

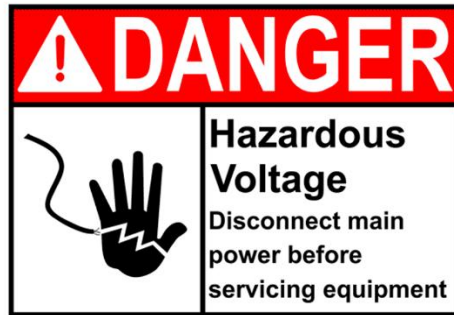
HCM Seal Plate Conversion Installation Instructions

Recommended Tools:

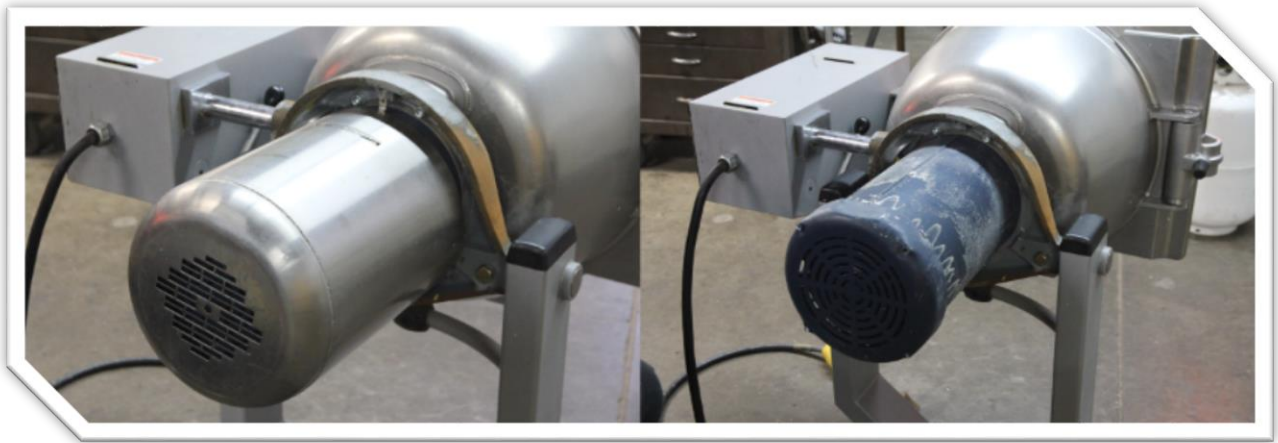
- Standard Socket and Wrench Set
- Food Grade Silicone / RTV
- Loctite® 242
- Metal File

The Kit Includes the Following Items:





1: Tilt the machine and remove the motor cover.



2: Tilt the machine up-right. Remove the electrical cabinet cover.



3: Remove the mounting bolts from the VFD and support the VFD outside of the electrical cabinet.



4: Unbolt the upper bowl support bracket from the inside of the electrical cabinet. This will also unbolt the handle shaft assembly, remove and set aside.

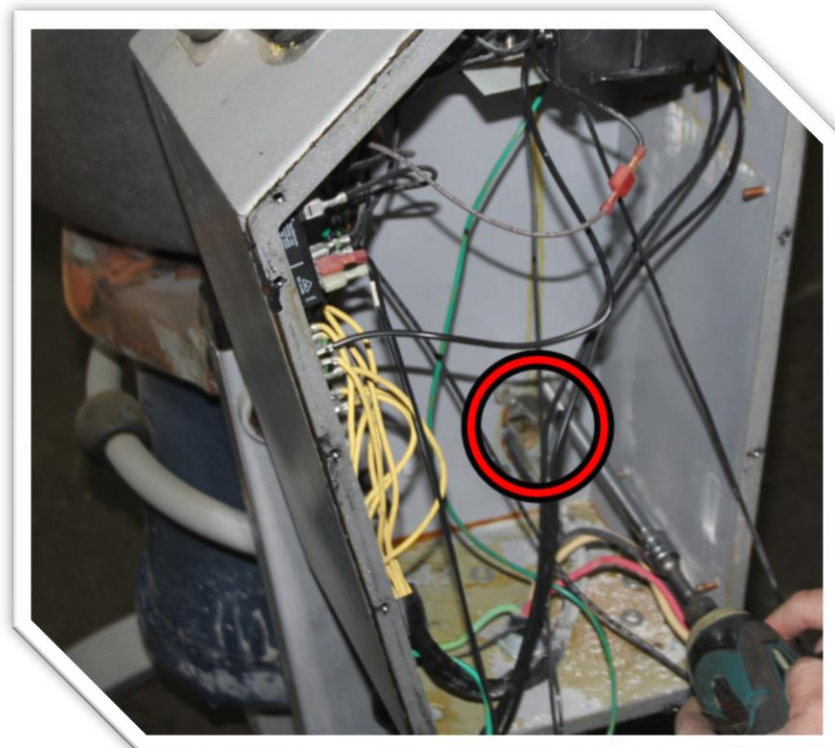


Optional: Remove the motor and start contact blocks for easier access. This job can be done without removing these components by utilizing a swivel socket to remove the support bracket nuts.

5: Open the lid. Remove the locking handle by removing the top nut.



6: Locate the nuts for the lower support bracket. Only remove the top two bolts and unscrew the bottom two 50% of the way. This will allow the electrical cabinet to pivot out of the way enough for the bowl to be removed. Avoid pinching the motor leads as the cabinet pivots. It is best to have someone else hold the cabinet in place when the bowl is removed in the next steps.



7: Carefully tilt the machine horizontal and remove the 4 bowl mounting screws. A cheater bar is recommended as the short side of the allen keys will not reach.



8: Tilt the machine vertical. Remove the upper bowl support from the electrical cabinet. You will have to break the seal of the OEM silicone sealant.

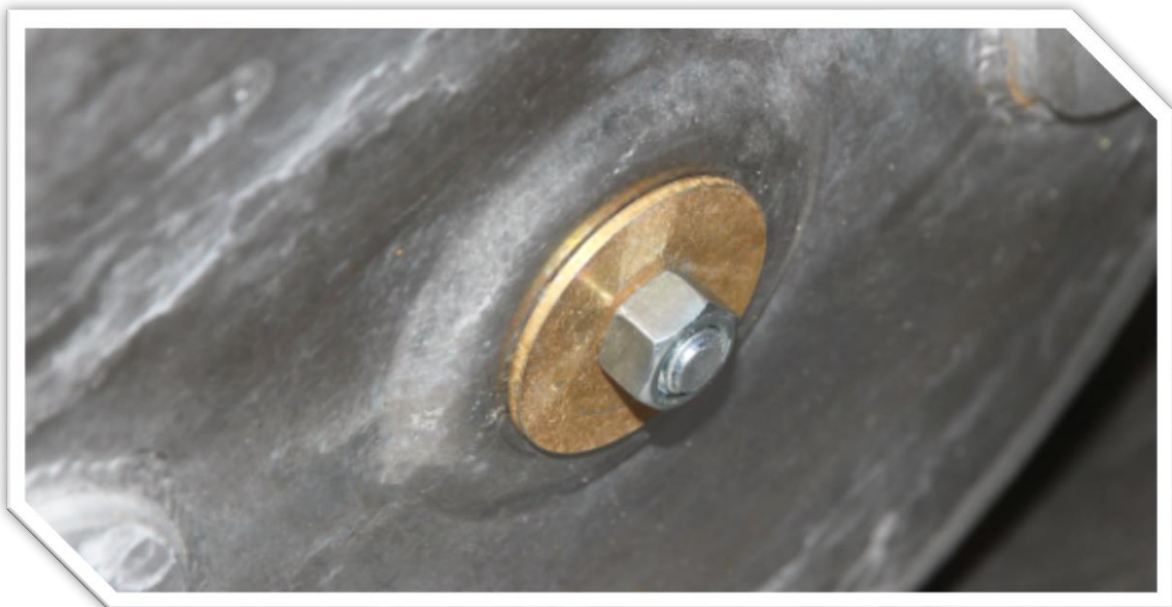


9: Remove the bowl. Install the drill jig from the inside of the bowl using the bolt, nut and washer.

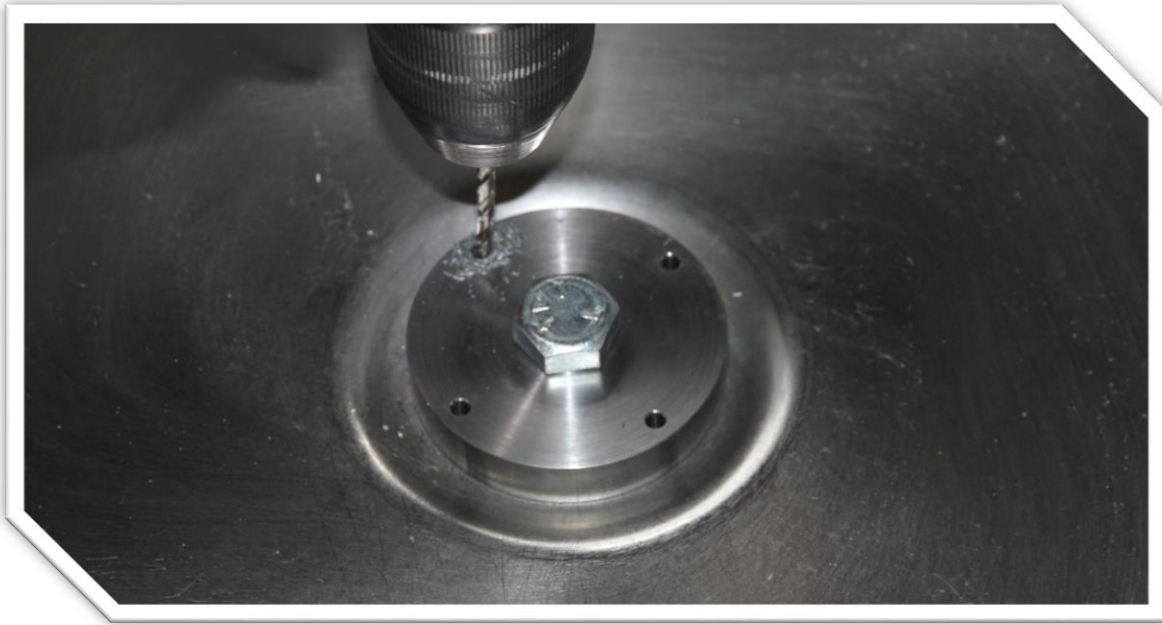
Important: For easy maintenance access (i.e. replacing gaskets), you will want to orientate the drill jig as shown. This will give better access to the nuts that will be installed on the underside of the bowl.



10: Tighten the nut on the underside of the drill jig:



10: Using the drill jig, drill the four holes needed for the seal plate installation. Be sure to hold the drill as vertical as possible for an accurate hole-pattern.



11: Remove the drill jig from the bowl and use a flat file to clean up any burrs on the bottom of the bowl. Check and clear any burrs on the inside of the bowl.

12: Install one to three gaskets on the seal plate and install through the drilled holes. For most machines, two gaskets is the perfect height for the bowl seal to seal correctly. The bowl seal fits properly when the v-seal makes contact with the seal plate.



13: Apply a small amount of Loctite® 242 (aka Blue Loctite®) to the nylon lock nuts. This will prevent the nuts from backing out due to vibrations.

14: Screw the prepped nylon nuts onto the studs of the seal. Tighten the nuts just enough for the gasket to seal to the inside of the bowl.

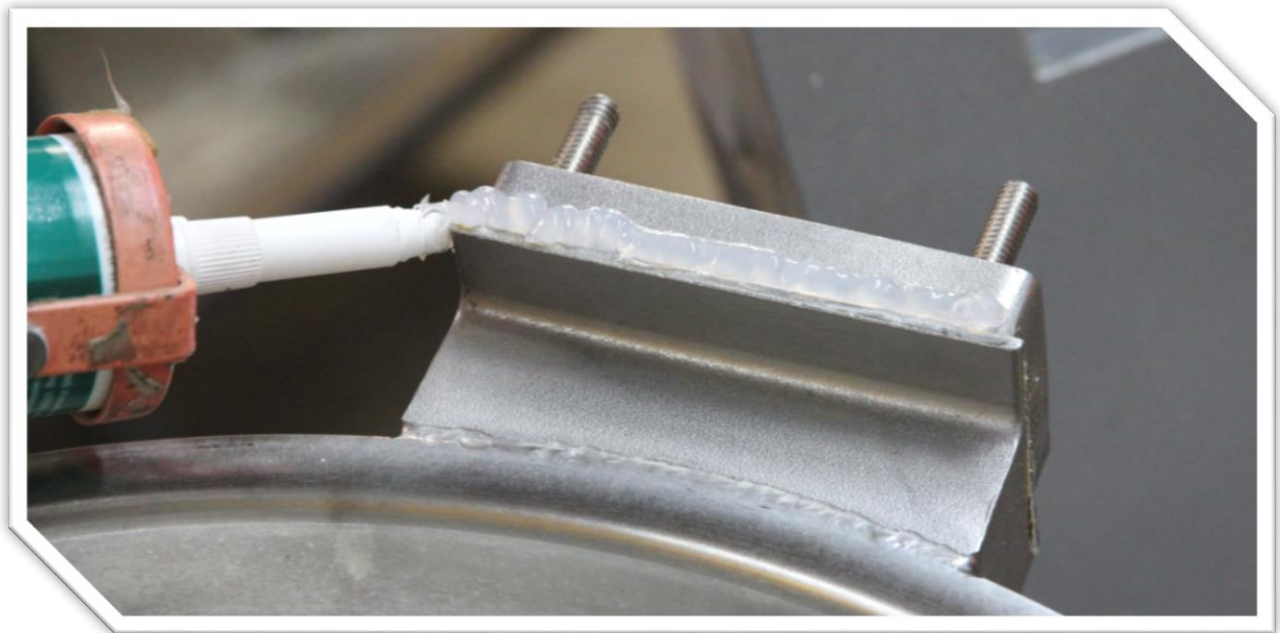
Important: Do not over tighten the nuts!



15: Remove any old silicone / RTV from the upper support bracket on the electrical cabinet.



16: Apply food grade silicone / RTV to the upper support bracket. Apply liberally and remove excess after installation.



Note: This bowl seal conversion kit will NOT work with the large style plastic spin off disks. JPM spin off disks (P/N: 944081) are available for purchase online at jpmparts.com.



17: Place the bowl back onto the machine.

18: Re-install the bolts for the upper support bracket, along with the handle shaft assembly.

19: Tilt the machine horizontal and install the 4 bowl mounting screws.

20: Tilt the machine vertical. Install the top two lower support bracket bolts. Tighten the bottom two lower support bracket bolts.

21: Install the VFD with the 3 mounting nuts.

22: Replace the electrical cabinet cover.

23: Apply the provided food grade lubricant on the inside of the provided bowl seal, along with the face of the black v-seal. Install the bowl seal on the shaft, pushing down until the bowl seal seats in position. Wipe away excess lubricant.



24: Fill the bowl with enough water to cover the seal and check for leaks.

Optional Steps Information:

If the motor contact block was removed be sure to **check for proper rotation**. Switch two lead wires if the mixer is spinning counter-clockwise. Clockwise is proper rotation. Amp draw should be in a range of 11 to 14 amps.

Questions? Concerns? Call us toll free! (800) 651-9271. You can also e-mail us anytime at sales@vcmparts.com. Thank you for your business!

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