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XCEL Series of Turbine Mixers

Bulletin 03-100
11/15/11
Supersedes 10/23/00

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Mixer Operation

1. Start-up Procedures

- A. Connect the motor wires in accordance with the wiring diagram present on the motor nameplate or on the inside of the junction box cover. The wiring, fusing, and grounding must be in accordance with the National Electrical Code and any local codes.
- B. As a precaution, check all the grease points and the gearbox oil level again to make sure it is filled to the recommended level. Make sure the unit is properly vented (if necessary) and all foundation fasteners and accessories are properly tightened. Before starting, if conditions permit, rotate the high speed shaft by hand to check for any obstructions. Finally, if a flexible grid or flexible gear coupling is being used, make sure they have been greased.
- C. **NEVER RUN THE MIXER WHILE THE TANK IS DRY. BEFORE OPERATING, MAKE SURE THE TANK CONTENTS AMPLY COVER ALL THE MIXER'S IMPELLER(S) BY AT LEAST 24".**

NOTE: Mixers are designed to operate while the impellers are fully covered with fluid and in a fully baffled cylindrical tank or square tank. If the liquid level varies, a liquid level sensor needs to be used to turn the mixer off when the liquid level is within one impeller diameter (or lower) of the upper most impeller. If the cylindrical tank is not baffled, add four (4) vertical baffles at 90° that are in accordance with UET's recommendation. If these conditions cannot be met, contact the factory immediately. Not meeting these conditions could catastrophically damage the mixer. For draw-down conditions the mixer may need to be upgraded.

- D. When the tank has been filled, jog the motor. Make sure the mixer shaft is rotating in the proper direction (when looking down at the top of the low speed shaft) indicated on the mixer nameplate. If it is not, simply switch any two of the power leads to reverse direction (on three phase motors only).
- E. Now turn on the mixer. It should start quickly and operate smoothly. If you experience excessive vibration, shaft run-out, loud noise, bearing or gear noise, these signal improper operation and the mixer should be shut down immediately and investigated.
- F. Allow unit to operate for several minutes then shut it down and recheck the oil level. If everything is satisfactory, the unit is ready for operation.
- G. We highly recommend that the motor current be checked after the mixer has been operation a short time and compared against the nameplate current.