



UET Mixers Inc.
 26 Maple St.
 Mechanic Falls, ME 04256
 Tel: (207)-345-3330
 Toll Free: (888)-838-9131
 Fax: (603)-627-9328

**XCEL Series of
 Turbine Mixers**

**TABLE OF
 CONTENTS**

-

TABLE OF CONTENTS

Bulletin 01-050 (Recommended bolting torques).....Pg.1

Bulletin 02-100 (Installation of Mixer Drive Size 300 to 900).....Pg. 2

Bulletin 04-100 (Maintenance of Mixer Drive Size 300 to 900).....Pg. 4

Bulletin 05-100 (Lubrication of Mixer Drive Sizes 300 to 900).....Pg. 6

Bulletin 05-101 (Lubrication of Mixer Drive Sizes S.E 300 to 900).....Pg. 8

Bulletin 07-100 (Double Reduction Mixer Drive Parts Guide for Size 300 to 900).....Pg. 10

Bulletin 07-100.1 (Seal & Bearing Manufacturer’s Data for Size 300).....Pg. 12

Bulletin 07-110 (Triple Reduction Mixer Drive Parts Guide for Size 300 to 900).....Pg. 13



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XCEL Series of Turbine Mixers

Bulletin 01-050
11/15/11
Supersedes 01/24/05

Page
01 of 01

Recommended Bolting Torques

1. Tightening Torques

Use the values specified in the following table for fastening motors, units, and accessories to their mounting surfaces with SAE Grade 5 non-lubricated fasteners. If the tightening torque exceeds the capacity of the torque wrench, use a torque multiplier.

Thread Dia-UNC (in)	Painted Metal to Painted Metal (lb-in)	Painted Metal to Concrete (lb-in)
.250-20	90	70
.314-18	185	145
.375-16	330	255
.500-13	825	640
.625-11	1,640	1,280
.750-10	2,940	2,290
.875-9	4,560	3,750
1.000-8	6,800	5,600
1.125-7	8,900	7,000
1.250-7	12,600	10,000
1.375-6	16,500	13,000
1.500-6	22,100	17,500



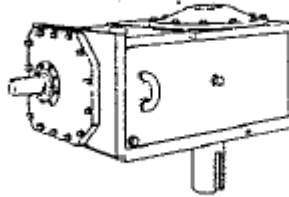
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XCEL Series of Turbine Mixers

Bulletin 02-100
01/13/2012
Supersedes 6/2/98

Page
01 of 02

Installation of Mixer Drive Sizes 300-900



1. General

Welding – **Never** weld on the gear unit or accessories. Welding can cause distortion of the housing or damage to the bearings and gear teeth.

Nameplate – Operate the mixer only at the horsepower and speed shown on the unit's nameplate. Before changing any of these, submit nameplate data and new application details for review by the factory.

ALWAYS USE GRADE 5 FASTENERS OR BETTER FOR MOUNTING

2. Instructions

Mounting – **CAUTION:** Mount unit only in position for which it was ordered. If it becomes necessary to mount the unit in a different position from that which it was ordered, contact UET for any necessary changes to provide proper lubrication.

Foundation, General – To facilitate oil drainage; elevate the unit foundation above the surrounding floor level. If desired, replace the unit oil drain plug with a valve, but provide a guard to protect the valve from accidental opening or breakage.

Foundation, Steel – When mounting the unit on structural steel, it is recommended that an engineered design be utilized to provide sufficient rigidity, to prevent induced loads from distorting the housing causing gear misalignment. In the absence of an engineered design, it is recommended that a baseplate, with thickness equal to or greater than the thickness of the unit base, be securely bolted to steel supports and extend under the entire unit.

Foundation, Concrete – If a concrete foundation is used, allow the concrete to set firmly before bolting down the unit. For the best type of mounting, grout structural steel mounting pads into the mounting base rather than grouting the unit directly into the concrete

*Motors and other components mounted on motor plates may become misaligned during shipment. **ALWAYS** check alignment after installation.*



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Bulletin 02-100
 01/13/2012
 Supersedes 6/2/98

Page
 02 of 02

Installation of Mixer Drive Sizes 300-900

Unit Alignment – Align unit by placing broad, flat shims under all mounting pads. Start at the low speed shaft end and level across the length and then the width of the unit. Check with a feeler guage to make certain that all pads are supported to prevent distortion of housing when unit is bolted down. After unit is aligned and bolted down, align motor to unit input shaft. See bulletin 02-900 for coupling alignment.

If equipment is received from UET mounted on a bedplate, the components were accurately aligned at the factory. Shim under the bedplate foot pads until the unit is level and all feet are in the same plane.

Double check the high speed shaft coupling alignment. If the coupling is misaligned, the bedplate or motor is shimmed incorrectly. Re-shim and recheck high speed coupling alignment.

Motor Brackets – the weight, location, and starting torque of the motor will cause some brackets to deflect downward and twist. This movement is within allowable engineered limits. If the customer considers the movement excessive, jackscrew supports for the bracket extension are available. To compensate for deflection caused by heavy motors AND to get CORRECT COUPLING ALIGNMENT, use more shims under the rear motor feet than the front feet.

Motors and other components (whether mounted on motor plates or brackets) may become misaligned during shipment. Always check alignment after installation. Refer to coupling alignment instructions in bulletin 02-900.

3. Tightening Torques

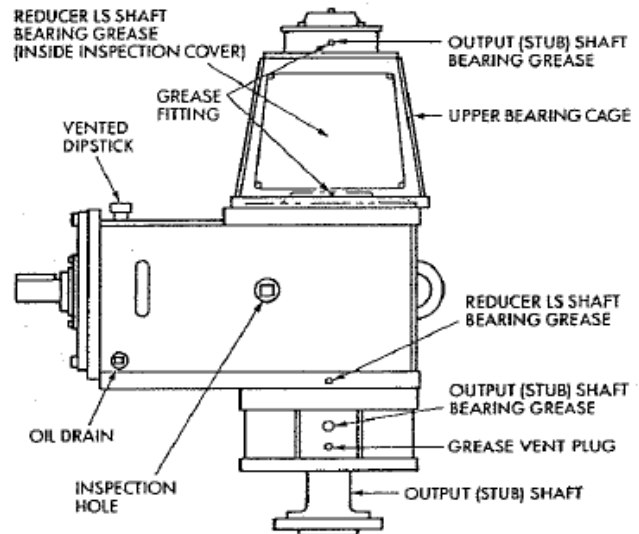
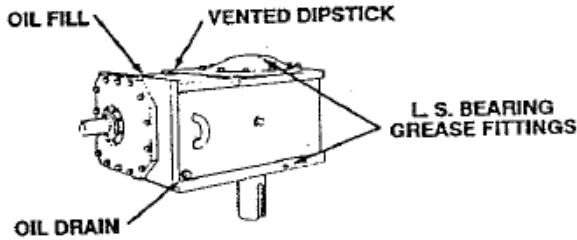
Use the values specified in the following table for fastening motors, units, and accessories to their mounting surfaces with SAE Grade 5 non-lubricated fasteners. If the tightening torque exceeds the capacity of the torque wrench, use a torque multiplier.

Thread Dia - UNC	Metal to Metal (in-lbs)	Metal to Concrete (in-lbs)
0.250-20	90	70
0.3125-18	185	145
0.375-16	330	255
0.500-13	825	640
0.625-11	1,640	1,280
0.750-10	2,940	2,290

Thread Dia - UNC	Metal to Metal (in-lbs)	Metal to Concrete (in-lbs)
0.875-9	4,560	3,750
1.000-8	6,800	5,600
1.125-7	8,900	7,000
1.250-7	12,600	10,000
1.375-6	16,500	13,000
1.500-6	22,100	17,500



Maintenance of Mixer Drive Sizes 300-900



Unit Size	Gallons
300	7
400	9
500	13
600	19
700	24
800	44
900	45

1. **Preventative Maintenance** – Always fill the unit with oil to the level indicated on the oil level dipstick. Also, make sure that the breather under the dipstick cap is fully functional. Use an oil as recommended in bulletin 05-100.
 - A. **After First Week** – Check alignment of the total system and realign where necessary. Also, tighten all external bolts and plugs where necessary. **DO NOT** re-adjust the internal gear or bearing settings in the reducer; these were permanently set at the factory.
 - B. **After First Month's Service** – Proceed as follows:
 - a. Operate unit until sump oil reaches normal operating temperature. Shut the unit down and drain immediately.
 - b. Immediately flush unit with an oil of the same type and viscosity grade as the original charge (warmed approximately 100°F in cold weather). Rapidly pour or pump a charge equal to 25-100% of the initial fill thru the unit or until clean oil flows through the drain.
 - c. Close the drain and refill the unit to the correct level with new or reclaimed oil of the correct type and viscosity. If determined to be in good condition by supplier, reclaimed oil may be reused if it's filtered through a 40 micron or finer filter.
 - C. **Periodically** – Carefully check the oil level of the unit when it is stopped and at ambient temperature, add oil if needed. If the oil level is **ABOVE** the high level mark on the dipstick, have the oil analyzed for water content. Moisture in the oil may indicate that a seal is leaking. If so, replace the defective part immediately and change the oil. **DO NOT** fill above mark indicated on dipstick as leakage or undue heating may result. Also check coupling alignment to make certain that foundation settling has not caused excessive misalignment.



Maintenance of Mixer Drive Sizes 300-900

D. Oil Changes – for normal operating conditions, change gear R&O lubricants every six months or 2500 hours of operation, whichever occurs first. In dusty areas or where temperatures are high, more frequent changes may be required. Lubricant suppliers can test oil samples from the drive periodically and recommend economical change periods base on the rate of lubricant contamination and degradation.

If the drive is operated in an area where temperatures vary with the seasons, change the oil viscosity grade to suit the temperature.

E. Grease Lubrication – All units have two grease lubricated low speed shaft bearings and grease purged high speed shaft oil seal. Re-grease bearings and seal at least every six months or when the grease becomes contaminated. The low speed shaft bearing grease capacities are listed in the table on page two. To purge the high speed seal, pump fresh grease through the fitting to flush out the old along the shaft where it can be wiped off. Select a grease from bulletin 05-100.

F. Couplings – Lubricate the high speed and low speed grid couplings per bulletin 05-900.

2. Stored and Inactive Units

A. Short Term Storage – Each Drive has been spin tested with rust preventative oil that protects internal parts against rust for a period of 4 months in outdoor storage or 12 months in a dry building.

B. Long Term Storage – Proceed as follows:

1. If a drive is stored or inactive beyond the periods specified under short term storage, the oil should be drained from the housing and add “Motorstor” (or equal product) vapor phase inhibitor to a volume of 5% of the units sump capacity. The low speed shaft should then be rotated several times. The air vent should be removed and replaced with a plug to create an inhibiting atmosphere inside the drive.
2. The unit should be inspected monthly for signs of corrosion and the low speed shaft rotated several times. Rust inhibitor should be added every six months or more often if storage area is humid or experiences wide temperature swings.
3. Note that before operating, the speed reducer should be vented and filled to the proper level with the recommended oil per bulletin 05-100.

Mixer Size	Bearing Location	Re-greasing Capacity (oz.)
300	Upper	3
	Lower	3
400	Upper	3
	Lower	3
500	Upper	4
	Lower	3
600	Upper	4
	Lower	3
700	Upper	6
	Lower	5
800	Upper	12
	Lower	10
900	Upper	12
	Lower	10



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Bulletin 05-100
 1/12/12
 Supersedes 04/08/98

Page
 01 of 02

Lubrication of Mixer Drive Size 300-900

1. Unit Lubrication

Read and carry out all instructions on lubrication plate and heed all warning tags. Determine the output rpm and minimum and maximum temperatures in which the drive will operate. Find the AGMA lubricant number from the following chart.

	Ambient Temperature	AGMA No.	Viscosity @ 104°F	
			SSU	cSt
Output RPM 80 and above	+15° to +60°F	4	626-765	135-165
	+50° to +125°F	5	918-1122	198-242
Output RPM below 80	+15° to +60°F	4	626-765	135-165
	+50° to +125°F	6	1335-1632	288-352

Select an R&O oil from the table below which corresponds to the AGMA lubricant number previously determined. Lubricants listed in this manual are typical products only and should not be construed as exclusive recommendations. All mineral oil (R&O) lubricants must have a minimum viscosity index of 90.

AGMA Viscosity Grade	4	5	6
ISO viscosity Grade	150	220	320
Viscosity at 104° F	626-765	918-1122	1335-1632
SSU	135-165	198-242	288-352
cSt			
Manufacturer	Lubricant	Lubricant	Lubricant
Amoco Oil Co.	Ind. Oil # 150	Ind. Oil # 220	Ind. Oil # 320
Ashland Oil, Inc.	100H ISO 150	100H ISO 220	100H ISO 320
BP Oil Co.	Turbinol T-150	Energol HL 220	Energol HL 320
Chevron U.S.A., Inc.	AW Machine Oil 150	AW Machine Oil 220	AW Machine Oil 320
Citgo Petroleum Corp.	Citgo Pacemaker 150	Citgo Pacemaker 220	Citgo Pacemaker 320
Conoco Inc.	Dectol R&O Oil 150	Dectol R&O Oil 220	Dectol R&O Oil 320
Exxon Company, U.S.A.	Terresstic 150	Terresstic 220	Terresstic 320
Gulf Oil	Harmony 150 or 150D	Harmony 220	Harmony 320
E.F. Houghton & Co.	Hydro-Drive HP 750	Hydro-Drive HP 1000	...
Imperial Oil Ltd.	Teresso 150	Teresso N 220	Teresso N 320
Kendall Refining Co.	Kenoil R&O 080EP
Keystone Div Pennwalt Corp	KLC-40
Lyondell Petrochemical(ARCO)	Duro 150	Duro 220	Duro 320
Mobil Oil Corp.	DTE Oil Extra Heavy	DTE Oil BB	DTE Oil AA
Petro-Canada Products	Harmony 150 or 150D	Harmony 220	Harmony 320
Phillips 66 Co.	Magnus Oil 150	Magnus Oil 220	Magnus Oil 320
Shell Oil Co.	Morlina 150	Morlina 220	Morlina 320
Shell Canada Limited	Tellus 150	Tellus 220	Tellus 320
Sun Oil Co.	Sun R&O Oil L150
Texaco Inc.	Regal Oil R&O 150	Regal Oil R&O 220	Regal Oil R&O 320

Note: speed reducer housing temperature will range from 130 to 180 °F during normal operation using the oils listed above. If your reducer surpasses 180 °F, there may be cause for concern. If the unit is operated in an area where the temperatures vary with the season, change the oil viscosity to suit the season. For cold weather operation, use a light oil that will circulate freely at all times. The pour point of the oil should at least be 9 °F less than the minimum external temperature encountered. During hot weather, use a high viscosity oil that will not thin out and lose its lubricating qualities.



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XCEL Series of Turbine Mixers

Bulletin 05-100
 1/12/12
 Supersedes 04/08/98

Page
 02 of 02

Lubrication of Mixer Drive Size 300-900

2. Approximate Oil Capacities

Unit Size	Gallons
300	7
400	9
500	13
600	19
700	24
800	44
900	45

3. Grease Lubricated Bearings

The upper and lower low speed shaft bearings are grease lubricated. The bearings should be greased with a NLGL #2 bearing grease selected from the following table.

Manufacturer	Lubricant
Amoca Oil Co.	Amolith Grease No.2
Ashland Oil Co., Inc.	Multilube Lithium EP Grease
BP Oil Co.	Energrease LS-EP2
Chevron U.S.A., Inc.	Industrial Grease Medium
Citgo Petroleum Corp.	Premium Lithium Grease
Conoco Inc.	EP Conolith Grease No. 2
Exxon Company, U.S.A	Unirex N2
E.F. Houghton & Co.	Cosmolube 2
Imperial Oil Ltd.	Unirex N2L
Kendall Refining Co.	Multi-Purpose Lithium Grease L-421
Keystone Div. Pennwalt Corp.	Zeniplex-2
Lyondell Petrochemical (ARCO)	Litholine H EP 2 Grease
Mobil Oil Corp.	Mobilith 22
Petro-Canada Products	Multipurpose EP2
Phillips 66 Co.	Philube Blue EP
Shell Oil Co.	Alvania Grease 2
Shell Canada Limited	Alvania Grease 2
Sun Oil Co.	Ultra Prestige EP2
Texaco Inc.	Premium RB Grease
Unacol 76 (East & West)	Unoba EP2

Mixer Size	Bearing Location	Re-greasing Capacity (oz.)
300	Upper	3
	Lower	3
400	Upper	3
	Lower	3
500	Upper	4
	Lower	3
600	Upper	4
	Lower	3
700	Upper	6
	Lower	5
800	Upper	12
	Lower	10
900	Upper	12
	Lower	10

The greases listed above are recommended for a temperature range between 0°F and 200°F.

4. Grease Purged Seals:

The high speed shaft is furnished with grease purged seals which minimize the entry of taconite and other abrasive dusts into the unit. Utilize one of the recommended greases from the table.



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XCEL Series of Turbine Mixers

Bulletin 05-101
 1/13/12
 Supersedes 04/08/98

Page
 01 of 02

Lubrication of Mixer Drive Size 300-900 (Side Entering)

1. Unit Lubrication

Read and carry out all instructions on lubrication plate and heed all warning tags. Determine the output rpm and minimum and maximum temperatures in which the drive will operate. Find the AGMA lubricant number from the following chart.

	Ambient Temperature	AGMA No.	Viscosity @ 104°F	
			SSU	cSt
Output RPM 80 and above	+15° to +60°F	4	626-765	135-165
	+50° to +125°F	5	918-1122	198-242
Output RPM below 80	+15° to +60°F	4	626-765	135-165
	+50° to +125°F	6	1335-1632	288-352

Select an R&O oil from the table below which corresponds to the AGMA lubricant number previously determined. Lubricants listed in this manual are typical products only and should not be construed as exclusive recommendations. All mineral oil (R&O) lubricants must have a minimum viscosity index of 90.

AGMA Viscosity Grade	4	5	6
ISO viscosity Grade	150	220	320
Viscosity at 104° F	626-765	918-1122	1335-1632
SSU	135-165	198-242	288-352
cSt			
Manufacturer	Lubricant	Lubricant	Lubricant
Amoco Oil Co.	Ind. Oil # 150	Ind. Oil # 220	Ind. Oil # 320
Ashland Oil, Inc.	100H ISO 150	100H ISO 220	100H ISO 320
BP Oil Co.	Turbinol T-150	Energol HL 220	Energol HL 320
Chevron U.S.A., Inc.	AW Machine Oil 150	AW Machine Oil 220	AW Machine Oil 320
Citgo Petroleum Corp.	Citgo Pacemaker 150	Citgo Pacemaker 220	Citgo Pacemaker 320
Conoco Inc.	Dectol R&O Oil 150	Dectol R&O Oil 220	Dectol R&O Oil 320
Exxon Company, U.S.A.	Terresstic 150	Terresstic 220	Terresstic 320
Gulf Oil	Harmony 150 or 150D	Harmony 220	Harmony 320
E.F. Houghton & Co.	Hydro-Drive HP 750	Hydro-Drive HP 1000	...
Imperial Oil Ltd.	Teresso 150	Teresso N 220	Teresso N 320
Kendall Refining Co.	Kenoil R&O 080EP
Keystone Div Pennwalt Corp	KLC-40
Lyondell Petrochemical(ARCO)	Duro 150	Duro 220	Duro 320
Mobil Oil Corp.	DTE Oil Extra Heavy	DTE Oil BB	DTE Oil AA
Petro-Canada Products	Harmony 150 or 150D	Harmony 220	Harmony 320
Phillips 66 Co.	Magnus Oil 150	Magnus Oil 220	Magnus Oil 320
Shell Oil Co.	Morlina 150	Morlina 220	Morlina 320
Shell Canada Limited	Tellus 150	Tellus 220	Tellus 320
Sun Oil Co.	Sun R&O Oil L150
Texaco Inc.	Regal Oil R&O 150	Regal Oil R&O 220	Regal Oil R&O 320

Note: speed reducer housing temperature will range from 130 to 180 °F during normal operation using the oils listed above. If your reducer surpasses 180 °F, there may be cause for concern. If the unit is operated in an area where the temperatures vary with the season, change the oil viscosity to suit the season. For cold weather operation, use a light oil that will circulate freely at all times. The pour point of the oil should at least be 9 °F less than the minimum external temperature encountered. During hot weather, use a high viscosity oil that will not thin out and lose its lubricating qualities.



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Bulletin 05-101
 1/12/12
 Supersedes 04/08/98

Page
 02 of 02

Lubrication of Mixer Drive Size 300-900 (Side Entering)

2. Approximate Oil Capacities

Unit Size	Gallons
300	11
400	10
500	13
600	19
700	24
800	43
900	43

3. Grease Lubricated Bearings

The upper and lower low speed shaft bearings are grease lubricated. The bearings should be greased with a NLGL #2 bearing grease selected from the following table.

Manufacturer	Lubricant
Amoca Oil Co.	Amolith Grease No.2
Ashland Oil Co., Inc.	Multilube Lithium EP Grease
BP Oil Co.	Energrease LS-EP2
Chevron U.S.A., Inc.	Industrial Grease Medium
Citgo Petroleum Corp.	Premium Lithium Grease
Conoco Inc.	EP Conolith Grease No. 2
Exxon Company, U.S.A	Unirex N2
E.F. Houghton & Co.	Cosmolube 2
Imperial Oil Ltd.	Unirex N2L
Kendall Refining Co.	Multi-Purpose Lithium Grease L-421
Keystone Div. Pennwalt Corp.	Zeniplex-2
Lyondell Petrochemical (ARCO)	Litholine H EP 2 Grease
Mobil Oil Corp.	Mobilith 22
Petro-Canada Products	Multipurpose EP2
Phillips 66 Co.	Philube Blue EP
Shell Oil Co.	Alvania Grease 2
Shell Canada Limited	Alvania Grease 2
Sun Oil Co.	Ultra Prestige EP2
Texaco Inc.	Premium RB Grease
Unacol 76 (East & West)	Unoba EP2

Mixer Size	Bearing Location	Re-greasing Capacity (oz.)
300	Upper	3
	Lower	3
400	Upper	3
	Lower	3
500	Upper	4
	Lower	3
600	Upper	4
	Lower	3
700	Upper	6
	Lower	5
800	Upper	12
	Lower	10
900	Upper	12
	Lower	10

The greases listed above are recommended for a temperature range between 0°F and 200°F.

4. Grease Purged Seals:

The high speed shaft is furnished with grease purged seals which minimize the entry of taconite and other abrasive dusts into the unit. Utilize one of the recommended greases from the table.



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Bulletin 07-100
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Page
 01 of 02

Mixer Drive Parts Guide for Sizes 300-900

1. Double Reduction Units: Ratios 5.06 - 31.39

Housing Parts

Ref. No	Part Description
10	Housing
11	H.S. Head Plate
13	Dipstick & Vent Plug
15	Cooling Fan
16	Fan Guard
17	L.S. Oil Dam
20	H.S. Seal Cage (specify Ref. No. 120)
21 ✓	H.S. Oil Seal
30	L.S. Lower Seal Cage
34 ✓	L.S. Oil Seal
37	L.S. Grease Shield
43	L.S. Upper Cover
60	Bevel Pinion Bearing Cage
70-77	Shim-Gaskets available as a kit (specify Ref. No. 100)
80-89	Fasteners available as a kit (specify Ref. No. 110)
100 ✓	Shim Gasket Kit (includes Ref. No. 70, 73, 74, 75, 76, 77)
110	Fastener Kit (includes Ref. No. 80, 83, 84, 85, 88, 89)
120	H.S. Seal Assembly (includes Ref. No. 20, 21, & 70)

Shaft Assemblies

Ref. No.	Part Description
1A	High Speed Shaft Assembly
	Includes:
1A1 ✓	Outer Bearing
1A2 ✓	Inner Bearing
1A3	Shaft
1A4	Pinion
1A5	Spacer
4AB	Bevel Pinion Shaft Assembly
	Includes:
4AB1 ✓	Outer Bearing
4AB2 ✓	Inner Bearing
4AB4	Bevel Pinion & Shaft
4AB5	High Speed Gear
4AB6	Bearing Locknut & Washers
4AB7	Gear Spacer (sizes 800 & 900)
4AB8	Gear Locknut
5ABD	Low Speed Shaft Assembly
	Includes:
5AB1 ✓	Upper Bearing (includes Ref. No. 37)
5AB2 ✓	Lower Bearing
5ABD3	Shaft
5AB4	Umbrella
5AB5	Bevel Gear
5AB6	Upper Bearing Spacer

✓ - Recommended Spare Parts

*- Contact factory for parts and kits pricing



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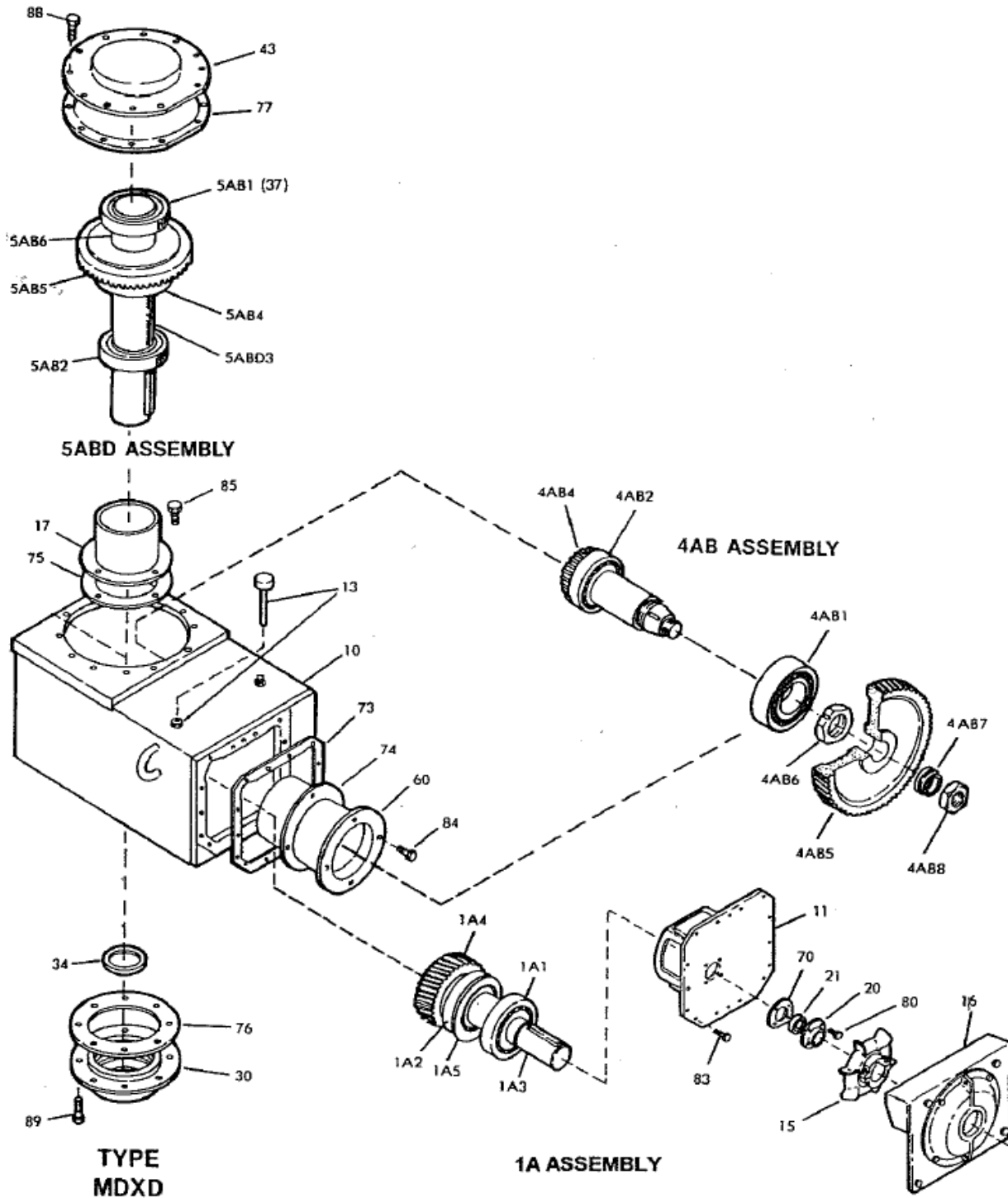
XCEL Series of Turbine Mixers

Bulletin 07-100
01/13/2012
Supersedes 05/26/98

Page
02 of 02

Mixer Drive Parts Guide for Sizes 300-900

1. Double Reduction Units: Ratios 5.06 - 31.39





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XCEL Series of Turbine Mixers

Bulletin 07-100.1
01/13/2012
Supersedes 10/23/00

**Page
01 of 01**

Seal & Bearing Manufacturer's Data for Size 300

1. Double Reduction Units: Ratios 5.06 – 31.39

Seal Identification Data

Falk Ref. No.	Part Description	Manufacturer's Part No.	
		Chicago Rawhide	National
21	H.S. Oil Seal	CRWA 17285	471504
34	L.S. Oil Seal	CRWH 33735	455165

Bearing Identification Data

Falk Ref. No.	Part Description	Manufacturer	Manufacturer's Part No.
1A1	Outer Bearing	Fafnir	208KG
1A2	Inner Bearing	SKF	305
4AB1	Outer Bearing	Timken	HM807046 / HM807010
4AB2	Inner Bearing	Timken	HM807046 / HM807010
5AB1	Upper Bearing	Timken	665 / 653
5AB2	Lower Bearing	Timken	665 / 653



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XCEL Series of Turbine Mixers

Bulletin 07-110
 01/13/2012
 Supersedes 05/26/98

Page
 01 of 02

Mixer Drive Parts Guide for Sizes 300-900

1. Triple Reduction Units: Ratios 38.44 – 194.6

Housing Parts

Ref. No	Part Description
10	Housing
11	H.S. Head Plate
13	Dipstick & Vent Plug
17	L.S. Oil Dam
20	H.S. Seal Cage (specify Ref. No. 120)
21 ✓	H.S. Oil Seal
30	L.S. Lower Seal Cage
34 ✓	L.S. Oil Seal
37	L.S. Grease Shield
40	Intermediate Cover
43	L.S. Upper Cover
50	Int. Thrust Plate (sizes 700-900)
52	Int. Bearing Spacer (sizes 500 & 600)
60	Bevel Pinion Bearing Cage
70-77	Shim-Gaskets available as a kit (specify Ref. No. 100)
80-89	Fasteners available as a kit (specify Ref. No. 110)
100 ✓	Shim Gasket Kit (includes Ref. No. 70, 73, 74, 75, 76, 77)
110	Fastener Kit (includes Ref. No. 80, 83, 84, 85, 88, 89)
120	H.S. Seal Assembly (includes Ref. No. 20, 21, & 70)

Shaft Assemblies

Ref. No.	Part Description
1B	High Speed Shaft Assembly
	Includes:
1B1 ✓	Outer Bearing
1B2 ✓	Inner Bearing
1B3	Shaft
1B4	Pinion
1B5	Spacer
3A	Intermediate Shaft Assembly
	Includes:
3A1 ✓	Outer Bearing
3A2 ✓	Inner Bearing
3A3	Shaft
3A4	Pinion
3A5	Spacer (sizes 400 – 600)
3A6	High Speed Gear
3A7	Gear Locknut
4AB	Bevel Pinion Shaft Assembly
	Includes:
4AB1 ✓	Outer Bearing
4AB2 ✓	Inner Bearing
4AB4	Bevel Pinion & Shaft
4AB5	Intermediate Gear
4AB6	Bearing Locknut & Washers
4AB7 ✓	Gear Spacer (sizes 800 & 900)
4AB8	Gear Locknut
5ABD	Low Speed Shaft Assembly
	Includes:
5AB1 ✓	Upper Bearing (includes Ref. No. 37)
5AB2 ✓	Lower Bearing
5ABD3	Shaft
5AB4	Umbrella
5AB5	Bevel Gear
5AB6	Spacer

✓ - Recommended Spare Parts

*- Contact factory for parts and kits pricing



UET Mixers Inc.
26 Maple St.
Mechanic Falls, ME 04256
Tel: (207)-345-3330
Toll Free: (888)-838-9131
Fax: (603)-627-9328

XCEL Series of Turbine Mixers

Bulletin 07-110
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Supersedes 05/26/98

Page
02 of 02

Mixer Drive Parts Guide for Sizes 300-900

1. Triple Reduction Units: Ratios 38.44 – 194.6

