



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**

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11/15/11
Supersedes 01/24/05

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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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12/21/11
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Installation of Mixer Drive Sizes 3F-10F

Inspection

Carefully uncrate and remove wrappings from your UET EXCEL-FLO mixer. Inspect all surfaces for damage. If any such damage is noted, report immediately to your shipper service and to UET.

Mixer is shipped with shaft and turbine detached to maintain shaft tolerance levels. Check for all parts- shipment is usually packed in two or more crates. Foreign shipments may be coated with rust inhibitor which is removable with kerosene, carbon tetrachloride or other solvent compound.

For long term storage, re-pack the XCEL mixer after inspecting. If stored for more than one year, all lubricated parts must be inspected and the proper lubricant applied before operating the mixer. See manual section on "Lubrication".

Installation

DO NOT attach shaft to gearbox before mounting without reading the directions on this page.

Step 1: Carefully lift XCEL **gearbox** from its crate and remove packing.

Step 2: (If mixer overhead clearance is under 20", Step 4 may be required before mounting gearbox.) Lift mixer to mounting surface, position and bolt in place. All bolts should be tightened an extra ½ turn to insure placement (see Bulletin 01-050 for recommended bolt torque).

Step 3: **Using extreme care**, uncrate and remove **shaft** from packing. DO NOT jar or bend shaft. Incautious handling may result in mixer vibration during operation.

Step 4: Make sure setscrews at top of gearbox are backed off. Insert shaft (from bottom) with shorter keyway and polished end toward gearbox directly into the reducer quill until keyway is fully exposed at top of quill.

Step 5: Insert shaft key and fasten cap plate to recommended torque (see Bulletin 01-050). Then lower shaft until the cap plate rests on top of quill (fully supporting shaft).

Step 6: Now tighten gearbox setscrews onto shaft outside diameter.

Step 7: Attached shaft safety guard with provided hardware.

Step 8: (See Bulletin 02-200 for illustration) Remove turbine/turbine hub from packing and slide hub over shaft end until above keyway. Insert key and lower hub into position. Tighten hub set screws into key and shaft.

Step 9: Firmly bolt blades in place on hub. Torque bolts to recommended value per Bulletin 01-050. Proceed to Bulletin 03-100, Mixer Operation.

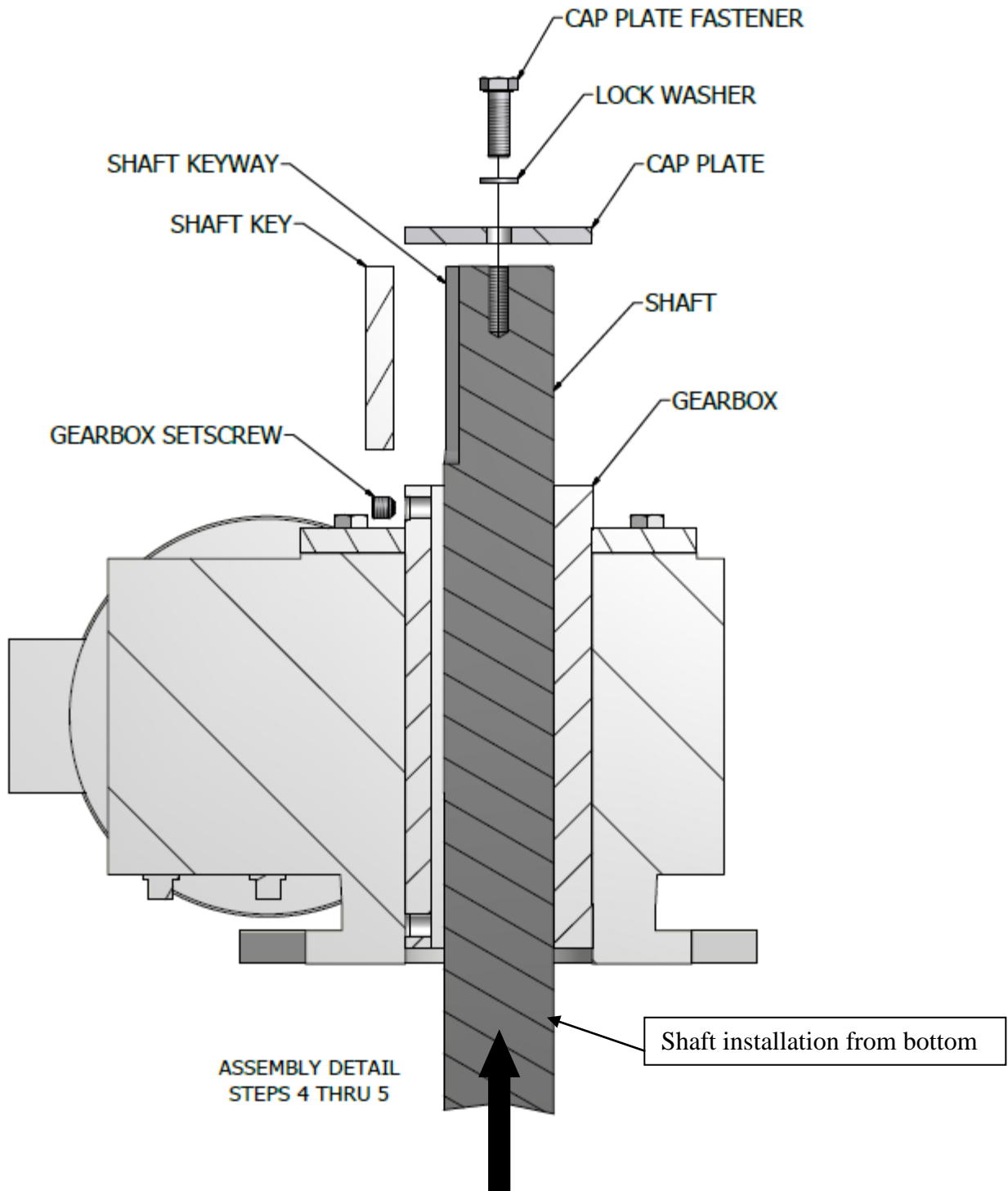


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NOTE:

IF YOUR MIXER INCLUDES A REMOTE OR PEDESTAL MOUNTED HIGH/LOW PRESSURE STUFFING BOX, PROCEED TO BULLETIN 02-800 FOR COMPLETE INSTALLATION INSTRUCTIONS.

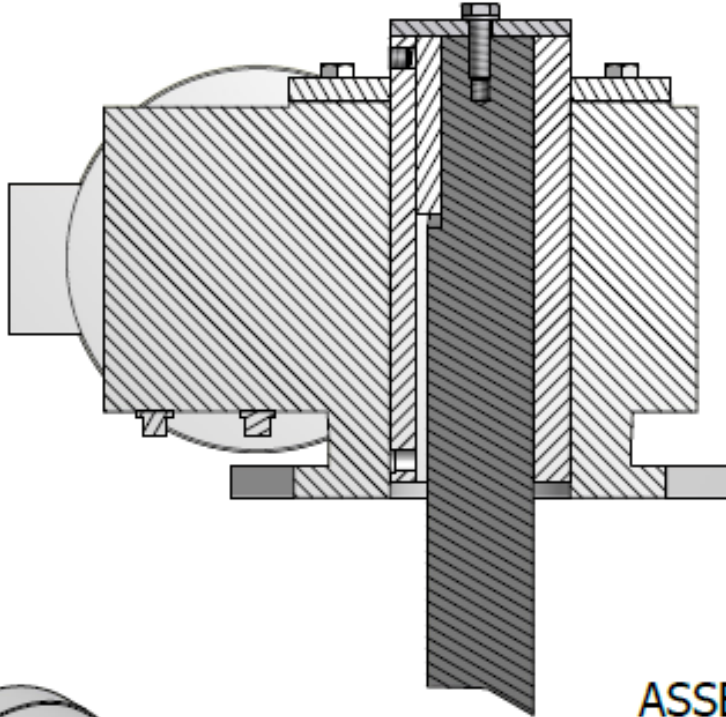


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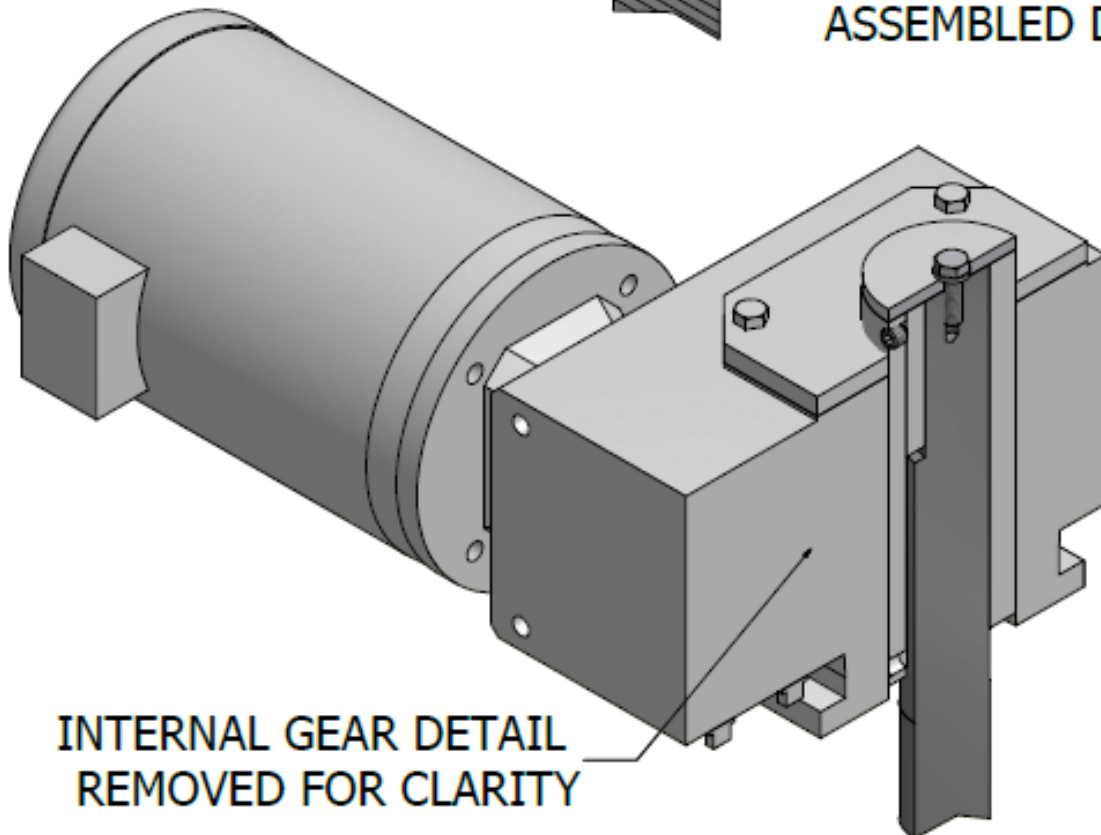
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ASSEMBLED DETAIL



**INTERNAL GEAR DETAIL
REMOVED FOR CLARITY**



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Maintenance of Mixer Drive Size 3F to 10F

1. Your UET XCEL Mixer has an air breather PORT which is either topped by a plug or sealed.

If plugged: Remove the temporary pipe plug and install the air breather that is loosely fastened to the unit.

If sealed: The air breather is attached at the factory and is sealed with a brass pin in the breather top. Lightly tap pin to puncture the seal. Repeatedly lift pin until it moves freely enough to serve as a poppet valve.

2. Refer to Figure 1 below. This shows recommended fill level for lubricant. Remove plug and check oil level.
3. For proper maintenance of new units, drain oil while warm after 1500 hours of operation. Add new oil to the recommended level.

RECOMMENDED OIL LEVELS AND CHANGES: Oil should be changed every 5,000 hours of operation, at the very least, with more frequent changes if operating in harsh environment, moisture condensation is detected in the oil or a sludge build-up is noted inside the housing.

Plug and Drain locations

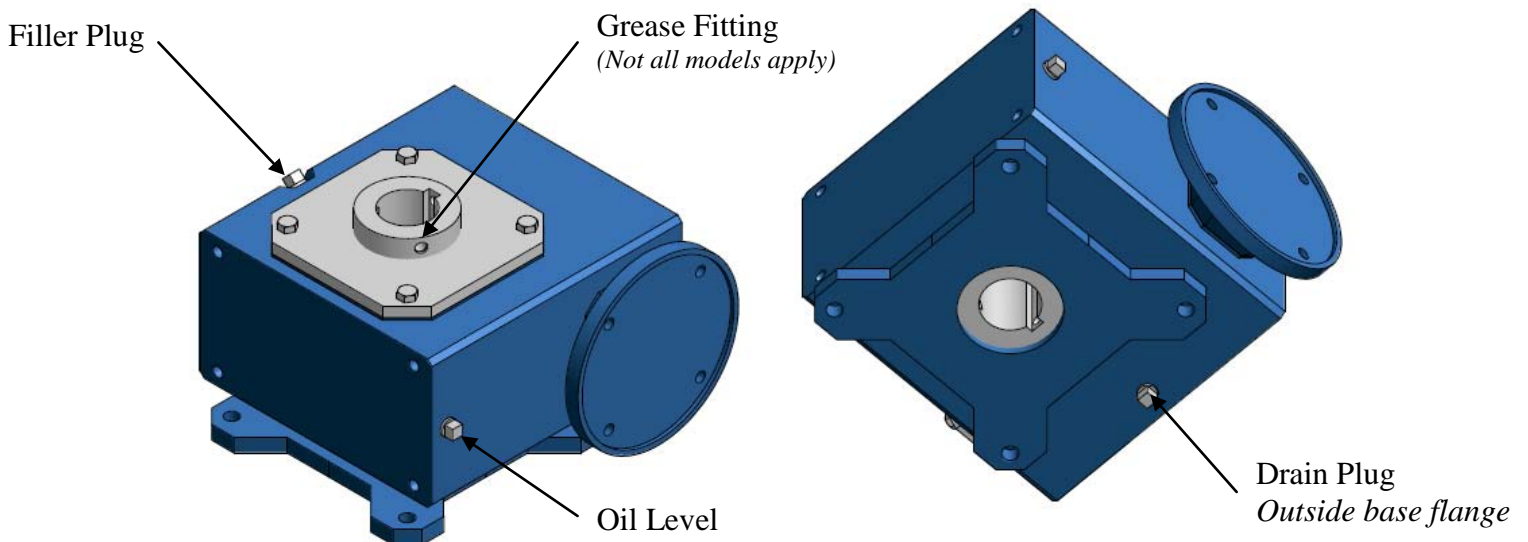


Figure 1



UET Mixers Inc.
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Lubrication of Mixer Drive Size 3F to 10F

1. Unit Lubrication

Oil Properties	
AGMA Viscosity Grade	4
ISO Viscosity Grade	150
Viscosity at SSU 104°F Cst	626-765 135-165
Manufacturer	Lubricant
Mobil Oil Corp. Or Equal	SHC629

Mixer Size	Mixer Oil Capacities	
	Oil Qty (Milliliters)	Oil Qty (ounces)
3	473	16.0
4	1360	46.0
5	1715	58.0
6	2188	74.0
8	3548	120
9	6387	216
10	9463	320

Lubricating Oils NOT Recommended—Ordinary motor oil (regardless of stated viscosity), automotive rear end oils, and EP lubricants that contain sulphur, chlorine, or phosphorus compounds (such compounds are extremely corrosive to bronze)

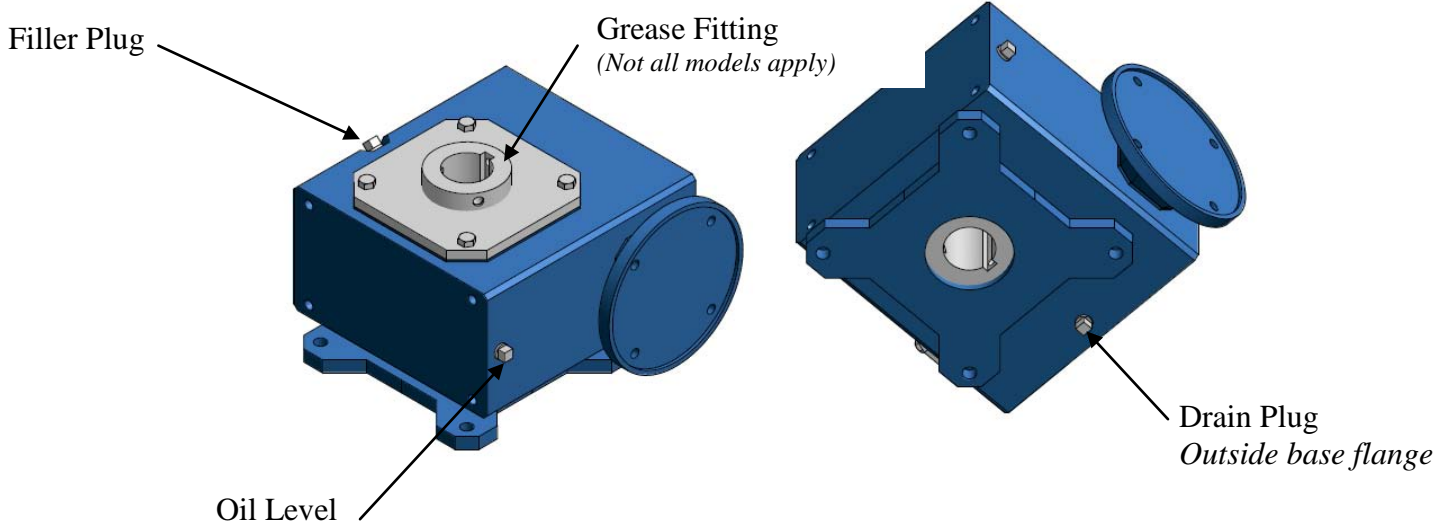
1ml = .061in³/.0019 pts/.0338 fl oz.

These are approximates. Always fill units to the level indicated by the oil level plug.

Operational Oil Temperatures – Although hot to the touch, mixer housings containing oil at temperatures of 130°F to 200°F are not uncommon and are not cause for concern. Operational temperatures above 200°F may signal a problem.

2. Grease Lubricated Bearings

Recommended Lubrication for Bearings – Bearings that are not adequately lubricated by the splash system will have grease fittings. Fiber grease with a work penetration of 310 to 340 at 77°F and an ASTM point of 350°F minimum should be used to pressure lubricate the bearings. **⚠ CAUTION! For personal protection, be sure oil has cooled to a safe temperature before performing maintenance.**





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Mixer Drive Parts Guide For Sizes 3F-10F

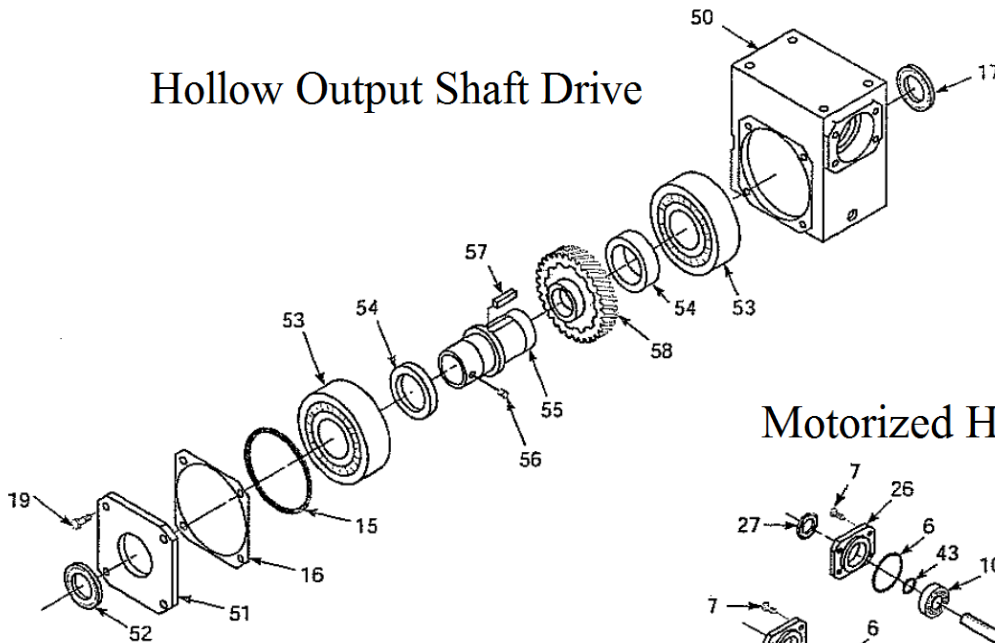
1. Preventive Maintenance Parts

Item #	Description	Quantity
41	Input Oil Seal	1
17	Output Oil Seal	1
52	Output Oil Seal	1
10	Input Bearing	1
53	Output Bearings	2
6 & 15	O-Ring Kit (1 ea. Items 6 & 15)	1 set
16	Output Cover Gasket	1

Notes:

1. Specify Model, Serial No., and Ratio when ordering any of the above parts
2. Consult with factory for current pricing & availability

Hollow Output Shaft Drive



Motorized Hollow Input Drive

