

# Agitator Conversion Kit

3A1931A  
ENG

*For converting agitator 1.5.5B to 24K360. For professional use only.*

## Part 24K408



### Important Safety Instructions

Read all warnings and instructions in this manual and the Gusmer-Decker RC system manuals. Save all instructions.

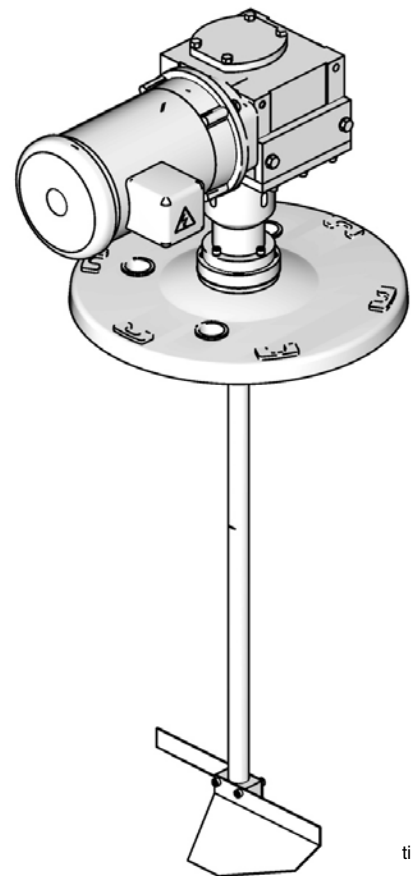
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## Related Manuals

Manuals are available at [www.graco.com](http://www.graco.com). Related manuals listed are in English.

Gusmer-Decker RC Manuals	
Part	Description
312750	Gusmer-Decker RC Operation
312751	Gusmer-Decker RC Repair and Parts
313264	Gusmer-Decker RC Electrical Diagrams

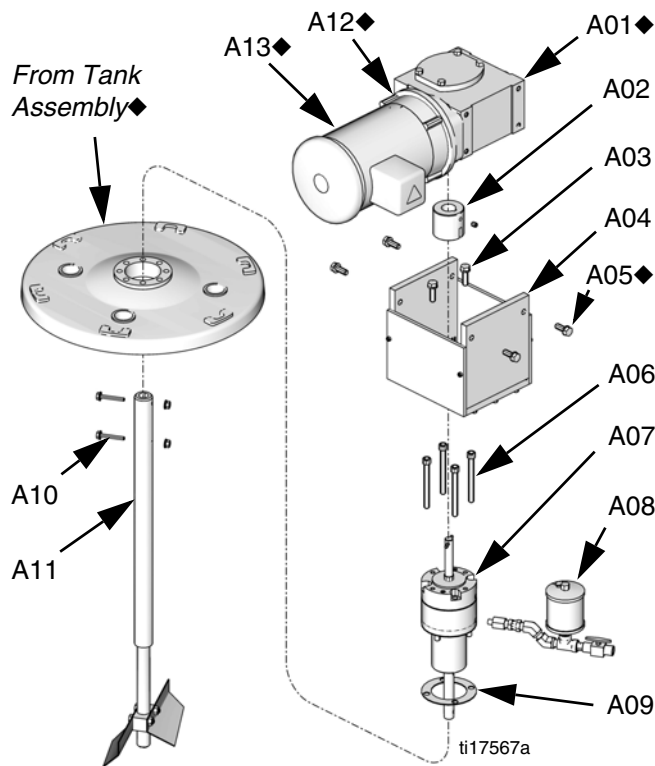


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*Kit is shown assembled with agitator motor, gear reducer, and tank lid for reference only*

# Installation

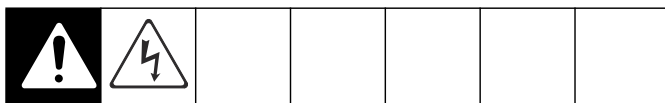
## Remove Agitator 1.5.5B



◆ Items are needed during 24K408 installation. All other items can be discarded.

FIG. 1

1. Perform the Shutdown and Pressure Relief Procedures in the Gusmer-Decker RC system manual.



2. Disconnect incoming power from agitator motor.
3. Disconnect all air lines from lid.

**!** To prevent injury, use proper lifting equipment to raise the tank lid and agitator assembly.

**NOTE:** The tank lid and agitator assembly weighs approximately 100 lb (45 kg).

4. Loosen tank lid clamps then remove tank lid and agitator assembly from tank.
5. Remove two hex head cap screws (A10) then remove agitator shaft (A11) from agitator housing (A07).
6. Remove lube cup and fittings assembly (A08) from the agitator housing (A07).

**NOTE:** Before performing the following step, use a small piece of masking tape to note the location of the motor relative to the tank lid. This will ensure the motor (A13) is re-installed in the proper orientation.

7. Remove four screws (A12) then remove agitator motor (A13) from gear reducer (A01).
8. Remove four screws and washers (A05) then remove gear reducer (A01) from base (A04).
9. Loosen coupling set screw then remove coupling (A02) from gear reducer.
10. Remove two hex head cap screws (A03) then remove base (A04) from agitator housing (A07).
11. Remove four socket head cap screws (A06) then remove agitator housing (A07) and seal (A09) from tank lid.

**NOTE:** Prior to beginning the **Install Kit 24K408 Components** procedure, discard or set aside all items except those noted in FIG. 1. This will prevent confusing parts from 1.5.5B with parts from 24K408.

## Install Kit 24K408 Components

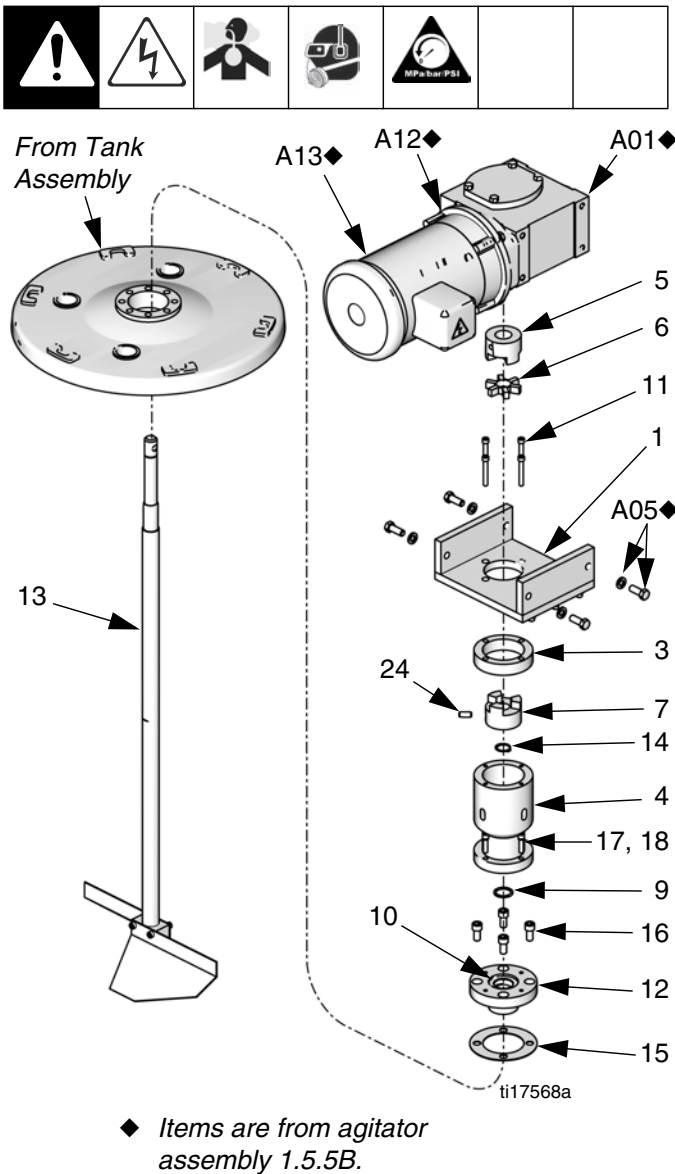


FIG. 2

1. Perform the **Remove Agitator 1.5.5B** procedure on page 2.
2. Use four screws (16) to install housing (12) and gasket (15) onto tank lid. Torque screws (16) to 30-45 ft-lb (41-61 N•m).
3. With spacer (9) installed over seal (10), use four screws (18) and washers (17) to install housing (4) onto other housing (12). Torque screws (18) to 75-80 in-lb (8.5-9.0 N•m).

4. Insert agitator shaft (13) through housings (4, 12) then use snap ring pliers to install snap ring (14) onto groove in shaft (13).
5. Rotate agitator shaft (13) so that flat spot for set screw is viewable through the opening in the housing (4).
6. Apply sealant (25) to set screw (24) then insert set screw into coupling (7).
7. Install coupling (7) onto agitator shaft (13).
8. Verify the set screw in the coupling (7) is located over the flat spot on the agitator shaft then temporarily tighten the set screw.

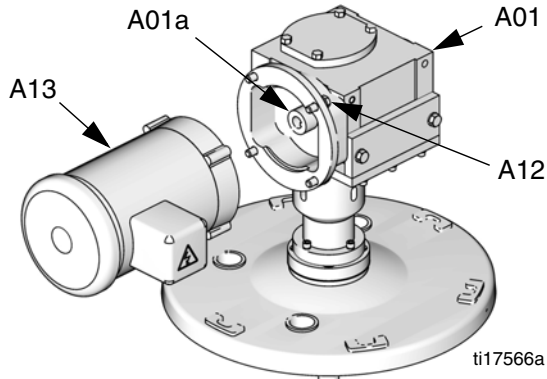
**NOTE:** In the following step, be sure to install base (1) so that motor can be installed in the orientation noted when it was removed. The opening in the base is off-center so the gear reducer will only fit in the base one way.

9. Place spacer (3) onto housing (4) then use four screws (11) to install base (1) onto spacer and housing assembly. Torque screws (11) to 8-12 ft-lb (11-16 N•m).

**NOTE:** In the following step, the face of the coupling (5) should be flush with the end of the gear reducer shaft (A01).

10. Install coupling (5) and alignment disk (6) onto gear reducer shaft (A01). Apply sealant (25) to set screw in coupling (5) then tighten set screw.
11. While rotating the agitator shaft (13) back and forth, insert gear reducer (A01) into base (1) then install screws and washers (A05). Torque screws (A05) to 30-45 ft-lb (41-61 N•m).

**NOTE:** In the following step, the agitator shaft must be rotated by turning the gear reducer input sleeve shaft (A01a). Attempting to rotate the agitator shaft by rotating the agitator shaft itself will not work. This is due to the design of the gear reducer. See FIG. 3.



**FIG. 3: Gear Reducer Input Sleeve Shaft**

12. Rotate the gear reducer input sleeve shaft (A01a) to turn the agitator shaft so that the set screw (24) in the coupling (7) is visible through the opening in the housing (4).
13. Loosen the set screw (24) in the coupling (7), then slide the coupling (7) against the other coupling (5) and tighten the set screw (24).

**NOTE:** The previous step ensures the two couplings are fully engaged.

14. Use screws and washers (A12) to install agitator motor (A13) onto gear reducer assembly (A01).

To prevent injury, use proper lifting equipment to raise the tank lid and agitator assembly.						

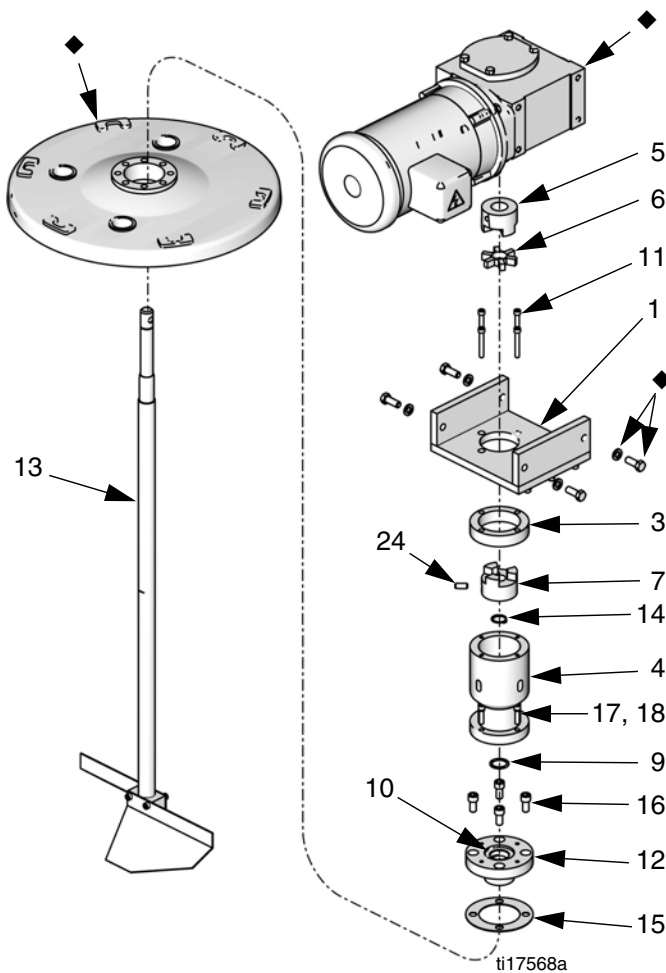
**NOTE:** The tank lid and agitator assembly weighs approximately 100 lb (45 kg).

15. Install agitator and tank lid assembly onto tank and tighten the lid clamps.

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16. Connect incoming power to the agitator motor.
17. Connect air lines to tank lid.

# Parts



Ref	Part	Description	Qty
1	24K359	BASE, agitator plate assy	1
3	15V746	SPACER, agitator motor	1
4	15Y358	HOUSING, upper, agitator, ASME, electric	1
5	121963	COUPLER, agitator motor, 1 in.	1
6	122760	COUPLING, alignment, disk, TPE	1
7	122761	HOSE, alignment, hub	1
8	122774	BEARING, ball, 3/4 bore x 1-3/4 dia. x 1/2	2
9	15Y360	SPACER, seal, shaft, ASME, agitator	1
10	122772	SEAL, 0.875 x 1.125, PTFE	1
11	---	SCREW, cap, sch	4
12	16K284	HOUSING, agitator to lid	1
13	24K358	BLADE, agitator assy	1
14	122776	RING, ret, ext, 0.750, ms	1
15	16K285	GASKET, agitator to lid	1
16	---	SCREW, cap, sch	4
17	---	WASHER, lock, spring (hi-collar)	4
18	---	SCREW, cap, sch	4
24	---	SCREW, socket head set screw, 5/16-18 x 0.75	1
25	113500	ADHESIVE, anaerobic, 0.017 fl oz, 0.5 ml	1

--- Not for sale.

◆ Items are not included with kit 24K408. Shown for reference only.

# Technical Data

See Gusmer-Decker RC system manual for technical data.

# Graco Standard Warranty

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*Original instructions. This manual contains English. MM 3A1931*

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