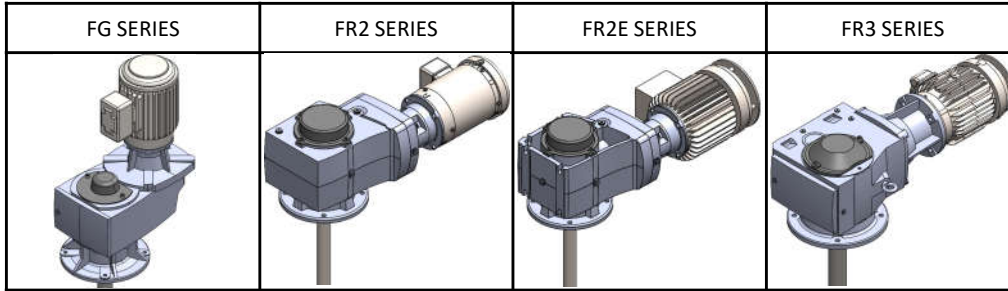
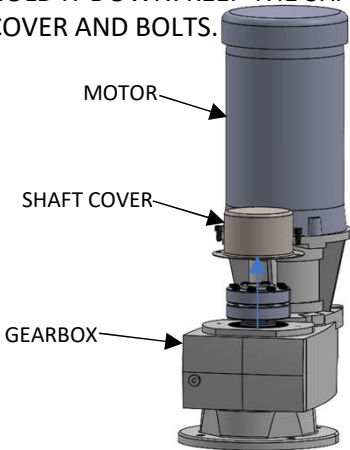


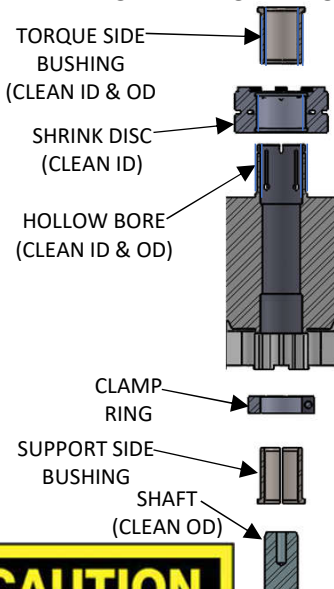
## SHAFT INSTALLATION – GRIPMAXX



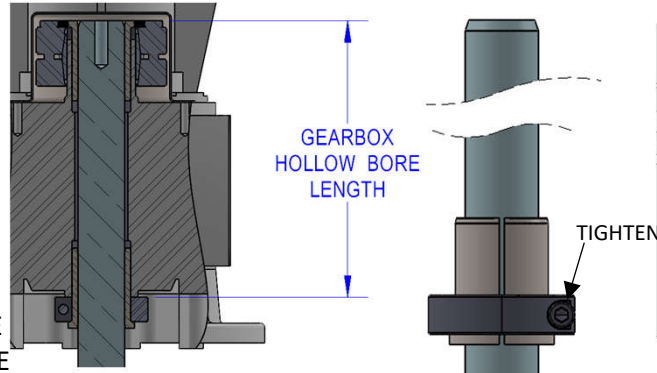
1.) REMOVE THE GEARBOX'S SHAFT COVER BY REMOVING THE BOLTS THAT HOLD IT DOWN. KEEP THE SHAFT COVER AND BOLTS.



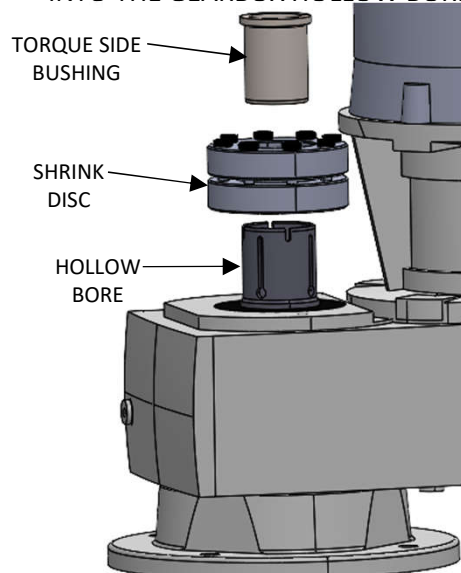
2.) DEBURR THE SHAFT. CLEAN THE FOLLOWING COMPONENTS WITH ACETONE OR A SIMILAR SOLVENT. THE SHRINK DISC AND UPPER BUSHING ARE TYPICALLY SHIPPED INSTALLED AND WILL NEED TO BE REMOVED TO CLEAN.



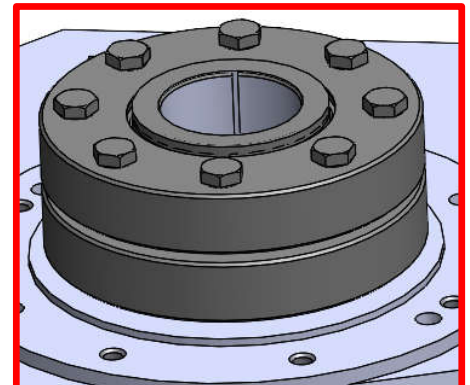
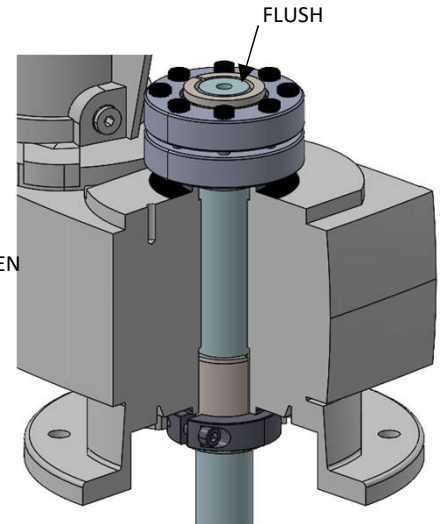
3.) POSITION THE CLAMP RING AND LOWER BUSHING OVER THE SHAFT AS SHOWN BELOW. POSITION THE SHAFT SO IT'S FLUSH WITH THE HOLLOW BORE OR AS INDICATED ON THE APPROVAL (OR AS MANUFACTURED) DRAWING. ONCE THE BUSHING AND CLAMP RING ARE IN THE CORRECT LOCATION, TIGHTEN THE CLAMP RING SCREW.



4.) VERIFY ALL THE BOLTS ON THE SHRINK DISC ARE LOOSE AND SLIDE THE SHRINK DISC ONTO THE HOLLOW BORE OD. SLIDE THE TORQUE SIDE BUSHING INTO THE GEARBOX HOLLOW BORE.



5.) INSERT THE SHAFT INTO THE GEARBOX HOLLOW BORE. IT MAY BE NECESSARY TO LOOSEN THE CLAMP RING TO GET THE SHAFT FLUSH OR TO THE SPECIFIED LOCATION ON THE APPROVAL (OR AS MANUFACTURED) DRAWING.



**CAUTION:** TIGHTENING SHRINK DISC WITHOUT SHAFT IN THE BORE, WILL CAUSE DAMAGE TO THE GEARBOX.

### CAUTION

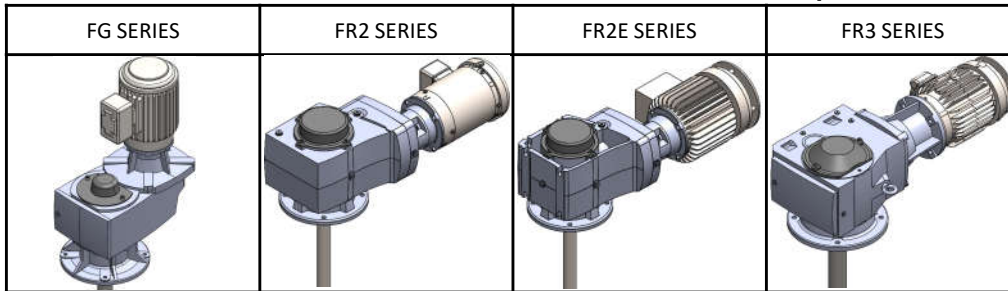
DISCONNECT MIXER FROM POWER SOURCE BEFORE ASSEMBLING, LIFTING, MOVING, OR SERVICING MIXER.

### CAUTION:

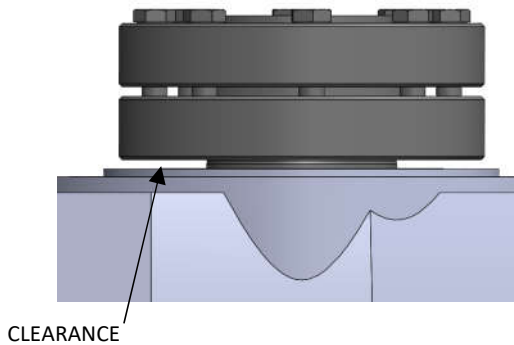
- THE VISCOSITY AND SPECIFIC GRAVITY OF THE FLUID AFFECTS MIXER SIZING AND SPECIFICATIONS

# SERIES: FLOW TOP & BOTTOM ENTRY

## SHAFT INSTALLATION – GRIPMAXX (CONTINUED)



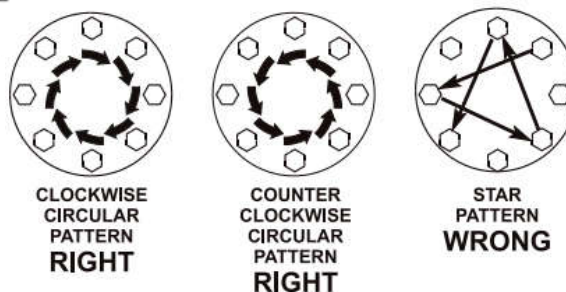
6.) VERIFY THERE IS CLEARANCE BETWEEN THE GEARBOX AND THE SHRINK DISC. HAND TIGHTEN 3 OR 4 EQUALLY SPACED BOLTS. THEN HAND TIGHTEN THE REMAINING BOLTS.



7.) TIGHTEN THE BOLTS IN A CIRCULAR PATTERN USING 1/4 (90°) TURNS, EVEN IF SOME BOLTS INITIALLY REQUIRE VERY LOW TIGHTENING TORQUE TO ACHIEVE 1/4 TURNS. TIGHTEN TO THE APPROPRIATE “TIGHTENING TORQUE” VALUE IN THE TABLE.

Screw Size	Wrench Size	Tightening Torque	4% Over Torque
M5	8	62 in-lb.	64 in-lb.
M6	10	106 in-lb.	110 in-lb.
M8	13	22 ft-lb.	23 ft-lb.
M10	17	44 ft-lb.	46 ft-lb.
M12	19	74 ft-lb.	77 ft-lb.
M16	24	184 ft-lb.	191 ft-lb.
M20	30	361 ft-lb.	375 ft-lb.

### BOLT TIGHTENING PATTERN

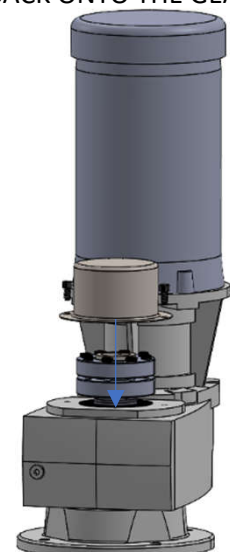


8.) CONTINUE THE TIGHTENING SEQUENCE DESCRIBED IN STEP 7. WHEN THE TORQUE ON THE BOLT IS AT THE “TIGHTENING TORQUE” VALUE WITH LESS THAN 1/4 TURN ON THE BOLT, PROCEED TO STEP 9.

9.) SET THE TORQUE WRENCH TO THE APPROPRIATE VALUE IN THE TABLE, BUT USE THE “4% OVER TORQUE” VALUE IN THE TABLE. DO ONE OR TWO COMPLETE ROTATIONS USING THE SAME CIRCULAR PATTERN TECHNIQUE.

10.) RESET THE TORQUE WRENCH TO THE APPROPRIATE “TIGHTENING TORQUE” VALUE IN THE TABLE. ENSURE ALL OF THE BOLTS ARE PROPERLY TIGHTENED USING THE CIRCULAR PATTERN.

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



## 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