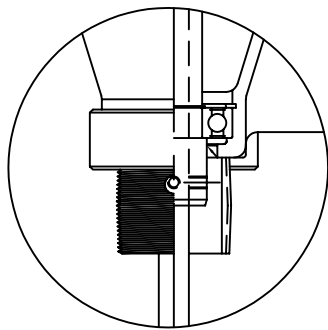


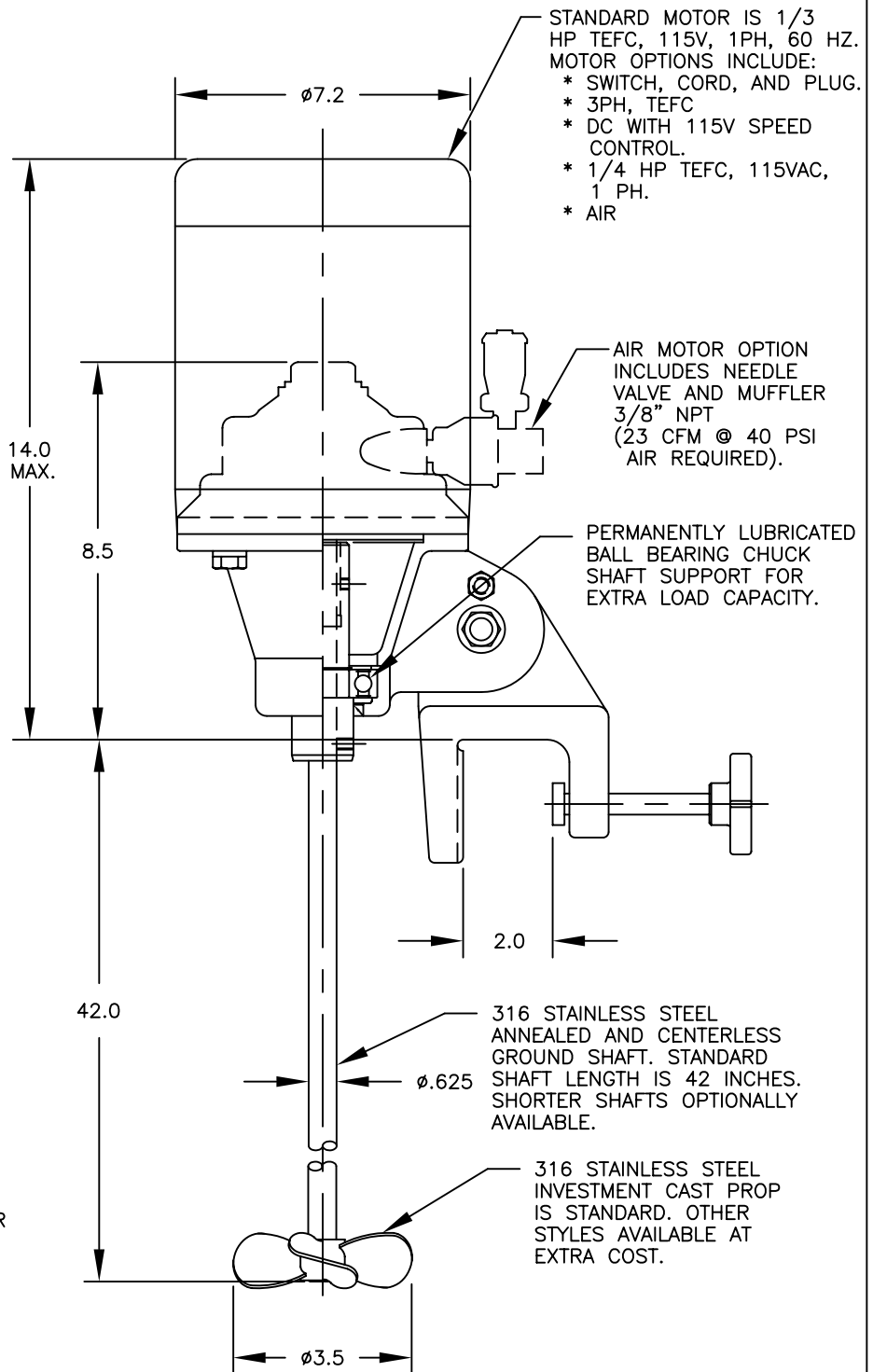
OPTIONAL MOUNTING PLATE



OPTIONAL 2" NPT DRUM ADAPTER

NOTES:

1. CLAMP AND MOUNTING PLATE MOUNTS PROVIDE 20° ANGULAR OFF CENTER MOUNTING AND 0 TO 60° VERTICAL ADJUSTMENT.
2. ALL DIMENSIONS IN INCHES.
3. APPROX. WGT: 24 LBS.



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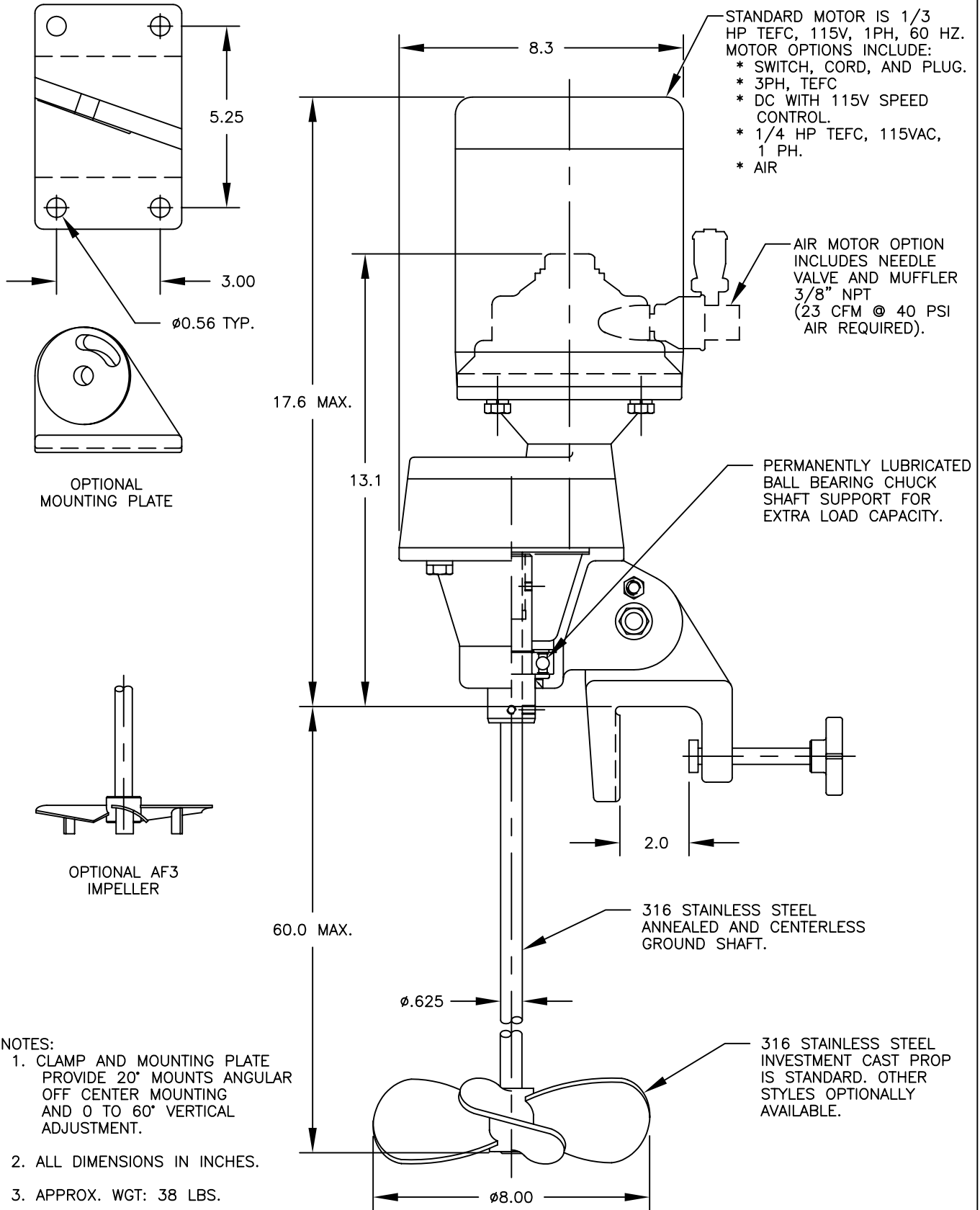
BRAUN™
MIXER, INC.
 3389 128TH AVENUE
 HOLLAND, MI. 49424
 PH. 616-399-5600
 FAX 616-399-3084

MIXER MODEL
SD25/33

DIMENSION AND ASSEMBLY DRAWING

DRAWN BY: CMW	DATE: 2-16-95	© 1995
APPROVED BY: GMc	DATE: 4-1-99	

DWG. NO. A- TK0006	REV. C
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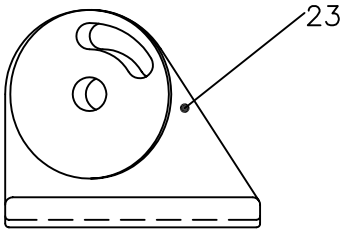
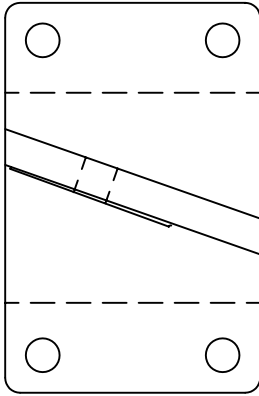
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MIXER MODEL
SG25/33

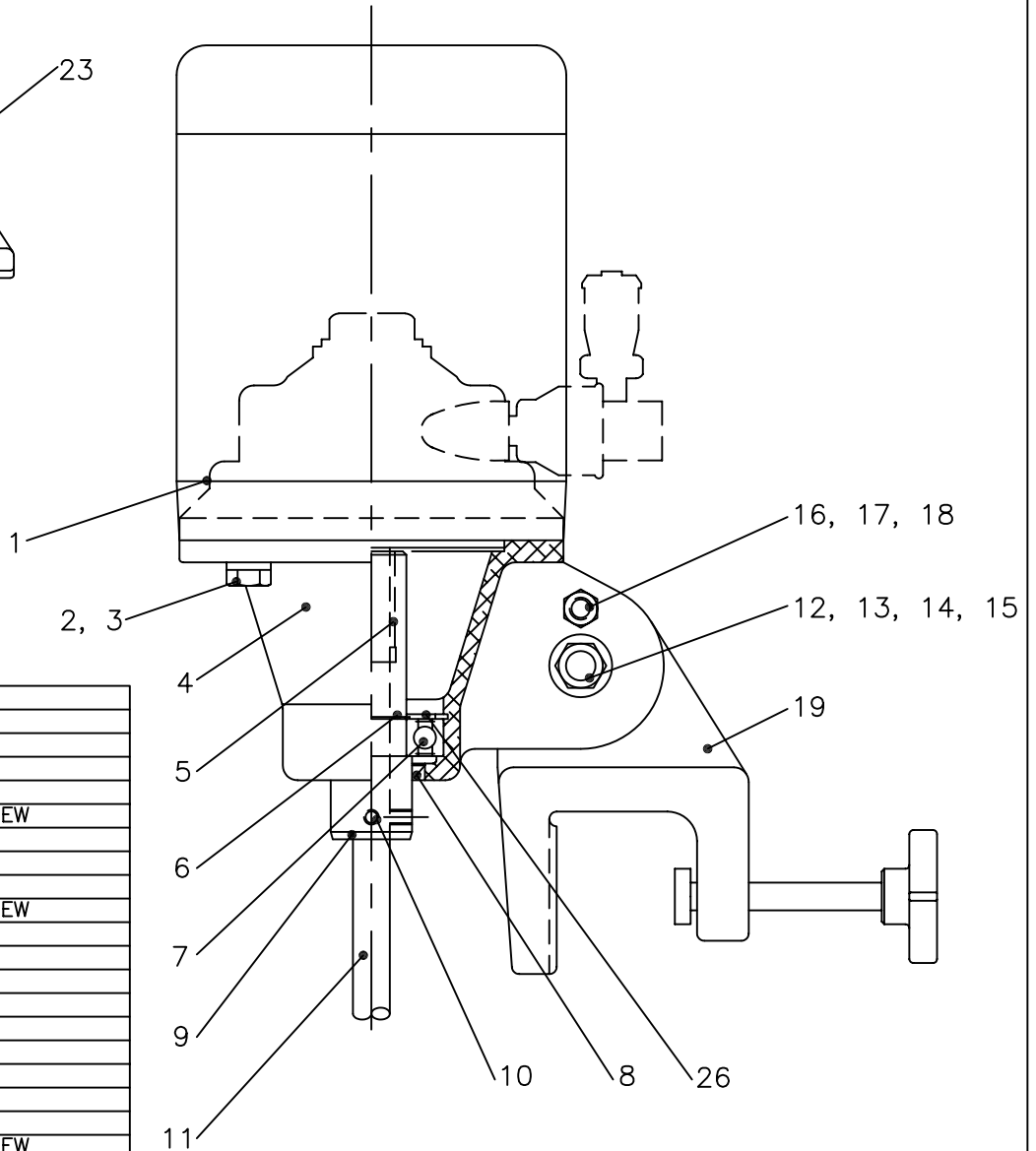
DIMENSION AND ASSEMBLY DRAWING

DRAWN BY: CMW	DATE: 2-16-95	© 1995
APPROVED BY: GMc	DATE: 4-1-99	

DWG. NO. A-	TK0007	REV. A
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OPTIONAL
MOUNTING PLATE



26	1	SNAP RING
23	1	MOUNTING PLATE
19	1	CLAMP ASSEMBLY
18	1	LOCK WASHER
17	1	FLAT WASHER
16	1	HEX HEAD CAP SCREW
15	1	HEX NUT
14	1	LOCK WASHER
13	1	FLAT WASHER
12	1	HEX HEAD CAP SCREW
11	1	MIXER SHAFT
10	2	SET SCREW
9	1	CHUCK SHAFT
8	1	LIP SEAL
7	1	BEARING
6	1	SNAP RING
5	1	KEY
4	1	BEARING HOUSING
3	4	LOCK WASHER
2	4	HEX HEAD CAP SCREW
1	1	MOTOR

ITEM NO.	QTY.	PART NAME
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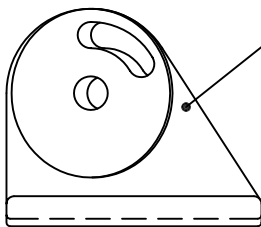
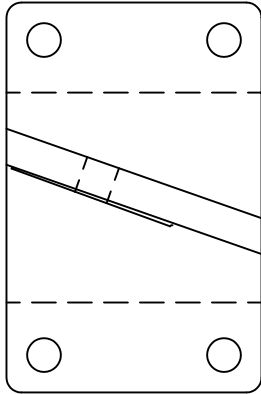
MIXER MODEL
SD25/33

DIMENSION AND ASSEMBLY DRAWING

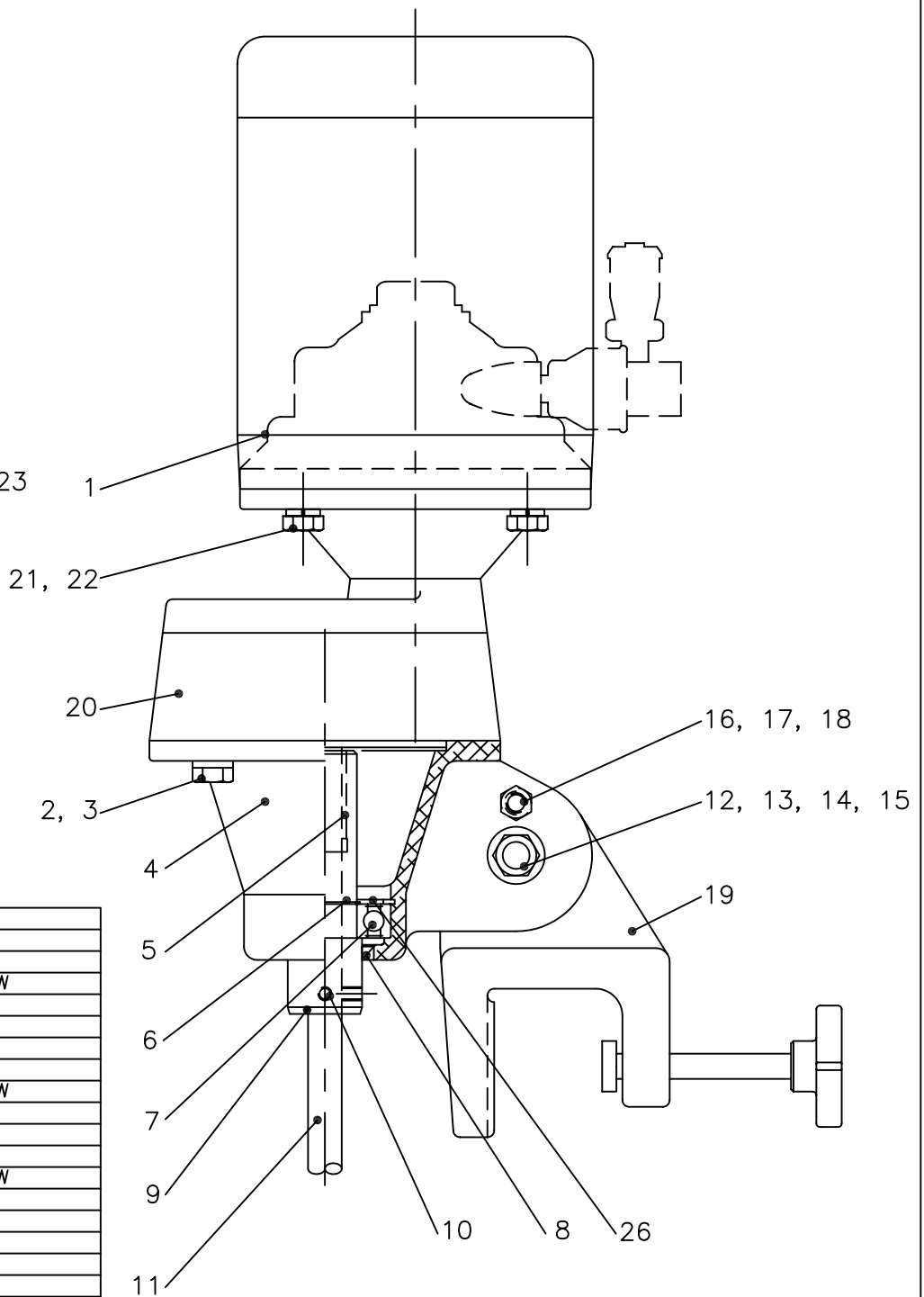
DRAWN BY: CMW DATE: 8-1-94 © 1994

APPROVED BY: DATE:

DWG. NO. **A- TK0036** REV. **A**



OPTIONAL
MOUNTING PLATE



26	1	SNAP RING
23	1	MOUNTING PLATE
22	4	LOCK WASHER
21	4	HEX HEAD CAP SCREW
20	1	GEARBOX
19	1	CLAMP ASSEMBLY
18	1	LOCK WASHER
17	1	FLAT WASHER
16	1	HEX HEAD CAP SCREW
15	1	HEX NUT
14	1	LOCK WASHER
13	1	FLAT WASHER
12	1	HEX HEAD CAP SCREW
11	1	MIXER SHAFT
10	2	SET SCREW
9	1	CHUCK SHAFT
8	1	LIP SEAL
7	1	BEARING
6	1	SNAP RING
5	1	KEY
4	1	BEARING HOUSING
3	4	LOCK WASHER
2	4	HEX HEAD CAP SCREW
1	1	MOTOR

ITEM NO.	QTY.	PART NAME
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 FAX 616-399-3084

MIXER MODEL
SG25/33

DIMENSION AND ASSEMBLY DRAWING

DRAWN BY: CMW DATE: 8-1-94 © 1994

APPROVED BY: DATE:

DWG. NO. **A- TK0037**

REV. **A**

CONTENTS

Mixer Installation / Assembly / Dimension Drawings

Safety 1
 Customer Service Contact 1
 Initial Inspection 2
 Installation 2 & 3
 Start-up 3
 Electric Motors 3 - 5
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SAFETY

The precautions mentioned in this manual are not intended to cover all hazards that may exist in a plant or on this equipment. Using safety mechanisms requires the constant attention of everyone in the vicinity of this (or any) equipment.

A plant and the related equipment are only as safe as the personnel are safety-minded. Proper equipment maintenance and the use of personal safety devices will contribute as much toward safety as will any number of mechanical safety devices.



- To assure maximum safety, optimum performance, and to gain knowledge of the product, it is essential that you or any other operator of this equipment read and understand the contents of this manual before the mixer is operated.
- Installation, operation and maintenance must be performed only by qualified personnel.
- Do not operate this equipment unless all safety devices are installed and working properly. Check all devices prior to starting the equipment.
- Disconnect and lock out electrical power before installing or servicing the mixer.
- Do not touch rotating parts (keep all guards and safety devices installed while operating).
- Develop a safety checklist for this equipment and perform regular maintenance to ensure continued

and proper operation. Develop a safety checklist for this equipment and perform regular maintenance to ensure continued and proper operation.

- Do not make any field changes or modifications without reviewing the change with your BRAWN sales representative or the BRAWN Customer Service Department.

CUSTOMER SERVICE

Mixer Model # **SD/SG-SERIES**
 Mixer Serial # _____
 Contact:
 ➤ Customer Service 616/399-5600
 ➤ E-Mail brawn@brawnmixer.com

You have received a quality engineered and manufactured BRAWN Mixer. We value your business, and we will strive to provide you with the proper service and equipment to meet your needs.

The information contained in this BRAWN Mixer Operator's Manual is designed to assist you in putting your BRAWN Mixer into operation without further delay. **Please read the entire manual before attempting to start your mixer.** If you have any further questions or if, by some chance, there are some missing components, contact your BRAWN Mixer Representative or the factory immediately.

We welcome your comments and suggestions concerning any BRAWN Mixer product. Please direct these comments in writing to the National Sales Manager at BRAWN Mixer, Inc., located in Holland, Michigan. To expedite troubleshooting service, please make your initial contact through your BRAWN Mixer Representative. If, for whatever reason, your representative cannot be reached and you have an emergency condition, please call us directly at 616/399-5600 and ask for the Customer Service Department.

Remember, you are backed by your BRAWN Mixer Technical representative and the factory support team. We are here to assist you; let us know how we can be of help.

INITIAL INSPECTION

1. Upon receipt of your Brawn Mixer, check for possible shipping damage. Report any damage immediately to the carrier and to Brawn Mixer, Inc.
2. All Brawn Mixers are shipped with the shaft and impeller(s) disassembled from the drive assembly. In addition, the clamp or cup mount and any mounting hardware for portable mixers are shipped loose.
3. Storage: Mixers should not be stored near vibrating machinery to avoid damage to the bearings. Store mixers as packaged by the factory. For longer storage periods, consult factory. If electric motors have been subjected to humid conditions, check the insulation resistance between phase and mass and between the different phases. The resistance should not be less than 100 megohms. If the resistance is less, please consult the factory. If mixer is stored for more than a year, the condition of the gear lubricant should be checked before the mixer is put in operation (see lubrication instructions).

INSTALLATION

[REFER TO ASSEMBLY / DIMENSION DRAWING]

Refer to the mixer installation / assembly drawing for important mounting structure design, assembly, mounting and dimensional data.

1. For clamp-mount units, install the mixer drive on the mounting structure and secure by tightening the clamp screw.
 - For plate-mount mixers, install the mixer drive on the mounting structure and secure with properly-sized, Grade 5 or better hardware. Torque the hardware as recommended in **TABLE 1**.
2. Inspect the impeller bore and shaft surface for evidence of damage and repair, if required, before installing the impeller(s) on the shaft or the shaft into the coupling. Install the impeller(s) on the mixer shaft by carefully sliding the impeller hub over the

shaft to its proper location and tighten the set screws. It is recommended that the shaft be spotted with a drill point at the set screw locations to prevent loosening of the impeller(s).

3. Install mixer shaft **[11]** by inserting the one end into the chuck driveshaft **[9]** until it bottoms out. (It is recommended that the mixer shaft portion engaged in chuck driveshaft be coated with an anti-seize compound.) Tighten setscrews **[10]** to secure shaft.

TABLE 1: RECOMMEND TORQUE VALUES

HARDWARE SIZE	TORQUE VALUES (FOOT POUNDS)	
	STANDARD GRADE 2 & 300 SERIES STAINLESS	HIGH STRENGTH GRADES 5 & 8
3/8-16	17	27
1/2-13	40	65

BOLT-TIGHTENING RECOMMENDATIONS:

Inadequately or improperly tightened hardware can loosen, due to vibration during mixer operation. This can result in reduced mixer life or damage to equipment. Recommended torque values for tightening all in-tank and mounting hardware are listed in **TABLE 1**. These average torque values should be considered only as a guide and not as absolute values.

The following guidelines are based on mixing in vertical cylindrical tanks with flat, dished, or shallow cone bottoms. Mixer installations may vary with tank shape, retention times, starting conditions and other requirements.

1. For liquid levels 0.5 to 1.1 times the tank diameter, a single impeller is suitable.
2. For liquid levels 1.1 to 1.6 times the tank diameter, use dual impellers.
3. Impellers may be located from 0.5 to 2.0 impeller diameters off the tank bottom, with one diameter off bottom being optimum.
4. When dual impellers are necessary, spacing between impellers should be approximately two impeller diameters with gear drives, and four to five impeller diameters with direct drive mixers.
5. Mixer position in tank should be as shown in **FIGURE A** [page 3] for maximum turnover of liquid.

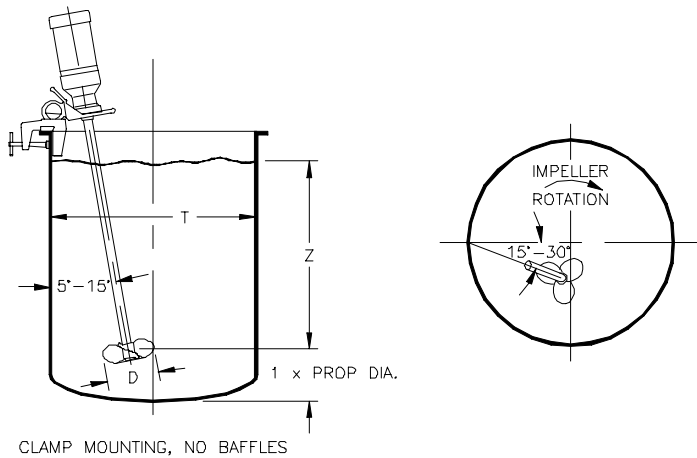


FIGURE A

START UP

1. All units are lubricated (SG series only) before shipment. The lubricant level should be checked with the unit mounted in its correct operating position. Lubricant should be added or removed to bring it to the correct level.
2. Connect the motor in accordance with the motor nameplate. The motor starter should incorporate overload protection. Before operating the mixer, jog the motor and observe mixer shaft rotation. Proper rotation is clockwise, as viewed from the top, unless otherwise noted.
3. Check all bolts and fasteners for tightness. It is good maintenance practice to recheck all bolts after two weeks of operation and periodically thereafter. Refer to **TABLE 1** for recommended torque values.
4. Do not attempt to start mixer with impellers buried in solids or solidified liquids.

ELECTRIC MOTORS

This equipment contains HAZARDOUS VOLTAGES, ROTATING PARTS AND HOT SURFACES. SEVERE PERSONAL INJURY OR PROPERTY DAMAGE CAN RESULT IF SAFETY INSTRUCTIONS ARE NOT FOLLOWED. Only qualified personnel should work on or around this equipment after becoming thoroughly familiar with all warnings, safety notices, and maintenance procedures contained herein. The successful and safe operation of this equipment is dependant upon proper handling, installation, operation and maintenance.



WARNING

Explosion-proof motors-these motors are constructed to comply with the U.L. Label Service Procedure Manual. When repairing and reassembling a motor that has an underwriter's label, it is imperative that the unit be reinspected and:

1. All original fits and tolerance be maintained.
2. All plugs and hardware be securely fastened.
3. Any parts replacements, including hardware, be accurate duplicates of the originals.

Repair work on explosion-proof motors can only be done by the original manufacturing or U.L. certified shops. Violations of any of the above items will invalidate the significance of the U.L. Label.

STORAGE

Motors must be stored in a clean, dry, well ventilated location free from vibration and rapid or wide temperature variations. If the unit is to be stored longer than three months, consult factory. Ball bearing motors are shipped from the factory properly lubricated and ready to operate. When in storage, the motor shaft must be turned several rotations every month and bearings relubricated every year. On non-explosion-proof TEFC motors, a removable plug in the bottom of the frame or housing permits removal of accumulated moisture. Drain regularly if storage atmosphere results in formation of condensation.

ELECTRIC MOTORS, Cont.**INSTALLATION**

Installation must be handled by qualified service or maintenance personal.

OPERATION**CAUTION**

Repeated trial starts can overheat the motor and may result in motor burnout. If repeated trial starts are made, allow sufficient time between trials to permit heat to dissipate from windings and rotor to prevent overheating. Starting currents are several times running currents, and heating varies as the square of the current.

After installation is completed, but before motor is put in regular service, make an initial start as follows:

1. Check motor starting and control device connections against wiring diagrams.
2. Check voltage, phase, and frequency of line circuit (power supply) against motor nameplate.
3. If possible, remove external load (disconnect drive) and turn shaft by hand to ensure free rotation. This may have been done during installation procedure; if so, and conditions have not changed since, this check may not be necessary.
 - a. If drive is disconnected, run motor at no load long enough to be certain that no unusual conditions develop. Listen and feel for excessive noise, vibration, clicking, or pounding. If present, stop motor immediately. Investigate the cause and correct before putting motor in service.
 - b. If drive is not disconnected, interrupt the starting cycle after motor has accelerated to low speed. Carefully observe for unusual conditions as motor coasts to a stop.
4. When checks are satisfactory, operate at minimum load and look for unusual condition. Increase load slowly to maximum. Check unit for satisfactory operation.

**CAUTION**

Guard against overloading. Overloading causes overheating and overheating means shortened insulation life. A motor subjected to a 10°C temperature rise above the maximum limit for the insulation may cause the insulation life to be reduced by 50%. To avoid overloading, be sure motor current does not exceed nameplate current when nameplate voltage is applied.

Electric motors operating under normal conditions become quite warm. Although some places may feel hot to the touch, the unit may be operational within limits. Use a thermocouple to measure winding temperature.

The total temperature, not the temperature rise, is the measure of safe operation. Investigate the operating conditions if the total temperature measured by a thermocouple placed on the windings exceeds:

- 230°F (110°C) for class "B" insulation
- 275°F (135°C) for class "F" insulation
- 302°F (150°C) for class "H" insulation

VOLTAGE REGULATION

Motors will operate successfully under the following conditions of voltage and frequency variation, but not necessarily in accordance with the standard established for operation under rated conditions:

1. When the variation in voltage does not exceed 10% above or below normal, with all phases balanced.
2. When the variation in frequency does not exceed 5% above or below normal.
3. When the sum of the voltage and frequency of the voltage does not exceed 10% above or below normal (provided the frequency variation does not exceed 5%).

MAINTENANCE

Failure to properly maintain the equipment can result in severe personal injury and product failure. The instructions contained herein should be carefully reviewed, understood and followed. The following maintenance procedures should be performed regularly:

1. Insulation resistance check
2. Cleaning

ELECTRIC MOTORS, Cont.

This checklist does not represent an exhaustive survey of maintenance steps necessary to ensure safe operation of the equipment. Particular applications may require further procedures

Dangerous voltages are present in the equipment which can cause severe personal injury and product failure. Always de-energize and ground the equipment before maintenance. Maintenance should be performed only by qualified personal.

The use of unauthorized parts in the repair of the equipment, tampering by unqualified personal, or removal or alteration of guards or conduit covers will result in dangerous conditions which can cause severe personal injury or equipment damage. Follow all safety instructions contained herein.

INSULATION RESISTANCE

Check insulation resistance periodically. Any approved method of measuring insulation resistance may be used, provided the voltage across the insulation is at a safe value for the type and condition of the insulation. A hand crank megger of not over 500 volts is the most convenient and safest method. Standards of the Institute of Electrical and Electronics Engineers, Inc., recommend that the insulation resistance of the stator windings at 75° C, measured at 500 volts dc, after one minute should not be less than:

$$\frac{\text{Rated Voltage of Machine} + 1000}{1000} = \text{Insulation Resistance in Megohms}$$

This formula is satisfactory for most checks. For more information, see IEEE Standard No. 43 "Recommended Practice for Insulation Resistance Testing of AC Rotating Machinery."

CLEANING



WARNING

Do not attempt to clean the motor while it is operating. Contact with rotating parts can cause severe personal injury or property damage. Stop the motor and lock out switch before cleaning.

The motor exterior must be kept free of oil, dust, water, and chemicals. For fan cooled motors, it is particularly important to keep the air intake openings free of foreign material. Do not block air outlet or inlet.

On non-explosion-proof TEFC motors, a removable plug in the bottom center of the motor frame or housing permits removal of accumulated moisture. Drain regularly.

AIR MOTORS

If your mixer was supplied with an air motor, certain precautions must be taken as follows:

1. The mixer was shipped with a needle valve installed on the motor inlet port. A muffler is provided for installation at the exhaust port. The function of the needle valve is to control the motor speed.
2. The air supply must be adequately sized to provide the proper pressure and volume of clean filtered, dry air. A pressure regulator followed by an air line lubricator is required prior to connection to the needle valve. A combination filter/regulator/lubricator is commonly used for this purpose. The air line filter should be capable of 25 micron or better.
3. Blow out the air supply line before connecting to the motor to remove any dirt or debris in the air line.
4. The exhaust port must not be obstructed such as to cause a back pressure on the motor. An obstructed exhaust has an adverse affect on the air motor. This may also cause the motor shaft seal to fail thus pressurizing the gearbox and/or mixer drive housing and causing seal failure.

LUBRICATION

The gear box (SG series only) is considered "lubricated for life". It is factory filled with an AGMA #7C gear lubricant, which is suitable for an ambient temperature range from 30 to 100 degrees F. If the application calls for outdoor installation in extremely cold or extremely warm temperatures, or in corrosive environments, consult the factory.

If it becomes necessary to change the gear lubricant, a drain plug is conveniently provided on the bottom of the gear housing under the motor pinion shaft. A fill plug is located on the top of the housing, above the output gear. Refill with 10 ounces of the recommended lubricant.



CAUTION

In the Food and Drug Industry (including animal food), consult the lubrication supplier for recommendation of lubricants which are acceptable to the Food and Drug Administration and/or other authoritative bodies having jurisdiction. Factory supplied oil is not suitable for these applications or this industry.

STORAGE

Units shipped from Brawn Mixer, Inc. are intended to be used within 30 days after receipt and presumed to be stored indoors in a heated building. Store mixers as packaged by the factory. If you intend storing units under adverse conditions or for a long period of time, special storage precautions will be necessary.

1. Store in a sheltered area away from chemical vapors or steam.
2. Cover.
3. Do not store in sunlight or near high heat.
4. Spray oil on exposed shafts and seals. Remove oil on start-up.
5. Rotate output shaft 360° every 3-4 weeks.
6. Mixers should not be stored near vibrating machinery to avoid damage to the bearings.
7. If electric motors have been subjected to humid conditions, check the insulation resistance between phase and mass and between the different phases. The resistance should not be less than 100 megohms. If the resistance is less, please consult the factory.

WARRANTY

WARRANTY: All equipment or parts covered by this manual are guaranteed free from defective material and workmanship for a period of twelve (12) months from date of shipment, under normal use and service. This warranty does not cover failure of normal wear parts unless the failure of such part has resulted from defective material and workmanship. BRAWN Mixer, Inc. will repair or replace, at its option, any equipment which has been found to be defective and is within the warranty period, provided that the equipment is shipped, with previous factory authorization, freight prepaid, to BRAWN's plant in Holland, Michigan, USA. All return shipments are made FOB BRAWN's factory. BRAWN is not responsible for removal, installation, or any other incidental expenses incurred in shipping the equipment to or from BRAWN. In the case of components purchased by BRAWN Mixer, Inc. and incorporated in the equipment, the component manufacturer's guarantee shall apply. NOTE: Any modifications or corrective work done to the equipment which were not specifically authorized in writing by BRAWN Mixer, Inc. shall void this limited warranty, and BRAWN Mixer, Inc. shall accept no liability for any of the corrective work or expenditures which were conducted without their prior, written authorization. BRAWN Mixer, Inc. shall not be held liable for any further cost, expense, or labor to replace equipment or replaceable parts, or indirect or consequential damages.

With the exceptions of the limited warranty set out above, there are no other understandings, agreements, representatives, or warranties implied (including any regarding the merchant-ability or fitness for a particular purpose), not specified herein, respecting this agreement or equipment, hereunder. This contract states the entire obligation of BRAWN Mixer, Inc. in connection with this transaction.

SHOULD WE MAKE A MISTAKE...**BRAWN Mixer, Inc.'s
Direct Returns Policy**

To ensure proper handling of your return, please take a moment to read the following:

- **ALL** returns require a **RETURN GOODS AUTHORIZATION (RGA) NUMBER**. We are unable to process your return or issue proper credit without an approved **RGA** number.
- **ALL** returns must be **COMPLETE**, including all original warranties, manuals, documentation and packaging.
- **ALL** product must be received within 14 days of issuing an **RGA** number.

How to Return Product

You must have a **RETURN GOODS AUTHORIZATION (RGA)** number before you return any product to BRAWN Mixer, Inc. To obtain this number, call **616/399-5600** and ask for Customer Service. Be sure to have available the following information:

- ✓ your order number
- ✓ the BRAWN product serial number
- ✓ the part number and description of the product
- ✓ the reason for the return

◆ IMPORTANT ◆

The Return Goods Authorization number must be written clearly on all boxes being returned. C.O.D. shipments will not be accepted.