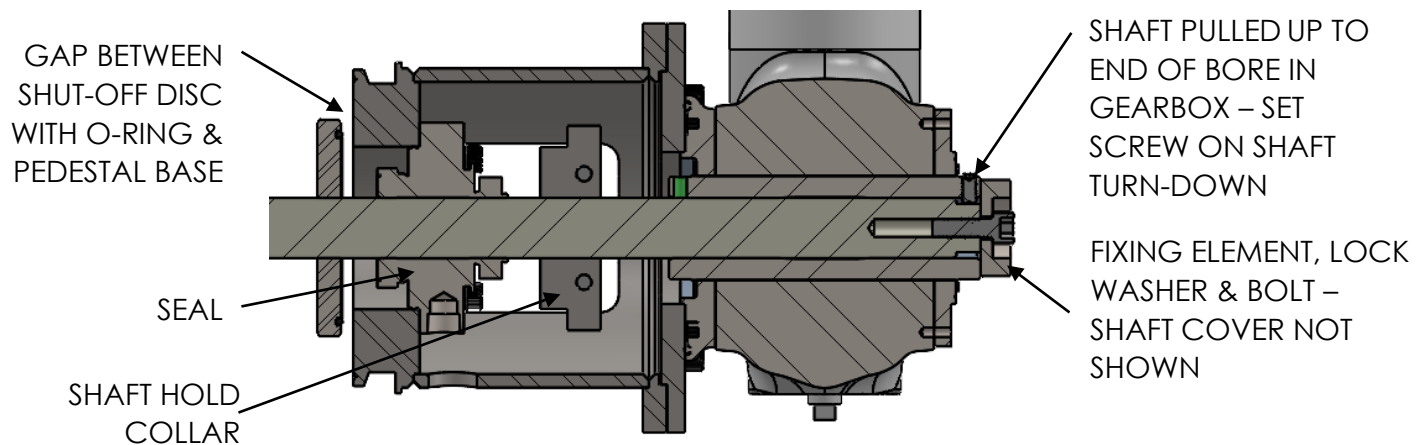



**CAUTION:**

- **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.**
- **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


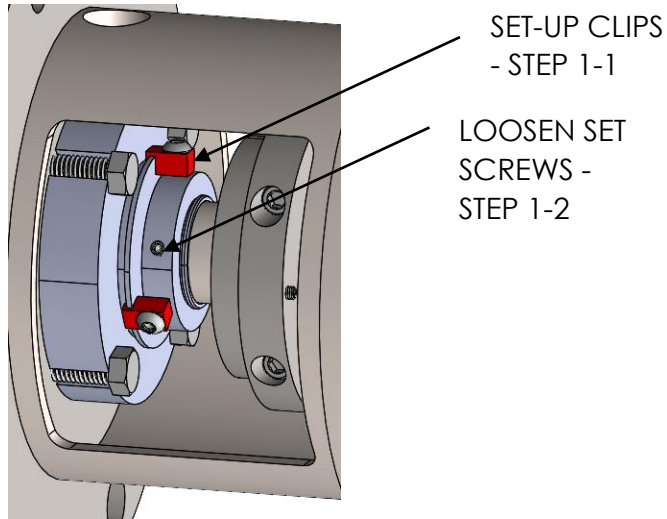
## 1) Begin In Tank Shut-Off Engagement



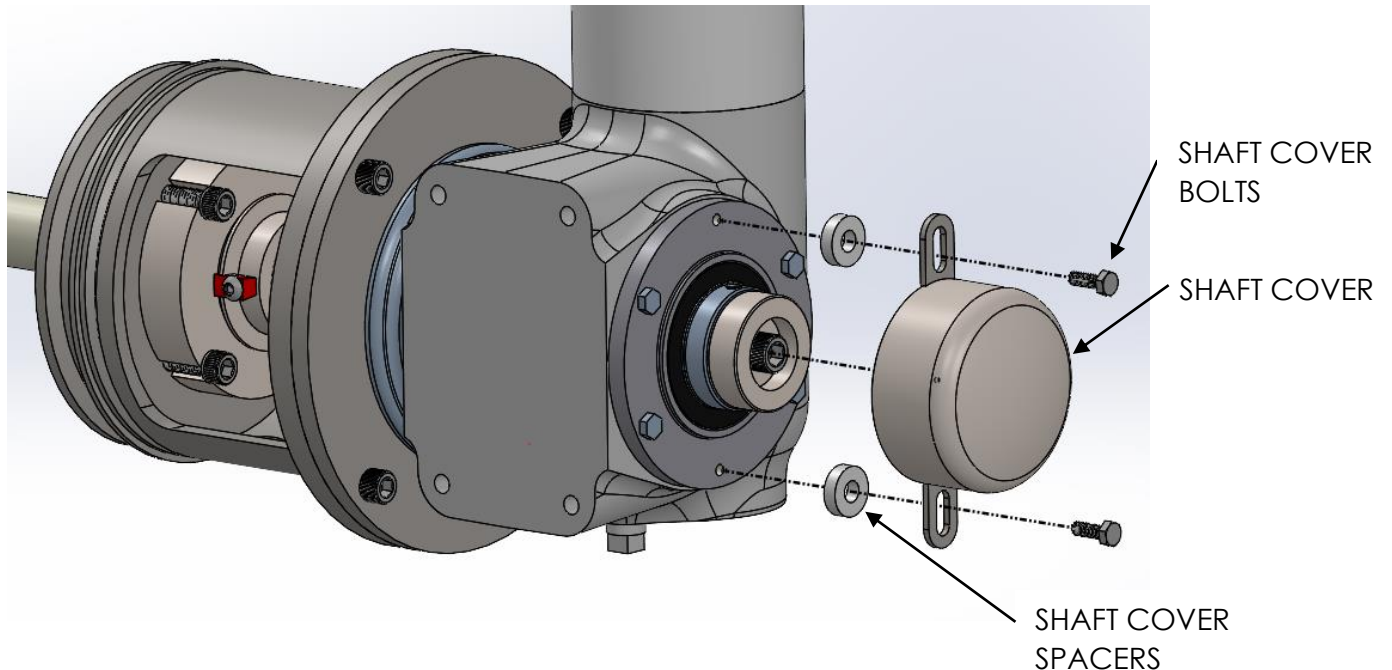
Before beginning any maintenance on your side entry mixer make sure power source is disconnected and make sure to follow Lock Out Tag Out procedure. Make sure mounting flange is secure to tank before beginning. If the O-ring in the shut-off disc is damaged, the shut-off will not effectively seal off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

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

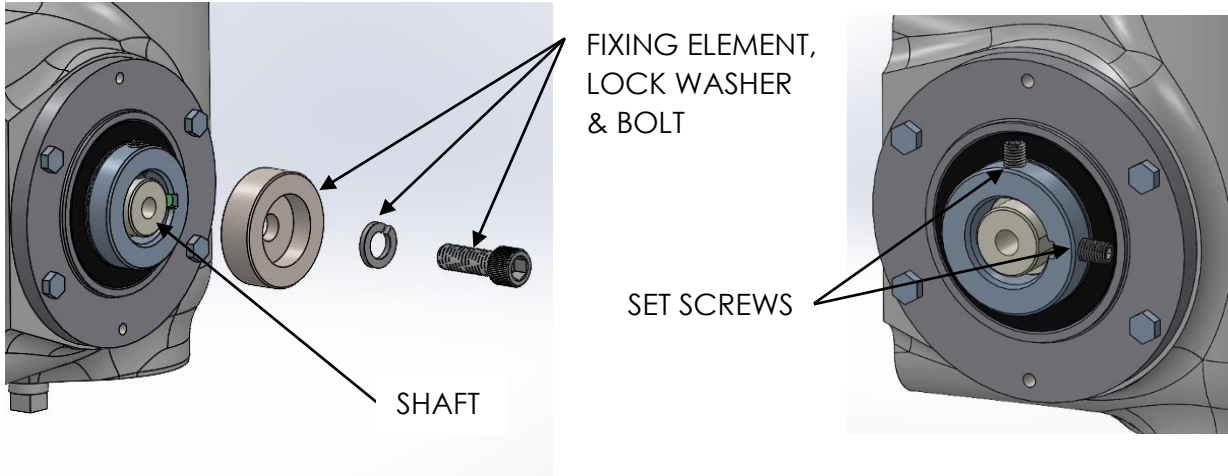
**\*REINSTALL SET-UP CLIPS BEFORE ENGAGING THE ITS0\***



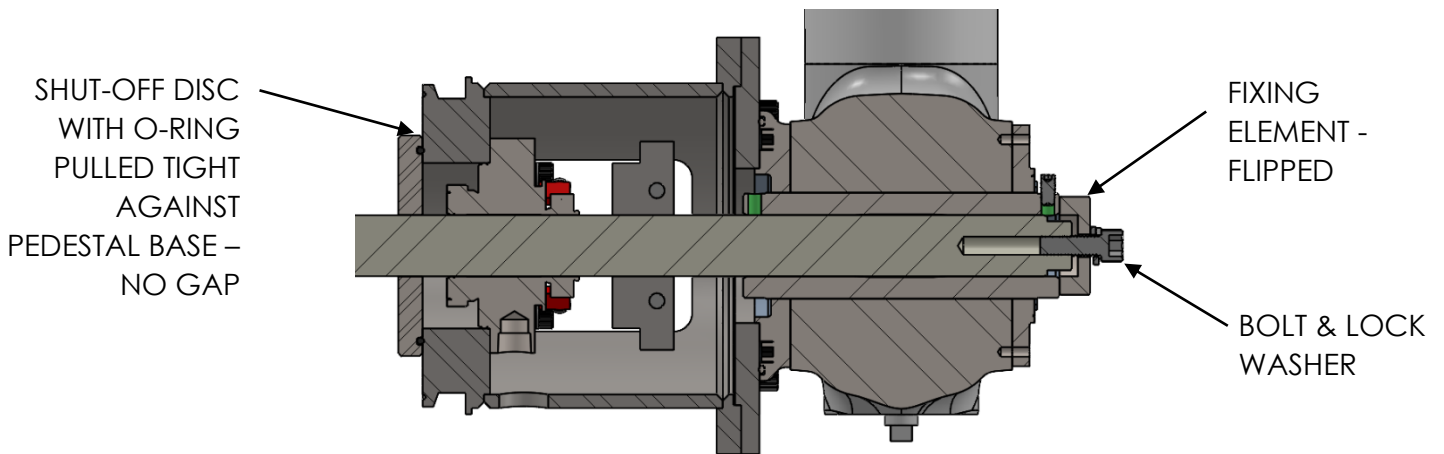
- 1-3) Remove shaft cover on gearbox by removing bolts, cover, & spacers if equipped. See image below.



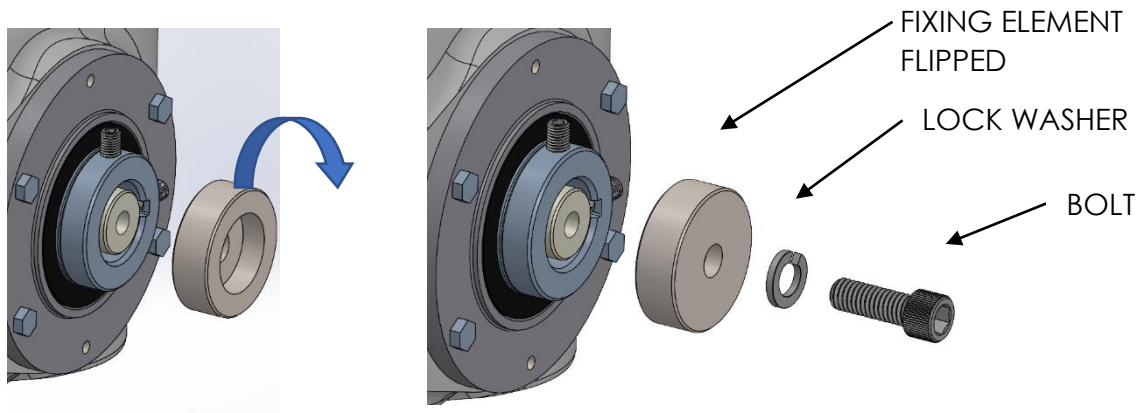
1-4) Remove fixing element, lock washer, & bolt. Back out set screws so they are clear of gearbox bore. See assembly images below.



1-5) Below is a section view showing the shaft drawn back to **engage ISO**. The following steps will explain the process.



1-6) Flip the fixing element around so the side with the counterbore is facing towards the gearbox as shown below. This must be done so the shaft can be pulled into counterbore area. Insert the bolt & lock washer. Once bolt is engaged to the threads in the shaft, tighten to secure the shut-off.



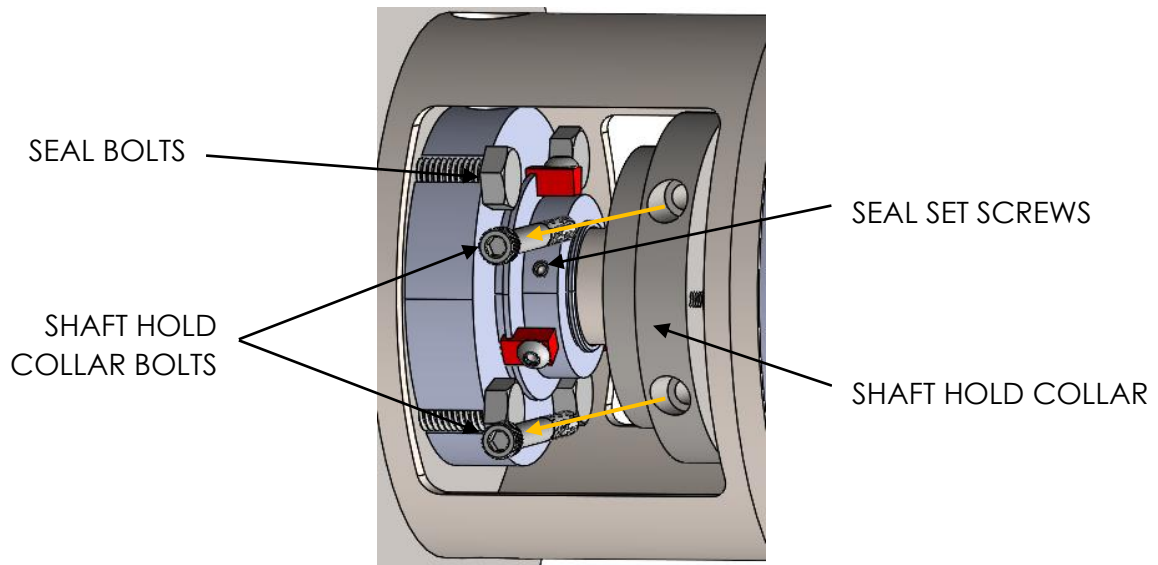
2) The following instructions will cover the removal of a Seal in a side entry configuration with the In Tank Shut-Off (ITSO).



**CAUTION:**

- **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.**
- **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.**
- **EXCESSIVE PRESSURE HAZARD: MAKE CERTAIN INTERNAL PRESSURE OF THE MIXING VESSEL & ANY BUFFER /BARRIER PLUMBING IS RELIEVED BEFORE BEGINNING. FAILURE TO FOLLOW THESE INSTRUCTIONS COULD RESULT IN DEATH, SERIOUS PERSONAL INJURY OR PROPERTY DAMAGE.**

2-1) Ensure that the seal set-up clips are installed (Step 1-1; pg 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.

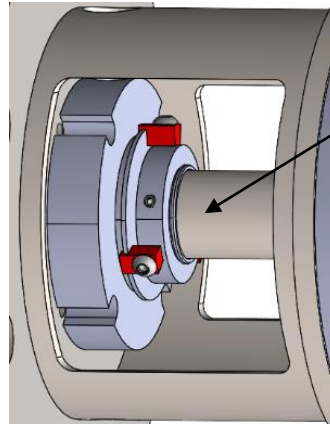


- 2-2) If your seal is equipped with any plumbing to the flush port, buffer ports or barrier ports, make sure pressure is relieved in plumbing, then disconnect and remove. Then remove seal bolts.



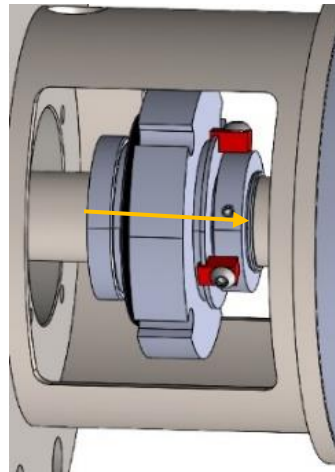
**CAUTION:**

**EXCESSIVE PRESSURE HAZARD: MAKE CERTAIN INTERNAL PRESSURE & TEMPERATURE OF THE MIXING VESSEL & ANY BUFFER /BARRIER PLUMBING IS AT AN ACCEPTABLE LEVEL BEFORE REMOVING.**

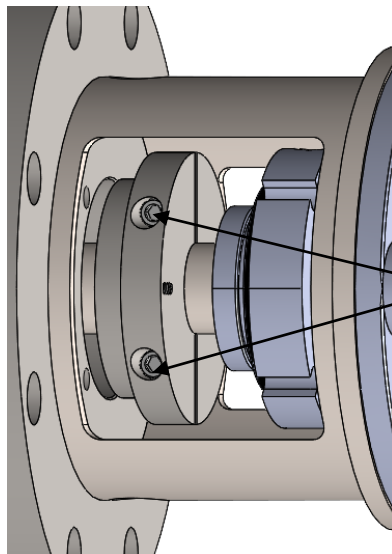


APPLY OIL OR GREASE TO SHAFT – THIS WILL HELP WITH THE NEXT STEP TO SLIDE SEAL ON SHAFT

- 2-3) Slide the seal towards the gearbox.

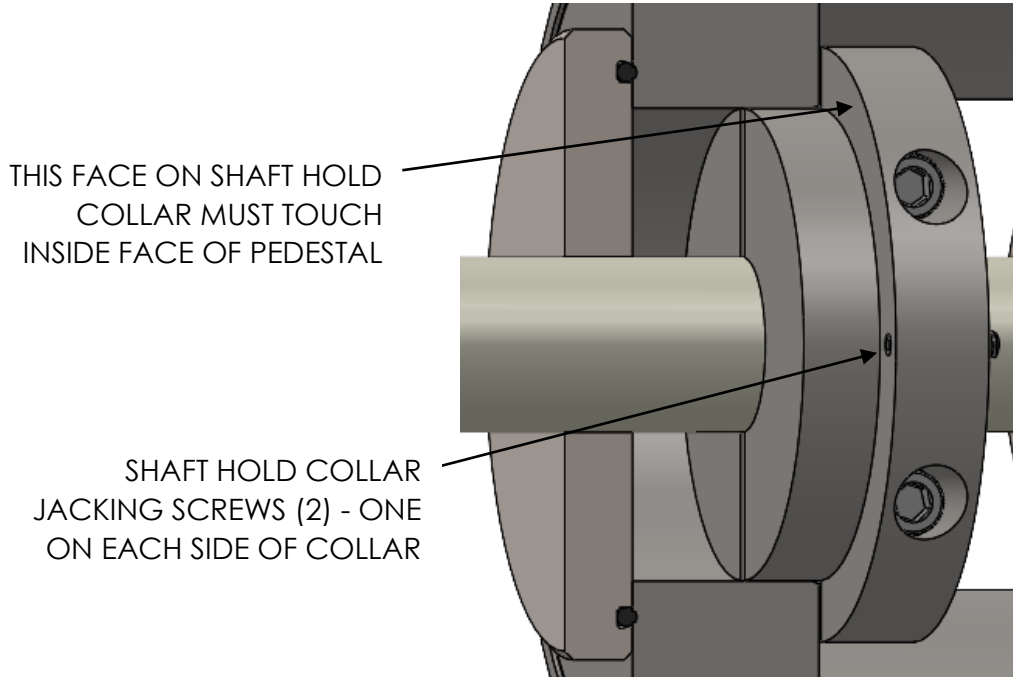


- 2-4) Install the shaft hold collar, in the orientation as shown below. The two shaft hold collar screws will have to be removed completely so the two shaft hold collar halves can be placed around the shaft. Reinstall the two shaft hold collar screws, leave them loose so the shaft collar can still slide on the shaft.

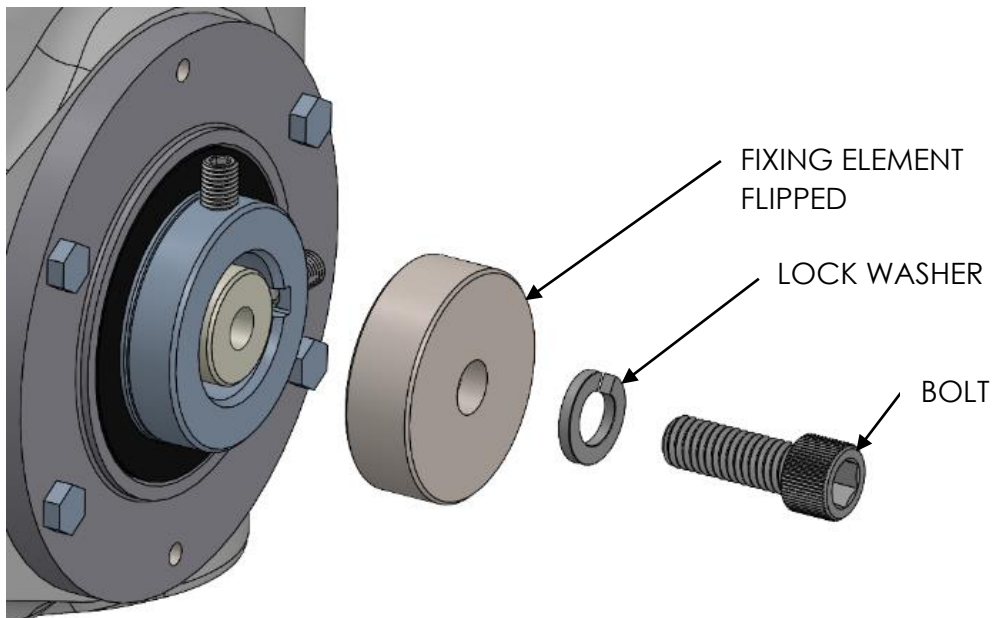


SHAFT COLLAR SCREWS

- 2-5) Slide the shaft hold collar towards the tank. Slide the smaller outer diameter of the shaft hold collar into the pedestal bore until face of collar touches the face of the pedestal as shown below (image shown in section). Once the shaft holding collar face is in contact with the pedestal face, tighten the shaft collar screws. Tighten the two jacking screws evenly. This will keep the ITSO properly sealed against the flange.



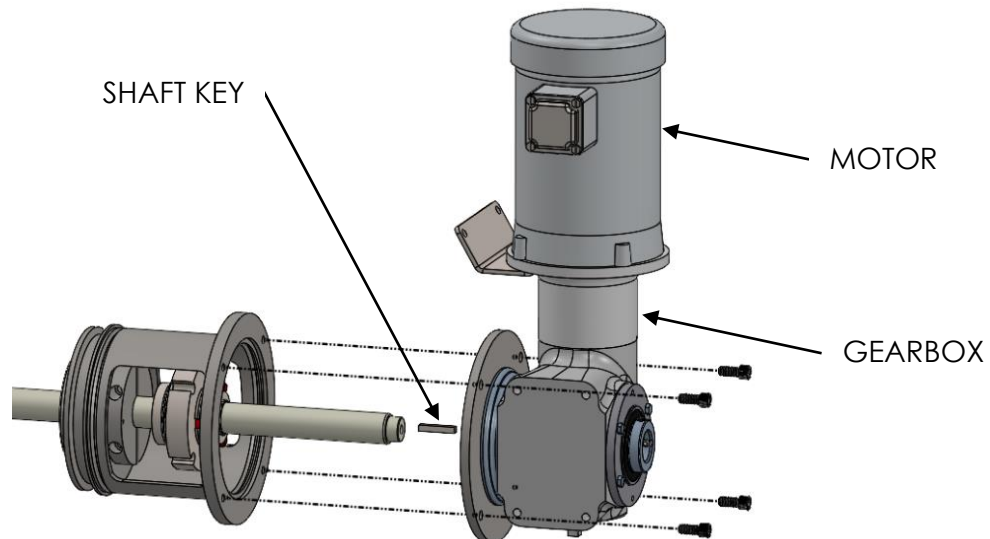
- 2-6) With the shaft hold collar securely in place, remove the shaft shut-off hardware used – bolt, lock washer, & fixing element. Continue to the next step.



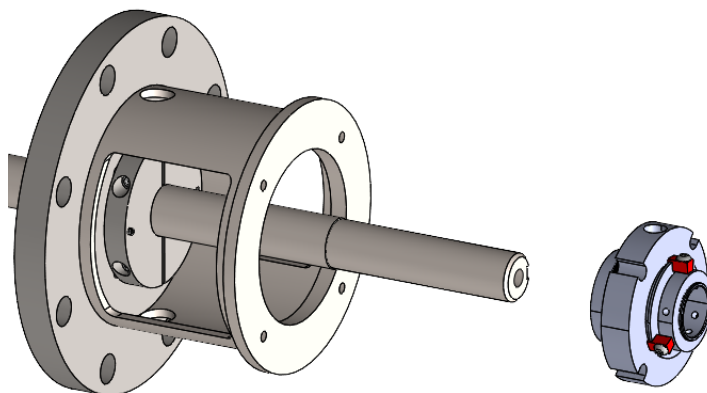

**CAUTION:**

- **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.**

2-7) 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.**



2-8) Slide the seal off the end of the shaft to remove. Follow appropriate instructions if the seal is to be rebuilt or replaced.



2-9) Reverse the seal removal steps to install a new or rebuilt seal. Follow the appropriate Seal Installation instructions for your application. Use Fusion Manual **FM-1033** for RT153 Seal Installation. Be careful to not cut O-ring on the new or rebuilt seal and use a process-compatible lubricant on the O-rings before installation.