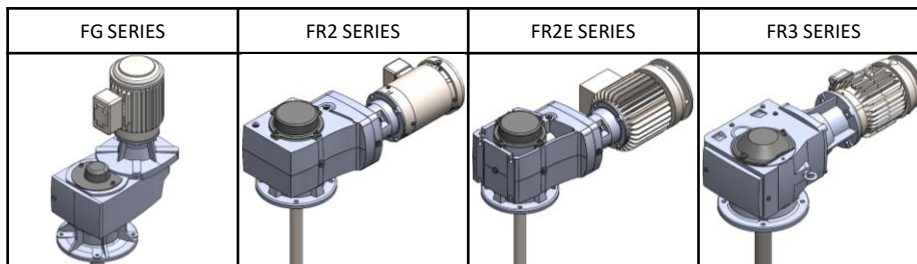
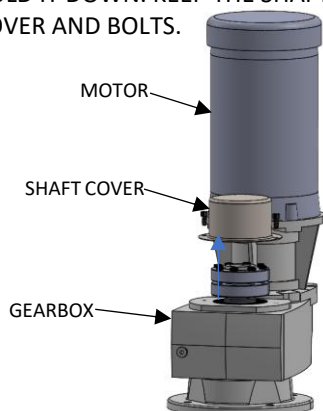


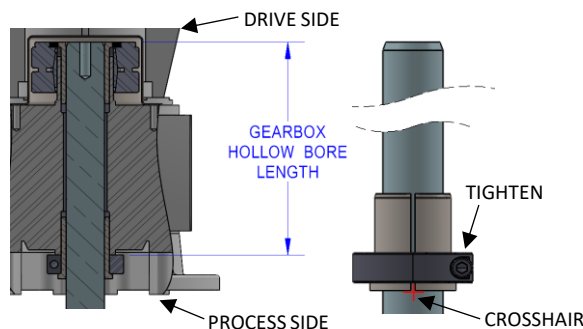
SHAFT INSTALLATION – GRIPMAXX



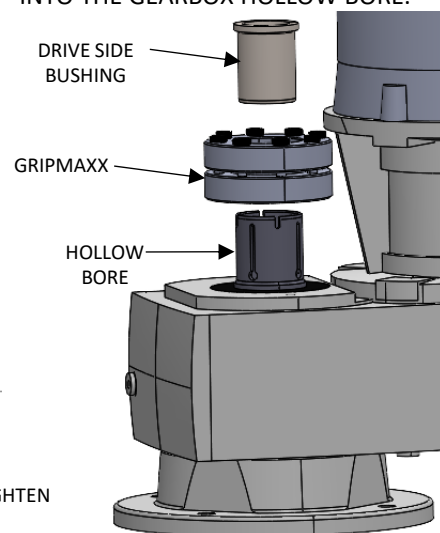
1.) REMOVE THE GEARBOX'S SHAFT COVER BY REMOVING THE BOLTS THAT HOLD IT DOWN. KEEP THE SHAFT COVER AND BOLTS.



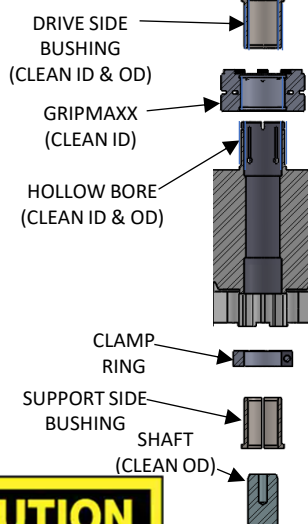
3.) THE PROCESS SIDE BUSHING WILL BE ETCHED WITH A "P" AND DRIVE SIDE BUSHING WILL BE ETCHED WITH A "D". POSITION THE CLAMP RING AND PROCESS BUSHING OVER THE SHAFT AS SHOWN BELOW. THE PROCESS SIDE BUSHING WILL ALIGN ITS SLOT WITH THE CLAMP RING AND A CROSSHAIR MARK ON THE SHAFT. THE BOTTOM FACE OF THE BUSHING SHOULD BE FLUSH WITH THE CROSSHAIR. ONCE THE BUSHING AND CLAMP RING ARE IN THE CORRECT LOCATION, TIGHTEN THE CLAMP RING SCREW.



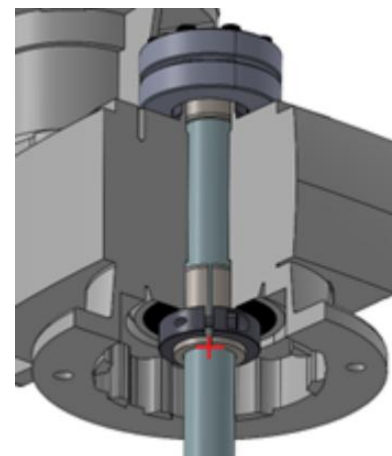
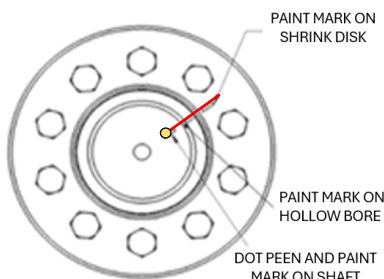
5.) VERIFY ALL THE BOLTS ON THE GRIPMAXX ARE LOOSE AND SLIDE THE GRIPMAXX ONTO THE HOLLOW BORE OD. SLIDE THE DRIVE SIDE BUSHING INTO THE GEARBOX HOLLOW BORE.



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



4.) NOTE THAT THE GEARBOX HOLLOW BORE, DRIVE SIDE BUSHING, GRIPMAXX, AND SHAFT WILL BE MARKED WITH A DOT PEEN AND PAINT PEN MARK. ENSURE THESE MARKS ALIGN.

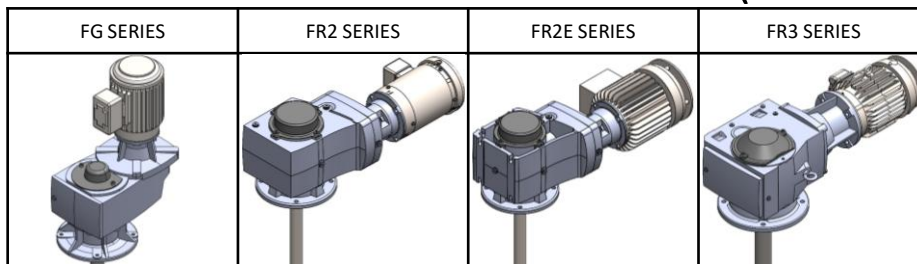


CAUTION

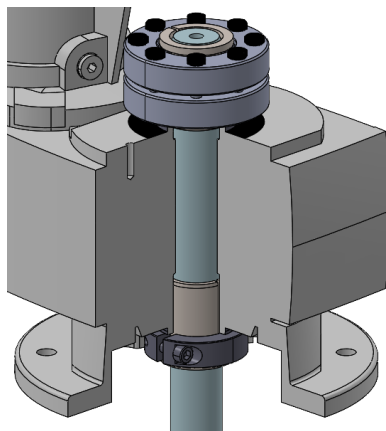
DISCONNECT MIXER FROM POWER SOURCE BEFORE ASSEMBLING, LIFTING, MOVING, OR SERVICING MIXER.

SERIES: FLOW TOP & BOTTOM ENTRY

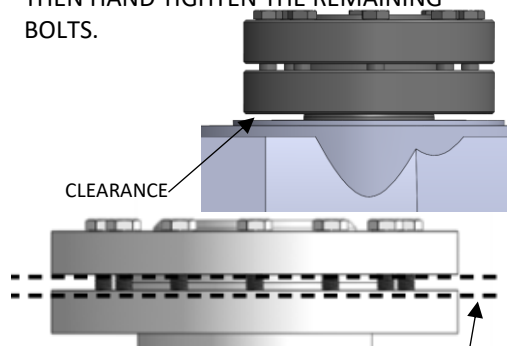
SHAFT INSTALLATION – GRIPMAXX (CONTINUED)



6.) INSERT THE SHAFT INTO THE GEARBOX HOLLOW BORE FROM BELOW. THE CLAMP RING WILL BE FLUSH TO THE ROTATIONAL FACE OF THE GEARBOX AND THE SHAFT FACE WILL BE FLUSH WITH THE DRIVE SIDE BUSHING OR AS SPECIFIED IN THE APPROVAL (OR AS MANUFACTURED) DRAWING.



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

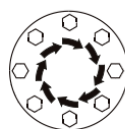


ENSURE THE GRIPMAXX IS TIGHTENING EVENLY AND PARALLEL

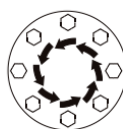
8.) TIGHTEN THE BOLTS IN A CIRCULAR PATTERN USING 1/4 (90°) TURNS, EVEN IF SOME BOLTS INITIALLY REQUIRE VERY LOW TIGHTENING TORQUE TO ACHIEVE 1/4 TURNS. TIGHTEN TO THE APPROPRIATE "TIGHTENING TORQUE" VALUE IN THE

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.

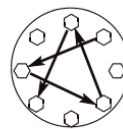
BOLT TIGHTENING PATTERN



CLOCKWISE CIRCULAR PATTERN
RIGHT



COUNTER CLOCKWISE CIRCULAR PATTERN
RIGHT



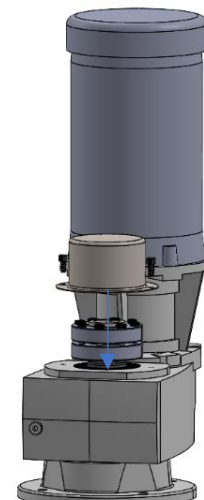
STAR PATTERN
WRONG

9.) CONTINUE THE TIGHTENING SEQUENCE DESCRIBED IN THE PREVIOUS STEP. WHEN THE TORQUE ON THE BOLT IS AT THE "TIGHTENING TORQUE" VALUE WITH LESS THAN 1/4 TURN ON THE BOLT, PROCEED TO THE NEXT STEP.

10.) SET THE TORQUE WRENCH TO THE APPROPRIATE "4% OVER TORQUE" VALUE IN THE TABLE. DO ONE OR TWO COMPLETE ROTATIONS USING THE SAME CIRCULAR PATTERN TECHNIQUE.

11.) 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.

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



CAUTION: TIGHTENING GRIPMAXX WITHOUT SHAFT IN THE BORE WILL CAUSE DAMAGE TO THE GEARBOX.

CAUTION

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