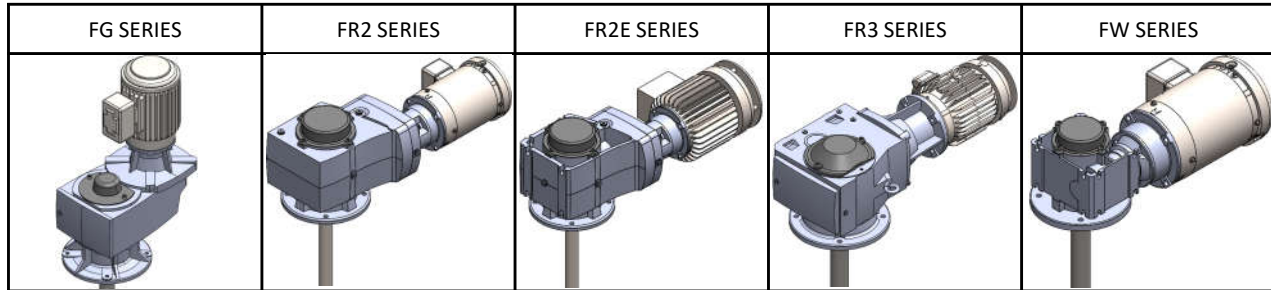
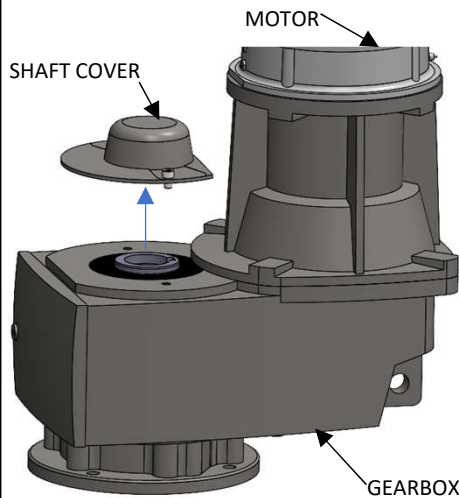


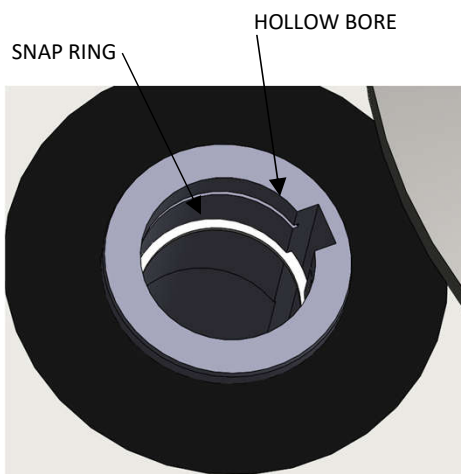
SHAFT INSTALLATION – FIXING ELEMENT & SHAFT COLLAR



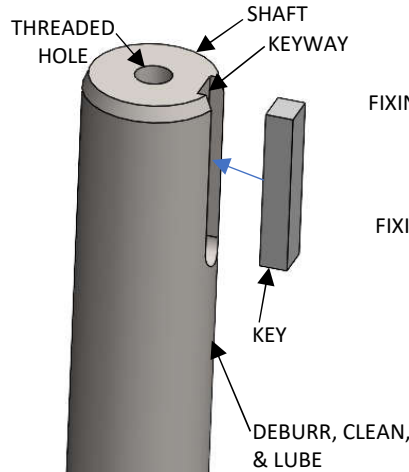
1.) Remove the gearbox's shaft cover by removing the bolts that hold it down. Keep the shaft cover and bolts.



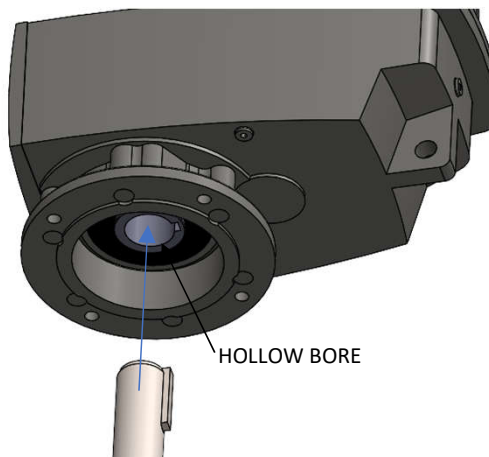
2.) Ensure the snap ring is in the gearbox's hollow bore.



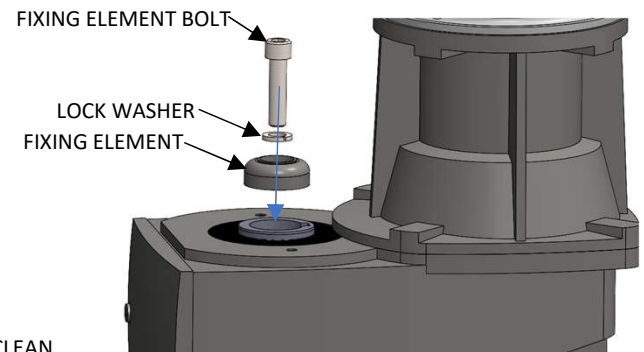
3.) Insert the key into the keyway of the shaft. Deburr, clean, then lightly lubricate the section of shaft that will go into the gearbox.



4.) 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.

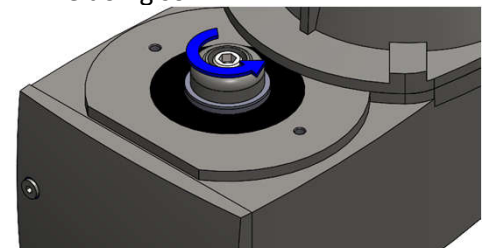


5.) Attach the shaft to the gearbox using the fixing element, lock washer, fixing element bolt (all provided). Apply service removable thread locker to the bolt and tighten to the appropriate value in the table.



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.

6.) Loosen the fixing element bolt 3 rotations, ensuring the shaft lowers while doing so.



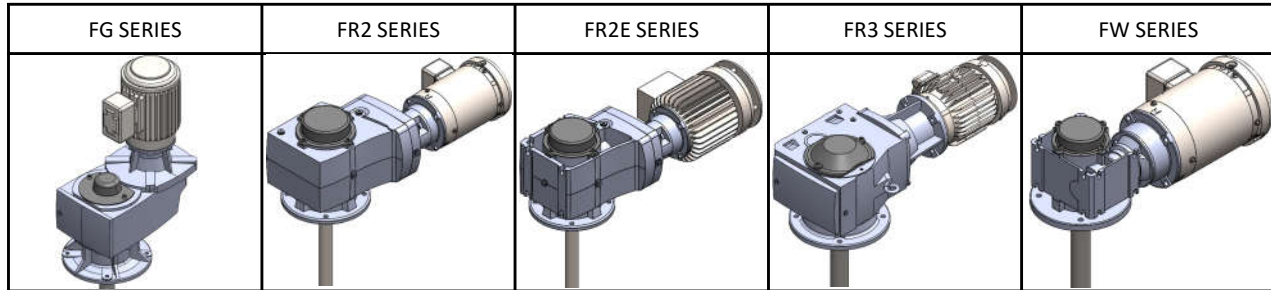
CAUTION

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

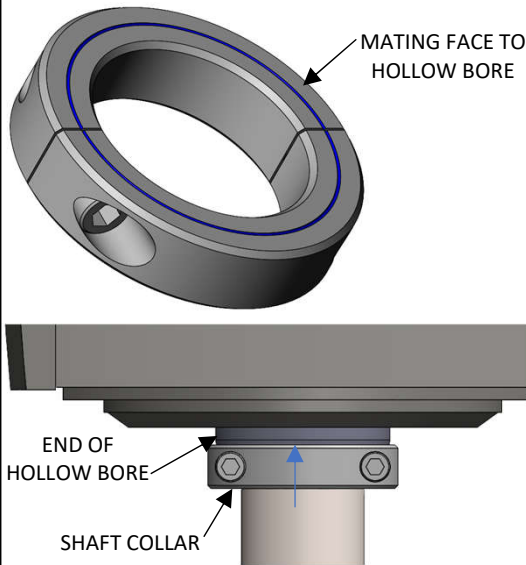
CAUTION:

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

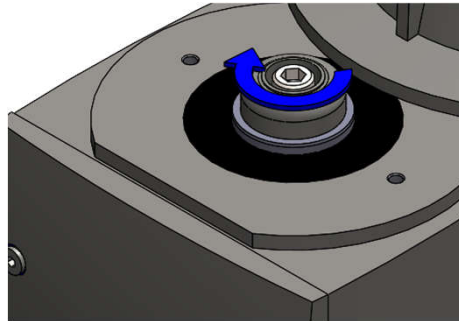
SHAFT INSTALLATION – FIXING ELEMENT & SHAFT COLLAR



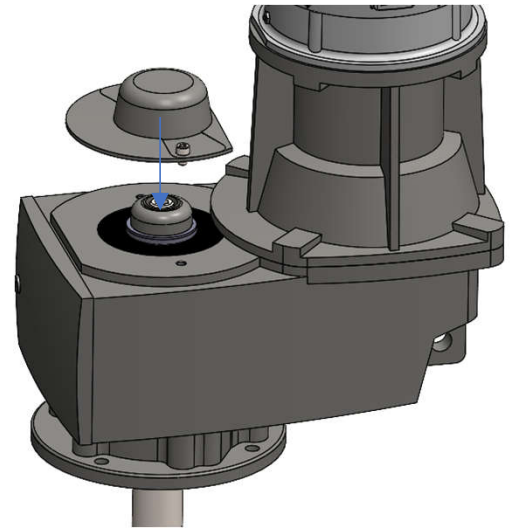
7.) Attach the shaft collar (supplied) to the shaft on the opposite end of the gearbox hollow bore. Ensure the collar's face with the groove cut into it (shown blue) is up against the gearbox's hollow bore. Tighten the shaft collar bolts to the appropriate value in the table.



8.) Re-tighten the fixing element bolt to the appropriate value in the table.



9.) Install the shaft cover and its bolts back onto the gearbox.



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.

Hollow Bore Dia.		Bolt	Torque
From	Up to (incl.)		
3/4"	1 9/16"	1/4-28	115 in-lb.
1 5/8"	2 7/16"	5/16-24	17 ft-lb.
2 1/2"	6"	3/8-24	29 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