FUSION FLUID EQUIPMENT

QSG-141-B

QUICK START GUIDE (QSG)

SERIES: FLOW
BOLTED PITCH BLADE TURBINE
IMPELLER BLADE INSTALLATION

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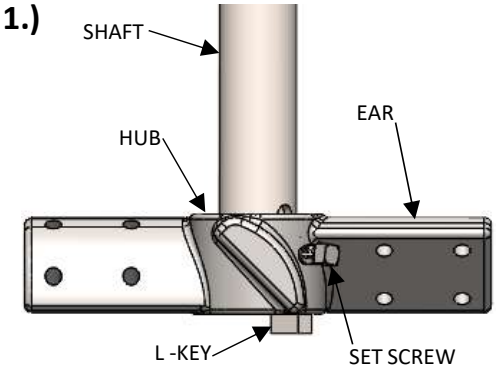
1.) FOLLOW THE "IMPELLER HUB WITH KEY INSTALLATION" QSG TO ATTACH THE IMPELLER HUB(S) TO THE SHAFT.

2.) THERE ARE 4 POSSIBLE IMPELLER CONFIGURATIONS, THEY ARE SHOWN BELOW. DETERMINE WHICH CONFIGURATION YOUR MIXER IS FROM THE APPROVAL (OR AS MANUFACTURED) DRAWING. **THE BLADES ARE ALWAYS BACKED BY THE HUBS EARS.**

3.) ATTACH THE BLADES TO THE HUB'S EARS USING THE PROVIDED BOLTS. APPLY SERVICE REMOVABLE THREAD LOCKER TO THE BOLT AND TIGHTEN TO THE APPROPRIATE VALUE IN THE TABLE.

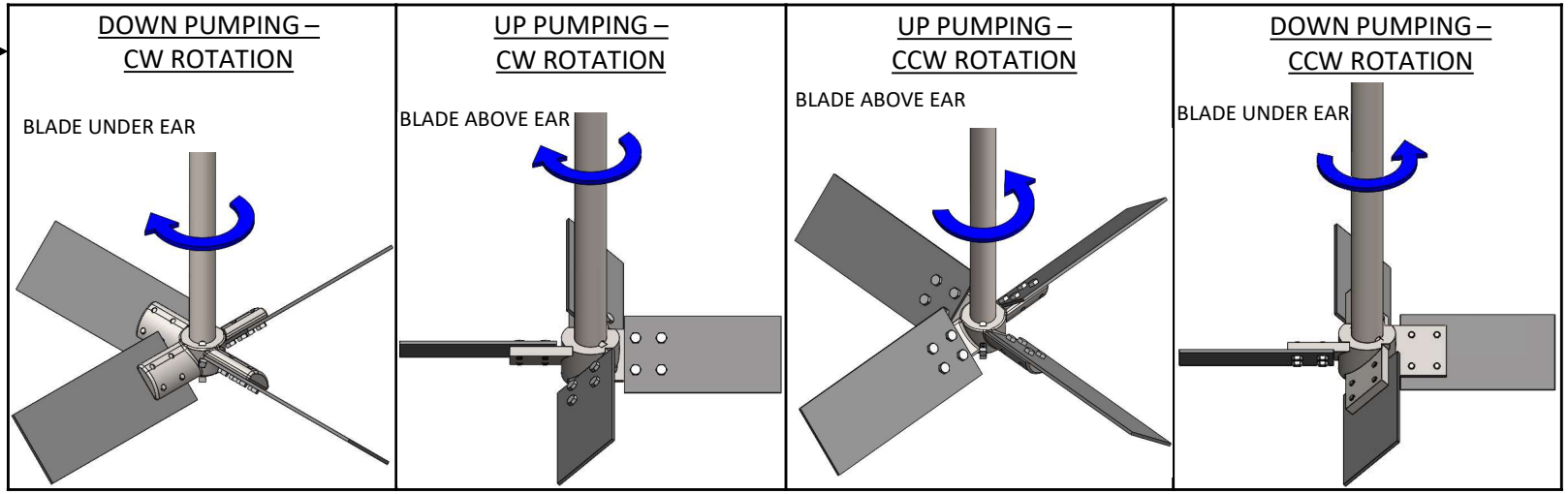
1.)



2.)

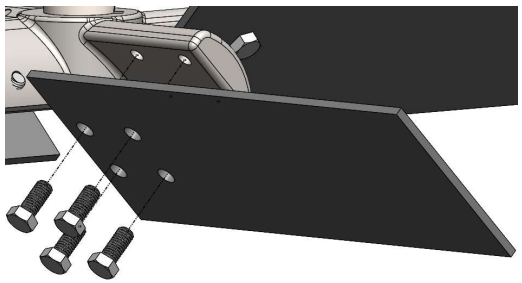
MOST TYPICAL →

- IMPELLER ROTATION AS VIEWED FROM THE TOP OF THE TANK FOR TOP AND BOTTOM ENTRY MIXERS.
- IMPELLER ROTATION AS VIEWED FROM THE MIXER DRIVE FOR SIDE ENTRY MIXERS



DAMAGE IS HIGHLY LIKELY IF THE BLADES ARE MOUNTED ON THE WRONG SIDE OF THE HUB'S EARS OR ROTATION IS INCORRECT.

3.)



- BLUE 242 LOCTITE OR SIMILAR SERVICE REMOVABLE THREAD-LOCKER RECOMMENDED.
- CHECK PROCESS COMPATIBILITY.
- REDUCE TORQUE VALUES TO 80% OF TABLE VALUES IF THREAD LOCKER IS UTILIZED.

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

Torque Specifications:

BOLT SIZE	18-8 & 304 STAINLESS (uncoated/no lube)		316 STAINLESS (uncoated/no lube)		Gr5 / Gr8 STEEL (uncoated/no lube)	
1/4"-20	57	*in-lbs*	60	*in-lbs*	75	*in-lbs*
5/16"-18	103	*in-lbs*	108	*in-lbs*	14	FT-LBS
3/8"-16	16	FT-LBS	17	FT-LBS	25	FT-LBS
7/16"-14	26	FT-LBS	27	FT-LBS	40	FT-LBS
1/2"-13	36	FT-LBS	38	FT-LBS	61	FT-LBS
9/16"-12	48	FT-LBS	51	FT-LBS	88	FT-LBS
5/8"-11	81	FT-LBS	84	FT-LBS	121	FT-LBS
3/4"-10	114	FT-LBS	118	FT-LBS	215	FT-LBS
7/8"-9	178	FT-LBS	186	FT-LBS	251	FT-LBS
1"-8	269	FT-LBS	281	FT-LBS	375	FT-LBS
1-1/4"-7	492	FT-LBS	513	FT-LBS	750	FT-LBS

Note: These values are provided for reference only. Every torquing situation needs to be evaluated as small differences can have significant impact on torque. These numbers assume clean, uncoated, non-lubricated stainless threads. In general, lubricated threads require less torque, while coated threads may require more or less. Dirty threads will require more torque.