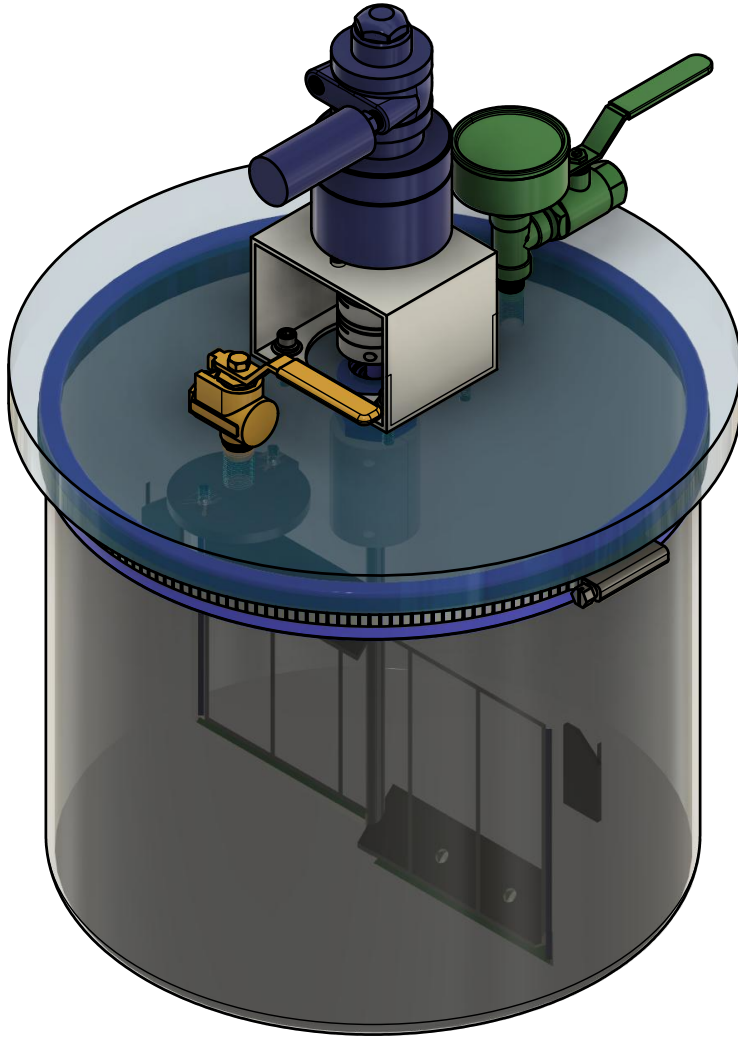


B

B

A

A



2.5 GALLON VACUUM MIX POT ASSEMBLY AND OPERATION

Prepared By:

Stephen August

Reviewed By:

Eng Branch Head:

Size

Cage Code

WT GP

NAVSEA DWG NO.

REV

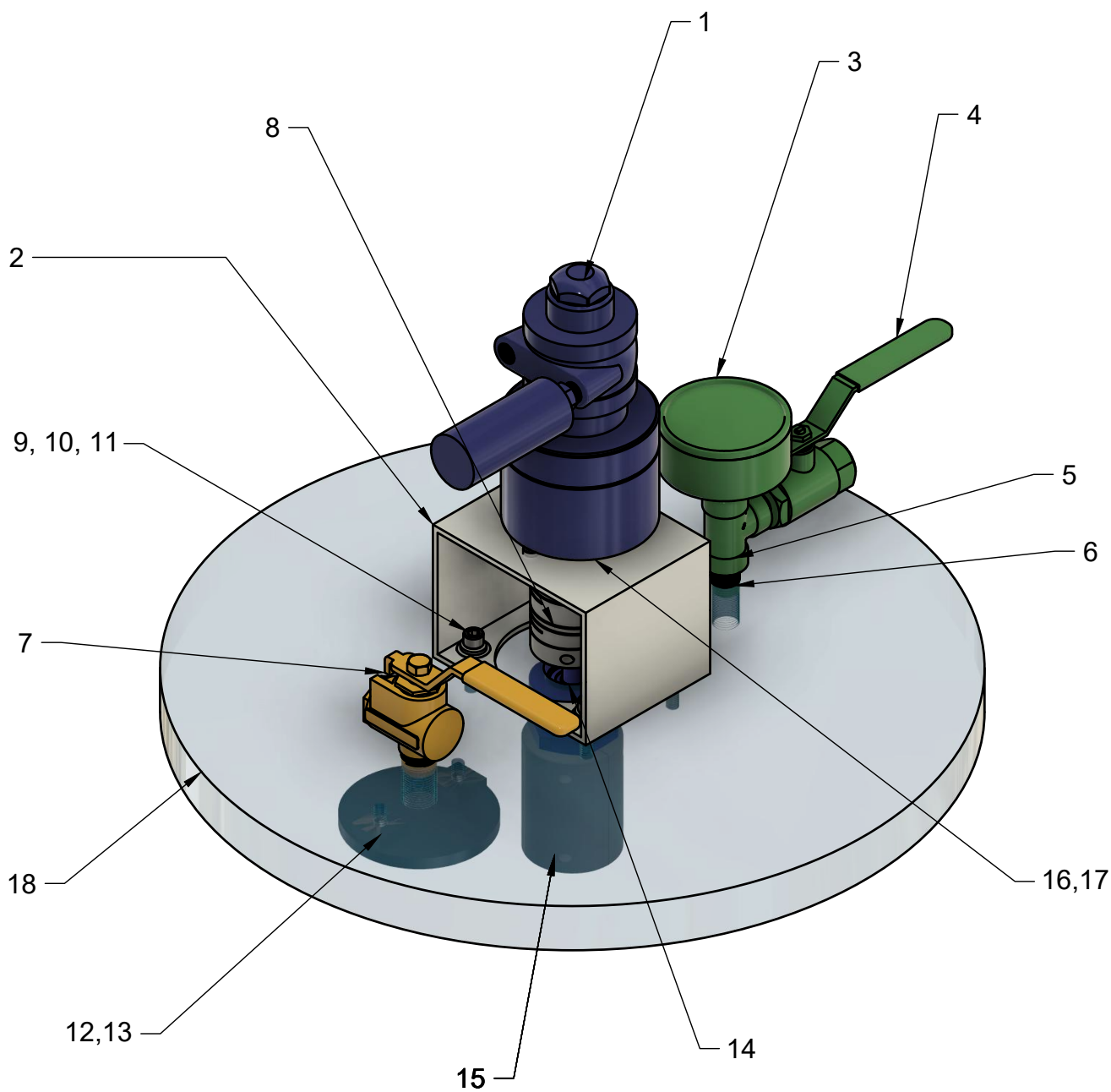
A

A

SCALE: NONE

UNCLASSIFIED

SHEET 1 of 16



Assembly of Lid

Size

A

Cage Code

WT GP

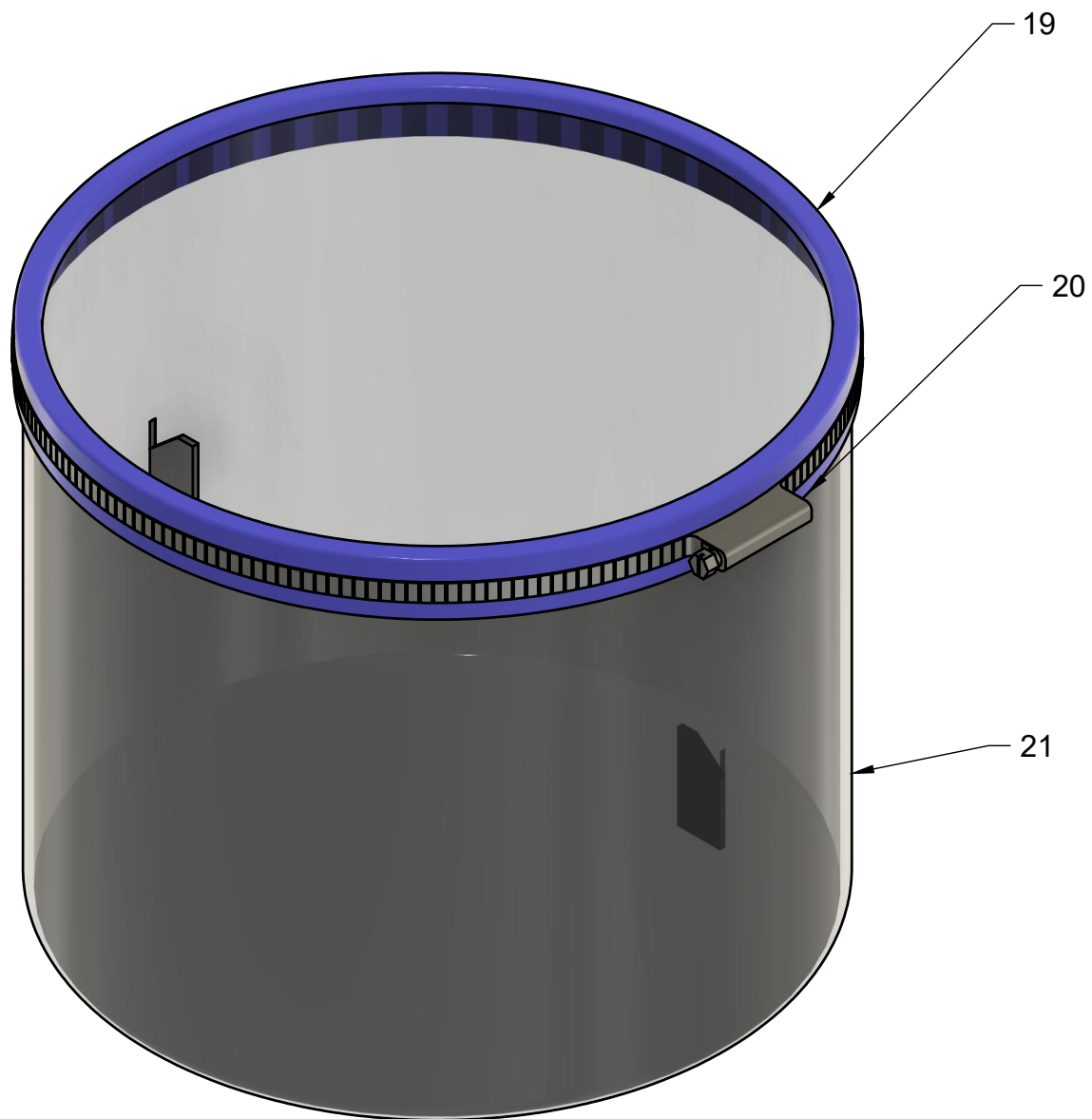
NAVSEA DWG NO.

REV

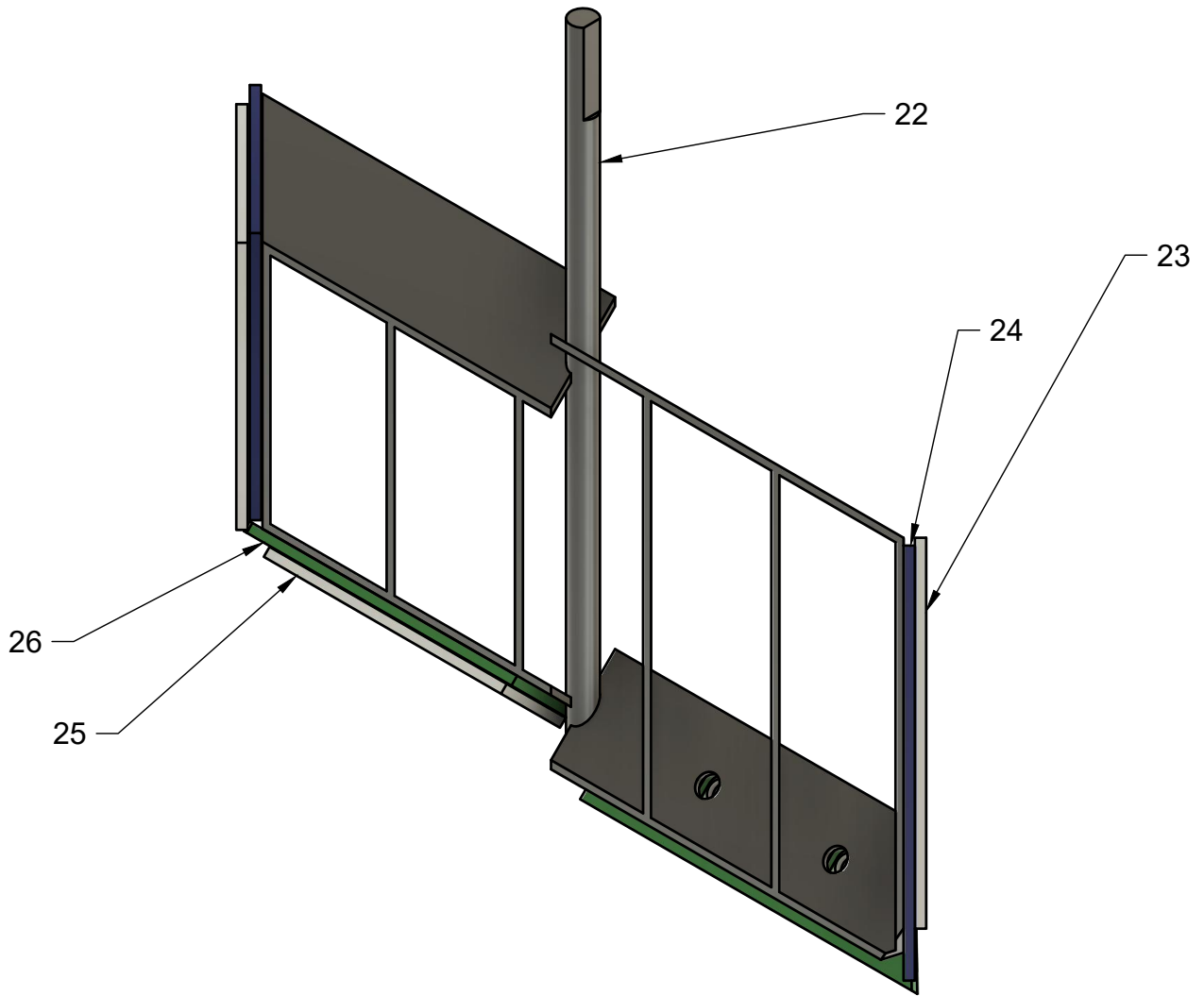
SCALE: NONE

UNCLASSIFIED

SHEET 2 of 16



Assembly of Bucket	Size	Cage Code	WT GP	NAVSEA DWG NO.	REV
	A				A
	SCALE: NONE		UNCLASSIFIED		SHEET 3 of 16



Assembly of Mix Blade	Size	Cage Code	WT GP	NAVSEA DWG NO.	REV
	A				A
	SCALE: NONE		UNCLASSIFIED		SHEET 4 of 16

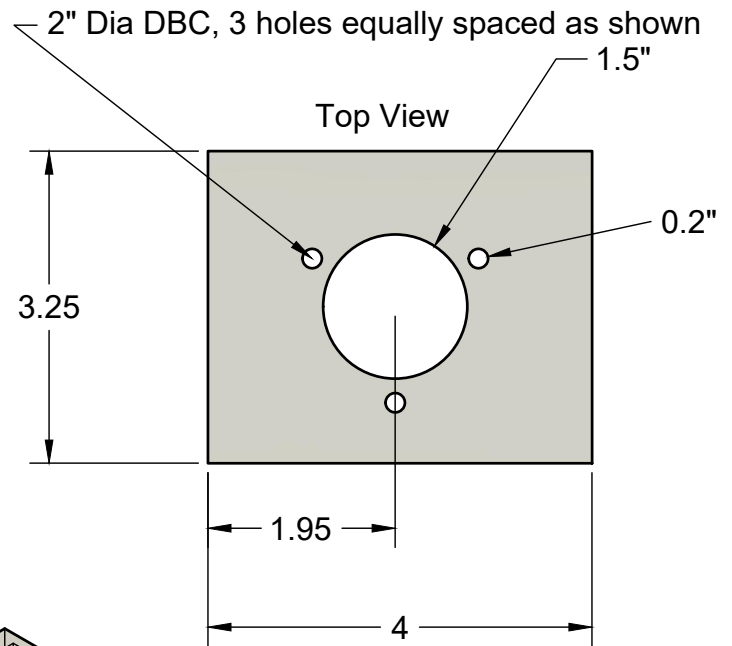
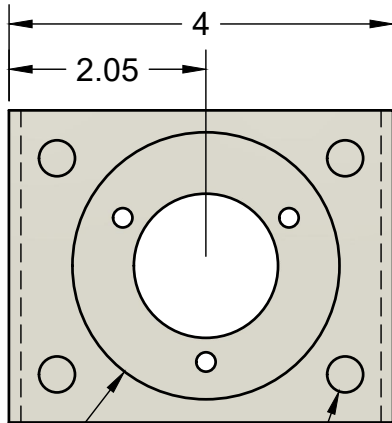
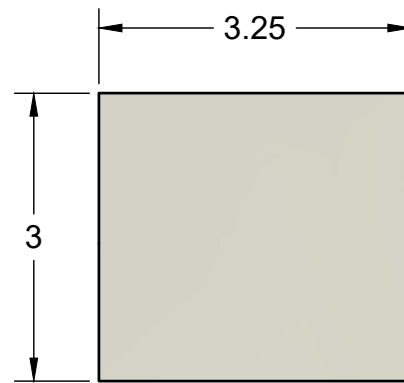
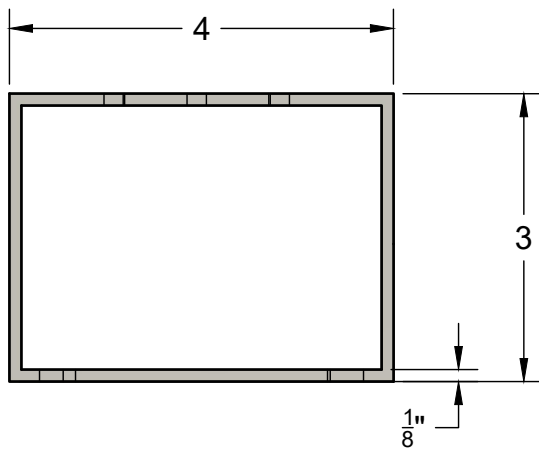


Item Number	Part Name	Manufacturer/Part #	Quantity	Notes
1	Air Powered Gear Motor	Mcmaster 59795K790	1	
2	Motor Mount	Manufactured	1	See Sheet 6
3	Vacuum Gauge	Mcmaster 3941K123	1	
4	Ball Valve	Mcmaster 4726K460	1	
5	Pipe Tee	Mcmaster 4452K432	1	
6	Pipe Nipple	Mcmaster 44615K412	1	
7	Ball Valve	Mcmaster 47K120	1	
8	Flexible Shaft Coupler	Mcmaster 6208K623	1	
9	Socket Head Cap Screw	Mcmaster 91251A539	4	$\frac{1}{4}$ "-20 $\frac{3}{8}$ "
10	Washer	Mcmaster 90107A029	4	$\frac{1}{4}$ "
11	Lock Washer	Mcmaster 9214A029	4	$\frac{1}{4}$ "
12	Vent Diffuser	Manufactured	1	See Sheet 14
13	Socket Head Cap Screw	Mcmaster 91251A539	2	$\frac{1}{4}$ "-20 $\frac{3}{8}$ "
14	Vacuum Bearing	FerroTec 132910-SS-375-SLBE -HD-STD	1	
15	Shaft Coupler	Mcmaster 6115K220	1	
16	Socket Head Cap Screw	Mcmaster 91251A340	3	10-32 $\frac{3}{8}$ "
17	Washer	Mcmaster 90107A011	3	10-32"
18	Lid	Manufactured		See Sheet 7
19	Mix Bucket O-Ring	Lacotech LGR18B	1	
20	Hose Clamp	LacoTech LMS8101	1	
21	Mix Bucket	Manufactured	1	See Sheet 13
22	Mix Blade	Manufactured	1	See Sheet 8
23	Side Wiper Bracket	Manufactured	2	See Sheet 10
24	Side Wiper	Manufactured	2	See Sheet 12
25	Bottom Wiper Bracket	Manufactured	2	See Sheet 9
26	Bottom Wiper	Manufactured	2	See Sheet 11



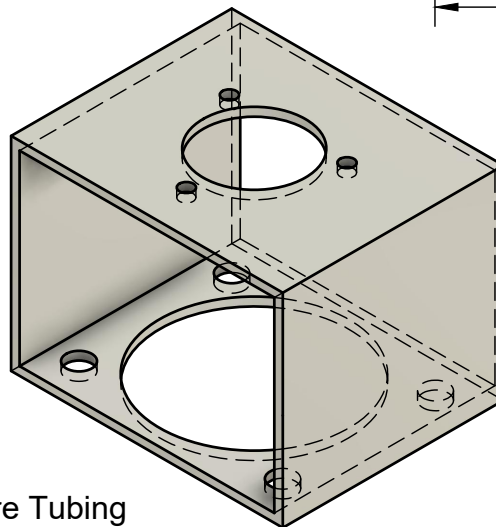
Parts List	Size	Cage Code	WT GP	NAVSEA DWG NO.	REV
	A				A
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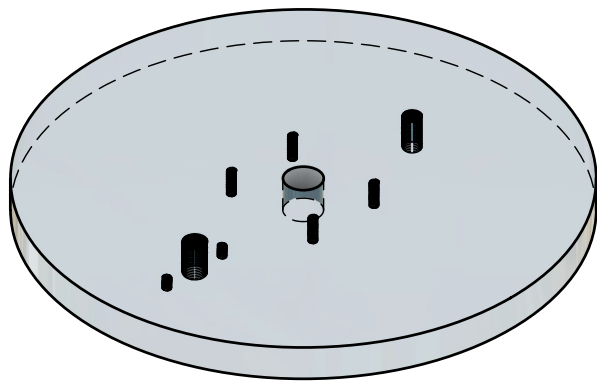
Bottom View

3/8" Dia thru hole
4 places as shown



Material: 3"x4"x¹/₈" Aluminum Square Tubing
Dimensions: Inch

Motor Mount	Size	Cage Code	WT GP	NAVSEA DWG NO.	REV
	A				A
	SCALE: NONE		UNCLASSIFIED		SHEET 6 of 16



Material: 1" Acrylic
Dimensions: Inch

Qty: 2, $\frac{1}{4}$ "-20 as drawn

$\frac{3}{8}$ " NPT

Qty: 4, $\frac{1}{4}$ "-20 as drawn
located from center

$\varnothing 1.06$

$\frac{1}{4}$ " NPT

$\frac{3}{4}$ " $\frac{1}{4}$ -20 threaded

.38

1

15.25

Size

Cage Code

WT GP

NAVSEA DWG NO.

REV

Acrylic Lid

A

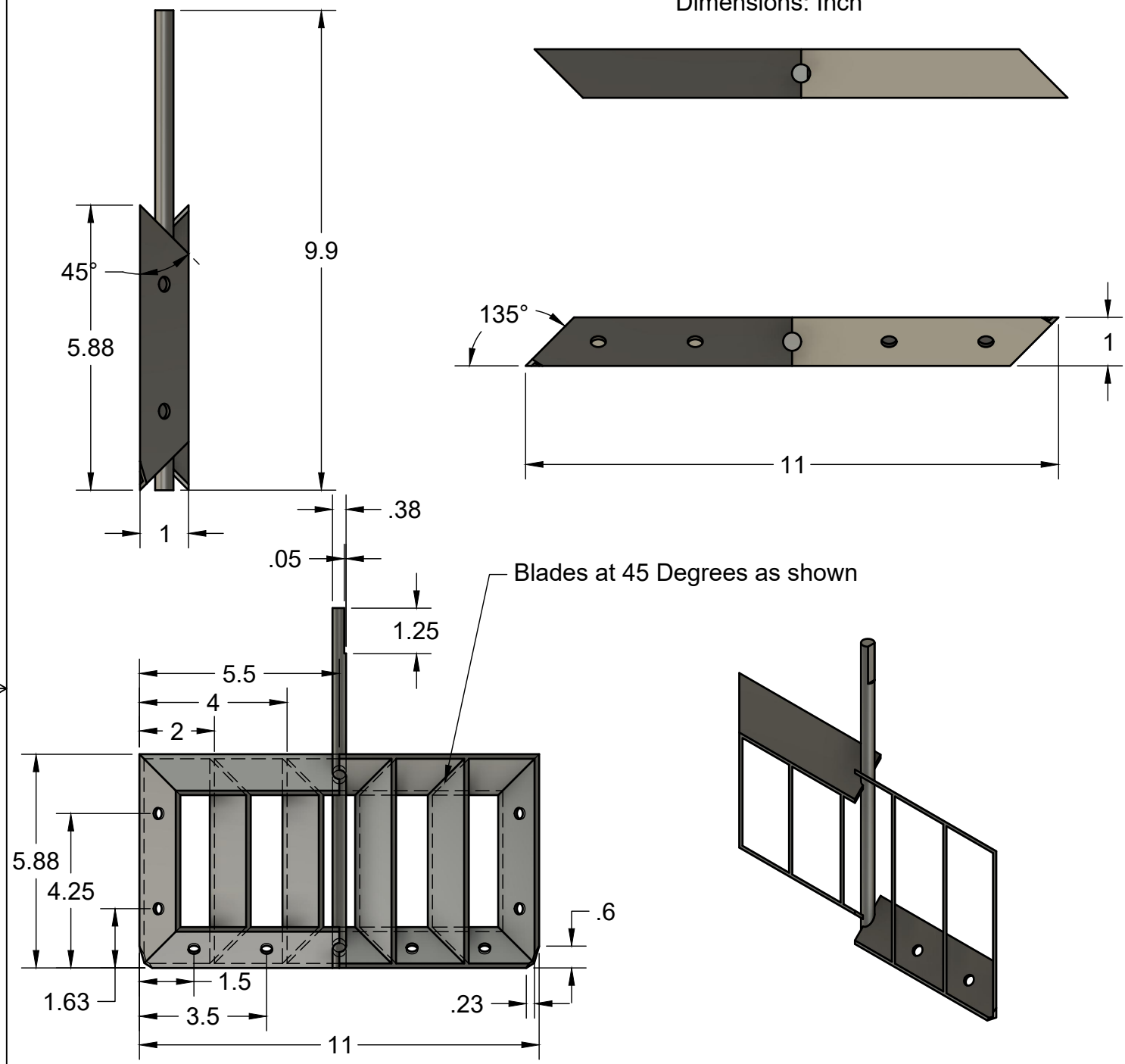
A

SCALE: NONE

UNCLASSIFIED

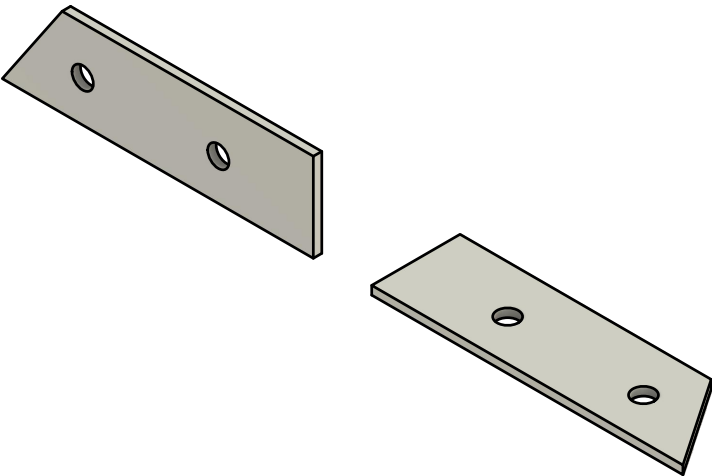
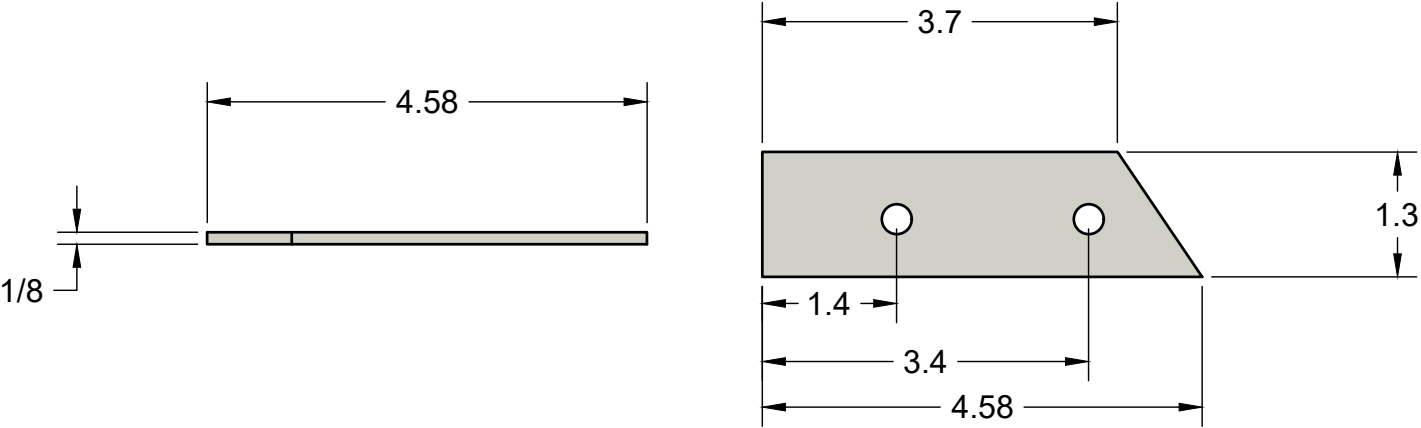
SHEET 7 of 16

Material : Steel
Dimensions: Inch



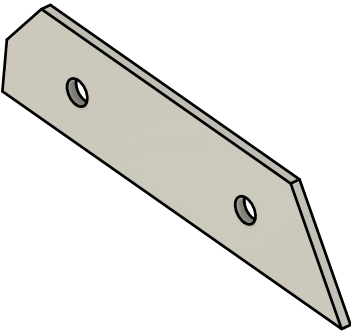
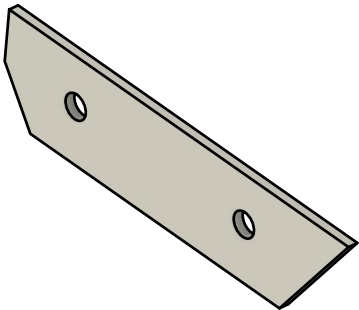
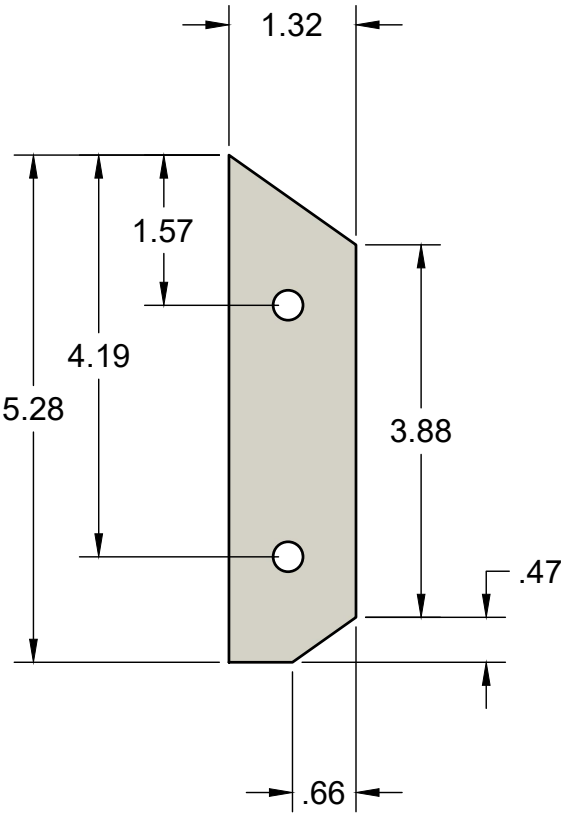
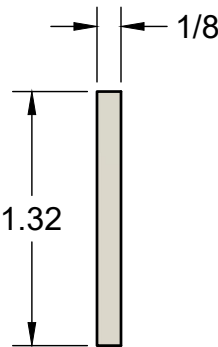
Mix Blade	Size	Cage Code	WT GP	NAVSEA DWG NO.	REV
	A				A
	SCALE: NONE		UNCLASSIFIED		SHEET 8 of 16

Material: $\frac{1}{8}$ " Steel
Dimensions: Inch



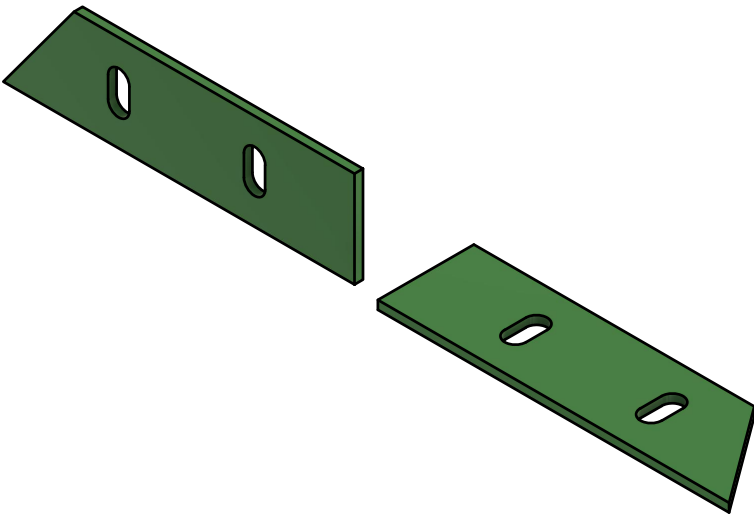
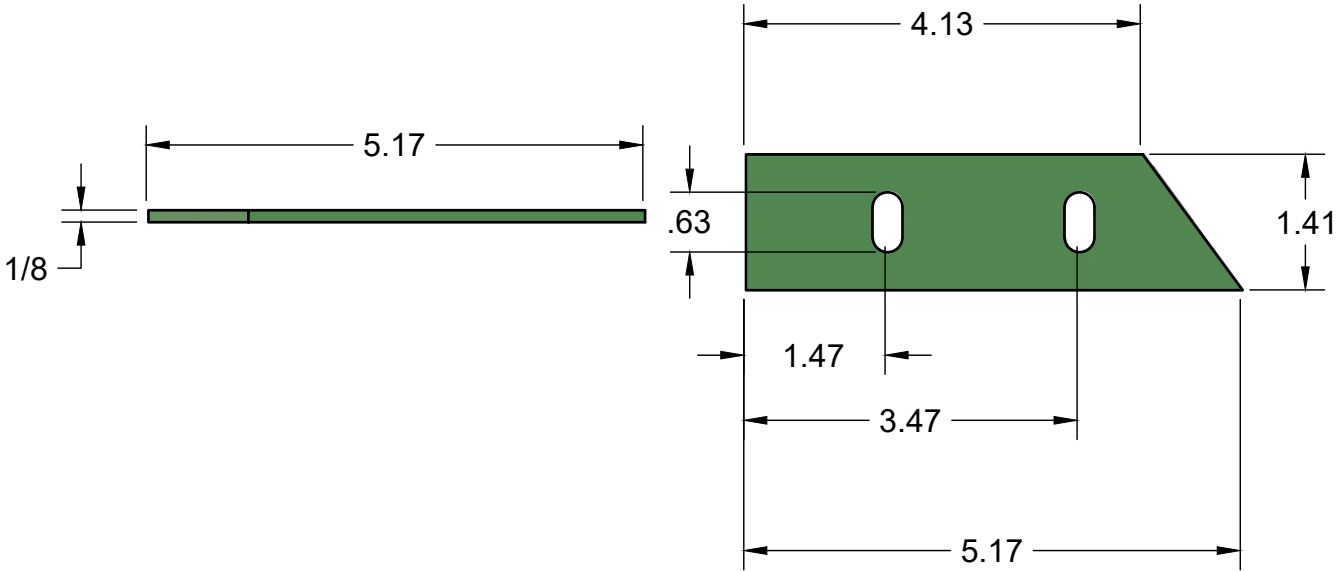
Bottom Wiper Bracket	Size	Cage Code	WT GP	NAVSEA DWG NO.	REV
	A				A
	SCALE: NONE		UNCLASSIFIED		SHEET 9 of 16

Material: $\frac{1}{8}$ " Steel
Dimensions: Inch



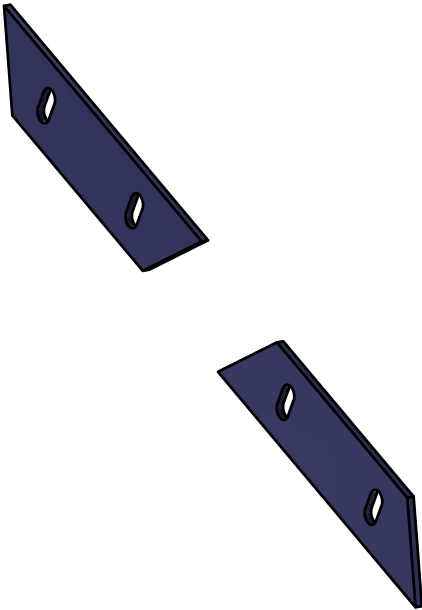
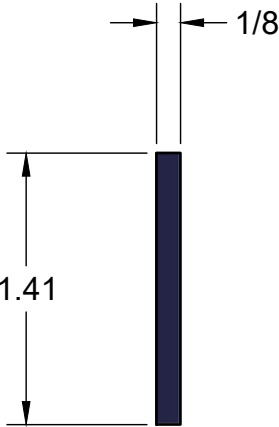
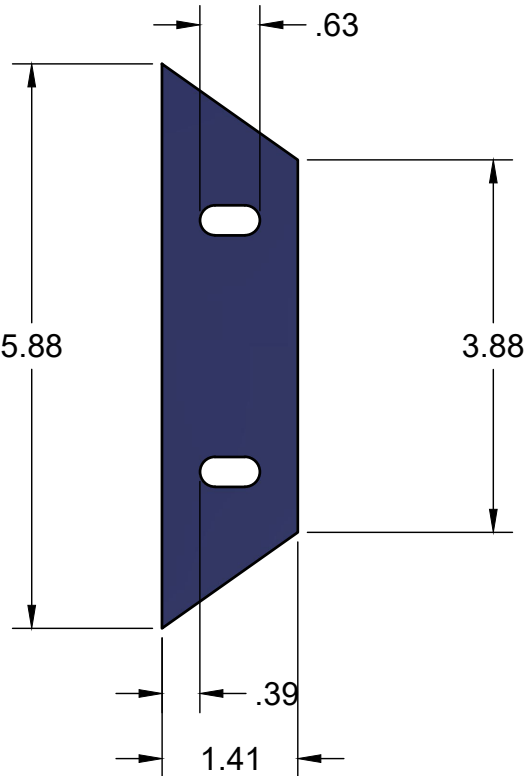
Side Wiper Bracket	Size	Cage Code	WT GP	NAVSEA DWG NO.	REV
	A				A
	SCALE: NONE		UNCLASSIFIED		SHEET 10 of 16

Material: $\frac{1}{8}$ " PTFE
Dimensions: Inch



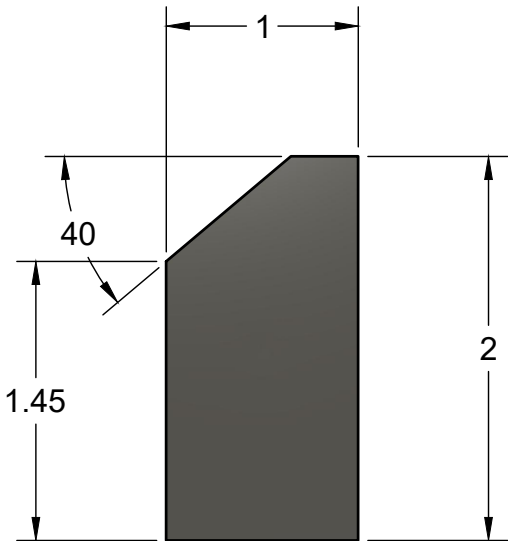
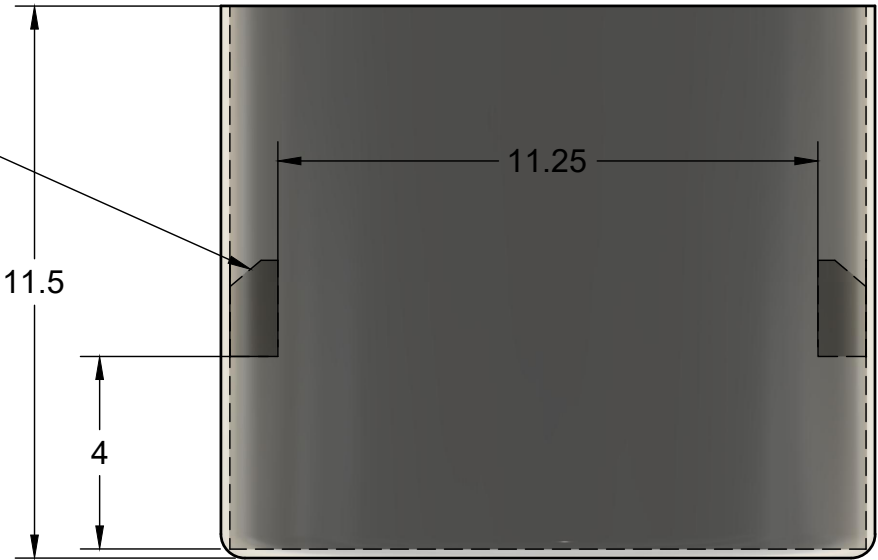
Bottom Wiper	Size	Cage Code	WT GP	NAVSEA DWG NO.	REV
	A				A
	SCALE: NONE		UNCLASSIFIED		SHEET 11 of 16

Material: $\frac{1}{8}$ " PTFE
Dimensions: Inch

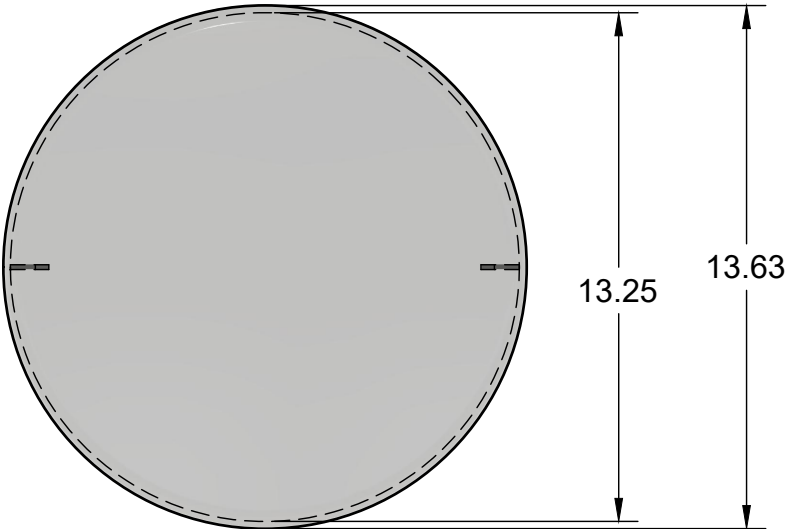


Side Wiper	Size	Cage Code	WT GP	NAVSEA DWG NO.	REV
	A				A
	SCALE: NONE		UNCLASSIFIED		SHEET 12 of 16

See Detail A

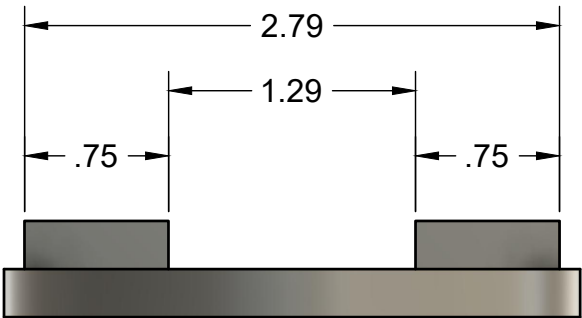
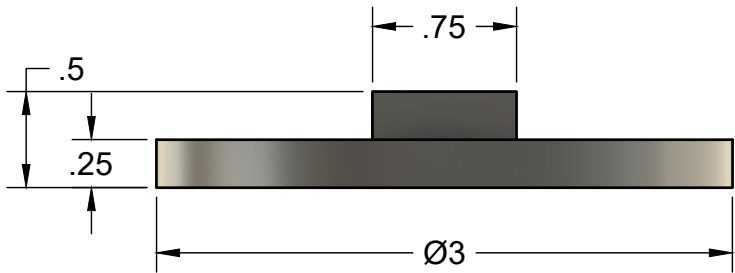
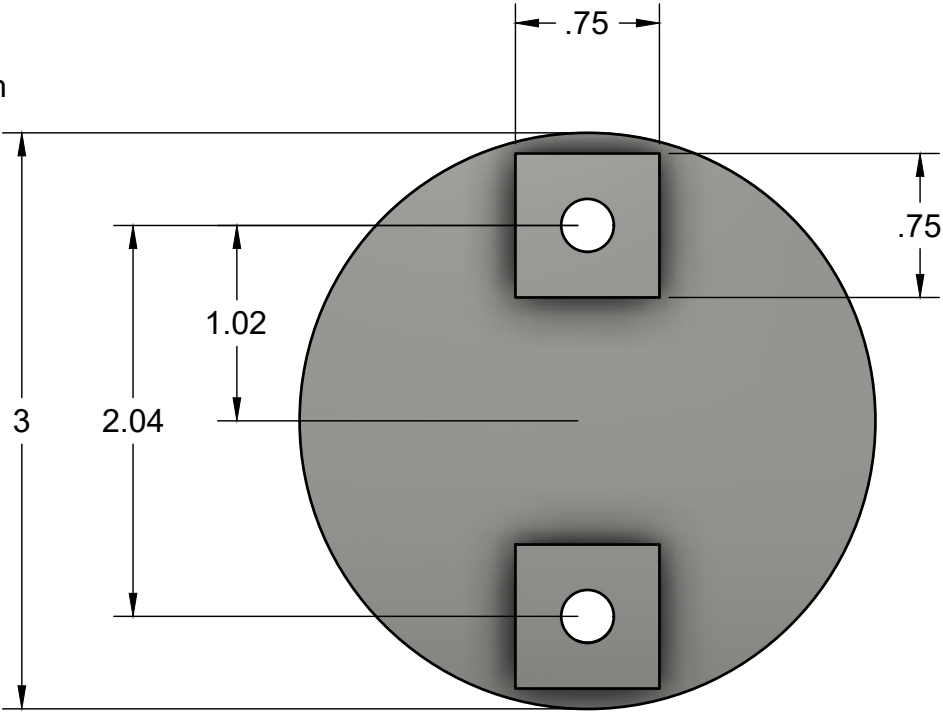


Detail A: Weld In Bucket Tab



Mix Bucket	Size	Cage Code	WT GP	NAVSEA DWG NO.	REV
	A				A
	SCALE: NONE		UNCLASSIFIED		SHEET 13 of 16

Material: HDPE
Dimensions: Inch



Mix Bucket	Size	Cage Code	WT GP	NAVSEA DWG NO.	REV
	A				A
	SCALE: NONE		UNCLASSIFIED		SHEET 14 of 16

Safety

Wear gloves and eye protection when removing and installing fittings, valves, and hoses. Ensure all connections are tight.

Wear gloves and eye protection when operating mixer.

Inspection

Perform visual check of mix pot to ensure pneumatic hose, vacuum hose, and fittings are not damaged, frayed, or worn. Place lid on mix pot.

Mix Pot Set-Up

1. Verify all screws on the mix blade coupling are tight.
2. Connect the air, vacuum, and exhaust muffler hoses as shown in Figure (1).
3. Fully extend exhaust hose away from work area.
4. Place lid on mix pot.

NOTE: Prior to mixing material, verify operation of the mixer.

NOTE: Do not remove mix blade.

Set Up and System Check

1. Turn air valve on and open air pressure regulator (clockwise direction) to increase air pressure to 30-50 psi.
2. Reduce pressure to zero and close the valve.
3. Turn the vacuum valve on and verify a minimum of 28 in. Hg is achieved. Close the valve. If 28 in. Hg cannot be achieved, check connections, hoses for leaks, and gasket on top edge of mix pot.
4. SLOWY open the vacuum vent valve located on the side of the pot to release vacuum from the mix pot.
5. Remove the mix pot lid. Mix pot is ready to mix a 2.5 gallon kit of Versathane Neat Primer.

Set-Up and Safety Check	Size	Cage Code	WT GP	NAVSEA DWG NO.	REV
	A				A
	SCALE: NONE		UNCLASSIFIED		SHEET 15 of 16

-

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16. Use IPA with clean rags to wipe down mix pot, blade, and other areas of the mix pot assembly that were splattered with Versathane Neat Primer. The lid should not require cleaning. However, if cleaning is required, use IPA. DO NOT use Acetone on the lid.

<div>Mix Pot Operation</div>	Size	Cage Code	WT GP	NAVSEA DWG NO.	REV
	A				A
	SCALE: NONE		UNCLASSIFIED		SHEET 16 of 16