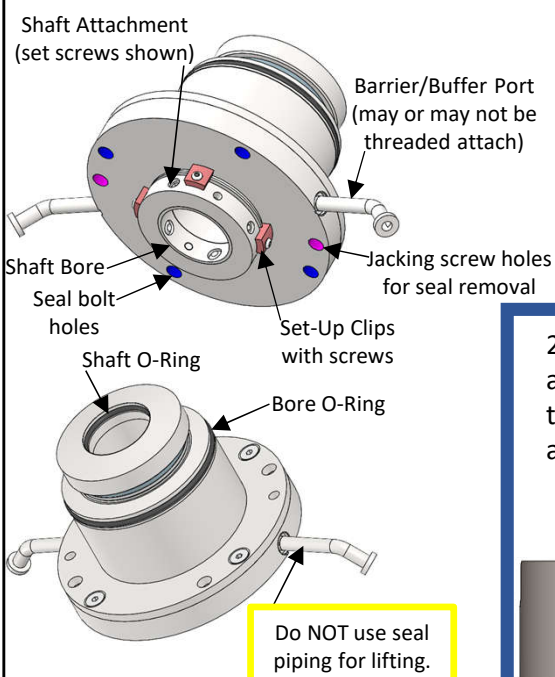


BOTTOM ENTRY SEAL INSTALLATION

ST SEAL SHOWN



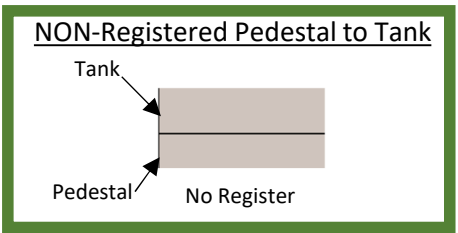
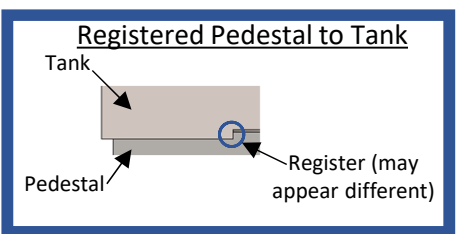
CAUTION:

- **CLEAN SEAL FACES WITH AN ISOPROPYL WIPE OR CLEAN LINT FREE CLOTH**
- **DO NOT TOUCH SEAL FACES WITH BARE HANDS OR DIRTY GLOVED HANDS**

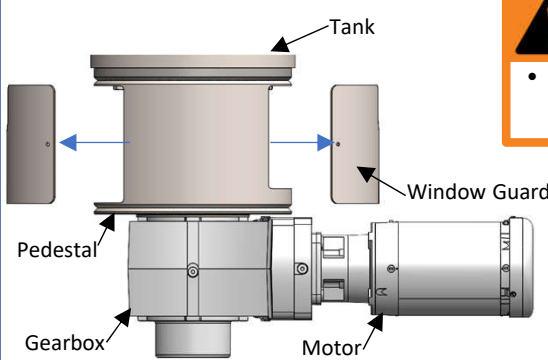
Note:

- Mixer can be installed without the motor and/or gearbox to reduce weight when that step comes.

1.) Apply process compatible lubricant to the shaft o-ring, being careful to only put lubricant on the o-rings. Based on your mixer configuration this process varies. If your pedestal is registered to the tank (image in blue) continue to step 2. If your pedestal is NOT registered to the tank (image in green), continue to step 7 on page 2.



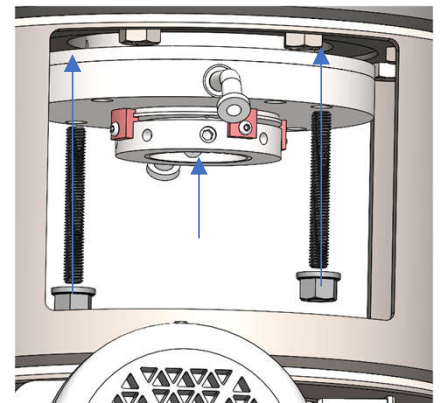
2.) With the motor, gearbox, pedestal, and seal assembly installed onto the tank, ensure that the window guard(s) are removed from the pedestal.



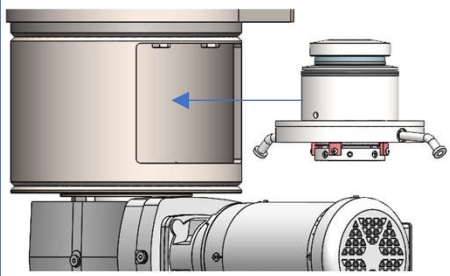
4.) Install threaded rod and nuts into the seal bolt holes at ~180° apart. This will hold the seal.

WARNING

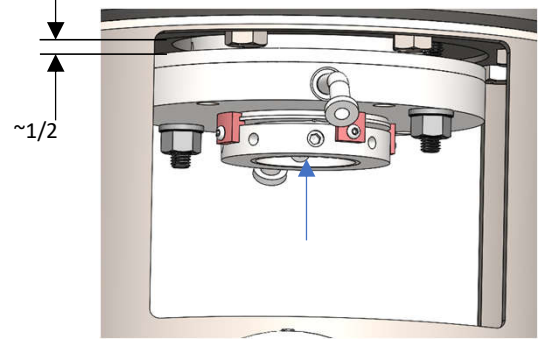
- Seal is heavy; keep body parts clear of pinch points.



3.) Insert the seal into the pedestal through the window. Orient the seal so the Buffer/Barrier ports are in the correct orientation according to the Approval/As Manufactured drawing.



5.) Tighten the nuts on the threaded rod evenly. Failure to tighten evenly will result in seal damage. Leave ~1/2" gap between the seal and pedestals mating surfaces. The seal is now "floated".



6.) Continue to step 13 pg. 3 to install the shaft.

CAUTION

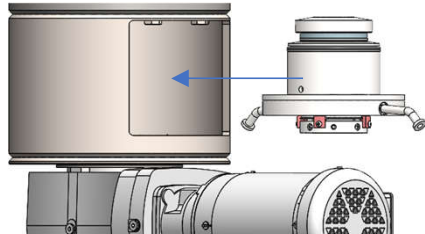
DISCONNECT MIXER FROM POWER SOURCE BEFORE ASSEMBLING, LIFTING, MOVING, OR SERVICING MIXER.

CAUTION:

- THE VISCOSITY AND SPECIFIC GRAVITY OF THE FLUID AFFECTS MIXER SIZING AND SPECIFICATIONS.
- **HANDLE SEAL WITH CARE, DO NOT SET SEAL DOWN ON THE SEAL'S NON-METALLIC SURFACES**

BOTTOM ENTRY SEAL INSTALLATION

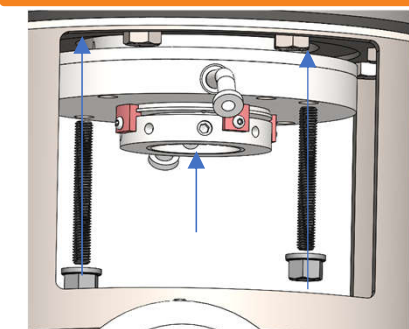
7.) With the mixer drive off of the tank, ensure that the window guard(s) are removed from the pedestal. Insert the seal into the pedestal through the window.



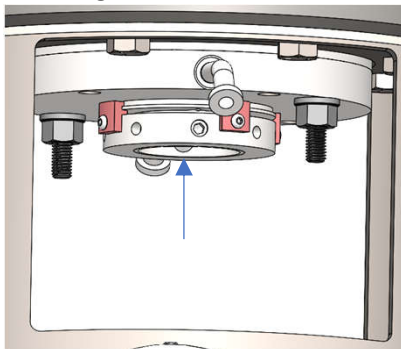
8.) Insert the seal into the seal bore. Install threaded rod and nuts into the seal bolt holes at ~180° apart. This will hold the seal.

! WARNING

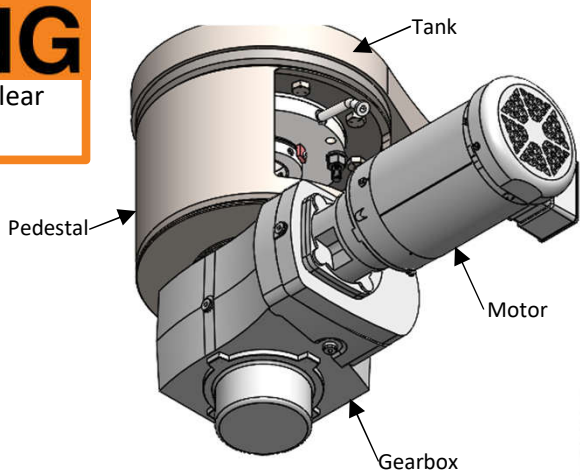
- Seal is heavy; keep body parts clear of pinch points.



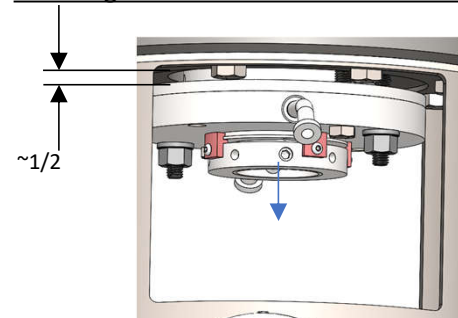
9.) Tighten the nuts on the threaded rod evenly until the seal mating face is seated against the pedestal mating face. Failure to tighten evenly will result in seal damage.



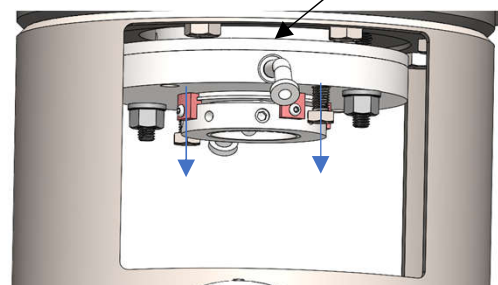
10.) Attach the mixer drive to the tank.



11.) Loosen the nuts on the threaded rod. If the seal does not lower with the nuts, use the jacking screw holes to ease the seal out of the bore. Tighten the jacking screws evenly. Allow for the seal to rest on the threaded rod's nuts. Leave ~1/2" gap between the seal and pedestals mating surfaces. The seal is now "floated". Do NOT use the jacking screws to tighten the seal to the nuts on the threaded rod. Tightening the seal to the nuts won't allow for the seal to "float". The jacking screw are just for breaking the seal loose from the bore.



12.) Loosen the jacking screws so they don't protrude out the tank side of the seal's face. Continue to pg. 3 to install the shaft.

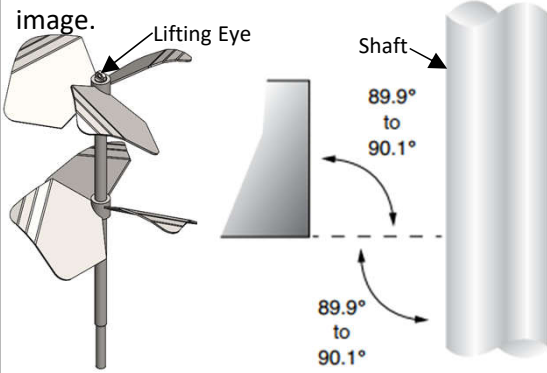


CAUTION

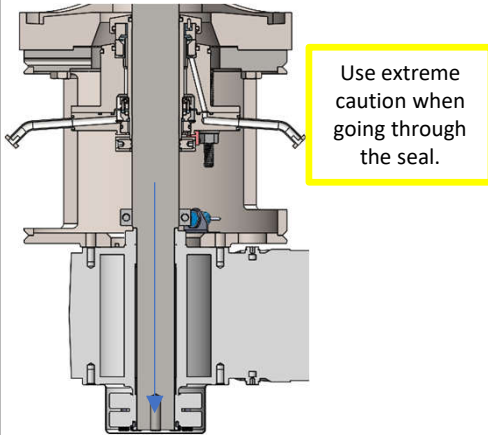
DISCONNECT MIXER FROM POWER SOURCE BEFORE ASSEMBLING, LIFTING, MOVING, OR SERVICING MIXER.

BOTTOM ENTRY SEAL INSTALLATION

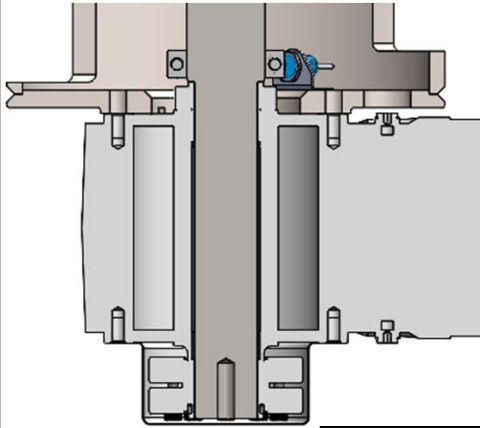
13.) Use the integral lifting eye on the shaft for rigging. Rig the shaft for installation in a way that adheres to this image.



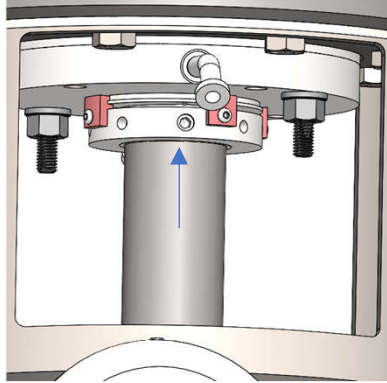
14.) Carefully lower the shaft into the tank thru the tank bottom, pedestal, seal shaft bore, and gearbox bore.



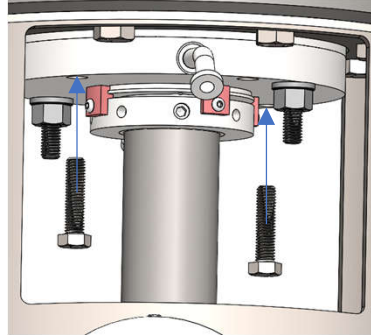
15.) Attach the shaft to the gearbox by following the appropriate QSG.



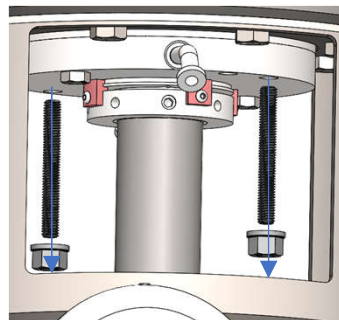
16.) Tighten the nuts on the threaded rod to raise the seal. Ensure that the seal registers into the pedestal. Failure to tighten evenly will result in seal damage.



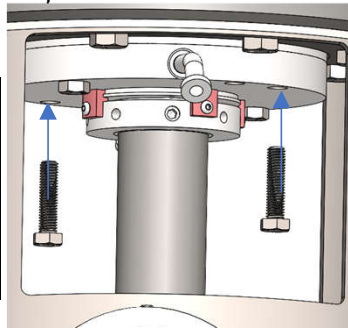
17.) Install the provided seal bolts into the remaining seal bolt holes.



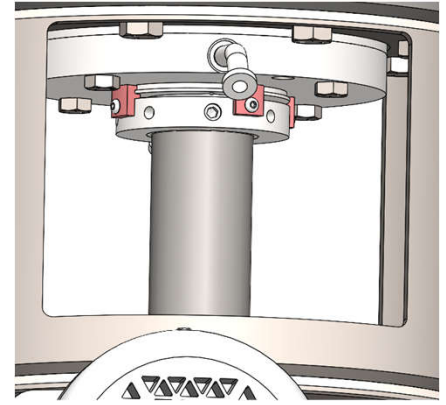
18.) Remove the threaded rods and nuts.



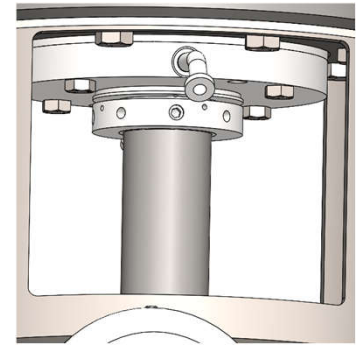
19.) Replace the threaded rod with the remaining seal bolts and tighten all the seal bolts to the appropriate value in the table. Tighten using the appropriate pattern.



20.) Attach the seal to the shaft by following the seal manufacturer's instructions.



21.) **Remove the set-up clips and retain for future use.** They will be needed in the future for seal maintenance.



REMOVE SET-UP CLIPS BEFORE OPERATING MIXER

22.) If the seal is a double, attach the seal support system according to the approval/as manufactured drawing and/or the seal manufacturer's specifications. Do not operate the mixer without the seal support system.

BOLT SIZE	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.

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- **HANDLE SEAL WITH CARE, DO NOT SET SEAL DOWN ON THE SEAL'S NON-METALLIC SURFACES**



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