

# Instructions



Read warnings and instructions.

## Agitator Modification Kit 237565

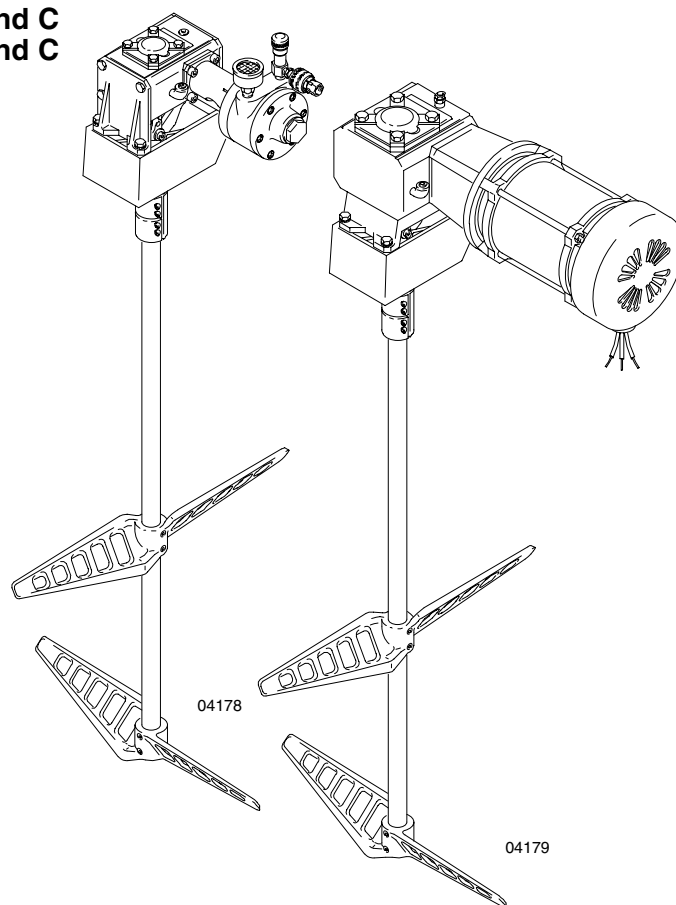
308481

Rev. F

**Model 218644 Agitator, Series A, B, and C**  
**Model 218645 Agitator, Series A, B, and C**

The kit consists of the following parts:

Ref. No.	Part No.	Description	Qty.
1	101524	SEAL	2
2	109478	LOCKNUT	1
3	112865	SET SCREW	1
4	112866	SCREW, shoulder	1
5	112867	WASHER	1
6	104034	WASHER	1
7	101526	BEARING, sleeve	1
8	112882	UNIVERSAL joint	1
9	112883	SET SCREW	1
10	190158	SHAFT	1
11	190271	KEY	1
12	190248	SPACER	1
13	190157	MOUNTING, gear reducer	1
14	070325	SEALANT, Loctite	1
15	161220	GASKET	1
16	150707	PLATE	1
17	100055	SCREW, drive	2



### WARNING

#### Hazard of Using Fluids Containing Halogenated Hydrocarbons

Never use 1,1,1-trichloroethane, methylene chloride, other halogenated hydrocarbon solvents or fluids containing such solvents in this equipment. Such use could result in a serious chemical reaction, with the possibility of explosion, which could cause death, serious injury and/or substantial property damage.

Consult your fluid suppliers to ensure that the fluids being used are compatible with aluminum and zinc parts.

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# Installation for Agitator Model 218644

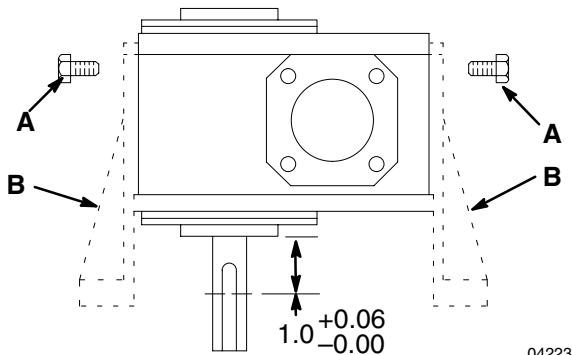
## Applicable Manuals

Instruction-Parts List 307693 Rev D  
Instruction-Parts List 307693 Rev E

**NOTE:** Reference numbers in parentheses refer to the **Ref No.** of the Parts Drawings and Parts Lists in the Instruction-Parts List manuals listed above.

## Disassembly

1. Refer to Instruction-Parts List 307693 Rev D.
2. Remove shaft (37) and coupling (18).
3. Remove screws (4), washers (2), and gear reducer (25) with universal shaft assembly (38).
4. Remove universal shaft assembly (38) from gear reducer (25). Save key (19).
5. Loosen hose clamp (10) and remove hose clamp, flexible coupling (7), and air motor (23).
6. Remove screw (9) and washer (2) and remove gasket (21) and gear reducing mount (26).
7. Remove four screws (A) and remove two mounting feet (B) from gear reducer (Fig 1).



## Modification

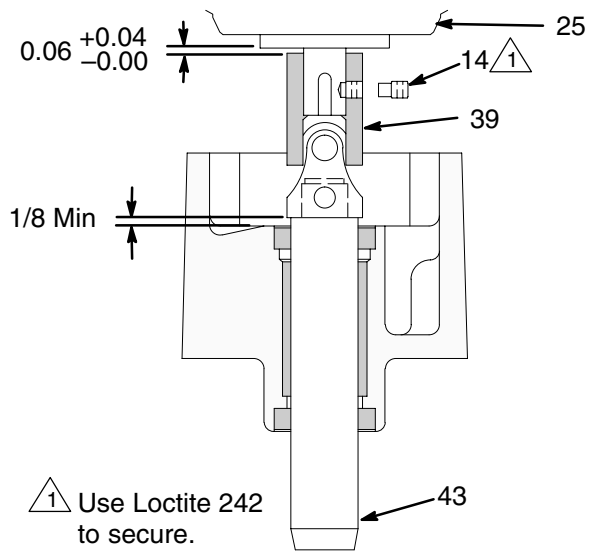
1. Cut output shaft of gear reducer (25) with a band saw per dimension in Fig 1.
2. Cut and shape key (19) to fit shortened keyway of output shaft.

## Assembly

1. Refer to Instruction-Parts List 307693 Rev E.
2. Fig 1. Install two mounting feet (B) on gear reducer (26) with four screws (A).
3. Install gasket (21) and gear reducing mount (26) with washer (2) and screw (9).
4. Install hose clamp (10), flexible coupling (7), and air motor (23). Tighten hose clamp (10).
5. Assemble universal joint (39) and agitator shaft (43) with shoulder screw (42), washer (41), washer (40) and locknut (38).
6. Slide universal joint (39) on output shaft of gear reducer (25) and locate as shown in Fig 2.

**NOTE:** Location of universal joint is not critical, but make sure that dog set screw (44) is pushing on key (19). Dog set screw supports the weight of the shaft.

7. Install gear reducer (25), universal joint (39) and shaft (43) with screw (4), washer (2).
8. Install shaft (37) and coupling (18).



# Installation for Agitator Model 218645

## Applicable Manuals

Instruction-Parts List 307693 Rev D  
Instruction-Parts List 307693 Rev E

**NOTE:** Reference numbers in parentheses refer to the **Ref No.** of the Parts Drawings and Parts Lists in the Instruction-Parts List manuals listed above.

## Disassembly

1. Refer to Instruction-Parts List 307693 Rev D.
2. Remove shaft (19) and coupling (12).
3. Remove screws (26), washers (27), and gear reducer (29) with universal shaft assembly (20).
4. Remove universal shaft assembly (20) from gear reducer (29). Save key (13).
5. Remove screws (26) and washers (27) and remove electric motor (28) from gear reducer (24).
6. Remove screws (6) and washers (2) and remove gasket (15) and gear reducing mount (17).
7. Remove four screws (A) and remove two mounting feet (B) from gear reducer (Fig 3).

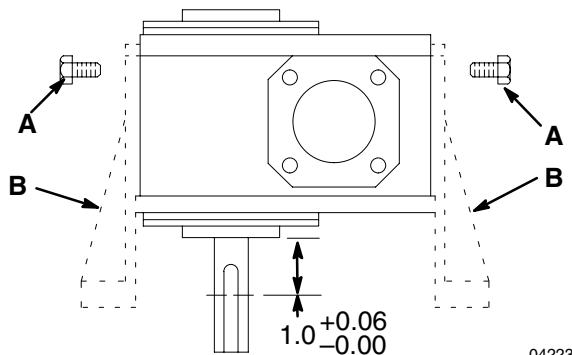


Fig. 3

## Modification

1. Cut output shaft of gear reducer (29) with a band saw per dimension in Fig 3.
2. Cut and shape key (13) to fit shortened keyway of output shaft.

## Assembly

1. Refer to Instruction-Parts List 307693 Rev E.
  2. Fig 3. Install two mounting feet (B) on gear reducer (24) with four screws (A).
  3. Install gasket (12) and gear reducing mount (14) with washers (2) and screws (6).
  4. Install electric motor (27) on gear reducer (24) with screws (25) and washers (26).
  5. Assemble universal joint (17) and agitator shaft (23) with shoulder screw (19), washer (21), washer (20) and locknut (18).
  6. Slide universal joint (17) on output shaft of gear reducer (24) and locate as shown in Fig 4.
- NOTE:** Location of universal joint is not critical, but make sure that dog set screw (22) is pushing on key (13). Dog set screw supports the weight of the shaft.
7. Install gear reducer (24), universal joint (17) and shaft (23) with screws (4), washers (2) and spacers (28).
  8. Install shaft (16) and coupling (10).

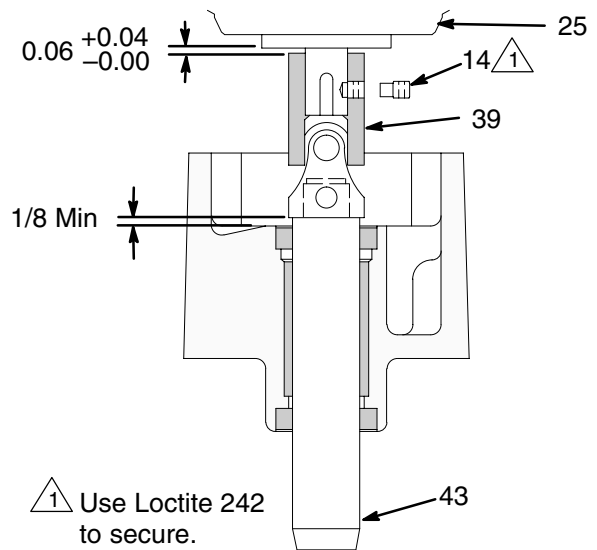


Fig. 4

# Graco Phone Number

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**1-800-367-4023 Toll Free**

**612-623-6921**

**612-378-3505 Fax**

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