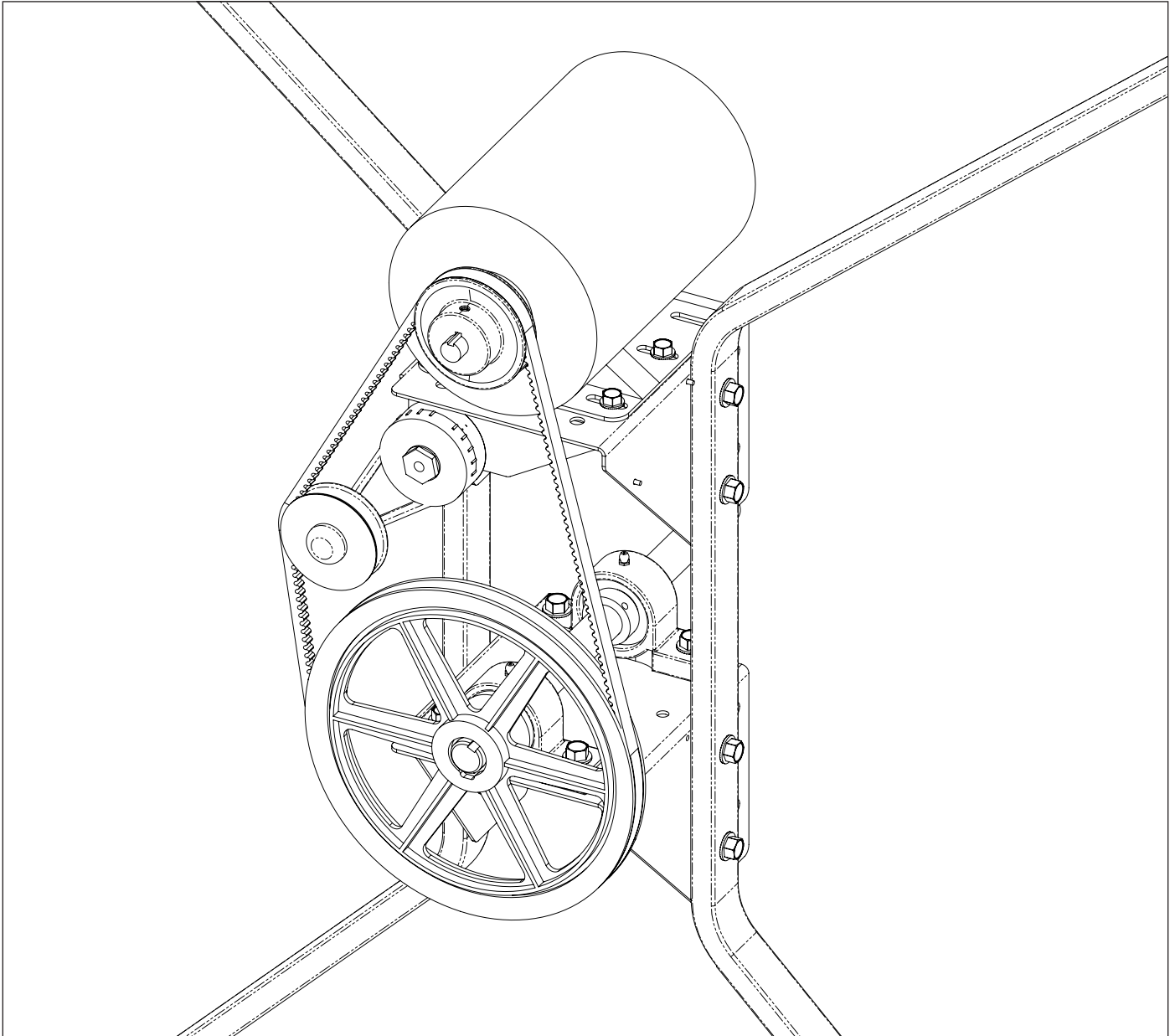




Knock Down Fan Assembly Fixture

Installation Quick Sheet

950160



The knock down fan assembly fixture is designed to aid in the assembly of knock down fans to ensure that the motor and fan blade shafts are in alignment with each other. If the motor shaft and fan shaft are not assembled in perfect alignment with each other, excess wear will result in lower performance, decreased belt life, pulley failure, and possible product failure.

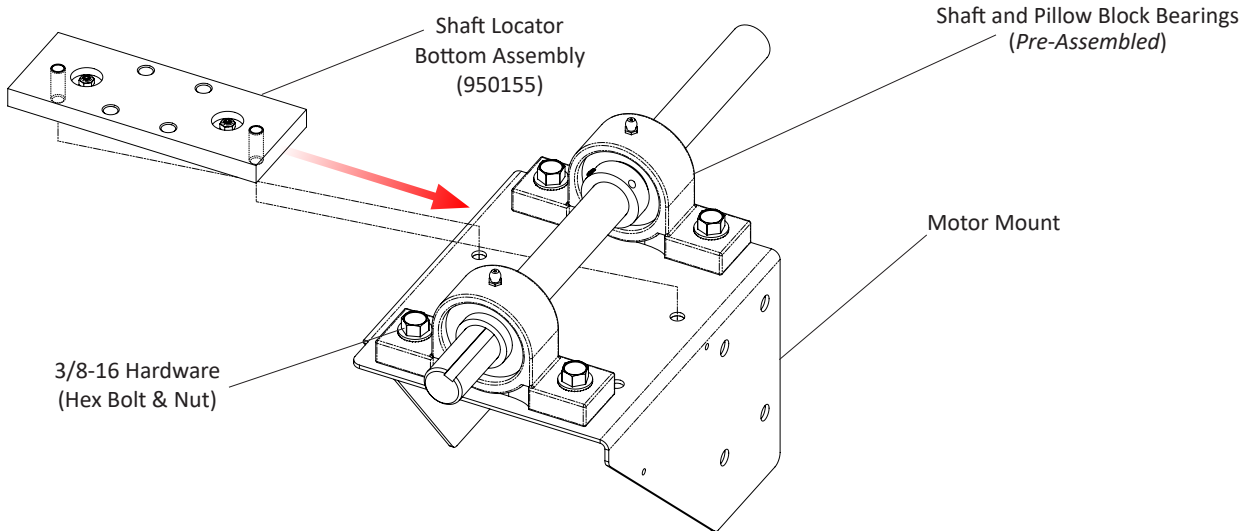
Knock Down Fan Assembly Fixture Installation

Shaft and Pillow Block Bearings Assembly

1. Install the shaft locator bottom assembly (950155) to the motor mount, by inserting the pins in the shaft locator bottom assembly into the holes in the motor mount, as shown in Figure 1. Assemble the pre-assembled shaft and pillow block bearings to the motor mount, over the shaft locator bottom assembly, using the 3/8-16 hardware provided. Do not tighten hardware at this time; keep the shaft and pillow block bearings loose.

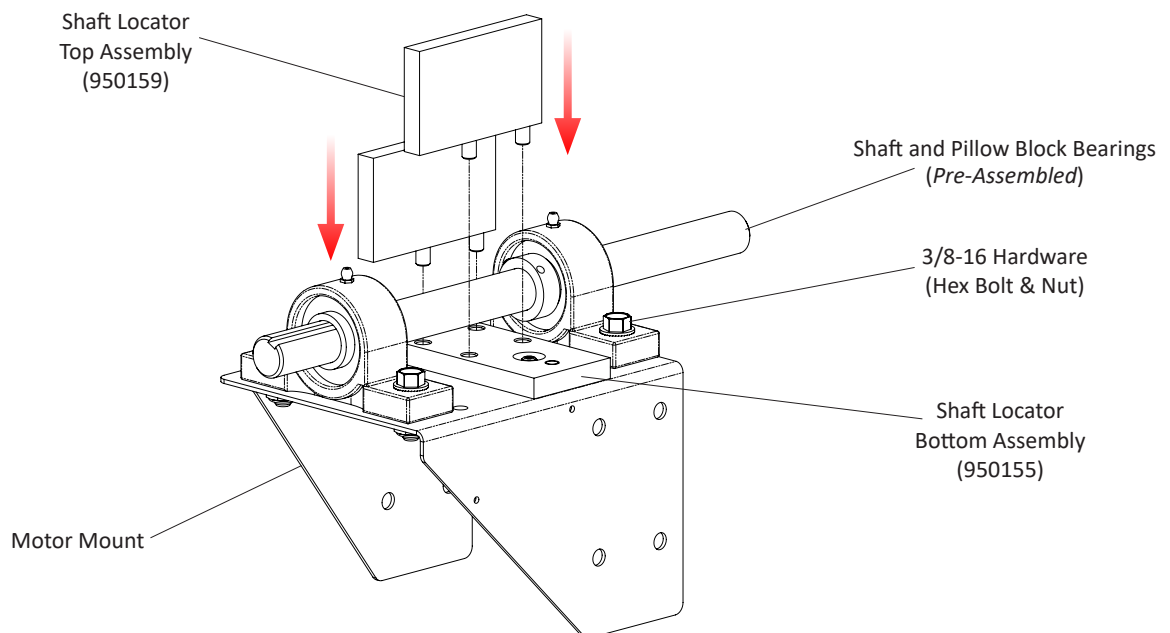
NOTE: The shaft and pillow block bearings can be assembled to the motor mount first, and the shaft locator bottom assembly can be slid underneath afterwards, but it is easier to assemble the shaft locator bottom assembly to the motor mount first.

Figure 1



2. After the shaft and pillow block bearings are assembled to the motor mount with the shaft locator bottom assembly, assemble (2) shaft locator top assemblies (950159) to the shaft locator bottom assembly, by inserting the pins in the shaft locator top assemblies into the holes in the shaft locator bottom assembly, as shown in Figure 2. Align the shaft and pillow block bearings flush and square with the assembled fixture and then tighten the hardware on the shaft and pillow block bearings to secure them to the motor mount. Once the hardware is tightened, remove the shaft locator top and bottom assemblies. (There is enough clearance to lift the shaft locator bottom assembly up under the shaft and slide it out.)

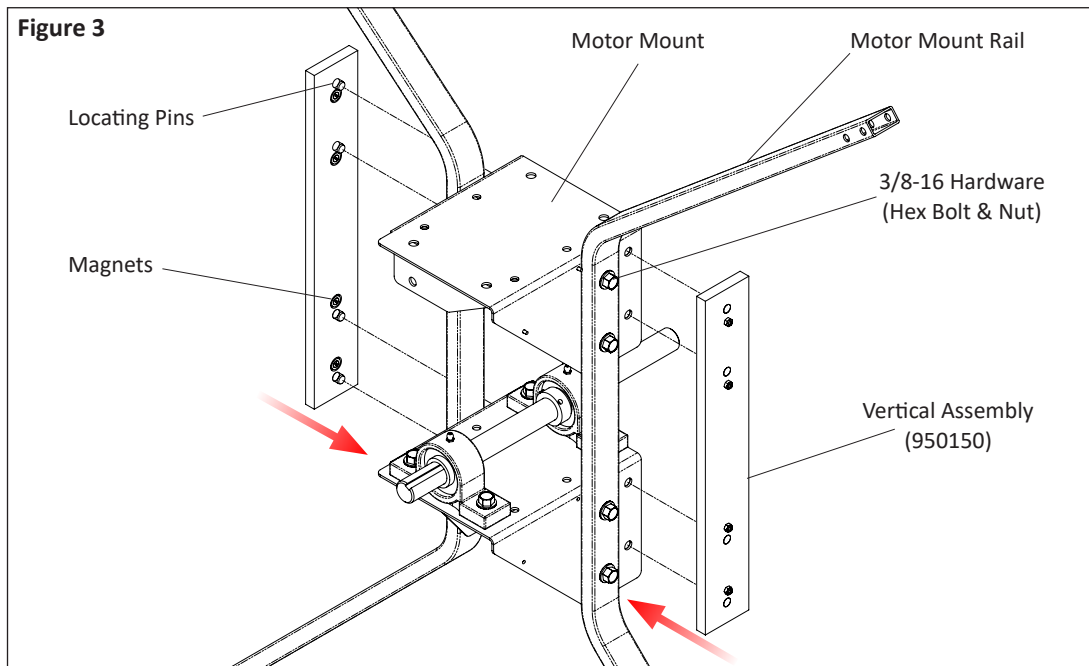
Figure 2



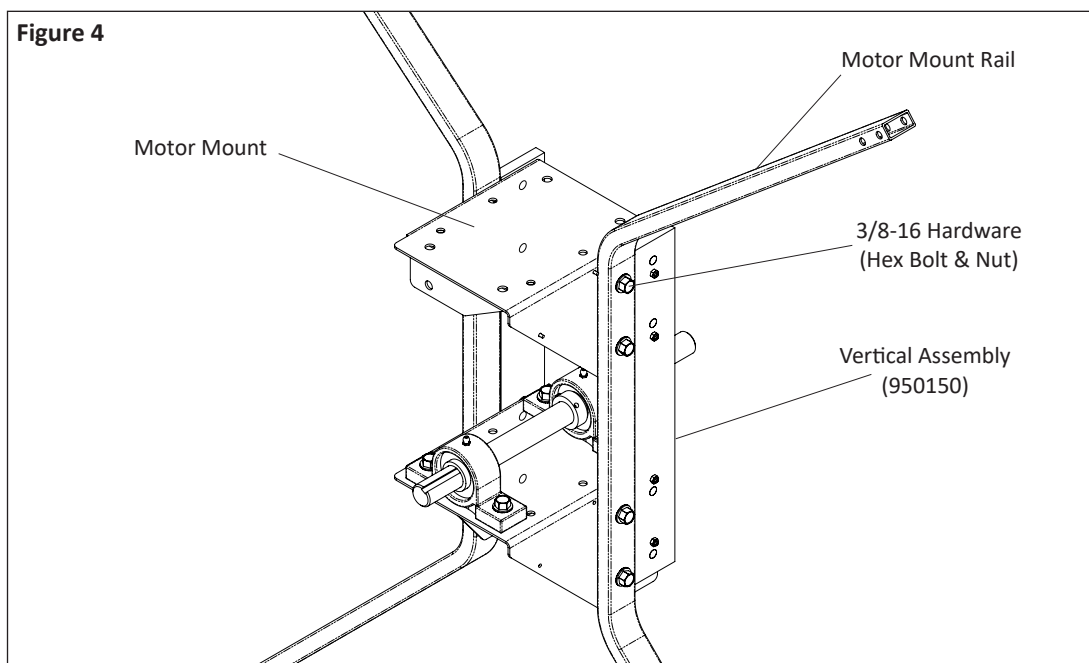
Knock Down Fan Assembly Fixture Installation - continued

Motor Mount Rail Assembly

3. Once the shaft and pillow block bearings are secured to the motor mount, assemble (2) motor mount rails and a second motor mount to the rails using supplied 3/8-16 hardware. Keep the hardware loose and attach (2) vertical assemblies (950150) to the motor mount rails, by inserting the pins in the vertical assemblies into the holes in the motor mounts, as shown in Figure 3. (*Magnets in the vertical assemblies help keep them attached to the motor mounts, even when assembled in an upright position.*)



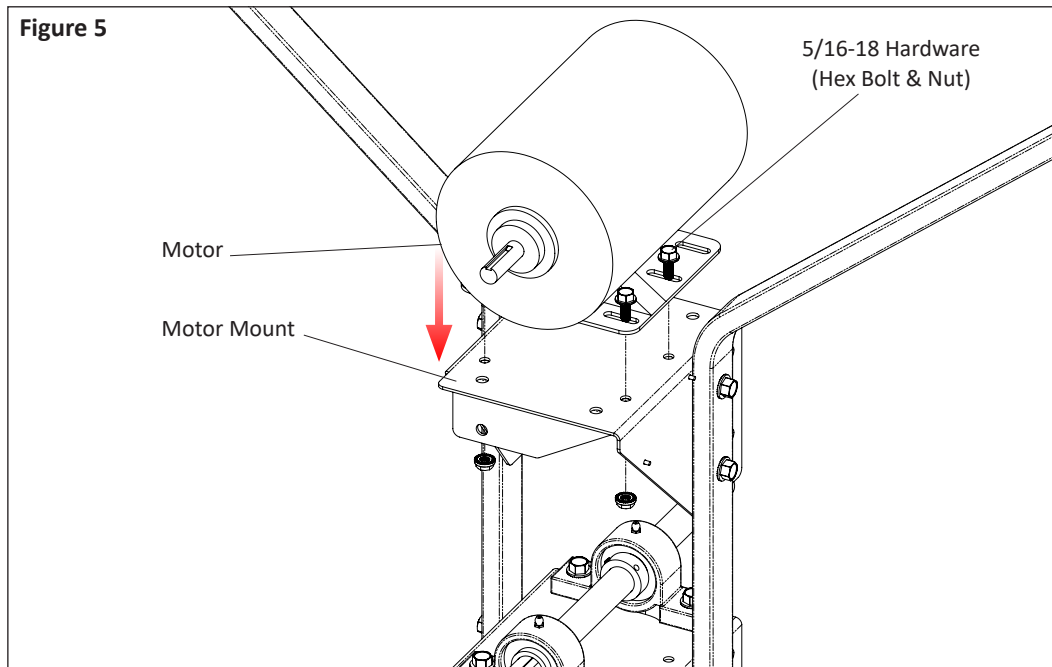
4. After the vertical assemblies are properly located, tighten the hardware connecting the motor mount rails to the motor mounts, ensuring that the sub-assembly is flush and square, as shown in Figure 4. Once the hardware is tightened and the motor mounts are secured to the motor mount rails, remove the vertical assemblies.



Knock Down Fan Assembly Fixture Installation - continued

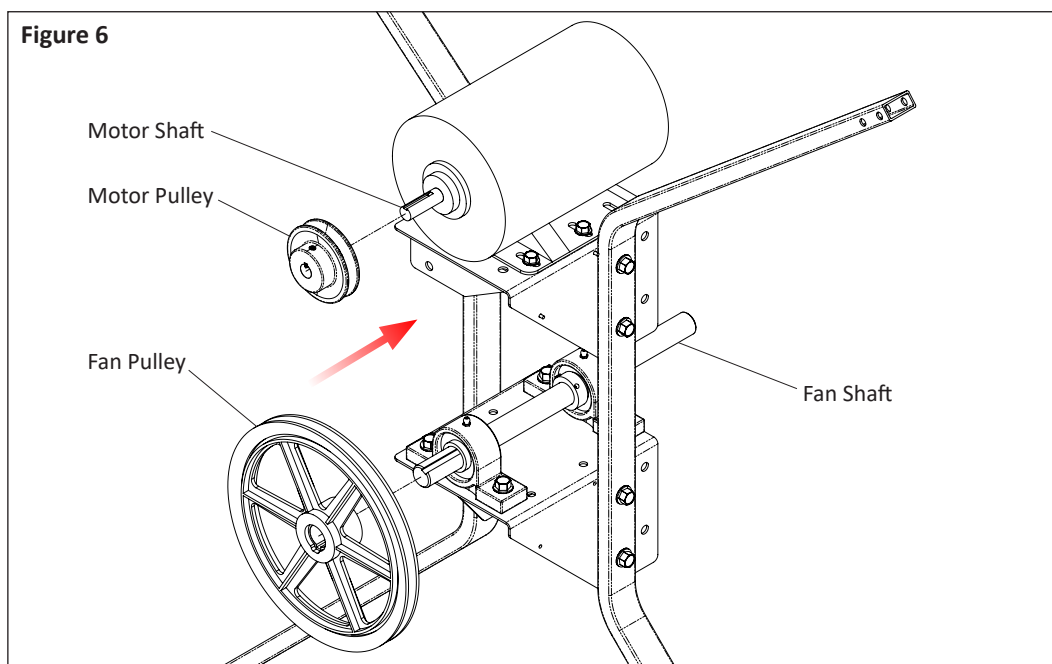
Motor Assembly

5. Once the motor mount rails are secured to the motor mounts, attach the motor to the top motor mount, using supplied 5/16-18 hardware, as shown in Figure 5. Tighten the hardware and secure the motor to the motor mount before the next step.



Pulley Assembly

6. After the motor is installed and secured, slide the motor pulley onto the motor shaft, and the fan pulley onto the fan shaft in the shaft and pillow block bearings assembly, as shown in Figure 6. Do not tighten the set screws in pulleys to the shafts at this time, leave the pulleys loose on the shafts so they can slide for further adjustment.

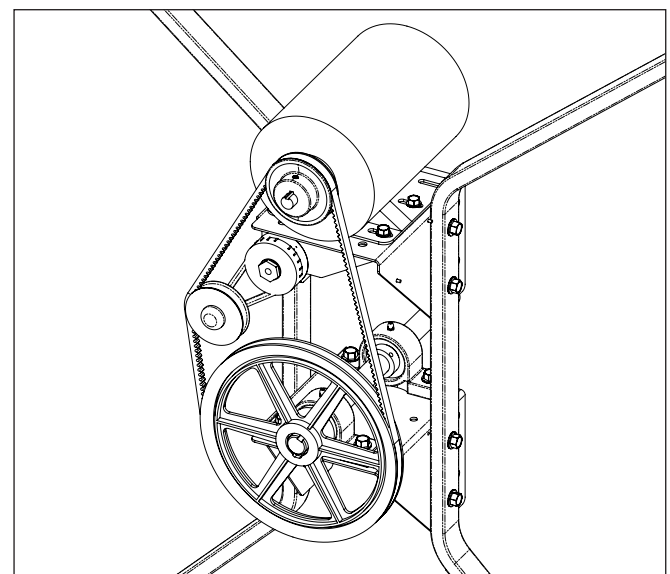
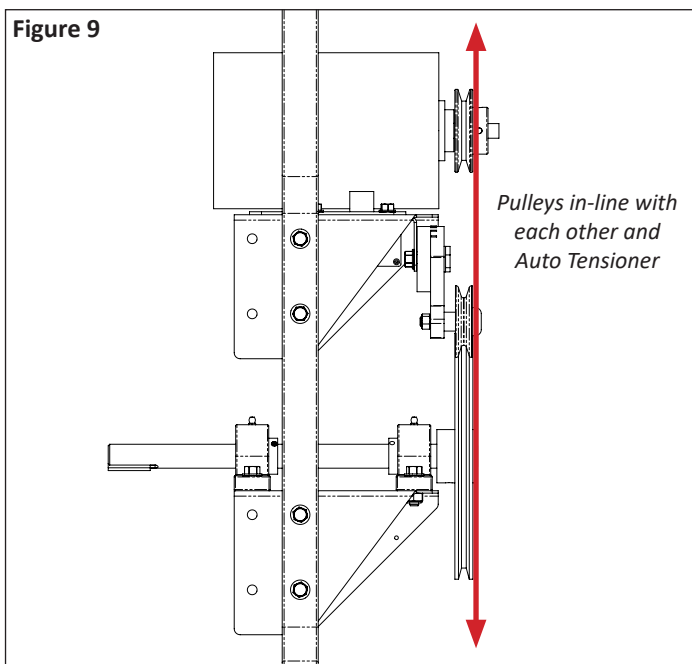
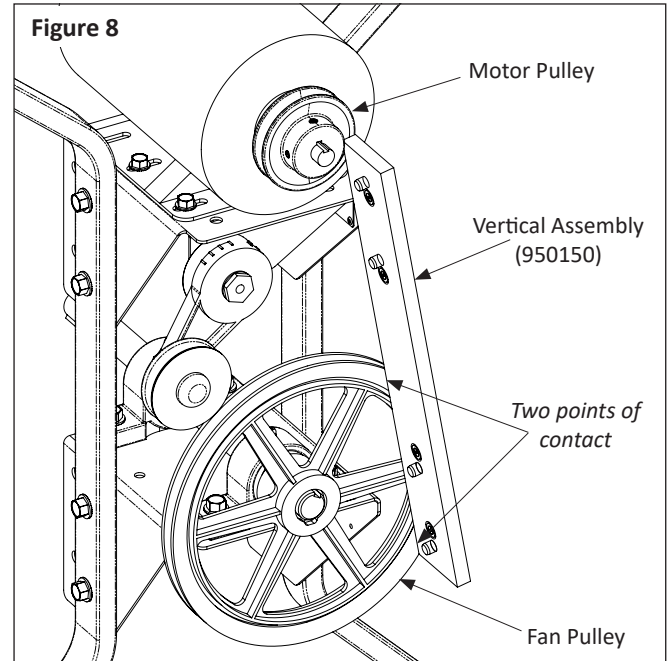
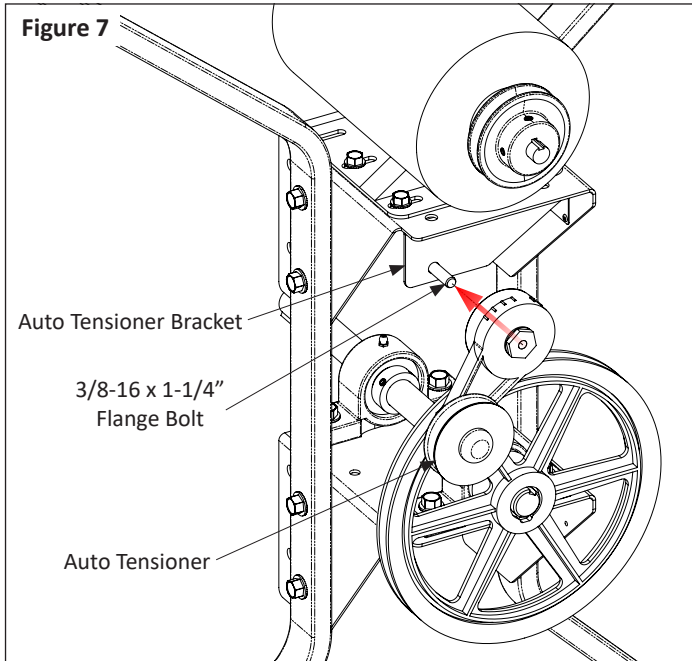


Knock Down Fan Assembly Fixture Installation - continued

Pulley Alignment

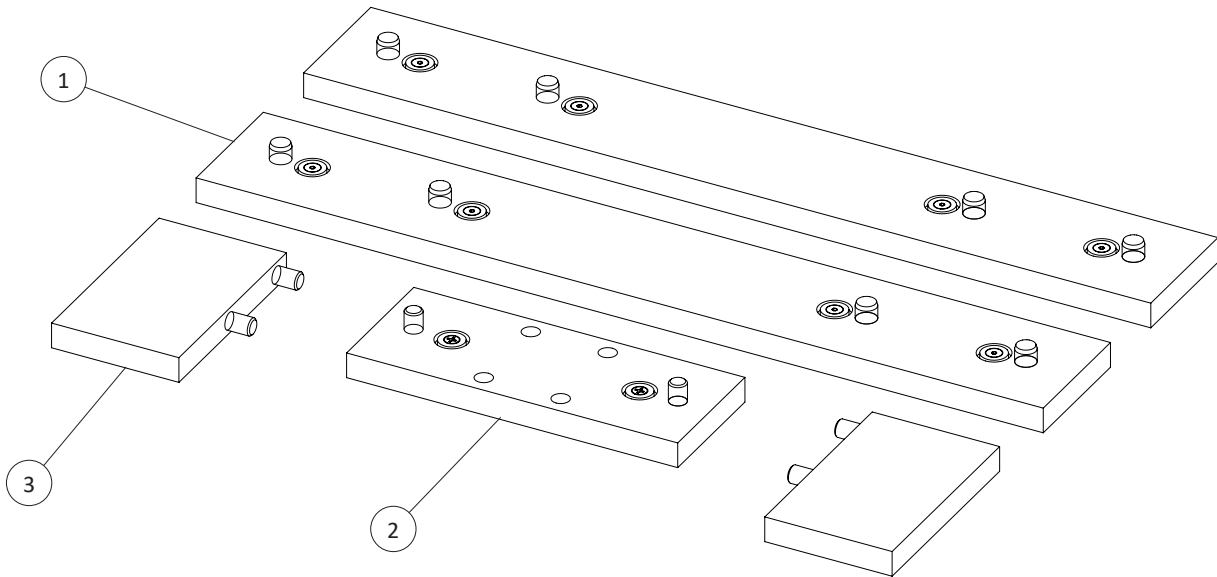
7. Attach the auto tensioner (980066) to the auto tensioner bracket using a 3/8-16 x 1-1/4" flange bolt (936026) as shown in Figure 7, and **leave the bolt finger tight until instructed to tighten**. Align the fan pulley with the auto tensioner.
8. Once the pulleys are both assembled to their respective shafts, use one of the vertical assemblies to align them flush with each other, as shown in Figure 8. Figure 9 shows the pulleys in-line with each other and the auto tensioner.

NOTE: Make sure there are two points of contact across the face of the large fan pulley that line-up flush with the face of the smaller motor pulley, as shown in Figure 8. Pulleys **MUST** align along a straight edge.



9. After the pulleys are aligned, tighten the set screws provided with each to their respective shafts securely, approximately 80 – 85 in. lbs. (9 Nm), and finish completing the assembly as instructed in the **Fan Installation Manual** associated with the fan being installed.

Parts List



ITEM #	PART #	QTY	DESCRIPTION
KNOCK DOWN FAN ASSEMBLY FIXTURE (950160)			
1	950150	2	VERTICAL ASSEMBLY
2	950155	1	SHAFT LOCATOR BOTTOM ASSEMBLY
3	950159	2	SHAFT LOCATOR TOP ASSEMBLY

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