



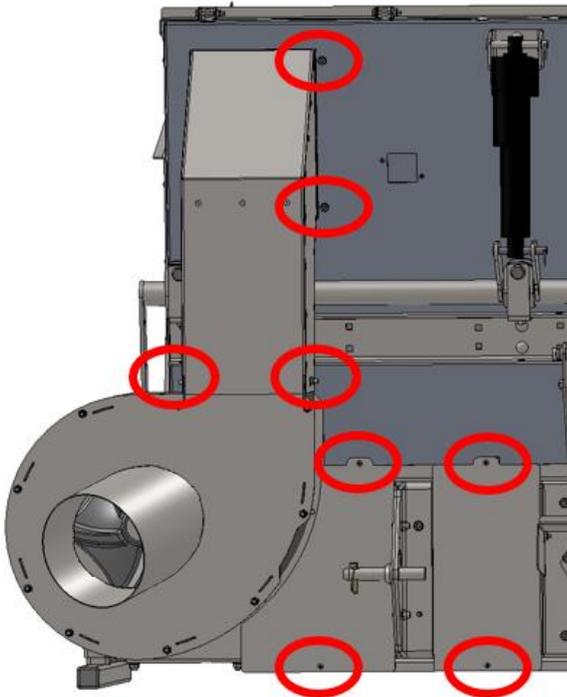
ST70016

TKV20 Urethane Impeller Conversion Kit Installation Instructions

Parts Included

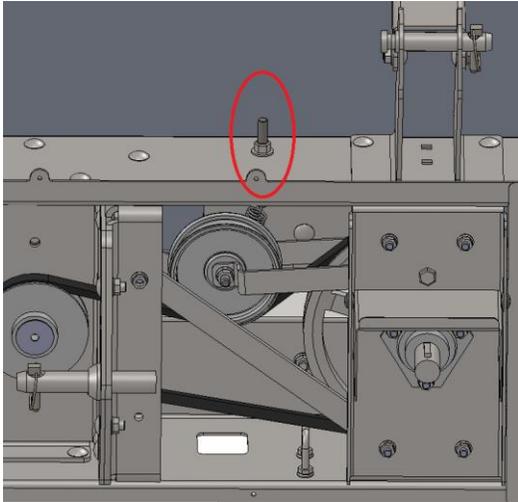
Part Number	Description	Qty
ST48629	Urethane Impeller	1
ST48686	Stepped 1.00" diameter drive shaft	1
ST65209	Key SQ 1/4 x 1-1/8	2
ST65286	5/16" ID X 2" OD X 1/4" thick washer	1
ST65014	5/16" X 1" long flange bolt	1
ST44028	Anti-Seize Lubricant Single Use Pouch 4g	1
ST44029	Threadlocker Medium Strength Blue Single Use Pouch 1g	1

Step #1



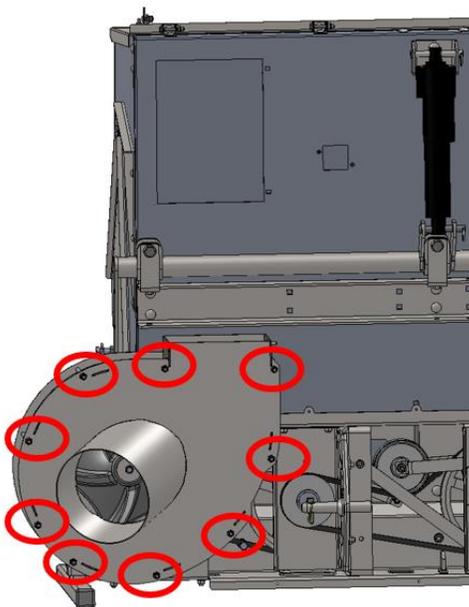
- 1.) Remove the circled 4 nuts/bolts from the upper chute.
- 2.) Remove upper chute by tilting it back, sliding it upward and into the metal bin.
- 3.) Remove the circled 4 philips sheet metal screws.
- 4.) Both drive system guard plates can now be removed.

Step #2

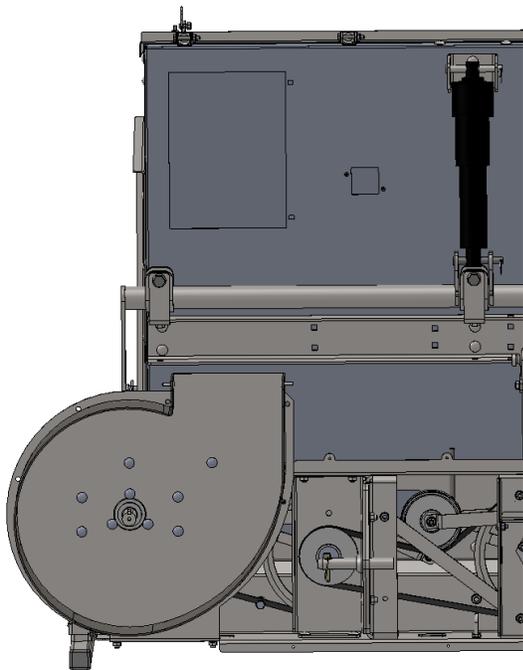


- 1.) Note the length of exposed threads on tension rod and loosen nut to remove tension from drive belt on blower

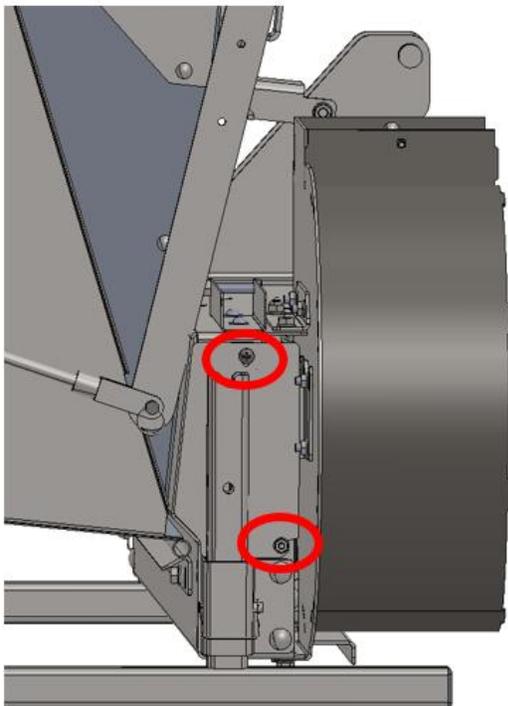
Step #3



- 1.) Remove the circled 9 nuts/bolts.
- 2.) Remove blower housing front.
- 3.) Remove 1 bolt/washer holding on impeller.
- 4.) Remove metal impeller.
- 5.) See image below for reference after removal of items.

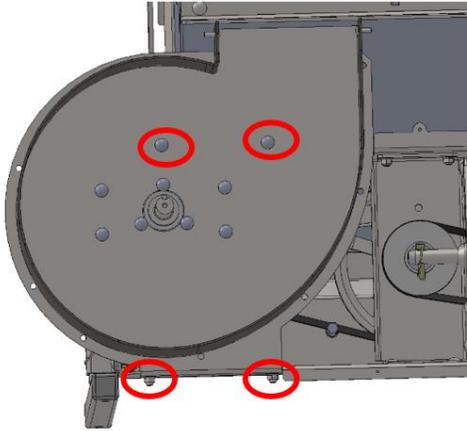


Step #4



- 1.) Remove the circled 2 nuts/bolts.
- 2.) Remove side cover plate.

Step #5

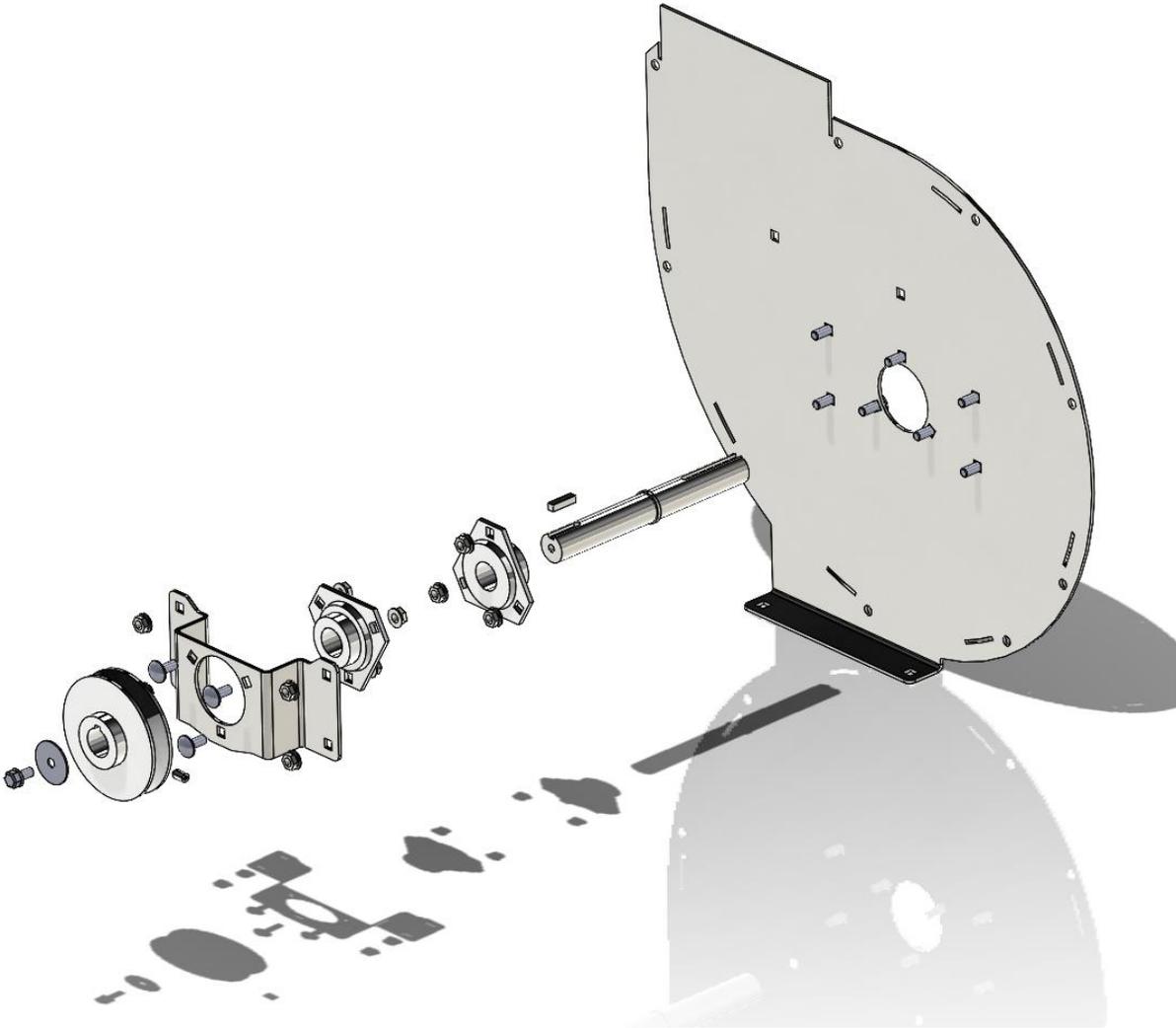


- 1.) Remove metal outer blower housing ring.
- 2.) Remove the circled 4 nuts/bolts.
- 3.) Remove circled belt from pulley behind impeller.
- 4.) Entire blower housing back assembly can now be removed from the entire unit.



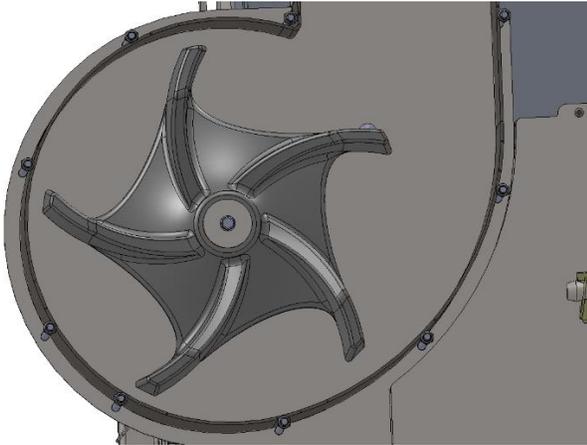
Step #6

- 1.) Reference parts diagram below to replace original shaft with new stepped shaft. Disassemble shaft/bearing/pulley/bracket assembly and reassemble in reverse order replacing the shaft with new stepped shaft. Make sure the keyway ends for the new shaft are in the correct orientation per the diagram below. The longer keyway will be the end that the new urethane impeller goes onto. Do not forget to install the keys, and tighten all set screws on bearings and pulley.





Step #7



- 1.) Once drive unit is assembled with new stepped shaft, reassemble everything in the reverse order. Apply anti-seize compound on the shaft for the urethane impeller metal hub connection. Install key and slide Impeller onto shaft.
- 2.) Apply threadlocker to threads on supplied 5/16" x 1" flange bolt and secure urethane impeller with 1/4" thick washer and 5/16" x 1" flange bolt .
- 3.) After tightening the bolt, spin the urethane impeller/belt assembly and make sure entire assembly rotates freely.

Step #8

- 1.) Complete the rest of the reassembly by following these instructions in reverse starting on step #5. Ensure all bolts and nuts are securely fastened and belt is tensioned