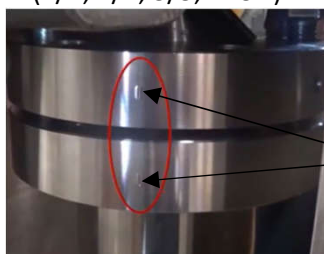


# RIGID COUPLING SHAFT INSTALLATION

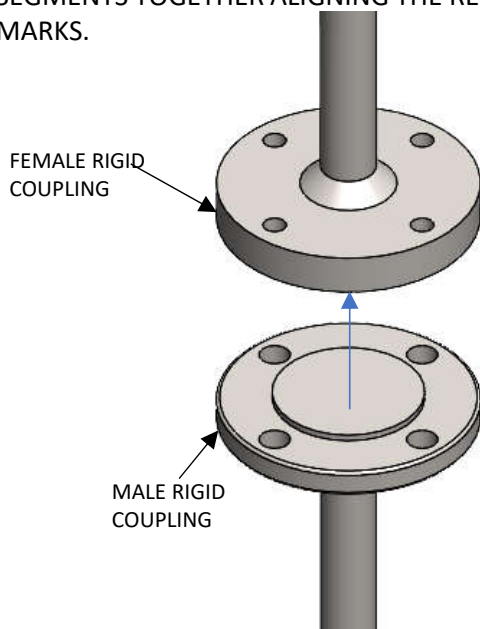


1.) ENSURE THE SHAFT SEGMENTS AND RIGID COUPLINGS ARE FOR THE MIXER BEING ASSEMBLED. IF THERE'S ONLY ONE MIXER ON THE ORDER, THEN THE REGISTRATION MARKS ON THE FEMALE AND MALE HALVES WILL LOOK LIKE THE ONES IN THE IMAGE BELOW. IF THERE'S MORE THAN ONE MIXER ON THE ORDER, THEN THE REGISTRATION MARKS ON THE SHAFT COUPLINGS SHOULD ALSO MATCH THE MIXER'S SERIAL NUMBER'S LAST DIGIT (1/1; 2/2; 3/3; ETC...).



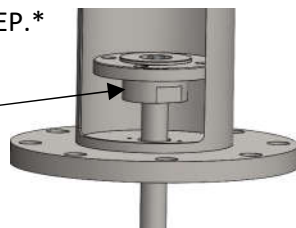
REGISTRATION MARKS

2.) INSTALL THE FIRST RIGID COUPLING SECTION TO THE MIXER DRIVE BY FOLLOWING THE APPROPRIATE SHAFT INSTALLATION QSG FOR YOUR SHAFT TYPE.  
 3.) DEBURR AND CLEAN THE MATING SURFACE OF THE MALE AND FEMALE COUPLINGS. BRING THE TWO SEGMENTS TOGETHER ALIGNING THE REGISTRATION MARKS.



\*ANY BOLTED REMOVABLE RIGID COUPLINGS MUST BE ASSEMBLED (USING THE QSG "BOLTED REMOVABLE RIGID COUPLING SHAFT INSTALLATION") PRIOR TO THE NEXT STEP.\*

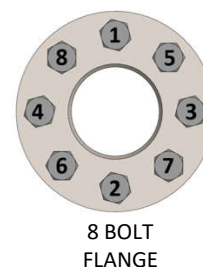
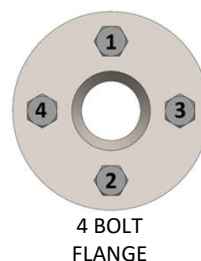
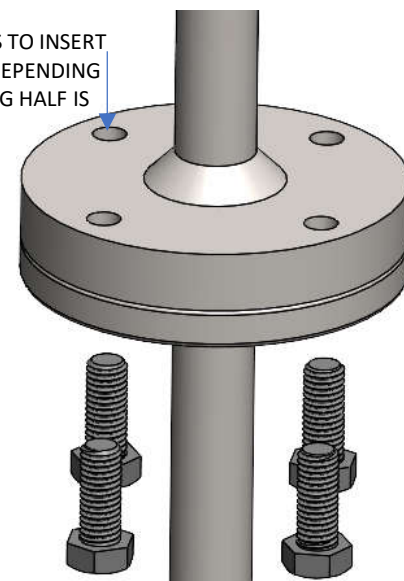
BOLTED REMOVABLE RIGID COUPLING EXAMPLE



4.) INSERT AND TIGHTEN THE PROVIDED BOLTS. TIGHTEN THEM FOLLOWING THE APPROPRIATE CROSSING PATTERN IN THE IMAGE BELOW. TIGHTEN TO THE VALUE SPECIFIED IN THE TORQUE TABLE.

POSSIBLE FOR BOLTS TO INSERT FROM OTHER SIDE DEPENDING ON WHICH COUPLING HALF IS THREADED

BOLT SIZE	316 STAINLESS
1/4"-20	60 in-lb.
3/8"-16	17 ft-lb.
1/2"-13	38 ft-lb.
5/8"-11	84 ft-lb.
3/4"-10	118 ft-lb.
7/8"-9	186 ft-lb.
1"-8	281 ft-lb.
1-1/4"-7	513 ft-lb.



5.) USE A .001" FEELER GAUGE TO ENSURE THE TWO HALVES ARE FULLY SEATED TOGETHER. IF THE FEELER GAUGE SLIDES BETWEEN THE HALVES ANYWHERE, DISASSEMBLE THE RIGID COUPLING. DEBURR AND CLEAN THE MATING SURFACES AGAIN, THEN REASSEMBLE.



### CAUTION

DISCONNECT MIXER FROM POWER SOURCE BEFORE ASSEMBLING, LIFTING, MOVING, OR SERVICING MIXER.

#### CAUTION:

- THE VISCOSITY AND SPECIFIC GRAVITY OF THE FLUID AFFECTS MIXER SIZING AND SPECIFICATIONS
- DO NOT LAY MIXER ON SHAFT