

ASSEMBLY INSTRUCTIONS FOR ACE 6469 (12L AND 22L) PILOT PLANT ASSEMBLIES

Tools needed: Screw Driver, Adjustable Wrench or Pliers and Allen Wrench Set.

- 1) Unpack all parts. Check items received against packing list for possible missing items.
- 2) Assemble frame support first. Find three legs with welded flat below hole at top and turned foot (longer), three extender legs (shorter) with turned foot [extender legs area part of the special support.], ring support, triangle with open front, straight flat connector and hex head bolts. For Special Support, secure extender leg to lower back of leg with welded flat, foot at bottom, pointing out in both cases, with hex bolts. Repeat with two other legs. Attach leg to outside of ring with hex bolt, ring should rest on flat, repeat with other two. Stand frame up and slide triangle around outside of three legs leaving front open. Line holes up on legs and secure with hex bolts. Straight flat connector closes open end of triangle.
- 3) Set heating mantle in frame and place flask in mantle.
- 4) Find Catalog No. 6468-13, two piece Head Clamp and eight nuts and bolts. Remove insert from one half of clamp and gently slide over center neck of flask, flat side up, and replace insert.
- 5) Attach 8089/8091 Agitator to 8071/8079 Rod. Slide collar and lock nut of agitator over top
- 6) Insert rod with agitator attached into center neck of flask. Slip 6495-10 Gasket over rod and then 6469-26 Head over rod. Place other half of head clamp over rod and head, flat side down, and secure loosely with bolts and nuts at positions 1,4,5, and 8. See Fig 2. **IMPORTANT: Teflon Rod may need to be shortened to fit. Complete remainder of assembly only to the extent that you can determine if rod needs to be cut to be able to secure in chuck and be off bottom of flask.**
- 7) Into positions 2, 3, 6, and 7, insert straight rods of motor mount, long thread down with one nut on each as stop. Secure bottom with second nut. All bolts and nuts can now be tightened with even torque.
- 8) Slide 8042/8065 Bearing over rod and insert lightly greased joint into head joint.
- 9) Secure motor mount platform to top of four vertical rods with nuts. Large hole in platform should be over rod.
- 10) To 13649-12 motor attach black motor base and to geared shaft attach 8124 Chuck using Allen wrench. Remove locking cap and donut ring from chuck and slide them over rod, in that order with countersink of ring facing flask. Slip neoprene insert over end of rod.
- 11) Carefully, bolt motor to platform so chuck lines up with rod. Secure bent aluminum support rods to rear top of platform and secure bottom, with "C" clamps to lip of heating mantle. Make any necessary adjustments now to position rod vertically in bearing and secure rod in chuck. Be sure rod runs true and is off bottom of flask.
- 12) Secure 6469-40 Stopcock Adapter to bottom spherical joint of flask using 7666-15 Clamp in the following manner. Remove inner flat section of clamp from outer. Remove "C" insert, slide flat section over ball joint on flask, insert side down, and replace insert. Section should not fall off ball joint. Next, remove "C" insert from outer section of clamp, slide over socket joint of adapter and slide insert on. You should now be able to hold outer section of clamp without adapter falling. Now, secure lightly greased socket joint to flask ball joint by threading inner flat to outer section of clamp. Tighten clamp using spanner wrench supplied.
- 13) Connect motor controller to motor, voltage controllers to mantles (Note! voltage controllers cannot be mounted as shown in photo) and then to power source. Place thermometer, funnel and stopper in their respective openings. You should now be ready to operate.

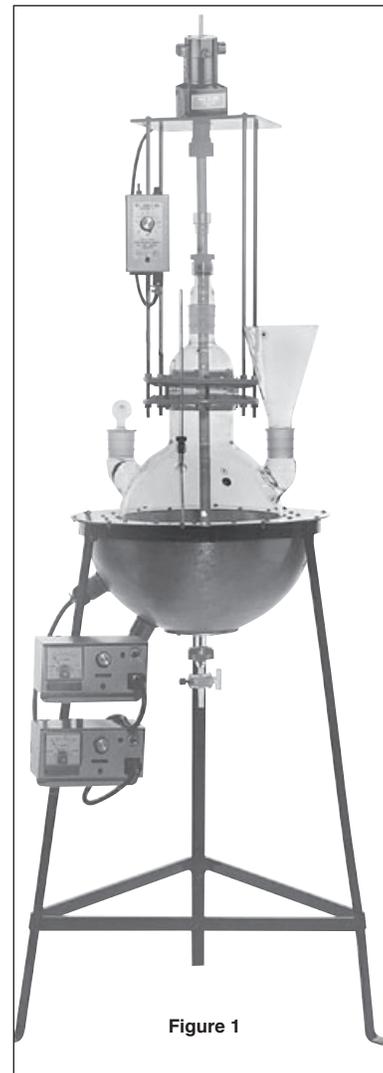
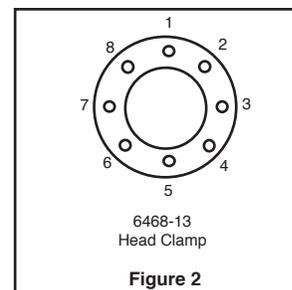


Figure 1



6468-13
Head Clamp

Figure 2

