



**UET Mixers**  
c J kckukp qhF G O G  
26 Maple St.  
Mechanic Falls, ME 04256  
Tel: 207-345-3330

## **XCEL Series of Turbine Mixers**

**Bulletin 06-100**  
11/21/11  
Supersedes 01/04/05

**Page**  
**1 of 1**

### **General Troubleshooting Guide for All Mixers**

<b>SYMPTOM</b>	<b>POSSIBLE CAUSE</b>	<b>POSSIBLE SOLUTIONS</b>
<b>Noises and Vibration</b>	Mounted on poor foundation	Improve installation rigidity. Tighten foot bolts.
	Misaligned couplings	Recheck alignment.
	Loose or broken parts	Check for breaks or cracks. Tighten all bolts.
	Excessively worn gears	Check Shimming for Proper contact. Check Possible Machine Overload. Keep oil clean. Replace gears if necessary.
	Worn or faulty bearings	Check alignment, adjustment and possible overload. Clean and flush reducer, replace worn bearings and add new lubricant as required.
	Low liquid level or excessive forces in tank	Turn Mixer off and return tank level to 2' above lower impeller before resuming operation.
	Excessive backlash or shaft end play	Check for worn bearings, gears and proper shimming.
<b>Overheating</b>	Lack of, or improper lubricant	Keep oil at proper level and use recommended types. Change oil Periodically.
	Excessive churning of oil in operation	Drain excessive oil to proper level.
	Obstructed air flow	Check air supply for proper motor fan circulation. Avoid high surrounding ambient temperatures.
	Unit operating over thermal rating	Check rating with actual load.
<b>Oil Leakage</b>	Loose Covers or end plates	Check for torn gaskets. Tighten all bolts
	Worn or damaged oil seals	Replace with new seals. Avoid inserting seal over sharp edges.
	Too much oil	Check oil level. Drain to proper capacity.
	Improper venting	Replace clogged breathers.
	Foaming oil	Replace oil with proper type (non-foaming).
<b>Excessive Shaft Runout</b>	Loose bolts on coupling	Tighten all bolts.
	Misaligned coupling	Loosen all bolts, align, tighten all bolts.
	Bent shaft	Straighten or replace shaft.
	Low liquid level or excessive forces in tank	Turn mixer off and return tank level 2' above lower impeller before resuming operation.
	Worn or failed gearbox bearings	Replace bearings.
	Loose, bent, or missing impeller blade	If loose, replace and tighten all bolts. If blade is bent or missing, replace blade with proper size and type.
<b>Mixer impeller operating in wrong direction</b>	Motor is wired incorrectly	Switch any two leads in motor junction box (3 phase motors only!).

**NOTE: IF PROBLEMS PERSIST, NOTIFY YOUR LOCAL REPRESENTATIVE OR THE FACTORY IMMEDIATELY FOR ASSISTANCE.**