

## Axial Replacement Fan Blade Installation

These installation instructions incorporate bulletin 1179.

Diameter and HP	28-12	24-10	24-7	24-5	18-3	18-1	14-1	12-.75
Blade	850719-1	850677-1	850685-1	850636-1	769570-1	850644-1	747527-1	850651-1
Spinner Cap	734855-1	715193-1	734301-1	715193-1	715193-1	736496-1	763284-1	734954-1
Bushing	715227-1	715227-1	715227-1	715227-1	715219-1	769059-1	715201-1	715201-1
Screw	777136-2	777128-2	777136-2	777128-2	777128-2	777100-2	777094-2	753277-2
Bolt	777144-3	777144-3	777144-3	777144-3	777144-3	707893-2	707893-2	707893-2
Bolt Torque (in-lbs)	100	100	100	100	80	60	75	60
Bolt Torque (ft-lbs)	8	8	8	8	6.5	5	6.25	5

### Chart Key:

850719-1 = (1) Fan blade with part number 850719  
 777143-3 = (3) Bolts with part number 777144

1. Disconnect power to fan to avoid any accidental starting of motor while replacing blade.
2. Remove existing spinner cap and blade.
3. Place new fan blade on motor shaft and place bushing in center of blade. Align key with motor shaft and bushing and install the bolts in the bushing. The three bolts should be fingered tightened, before being torqued down. The bolts should now be torqued to the required torque that is found in the table above. When torqueing, work around the bushing in a counter clock direction in small increments until the bolts are all torqued to the recommended torque rating.
4. Finally, install the spinner cap with the screws, taking care not to over tighten the screws enough to dent the spinner cap.
5. Make sure blade is centered in the axial fan housing. Reposition motor laterally to center from side to side. Shim the motor to motor mount bolted connection to accommodate centering the blade vertically. Then securely anchor motor in place. Finally, spin the fan blade by hand making sure that it does not contact the fan housing.
6. Reconnect power to fan and start unit to check for vibration.

**Note:** When installing or servicing electrical components, always lock out and tag out electrical power at the fan disconnect.