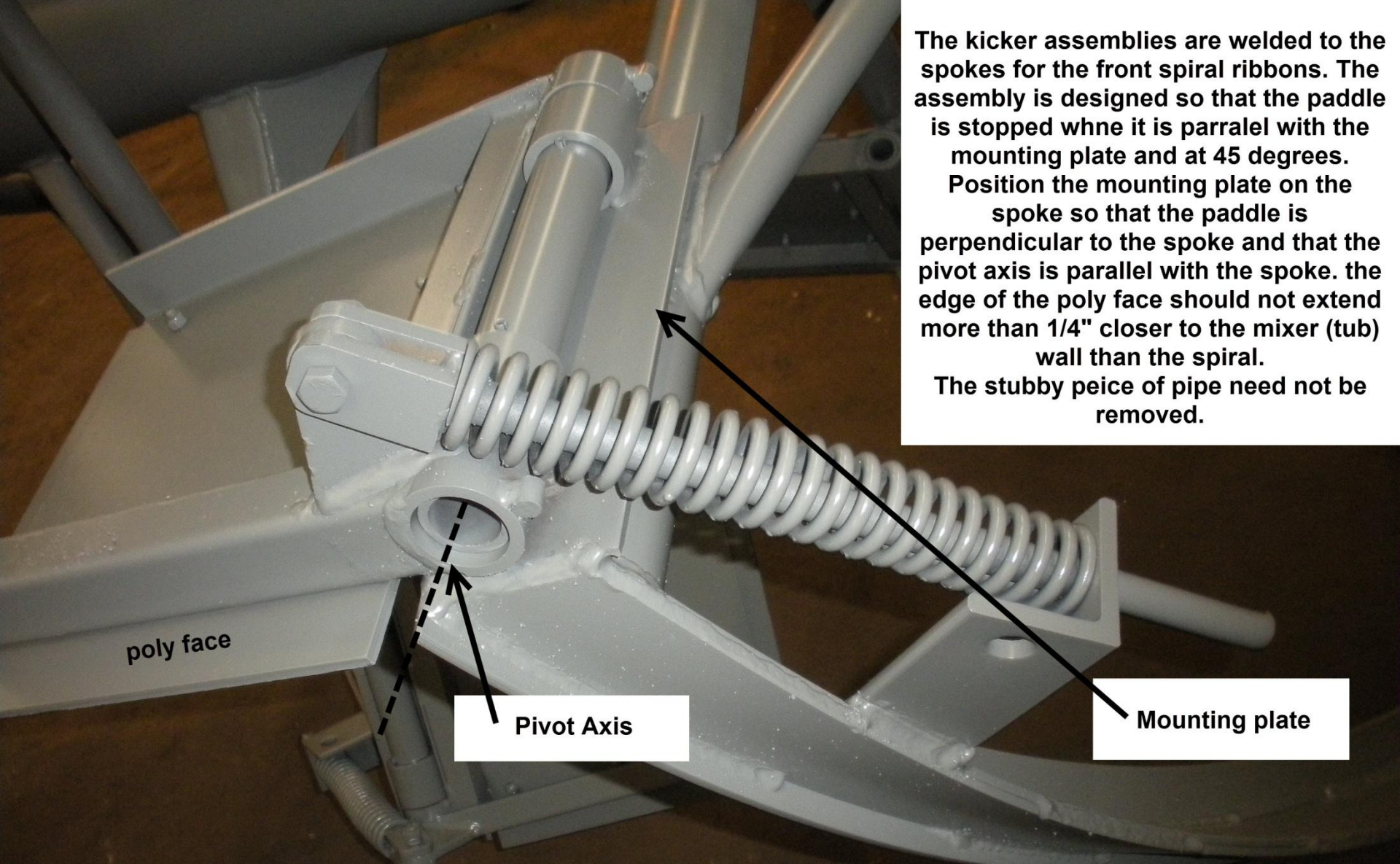


560/680 Additional Three Paddle Installation Instructions

November 29, 2017

This kit (P/N FAC 335Kit Left or Right) will add 3
of the new style paddles to pre 2017
Commercial mixers and leave in the remaining 3
paddles



The kicker assemblies are welded to the spokes for the front spiral ribbons. The assembly is designed so that the paddle is stopped when it is parallel with the mounting plate and at 45 degrees. Position the mounting plate on the spoke so that the paddle is perpendicular to the spoke and that the pivot axis is parallel with the spoke. The edge of the poly face should not extend more than 1/4" closer to the mixer (tub) wall than the spiral. The stubby piece of pipe need not be removed.

poly face

Pivot Axis

Mounting plate

OVERVIEW



The spring reaction angle should be welded to the spiral backing plate so that it is perpendicular to the spring rod and that the distance is 13.63" (5/8") between the lines shown

OVERVIEW

POSITION THE PADDLE ASSEMBLY ON THE SPOKE



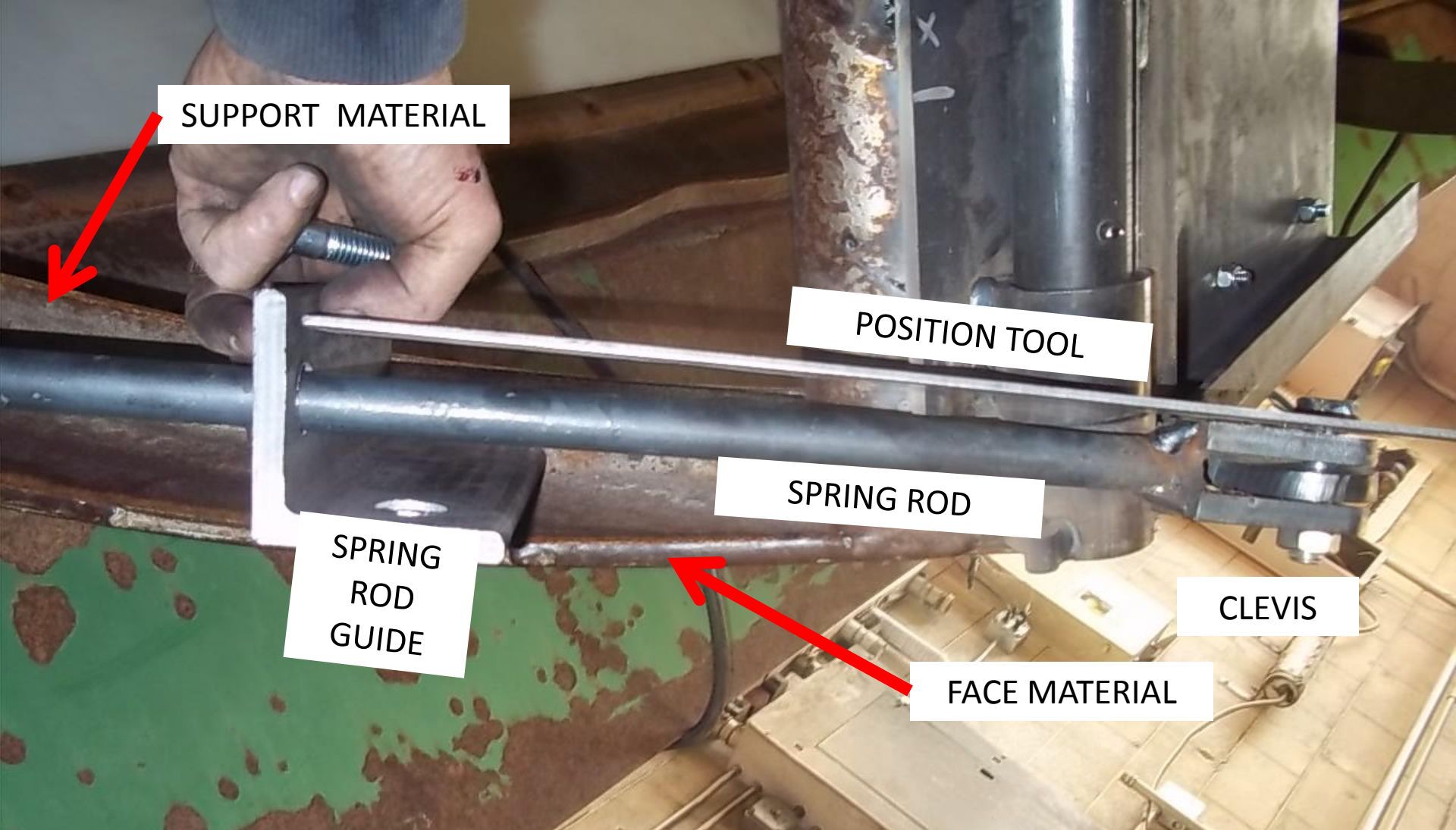


SPOKE CAP

Put the paddle assembly on the spoke and see if the paddles touch here. If they do then grind a little off the spoke cap unit the paddle moves freely.

WITH THE PADDLE ASSEMBLY LINED UP SO THAT THE PLATE IS PARALLEL WITH THE GROUND AND THE PADDLE PERPENDICULAR WITH THE SPOKE TACK THE ASSEMBLY TO THE SPOKE AND MAKE SURE YOU HAVE IT PIVOTING PARALLEL WITH THE SPOKE THEN WELD AS SHOWN IN THE IMAGE ON BOTH SIDES.





NOW POSITION THE SPRING ROD GUIDE. ATTACH THE SPRING ROD TO THE PADDLE USING THE BOLT AT THE END OF THE POSITION TOOL. THE TOOL SHOULD BE FLAT ON THE SPRING ROD GUIDE. THE SPRING ROD CLEVIS MORE OR LESS CENTERED IN THE TAB AND THE GUIDE TOUCHING BOTH THE SPIRAL SUPPORT AND FACE MATERIAL. TACK THEN REMOVE BOTH POSITION TOOL AND THE SPRING ROD AND WELD.

NOW INSERT THE SPRING ON THE SPRING ROD AND PLACE THE SPRING ROD INTO THE HOLE IN THE SPRING ROD GUIDE. ATTACHE THE SPRING COMPRESSOR TO THE CLEVIS OF THE SPRING ROD USING A ½" NUT. HOOK THE OTHER END OF THE COMPRESSOR TO THE SPRING ROD GUIDE NEAR THE SPIRAL FACE. TIGHTEN THE NUT ON THE TOOL TO COMPRESS THE SPRING. ONCE THE SPRING IS COMPRESSED ENOUGH TO INSTALL THE CLEVIS TO THE TAB ON THE PADDLE TIGHTLY ATTACH TWO VICE GRIPS TO THE SPRING ROD SO THAT THE ROD CAN NOT MOVE WHEN THE TOOL IS LOOSENED. CAREFULLY LOOSEN NUT ON THE TOOL TO RELAX IT ON THE SPRING/ROD/GUIDE ASSEMBLY. REMOVE IT AND PLACE THE CLEVIS OVER THE TAB AND INSTALL ½" BOLT. INSTALL BOTH JAM NUTS AND LOCK THEM TOGETHER.

