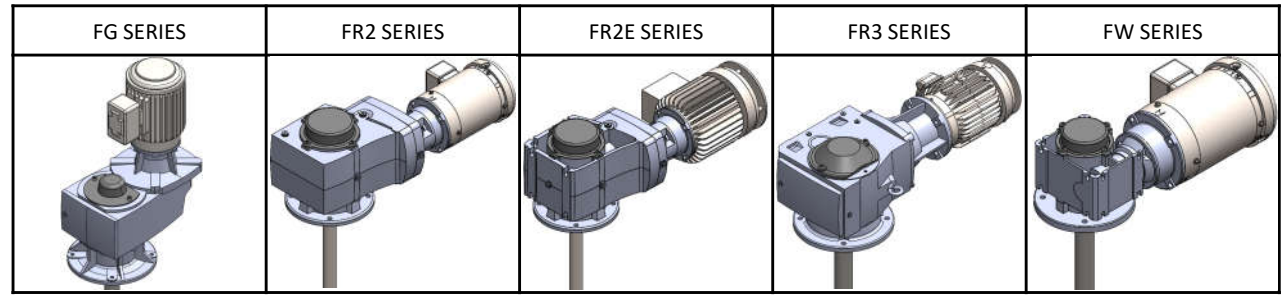
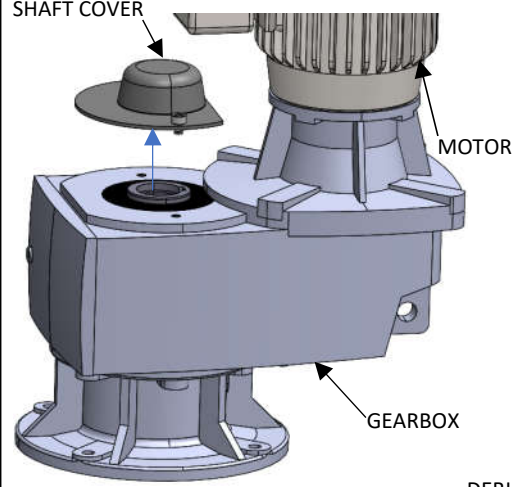


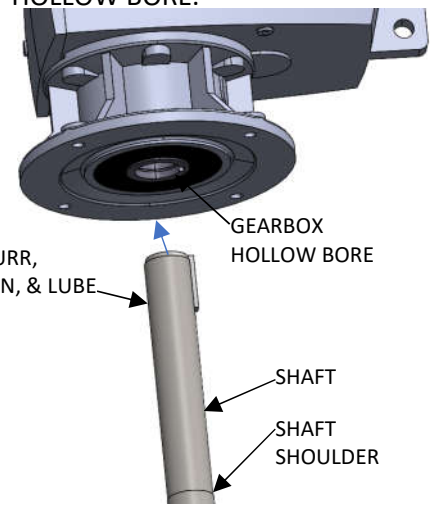
# SHAFT INSTALLATION – FIXING ELEMENT WITH SHOULDERED SHAFT

[LINK TO HOW TO VIDEOS](#)


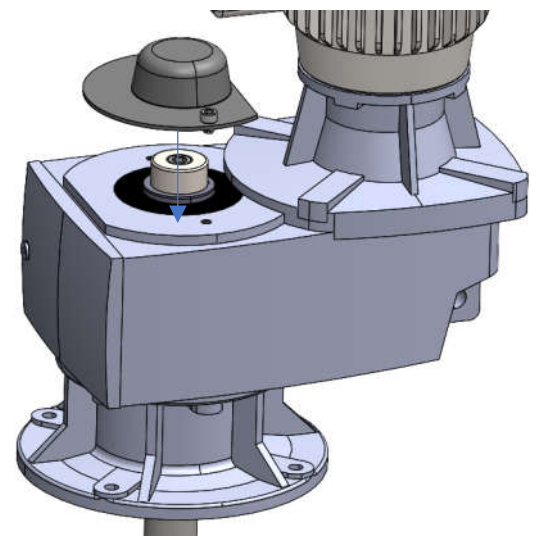
1.) REMOVE THE GEARBOX'S SHAFT COVER BY REMOVING THE BOLTS THAT HOLD IT DOWN. KEEP THE SHAFT COVER AND BOLTS.



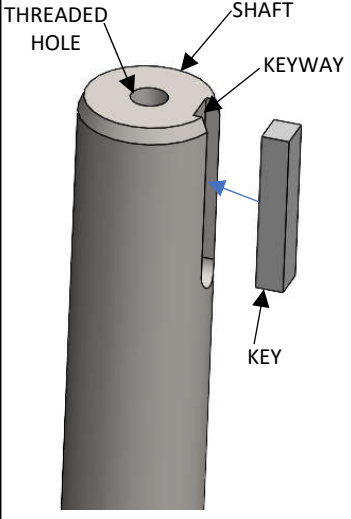
3.) DEBURR, CLEAN, THEN LIGHTLY LUBRICATE THE SECTION OF THE SHAFT THAT WILL GO IN THE GEARBOX. INSERT THE SHAFT AND KEY INTO THE GEARBOX'S HOLLOW BORE. ENSURE THAT THE KEY IN THE SHAFT IS ALIGNED WITH THE KEYWAY IN THE GEARBOX'S HOLLOW BORE. THE SHAFT SHOULDER SHOULD MAKE CONTACT WITH THE BOTTOM OF THE GEARBOX HOLLOW BORE.



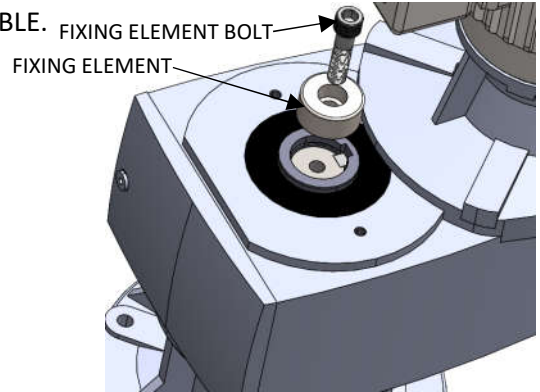
5.) INSTALL SHAFT COVER AND BOLTS BACK ONTO THE GEARBOX.



2.) INSERT THE KEY INTO THE KEYWAY OF THE SHAFT.



4.) ATTACH THE SHAFT TO THE GEARBOX USING THE FIXING ELEMENT AND FIXING ELEMENT BOLT (BOTH PROVIDED). APPLY SERVICE REMOVABLE THREAD LOCKER TO THE BOLT AND TIGHTEN TO THE APPROPRIATE VALUE IN THE TABLE. FIXING ELEMENT BOLT



BOLT SIZE	18-8 & 304 STAINLESS	316 STAINLESS	GRADES 5 & 8
10-32	15 in-lb.	16 in-lb.	17 in-lb.
1/4-20	29 in-lb.	30 in-lb.	38 in-lb.
5/16-18	52 in-lb.	54 in-lb.	84 in-lb.
3/8-16	96 in-lb.	102 in-lb.	13 ft-lb.
7/16-14	13 ft-lb.	14 ft-lb.	20 ft-lb.
1/2-13	18 ft-lb.	19 ft-lb.	31 ft-lb.
5/8-11	41 ft-lb.	42 ft-lb.	61 ft-lb.
3/4-10	57 ft-lb.	59 ft-lb.	108 ft-lb.
7/8-9	89 ft-lb.	93 ft-lb.	126 ft-lb.
1-8	135 ft-lb.	141 ft-lb.	188 ft-lb.

**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