

Assembly Process
of
The IWAKI Magnetic Drive Pump MXM, MDM, and MDE series.
(Insertion of the Drive magnet to the Motor shaft)

This instruction manual shows how to assemble the Drive magnet and the Motor shaft. Read through the instructions on this sheet as well as each instruction manual before assembly.

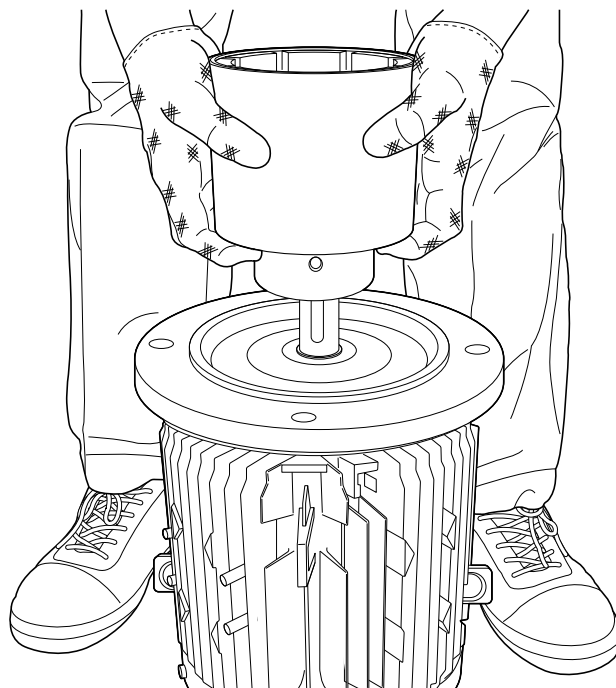
Pay attention to Magnet force field

The magnetic drive pump contains very strong magnets. The strong magnet field could adversely affect persons who are assisted by electronic devices such as pacemakers.

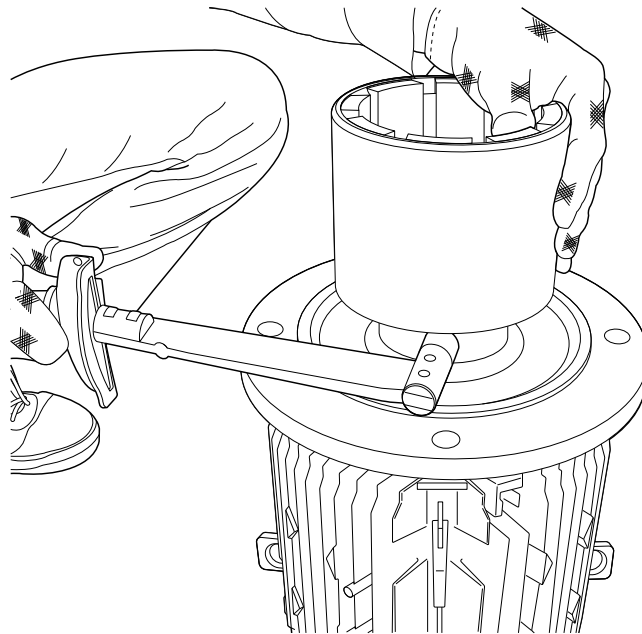


1. Assembly procedure

- (1) Make sure the pump is disconnected before assembly. If the motor rotates during assembly work, a serious accident may result.
- (2) Clean and sand the mating surface of the Motor shaft and the hole on the Drive magnet in order to remove burrs. The Drive magnet can crack easily. Be careful not to hit the Drive magnet.
- (3) Check that the Hex. socket set screw does not interfere with the Motor shaft at insertion.
- (4) Mount the Key to the Motor shaft and check the Key is mounted properly.
- (5) Mount the Drive magnet to the Motor shaft. Insert the Drive magnet until it comes to the step on the Motor shaft. If the Drive magnet is not inserted smoothly, remove the Drive magnet once and reconfirm there is nor burr and the Key is properly placed.



(6) Tighten the Hex. socket set screws to fix the Magnet drive to the Motor shaft. See the table below for the tightening torque. As for some types of the MXM, the. socket set screws need to be applied with adhesive. See the table below for the models which requires adhesive application on the screws.



Model name	Motor output	Tightening torque	Adhesive application	Adhesive agent
MXM	All	12N•m	NR	-
MDM	4.0kW or below	15N•m	NR	-
	5.5kW or above	15N•m	Required	LOCTITE Product271
MDE	All	15N•m	Required	LOCTITE Product271

(7) After fixing the Magnet drive on the Motor shaft, pull the Magnet drive to confirm there are no looseness or a jolt.

(8) Fix the motor with the bracket.