



RIGID COUPLING SHAFT INSTALLATION

QSG-112-B

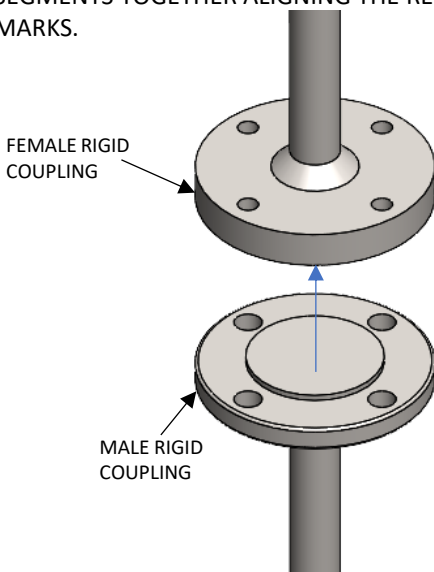
1.) VERIFY THAT THE COUPLING HALVES BELONG TO THE SAME MIXER BY CHECKING IDENTIFICATION MARKS. IF MULTIPLE MIXERS ARE INCLUDED IN YOUR ORDER, ENSURE THAT DRIVE AND SHAFT COUPLING SETS ARE MATCHED. ALIGN THE FACTORY MARKS ON BOTH COUPLING HALVES BEFORE BOLTING TOGETHER. THE REGISTRATION MARKS SHOULD MATCH YOUR MIXERS SERIAL NUMBER.



REGISTRATION MARKS

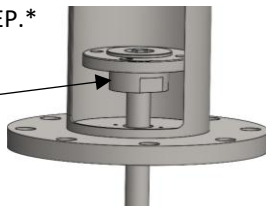
2.) INSTALL THE FIRST RIGID COUPLING SECTION TO THE MIXER DRIVE BY FOLLOWING THE APPROPRIATE SHAFT INSTALLATION QSG FOR YOUR SHAFT TYPE.

3.) DEBURR AND CLEAN THE MATING SURFACE OF THE MALE AND FEMALE COUPLINGS. BRING THE TWO SEGMENTS TOGETHER ALIGNING THE REGISTRATION MARKS.



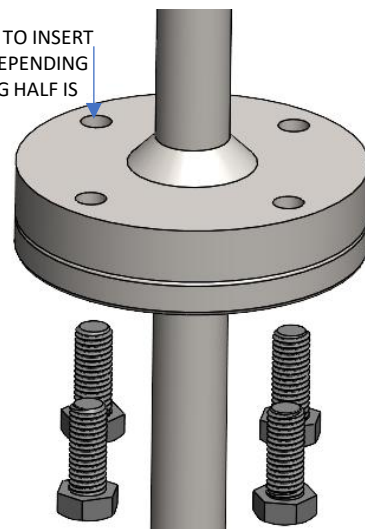
ANY BOLTED REMOVABLE RIGID COUPLINGS MUST BE ASSEMBLED (USING THE QSG "BOLTED REMOVABLE RIGID COUPLING SHAFT INSTALLATION") PRIOR TO THE NEXT STEP.

BOLTED REMOVABLE RIGID COUPLING EXAMPLE

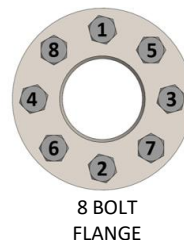
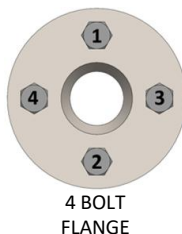


4.) INSERT AND TIGHTEN THE PROVIDED BOLTS. TIGHTEN THEM FOLLOWING THE APPROPRIATE CROSSING PATTERN IN THE IMAGE BELOW. TIGHTEN TO THE VALUE SPECIFIED IN THE TORQUE TABLE.

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