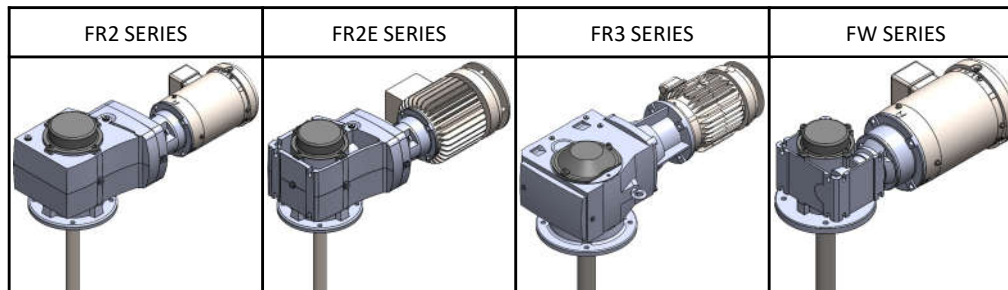
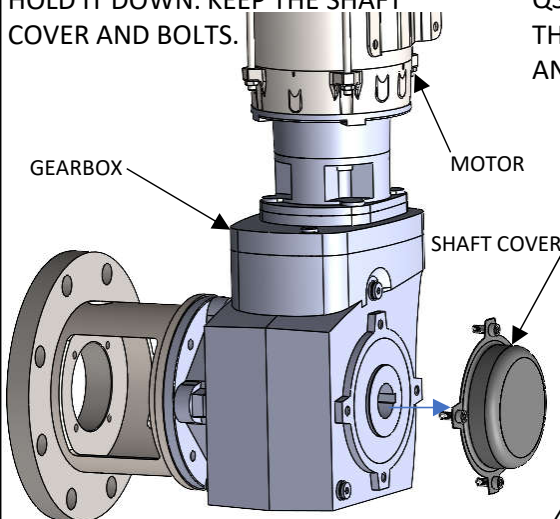




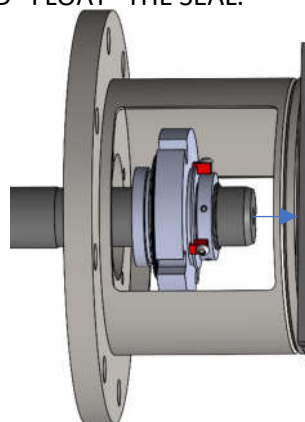
# SHAFT INSTALLATION – SIDE ENTRY MIXERS



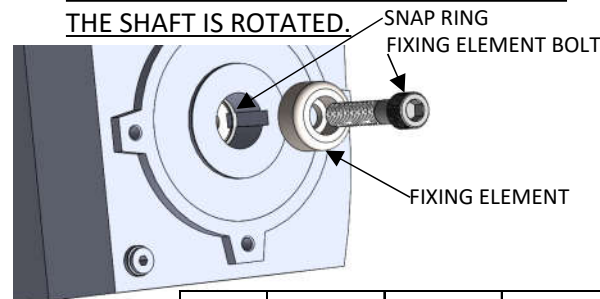
1.) REMOVE THE GEARBOX'S SHAFT COVER BY REMOVING THE BOLTS THAT HOLD IT DOWN. KEEP THE SHAFT COVER AND BOLTS.



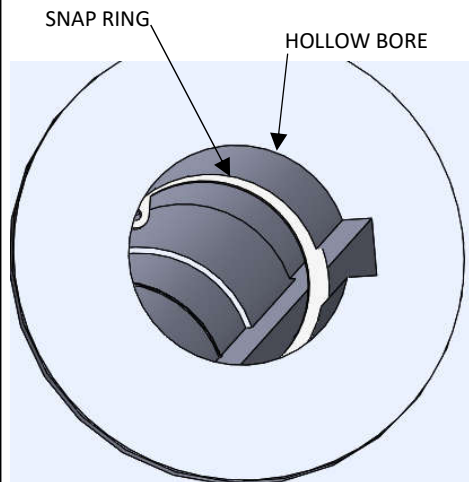
3.) REFER TO THE RT153 SINGLE OR RT153 DOUBLE SEAL INSTALLATION QSG TO INSERT THE SHAFT THROUGH THE PEDESTAL BORE AND SEAL BORE, AND "FLOAT" THE SEAL.



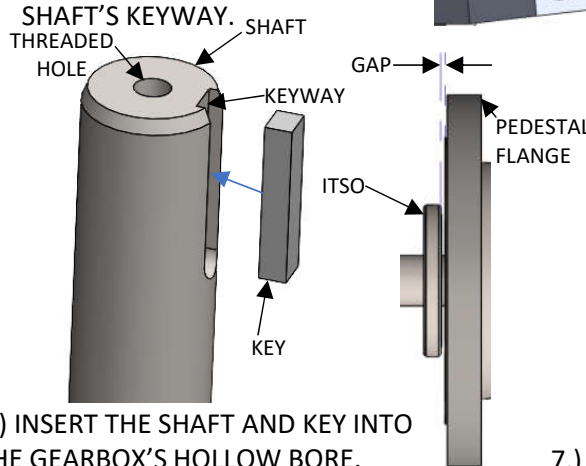
6.) ATTACH THE SHAFT TO THE GEARBOX USING THE FIXING ELEMENT AND FIXING ELEMENT BOLT (BOTH PROVIDED). APPLY SERVICE REMOVABLE THREAD LOCKER TO THE BOLT AND TIGHTEN TO THE APPROPRIATE VALUE IN THE TABLE. THE IN TANK SHUT-OFF (ITSO) SHOULD HAVE A GAP BETWEEN IT AND THE TANK SIDE OF THE ANSI FLANGE ONCE THE BOLT IS TIGHTENED. ENSURE THE ITSO ROTATES FREELY WHEN THE SHAFT IS ROTATED.



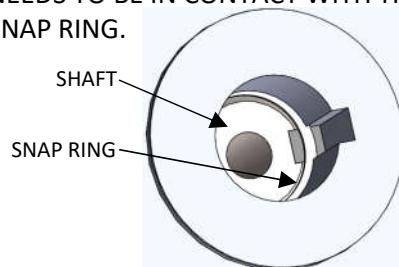
2.) ENSURE THE SNAP RING IS IN THE GEARBOX'S HOLLOW BORE ON THE SHAFT COVER SIDE.



4.) INSERT THE KEY INTO THE SHAFT'S KEYWAY.



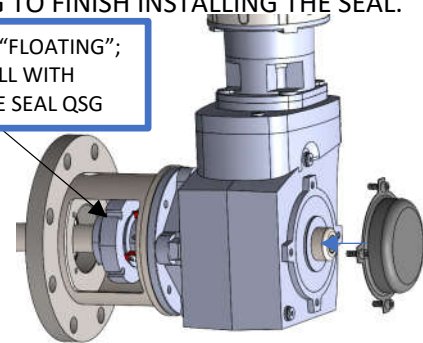
5.) INSERT THE SHAFT AND KEY INTO THE GEARBOX'S HOLLOW BORE. ENSURE THAT THE KEY IN THE SHAFT IS ALIGNED WITH THE KEYWAY IN THE GEARBOX'S HOLLOW BORE. THE SHAFT NEEDS TO BE IN CONTACT WITH THE SNAP RING.



7.) INSTALL SHAFT COVER AND BOLTS BACK ONTO THE GEARBOX. RETURN TO THE RT153 SINGLE OR RT153 DOUBLE QSG TO FINISH INSTALLING THE SEAL.

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.

SEAL IS STILL "FLOATING"; FINISH INSTALL WITH APPROPRIATE SEAL QSG



## 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