

TABLE FOR KEY

SHAFT DIA.	KEY
1.500	3/8 x 3/8
1.688	3/8 x 3/8
1.875	1/2 x 1/2
2.188	1/2 x 1/2
2.375	5/8 x 5/8
2.562	5/8 x 5/8
2.750	5/8 x 5/8
6.250	1-1/2 x 1-1/2
6.625	1-3/4 x 1-1/2
7.375	1-3/4 x 1-1/2
7.625	2 x 1-1/2
8.625	2 x 1-1/2

DIMENSIONS IN INCHES

SIZE	SHAFT (ratio)																				QTY.	LANTERN		WT. (LBS)	OIL (GAL.)		FLANGE COUPLING STANDARD															
	a ₁	a ₂	b ₁	b ₂	b ₃	c ₁	d ₁ * (20-71)	l ₁	d ₁ * (80-90)	l ₁	d ₂ * (20-35.5)	l ₂	d ₃	d ₄	e ₁	e ₃	E	G ₁	G ₂	h ₂		h ₃	H		m ₁	m ₂	m ₃	m ₄	n ₁	s ₁	Q ₃	d ₇	d _a	d ₆	h ₅	c ₂	k	s ₂	QTY.	z	WT.	
280	33.66	45.55	25.75	20.87	23.62	2.95	1.875	3.12	1.500	2.38	6.250	10.63	14.96	21.654	2.36	7.68	25.00	17.52	9.65	11.52	3.44	17.32	11.42	17.32	-	19.68	8.07	1.89	6	-	2822	9.5	17.32	12.441	22.44	2.36	15.551	.87	15	.20	325	
320	38.78	51.97	29.92	23.62	26.38	3.35	1.875	3.12	1.688	2.75	6.625	10.63	14.96	21.654	2.36	8.46	28.54	19.09	10.83	12.79	3.74	19.29	13.38	19.68	-	22.05	9.055	1.89	6	26.9	-	3749	8.7	17.32	12.441	23.62	2.36	15.551	.87	15	.20	368
360	41.93	57.48	32.88	26.77	29.53	3.75	2.375	4.12	1.875	3.12	7.375	12.20	18.11	25.200	3.94	9.25	31.89	21.06	12.21	14.27	4.23	21.06	13.98	21.65	-	24.80	10.04	2.20	6	-	4630	6.5	19.09	13.583	26.97	2.36	17.126	1.02	15	.20	480	
400	46.46	63.54	36.14	28.74	31.50	3.74	2.562	4.12	2.188	3.56	7.625	12.20	18.11	25.200	3.94	10.04	35.43	24.69	14.17	15.94	4.53	24.21	16.34	24.02	-	26.77	11.22	2.68	6	-	6283	18	19.09	13.583	28.94	2.66	17.126	1.02	15	.20	512	
450	52.76	71.02	40.08	32.28	36.22	3.94	2.750	4.75	2.375	4.12	8.625	13.78	21.26	27.953	3.94	11.02	39.96	26.06	16.34	17.72	4.72	26.46	22.05	3.54	31.89	10.236	1.89	12	-	7826	30	21.65	15.354	33.07	2.76	19.094	1.30	15	.20	672		

* Shaft diameters through 1" are held to limits of +.0000/-0005
 over 1" - 7" +.000/-001
 and over 7" +.0000/-0015

- NOTES:
 1. THIS DRAWING IS NOT TO BE USED FOR DESIGN UNLESS CERTIFIED.
 2. EPOXY PAINT.

CERTIFIED DRAWING
 FOR EIMCO PROCESS MACHINERY
 ORDER NO. B21640
 FLENDER ORDER NO. 041-808-273
 CERTIFIED BY P. LANGE
 DATE 10-12-88
 DIMENSIONS ARE BINDING FOR THIS ORDER

DRIVEN 190/890 RPM DRIVEN 32.6/24.5 RPM
 SERVICE RATING 100 HP
 CATALOG RATING 244 HP
 OIL CAPACITY 8.7 US GAL
 OIL VISCOSITY AT 100°F (38°C) 1100

SCALE NONE
 WEIGHT (LB) SEE CHART

DATE 10-12-88
 DRAWN BY
 CHECKED BY
 NAME OF PART
 DATE DEPT BY

FLENDER CORPORATION
 P.O. BOX 1449, ELGIN, IL 60120

AERATOR DRIVE
 TYPE: XSBN SIZE: 320
 SIZE TYPE DRAWING NO. SK02841
 MADE FROM SUPERSECES



**FLENDER
BOCHOLT**

Installation and maintenance
instructions for N-EUPEX couplings
Types A,B,D,E,F,G,H,K,L,M,O and P

**V 420
EN 12.83**

1. General information

- 1.1. N-EUPEX couplings are suitable for clockwise and counter clockwise rotation as well as for reversing operation.
- 1.2. Mounting of coupling parts on the shaft ends to be connected is optional.
- 1.3. A remaining gap between coupling part and shaft collar can be filled by a sleeve; but this is not essential for proper functioning of the coupling.
- 1.4. To ensure that coupling flexibles can be replaced without moving connected machines (possible only with types A, D, F and K) dimension P is listed in table 4.I, must be taken into account.
- 1.5. If required, we supply N-EUPEX couplings with finished bores, ready for mounting.

2. Safety precautions

- 2.1. Rotating parts should be guarded to prevent accidents, taking account of applicable local accident prevention regulations.

3. Finish boring of couplings supplied with rough bores, machining tapped holes for set screws

- 3.1. The maximum bore diameters D listed in our brochure K 420, must not be exceeded.
- 3.2. When finishing rough bores, the surfaces on page 2 marked with heavy lines (—) should be used as reference faces for correct bore concentricity.
- 3.3. In a drive type fastening with parallel key we recommend the following bore tolerances for given shaft limits:

Shaft tolerances					recommended bore tolerances
h6	h8	k6	m6	n6	
		Diameter in mm			
			>25		H7
		≤50			H7
				>100	H7
≤50					K7
>50					M7
	all				N7

- 3.4. For extraordinary operating conditions e. g. reversing under load, a tighter fit and keyway width according to ISO P9 tolerances or taper key stress type fastening should be provided.
- 3.5. Allocation of set screws to bore diameters:

Bore dia. over		10	12	17	22	30	38	44	50	58	65	75	85	95	110	130	150	170	200	230
to	10	12	17	22	30	38	44	50	58	65	75	85	95	110	130	150	170	200	230	

Threaded hole for set screw

N-EUPEX size

58, 68, 80

M6

95, 110

M8

125, 140, 160

M10

180, 200

M12

ab 225

M8

M10

M12

M16

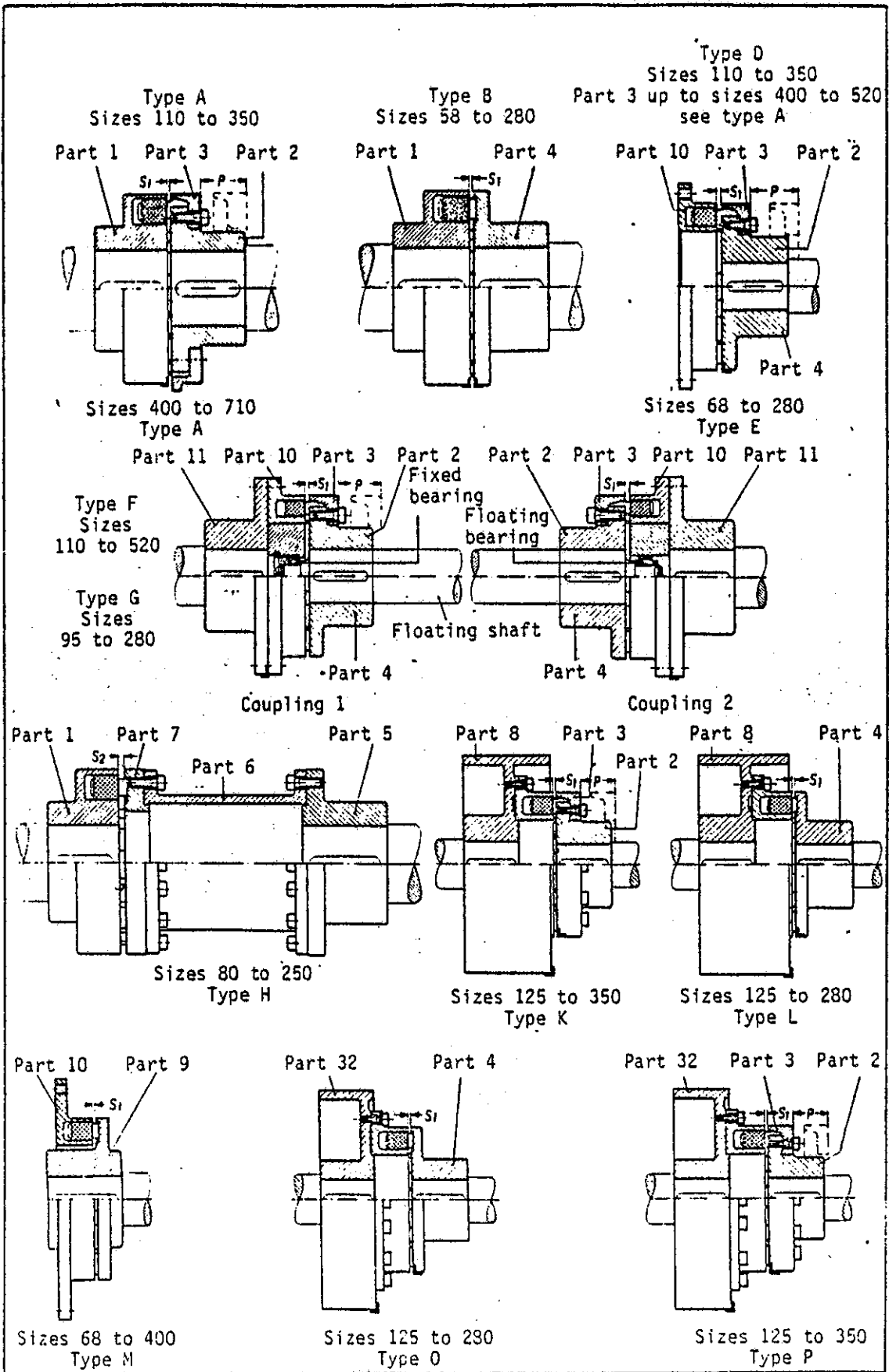
M20

M24

- 3.6. For sizes 58, 68, 80, 95 and 110 set screw holes must be located opposite keyway, this is also required for part 9 of sizes 125 and 140.

4. Mounting

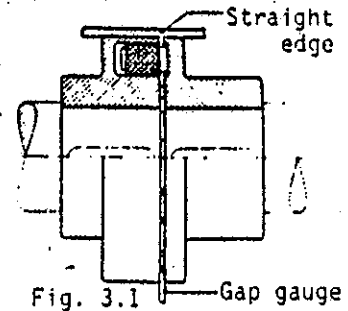
- 4.1. Before mounting the hubs, carefully clean shaft ends and coupling parts.
- 4.2. The coupling hubs should preferably be mounted with the aid of special tools which are available for this purpose; inside hubs to be flush with the shaft ends. Tighten set screw to secure axially.
- 4.3. Tighten set screws only with hexagon pin spanner according to DIN 911 without extension piece.
- 4.4. Heating of coupling parts will facilitate mounting, but the flexible elements must be removed first from coupling part 1.



- 4.5. Part 6 of type H is marked on one face with an "O". This is the connecting face to part 5.
- 4.6. Bring the coupling hubs together, taking care to observe dimension S_1 or S_2 respectively according to table 4.I.
- 4.7. Check all screw connections with screw tightening torques of table 4.I.

5. Alignment

- 5.1. N-EUPEX couplings will absorb deviations in the relative position of shafts to be connected (see section 6.).
- 5.2. When aligning the coupling halves, the angular and parallel offset misalignments of shafts relative to each other should be as small as possible. Alignment to be carried out in two planes as shown in fig. 3.1 with a straight edge (offset misalignment) and spacer bar (angular misalignment). A dial indicator will give greater accuracy.



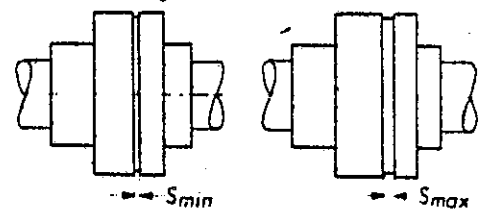
- 5.3. The gap dimension S_1 and S_2 respectively must be within the limits listed in table 4.I.

6. Possible misalignment

- 6.1. For types A, B, D, E, F, G, K, L, M, O, P, the permissible axial movement ΔK_a (fig. 3.2) is determined with:

$$\Delta K_a = S_{max} - S_{min}$$

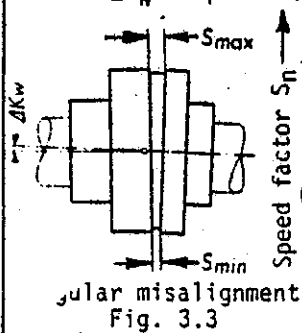
Axial movement ΔK_a of type H coupling parts relative to each other, are possible within the permissible limits for dimension S_2 listed in table 4.I.



Axial movement

Fig. 3.2

- 6.2. Angular misalignment ΔK_w (fig. 3.3) is measured as the difference between S_{max} and S_{min} . Possible values are listed in table 4.I referred to a speed of 1500 r.p.m. For differing speeds the permissible angular misalignment is calculated thus: $\Delta K_w = \Delta K_r \cdot S_n$ (for factor S_n see fig. 3.4).
- 6.3. See table 4.I for parallel offset misalignment ΔK_r (fig. 3.5) values referred to a shaft speed of 1500 r.p.m. For different speeds multiply ΔK_r with factor S_n (fig. 3.4).
- 6.4. Angular and parallel offset misalignment can occur at the same time. The sum of both misalignments should not exceed the values for ΔK_r or ΔK_w respectively.



Angular misalignment
Fig. 3.3

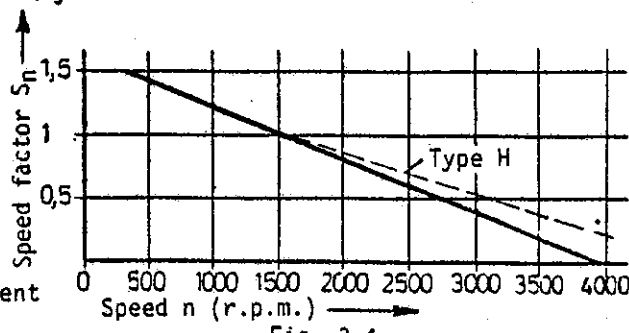
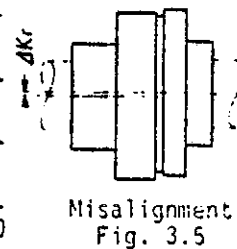


Fig. 3.4



Misalignment
Fig. 3.5

7. Operation

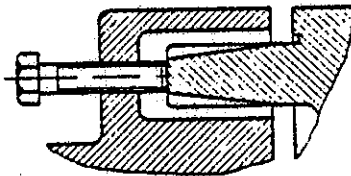
- 7.1. Before commencing initial operations check alignment and gap dimension S_1 or S_2 respectively and if necessary make corrections, further check screw connections. For screw tightening torques see table 4.I.

8. Maintenance

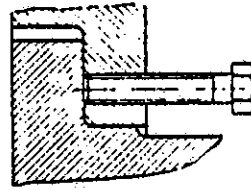
- 8.1. N-EUPEX couplings do not require any regular maintenance except for an occasional check on the torsional play or backlash between the driving and the driven halves. When N-EUPEX couplings are used in drives which do not require a minimum of torsional play or backlash in the coupling, the coupling flexibles can be allowed to wear down to 2/3 of their original thickness before they need replacing.

1. Replacing of flexibles

- 3.1. Uninterrupted torque transmission and reliability of operation cannot be guaranteed unless original N-EUPEX flexibles are used.
- 9.2. With the exception of types B, E, L, M and O, the flexibles can be replaced without moving connected shafts or machines.
- 9.2.1. Types A, D, F, K and P: After loosening screw connection 2/3, part 3 can be moved axially and the flexibles are freely accessible. In order to ease separation of the coupling parts, part 1 of coupling sizes 225 - 400 is provided with tapped holes for forcing screws. From size 440 up these tapped holes are located in coupling part 3 (see figs. 4.1 and 4.2).



Size 225 - 400
Fig. 4.1



Size 440 - 710
Fig. 4.2

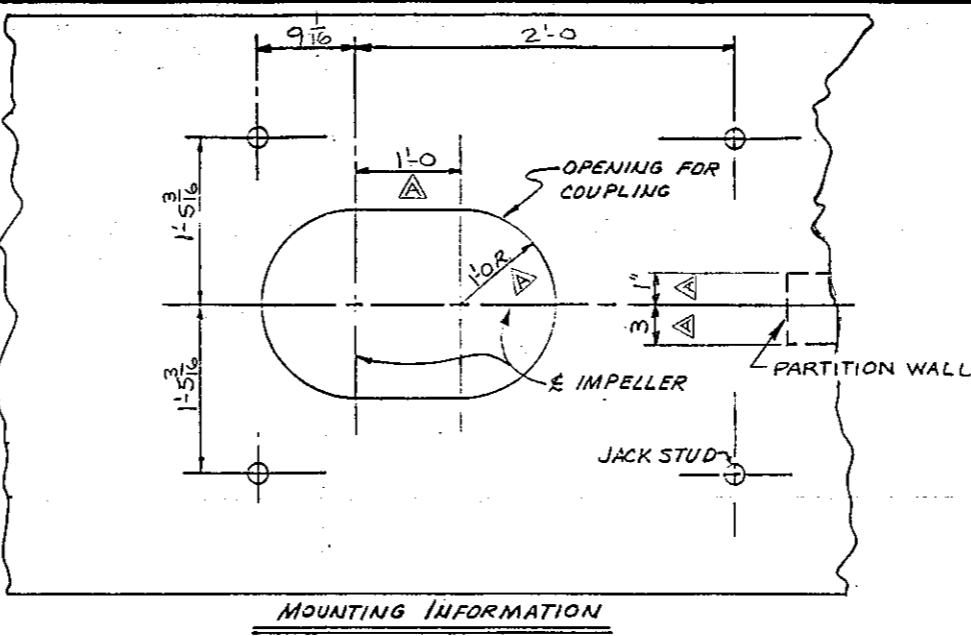
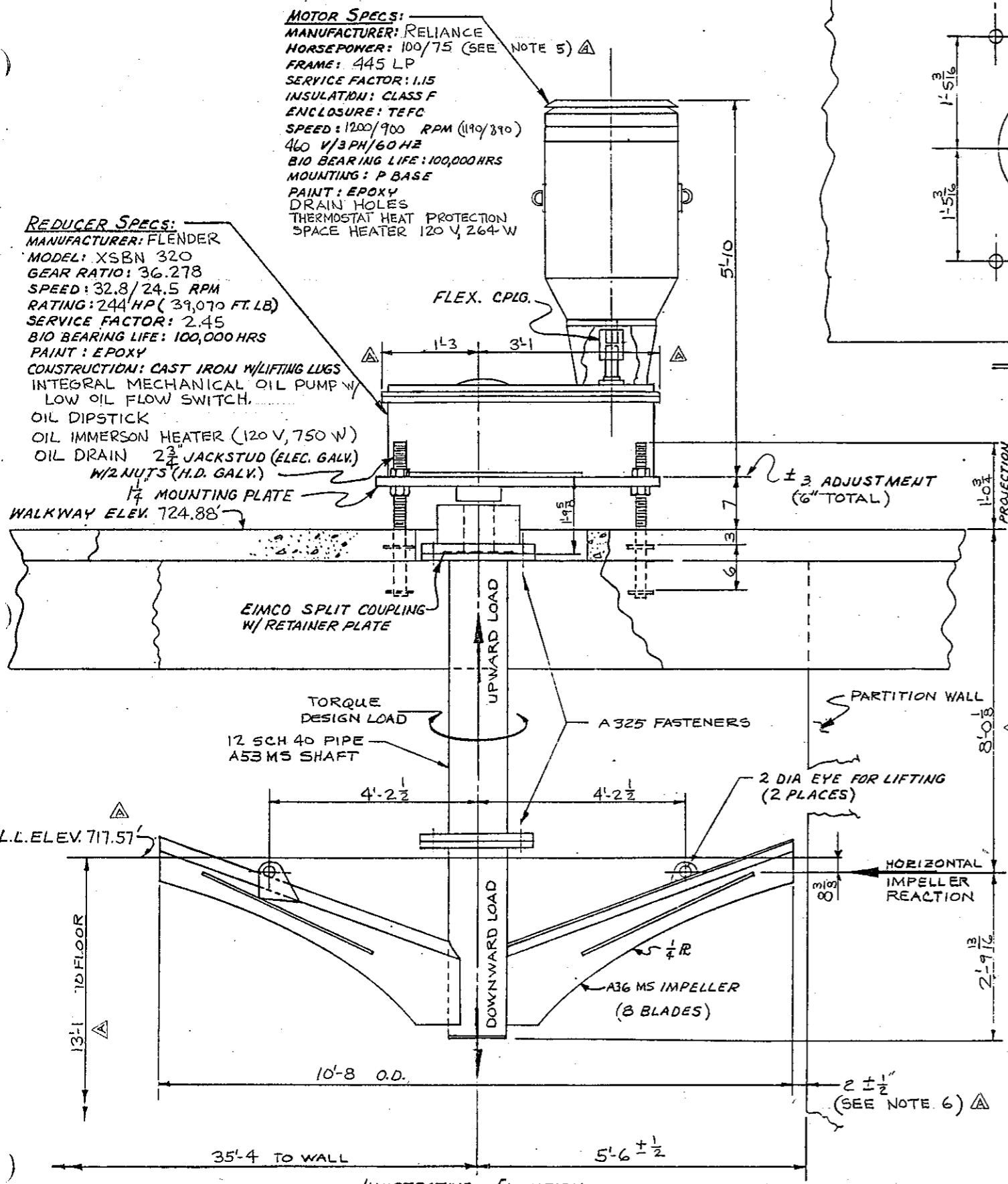
- 9.2.2. Type G: Loosen flange connection part 10/11 and the floating shaft with mounted coupling parts can be removed radially. Using suitable tools, part 10 can be pulled off from the floating bearing side. On the other side, the fixed bearing side, remove first the retaining ring from the floating shaft and after that, part 10 can be dismantled complete with ball and socket joint.
- 9.2.3. Type H: Loosen screw connections and force parts 5 and 7 out of their centerings with the help of forcing screws in part 6. Push part 7 as far as possible into part 1. Part 6 can now be removed radially. Bring part 7 back out of part 1; the flexibles are freely accessible now.
- 9.3. After fitting new flexibles, reassembly in reverse order. Before starting up take note of sections 4., 5., 6. and 7.

Table 4.1

Coupling size	S ₁ mm	S ₂ mm	perm. deviation S ₂ mm	Cap and P mm	Cap screw tightening torque T _A and width between flats S _w for socket head cap screws		Angular misalignment ΔK _w S _{max} - S _{min} at n = 1500 r.p.m. mm	Offset misalignment ΔK _r mm
					Part 2/3 Part 5/6 Part 6/7	Part 8/10 Part 10/11 Part 10/32		
58	2.. 4						0.10	0.10
68	2.. 4						0.11	0.11
80	2.. 4	5	+1		10		0.13	0.13
95	2.. 4	5	+1		10	5	0.15	0.15
110	2.. 4	5	+1	33	14	6	0.18	0.18
125	2.. 4	5	+1	38	17.5	6	0.21	0.21
140	2.. 4	5	+1	43	29	8	0.24	0.24
160	2.. 4	6	+1	47	35	8	0.27	0.27
180	2.. 6	6	+1	50	44	8	0.30	0.30
200	2.. 6	6	+1	53	67.5	10	0.34	0.34
225	2.. 6	6	+1	61	89	10	0.38	0.38
250	3.. 8	6	+1	69	145	14	0.42	0.42
280	3.. 8			73	185	14	0.47	0.47
315	3.. 8			78	200	14	0.52	0.52
350	3.. 8			83	260	17	0.56	0.56
400	3.. 8			88	340	17	0.65	0.65
440	5.. 10			99	420	17	0.72	0.72
480	5.. 10			104	550	19	0.78	0.78
520	5.. 10			115	670	19	0.85	0.85
560	6.. 12			125	710	19	0.92	0.92
610	6.. 12			135	1450	22	0.99	0.99
660	6.. 12			145	1450	22	1.05	1.05
710	6.. 12			155	1450	22	1.15	1.15

MOTOR SPECS:
 MANUFACTURER: RELIANCE
 HORSEPOWER: 100/75 (SEE NOTE 5) Δ
 FRAME: 445 LP
 SERVICE FACTOR: 1.15
 INSULATION: CLASS F
 ENCLOSURE: TEFC
 SPEED: 1200/900 RPM (1190/890)
 460 V/3 PH/60 HZ
 B10 BEARING LIFE: 100,000 HRS
 MOUNTING: P BASE
 PAINT: EPOXY
 DRAIN HOLES
 THERMOSTAT HEAT PROTECTION
 SPACE HEATER 120 V, 264-W

REDUCER SPECS:
 MANUFACTURER: FLENDER
 MODEL: XSBN 320
 GEAR RATIO: 36.278
 SPEED: 32.8/24.5 RPM
 RATING: 244 HP (39,070 FT.LB)
 SERVICE FACTOR: 2.45
 B10 BEARING LIFE: 100,000 HRS
 PAINT: EPOXY
 CONSTRUCTION: CAST IRON W/LIFTING LUGS
 INTEGRAL MECHANICAL OIL PUMP W/
 LOW OIL FLOW SWITCH,
 OIL DIPSTICK
 OIL IMMERSION HEATER (120 V, 750 W)
 OIL DRAIN 2 1/2" JACKSTUD (ELEC. GALV.)
 W/2 NUTS (H.D. GALV.)
 1/4" MOUNTING PLATE
 WALKWAY ELEV. 724.88



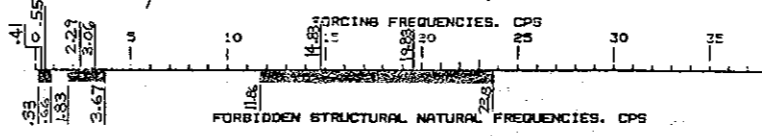
100/75 HP AERATOR
 Dead Weight = 10,225 lb
 Torque Design Load = 26,740 ft-lb (1.57 x F.L. Torque)

LOAD DIRECTION	OPERATING SHOCK LOAD	RECOMMENDED STATIC DESIGN LOAD
Upward (Normal Operation)	3470 lb	7800 lb
Downward (Start-up only)	2430 lb	3250 lb
Horizontal - Impeller Reaction	1080 lb	3240 lb
Causing this Bending moment at the Gear Reducer	9299 ft-lb	27,896 ft-lb

The "Horizontal - Impeller Reaction" is a radial force acting in a random direction at the top of the impeller cone. This force causes a "Bending Moment" at the top of the mounting plate. This moment is reacted to the platform through the gear reducer, mounting plate and jack studs.

STRESSES: We strongly recommend the stresses in the platform be no greater than the allowable values for fatigue per the following references:
 1. Steel Platforms - AISC Manual of Steel Construction, latest edition.
 2. Concrete Platforms - ACI Building Code for Concrete or Superseeding Specifications.

NOTE: The Consulting Engineer should check to be sure that the aerator mounting structure does not have torsional, lateral or vertical natural frequency modes within 80% to 120% of the motor (full load) running speed (19.83/14.23 CPS), the impeller shock load frequency (3.06/2.29 CPS) or the shaft running speed (1.55/.41 CPS).



- NOTES:**
- SEE DRAWING 23766B202 FOR ADDITIONAL INFORMATION.
 - EIMCO WILL FURNISH (6) SIX AERATORS AS SHOWN AND NOTED TO ROTATE CLOCKWISE.
 - IMPELLER SUBMERSION AS SHOWN IS FOR INITIAL INSTALLATION. FIELD TEST WILL DETERMINE FINAL SETTING.
 - BASIN ORIENTATION NOT SHOWN, PLANS WHERE NOT FURNISHED.
 - IMPELLER WILL ACTUALLY PULL 100 H.P. WHEN ROTATED AT 32.8 RPM & 52 HP WHEN ROTATED AT 24.5 RPM. MOTORS ARE CAPABLE OF 100 HP @ 1200 RPM & 75 HP @ 900 RPM.
 - WALL CLEARANCE OF 2" +/- 1/2" IS CRITICAL AND MUST BE HELD.

THIS DRAWING IS CERTIFIED FOR
 CUSTOMER: ELLISON INDUSTRIES/LACKLAND CITY WATER CO.
 CUSTOMER ORDER NUMBER: LW 23592
 EIMCO ORDER NUMBER: 23766-02
 PROJECT: MEDIO CREEK STP
 PROJECT LOCATION: SAN ANTONIO, TEXAS
 CONSULTING ENGINEER: VICKREY & ASSOCIATES
 BY: [Signature] DATE: 6-29-88
 EIMCO PROCESS EQUIPMENT COMPANY

ENVIROTECH EIMCO PMD - ENVIROTECH CORPORATION - Salt Lake City, Utah

DO NOT SCALE PRINTS

DATE: 6-29-88
 DRAWN: RJ
 CHECKED: NK
 APPR: RJ

EIMCO CARROUSEL AERATORS
 100/75 HP HUBERT LSC
 GENERAL ARRANGEMENT

DWG. NO. 23766D201 REV. A

REVISED PER CUSTOMER APPROVAL RJ VJA 8-24-88

PIECE MARK	NO. REQ'D	MATERIAL	DESCRIPTION/REMARKS	TOTAL WEIGHT
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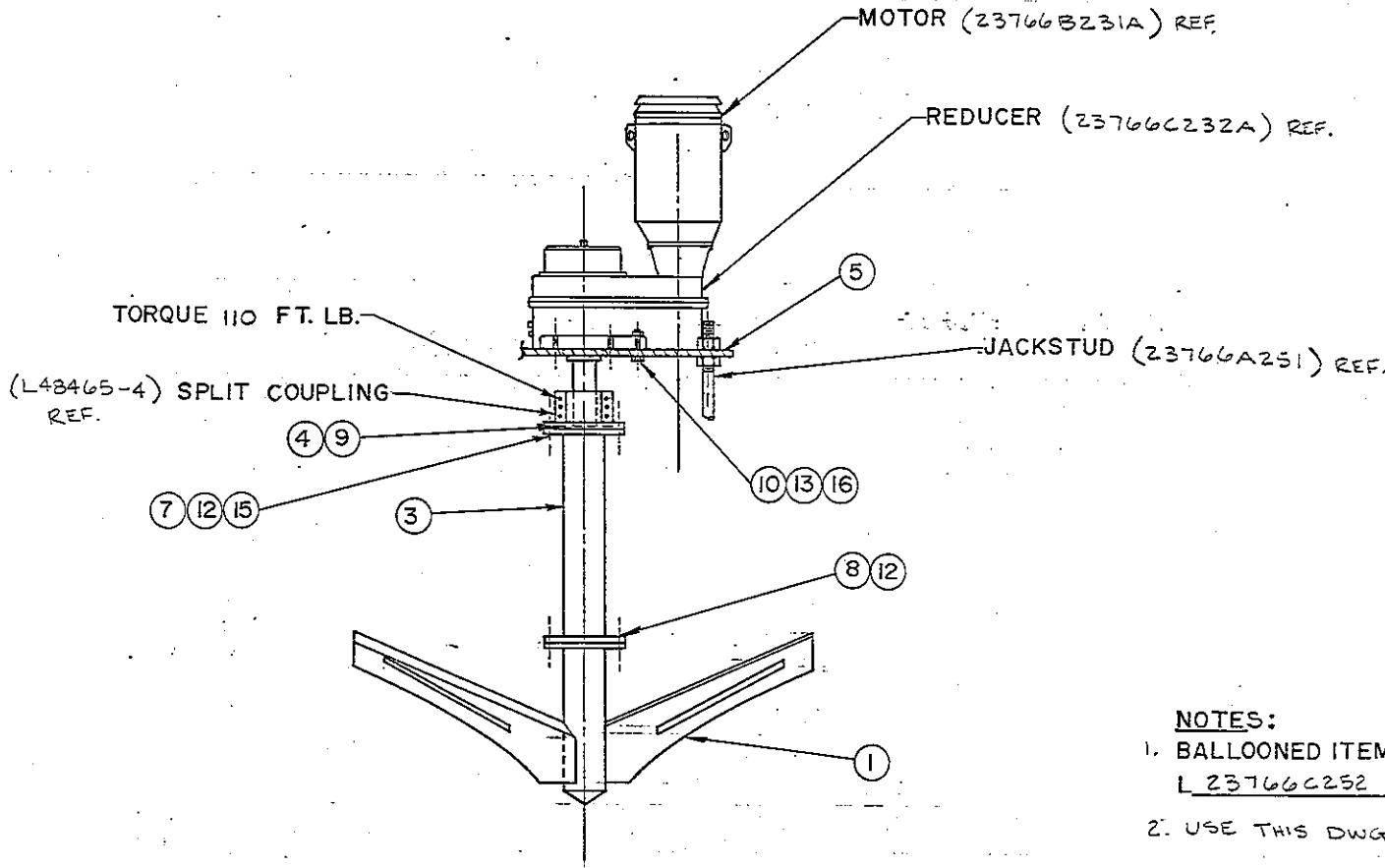
HIGH STRENGTH (H.S.) BOLTS (ASTM A325)

MUST BE USED WHERE SHOWN AND SPECIFIED. ASSEMBLY INSTRUCTIONS. TURN-OF-NUT METHOD. ALL JOINT SURFACES SHALL BE FREE OF LOOSE MILL SCALE, BURRS, AND FOREIGN MATERIAL. ENOUGH BOLTS SHALL BE BROUGHT TO A "SNUG TIGHT" CONDITION TO INSURE THAT THE PARTS OF THE JOINT ARE PROPERLY COMPACTED, I.E. BROUGHT INTO FULL CONTACT WITH EACH OTHER. SNUG TIGHT SHALL BE DEFINED AS THE TIGHTNESS ATTAINED BY A FEW IMPACTS OF AN IMPACT WRENCH OR THE FULL EFFORT OF A MAN USING AN ORDINARY SPUD WRENCH. FOLLOWING THE INITIAL TIGHTENING, BOLTS SHALL BE PLACED IN ANY REMAINING HOLES IN THE CONNECTION AND BROUGHT TO SNUG TIGHTNESS. ALL BOLTS IN THE JOINT SHALL BE TIGHTENED ADDITIONALLY BY THE APPLICABLE AMOUNT OF NUT ROTATION SPECIFIED BELOW, WITH TIGHTENING PROGRESSING SYSTEMATICALLY FROM THE MOST RIGID PART OF THE JOINT TO ITS FREE EDGES.

Bolt Length (as measured from underside of head to extreme end of point)	Disposition of Outer Faces of Bolted Parts		
	Both faces normal to bolt axis	One face normal to bolt axis and other face sloped not more than 1:20 (bevel washers not used)	Both faces sloped not more than 1:20 from normal to bolt axis (bevel washers not used)
Up to and including 4 diameters	1/3 turn	1/2 turn	2/3 turn
Over 4 diameters but not exceeding 8 diameters	1/2 turn	2/3 turn	5/6 turn

NUT ROTATION IS ROTATION RELATIVE TO BOLT, REGARDLESS OF THE ELEMENT (NUT OR BOLT) BEING TURNED. TOLERANCE ON ROTATION: 30° OVER OR UNDER. FOR OTHER THAN TURN-OF-NUT METHOD, FOLLOW PROCEDURES OUTLINED IN LATEST EDITION OF THE AISC STEEL CONSTRUCTION MANUAL.

E-2259 Rev. 5-81



NOTES:

- BALLOONED ITEMS ARE LISTED ON PARTS LIST L 23766C252.
- USE THIS DWG WITH DWG 23766D201.

SEPIA FROM: 295156



EIMCO PROCESS EQUIPMENT COMPANY — Salt Lake City, Utah

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HOLD FRACTIONAL MACHINED DIMENSIONS TO ± 1/32"

RELIANCE MOTOR
FLENDER REDUCER
HUBERT IMPELLER
ERECTION DETAILS

DO NOT SCALE PRINTS
DATE 5/22/83
DRAWN JPD
CHECKED RJ
APPR RJ

DWG NO. 23766C252 WAS 23766C52	JPD RJ 9-14-83
REVISION	BY CHECKED DATE

DWG. NO.	23766C252	REV.
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- ARROW  DENOTES VARIANCE FROM CONTRACT DOCUMENTS AND SHOULD BE PARTICULARLY NOTED.
- THE FOLLOWING DEFINES THE RESPONSIBILITY OF THE EIMCO PEC DIVISION OF ENVIROTECH CORPORATION (EIMCO), WITH REGARD TO THE INFORMATION AND DIMENSIONS SHOWN ON THIS DRAWING. (A): DIMENSIONS, LOADS, AND OTHER INFORMATION ARE PROVIDED TO ACCOMMODATE THE EQUIPMENT TO THE STRUCTURE AS SHOWN. (B): THE CUSTOMER IS TO PROVIDE CONCRETE STRUCTURES AND REINFORCING STEEL AND DESIGN TO SUIT LOCAL CONDITIONS AND JOB SPECIFICATIONS. (C): THIS DRAWING IS NOT TO BE USED FOR CONSTRUCTION OF INSTALLATION PURPOSES UNLESS IT BEARS THE APPROVAL OF THE OWNER, THE ENGINEER OR THEIR AUTHORIZED REPRESENTATIVE.
- EIMCO IS NOT RESPONSIBLE FOR CONCRETE DESIGN ~~OR FLOATING AERATOR ANCHORAGE DESIGN~~ WHICH DIFFER FROM THOSE SHOWN ON THIS DRAWING.
- THE EIMCO EQUIPMENT IS DESIGNED FOR THE MAXIMUM ANTICIPATED LOADINGS COVERING CONDITIONS OF START, WIND AT 15 PSF, AND DEAD LOAD.
- EIMCO DOES NOT FURNISH ELECTRICAL WIRING, CONDUIT, OR ELECTRICAL EQUIPMENT; PIPING, VALVES, OR FITTINGS; LUBRICATING OIL OR GREASE; FIELD PAINTING; FIELD WELDING OR ERECTION, (EXCEPT AS SPECIFICALLY NOTED).
- EIMCO IS NOT RESPONSIBLE FOR THE SELECTION OF STARTERS AND ELECTRICAL START CIRCUITS. RECOMMENDATION IS TO SELECT STARTER WITH HEATER ELEMENT AS LISTED IN THE FOLLOWING TABLE:

MOTOR		SLOW HEATERS
SERVICE FACTOR	INSULATION CLASS	SERVICE FACTOR
1.15	F	1.0

START PROCEDURE; START ONE UNIT AT A TIME WITH AT LEAST 2 MINUTE INTERVALS BETWEEN START OF EACH SUCCESSIVE UNIT.

- EIMCO IS NOT RESPONSIBLE FOR CONDITIONS THAT CAUSE OVERLOAD TO THE MOTOR AND GEAR REDUCER DUE BUT NOT LIMITED TO WATER LEVEL VARIATION, IMPELLER SUBMERGENCE, POWER SUPPLY VOLTAGE VARIATION, ICING, FLOATING DEBRIS; IMPROPER LUBRICATION AND MAINTENANCE.
- ~~EIMCO IS NOT RESPONSIBLE FOR BASIN EROSION OR ITS EFFECT ON PILES, COLUMN SUPPORTS OR CABLE ANCHORAGE WITH HARD SURFACE BOTTOMS ARE NOT USED. PROTECTIVE PROTECTION MAY BE OBTAINED THROUGH THE USE OF AN EROSION PAD WITH A DIAMETER TWICE THAT OF THE IMPELLER.~~


REVISED PER CUSTOMER APPROVAL

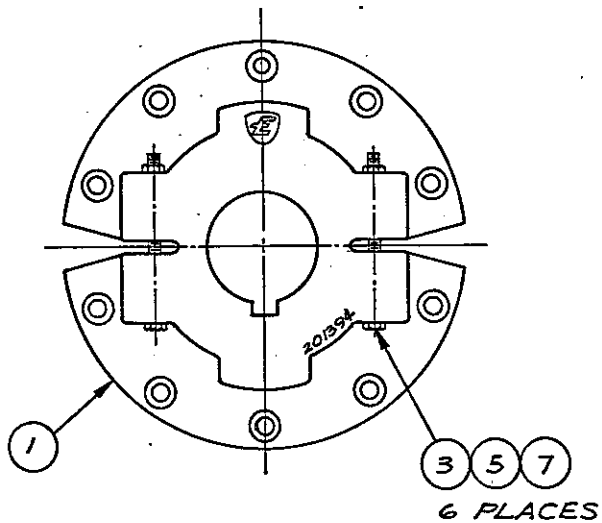
REVISION	BY	CHECKED	DATE
	RJ	JRA	8-24-88

PIECE MARK	NO. REQ'D	MATERIAL	DESCRIPTION/REMARKS	TOTAL WEIGHT
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- EIMCO DOES NOT SUPPLY NOR IS RESPONSIBLE FOR A SERVICE FACILITY TO MAINTAIN THE AERATOR(S). IT IS RECOMMENDED THAT THE CUSTOMER/USER PROVIDE A SERVICE FACILITY TO COMPLETELY REMOVE THE ASSEMBLED (OR DISASSEMBLED IF BRIDGE OR PLATFORM MOUNTED) AERATOR FROM THE BASIN FOR SERVICING. FOR HANDLING INSTRUCTIONS REFER TO THE INSTALLATION, OPERATION, AND MAINTENANCE INSTRUCTIONS MANUAL.
- AS THE AERATOR(S) WILL BE SHIPPED IN COMPONENT PIECES, EIMCO IS NOT RESPONSIBLE FOR ERECTION AND/OR INSTALLATION OF AERATOR COMPONENTS THAT DO NOT COMPLY WITH EIMCO'S DETAILED INSTRUCTIONS AND RECOGNIZED GOOD PRACTICE.
- SHOP PRIMER PAINT IS INTENDED TO SERVE ONLY AS A BONDING COAT BETWEEN METAL SURFACE AND PROTECTIVE FINISH OR SEALING COATS. AS SUCH, IT AFFORDS THE METAL ONLY MINIMAL PROTECTION AGAINST THE ELEMENTS. EIMCO IS NOT RESPONSIBLE FOR DETERIORATION OF SHOP PRIMED PAINTED SURFACES DURING TRANSIT, JOB STORAGE OR OTHER EXPOSURE TO THE ELEMENTS.
- WELD AREA CLEANING IS TO CONSIST OF: REMOVE ALL FLUX FROM WELDS; REMOVE SPATTER; REMOVE SLAG FROM BURNED EDGES; MINIMUM GRIND TO CLEAN-UP EDGES.
- SURFACE PREPARATION TO CONSIST OF: DRIVES TO BE MANUFACTURER'S STD. ALL FAB STEEL TO BE SSPC-SP-10 NEAR-WHITE BLAST CLEAN.
- SHOP PAINTING TO CONSIST OF: DRIVES TO BE MANUFACTURER'S STD.: ALL FAB STEEL TO HAVE (1) ONE SHOP COAT OF TNESEC NO. 37-77 PRIMER (2.0 MILS DFT) FINAL PAINT NOT BY EIMCO.
- FINAL PAINT AND COLOR COAT TO BE APPLIED BY THE CONTRACTOR IN THE FIELD.

SEPIA FROM: 48457

ENVIROTECH	EIMCO BSP DIVISION - ENVIROTECH CORPORATION - Salt Lake City, Utah	
	This drawing and all information thereon is the property of Eimco BSP and is confidential and must not be made public or copied. This drawing is loaned subject to return upon demand and is not to be used directly or indirectly in any way detrimental to our interests.	HOLD FRACTIONAL MACHINED DIMENSIONS TO ± 1/64"
DO NOT SCALE PRINTS		
DATE	6-23-88	
DRAWN	RJ	
CHECKD	NK	
APPR.	RJ	
GENERAL ARRANGEMENT NOTES		
DWG. NO.	23766B202	REV. A



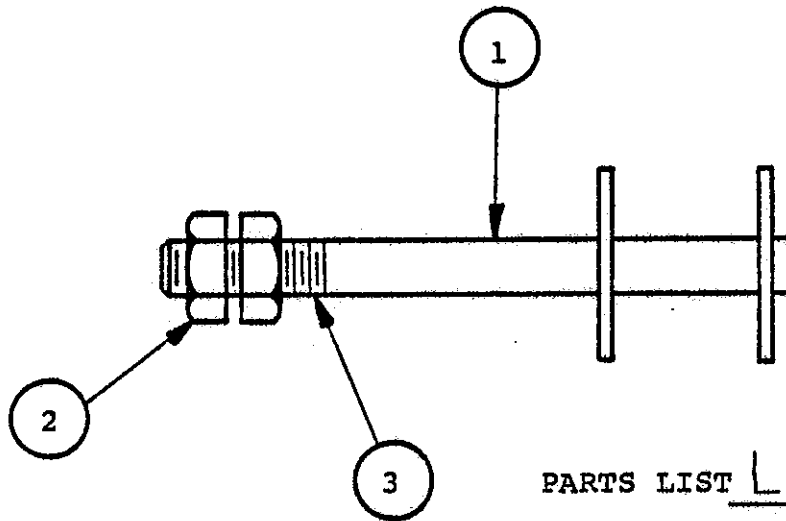
NOTE:

1. REMOVE PART NUMBER TAG(S) & AFFIX APPROPRIATE PARTS LIST NUMBER FOR PART IDENTIFICATION.
2. BOLT HALVES OF ITEM ① TOGETHER USING ITEMS ③ ⑤ & ⑦. DO NOT TORQUE. SNUG TIGHT, ONLY. USE ITEM ⑤ UNDER BOTH BOLT HEAD & NUT.

SHAFT SIZE	PART LIST N ^o .
6	L48465-1
6 1/2	L48465-2
5 7/8	L48465-3
6 5/8	L48465-4
7	L48465-5
6 1/4	L48465-6
5 5/8	L48465-7
6 3/8	L48465-8
6 5/16	L48465-9
6 11/16	L48465-10

F	5762	5-11-82
E	5479	8-8-80
D	5472	7-11-80
C	5403	2-21-80
B	5190	8-14-8
A	5149	6-20-78
	D/R	DATE

ENVIROTECH		EIMCO PMD -- ENVIROTECH CORPORATION -- Salt Lake City, Utah	
		This drawing and all information thereon is the property of Eimco PMD and is confidential and must not be made public or copied. This drawing is loaned subject to return upon demand and is not to be used directly or indirectly in any way detrimental to our interests.	
		HOLD FRACTIONAL MACHINED DIMENSIONS TO ± 1/64"	
DO NOT SCALE PRINTS		SPLIT COUPLING ASSY	
DATE	11-17-77		
DRAWN	J.K.M.		
CHECK'D	SWM		
APPR.	GEN	DWG. NO.	48465
		REV.	F




PARTS LIST L23766A251

INSTRUCTIONS:

- (1). NUTS AND STUDS ARE TO BE SHOP ASSEMBLED, AS SHOWN FOR SHIPPING.
- (2). PRIOR TO ASSEMBLING NUTS, APPLY LUBRICANT (3) TO THREADS OF STUD AND NUTS.
- (3). ONE NUT IS TO BE RUN COMPLETELY TO END OF THREADS ON STUDS TO INSURE PROPER FIT. NUTS MUST FIT SNUGLY, BUT NOT BIND.
- (4). IF FIT IS JUDGED IMPROPER, CONSULT INSPECTOR FOR POSSIBLE REJECTION OR REWORKING.
- (5). ASSEMBLED UNITS ARE TO BE BOXED FOR SHIPPING, WITH PROPER PACKING TO PROTECT THREADS. PACK UNUSED LUBRICANT (3) IN BOX WITH STUDS FOR USE AT JOBSITE.

C		
B		
A		
	D/R	DATE
REVISION		

SEPIA FROM 88375

ENVIROTECH 	EIMCO BSP DIVISION - ENVIROTECH CORPORATION - Salt Lake City, Utah	
This drawing and all information thereon is the property of Eimco BSP and is confidential and must not be made public or copied. This drawing is loaned subject to return upon demand and is not to be used directly or indirectly in any way detrimental to our interests.		
HOLD FRACTIONAL MACHINED DIMENSIONS TO ± 1/64"		
DO NOT SCALE PRINTS	STUD ASSEMBLY FOR LOW-SPEED AERATORS	
DATE	6-29-88	
DRAWN	RJ	
CHECK'D	NK	
APPR.	RJ	
DWG. NO.	23766A251	REV.