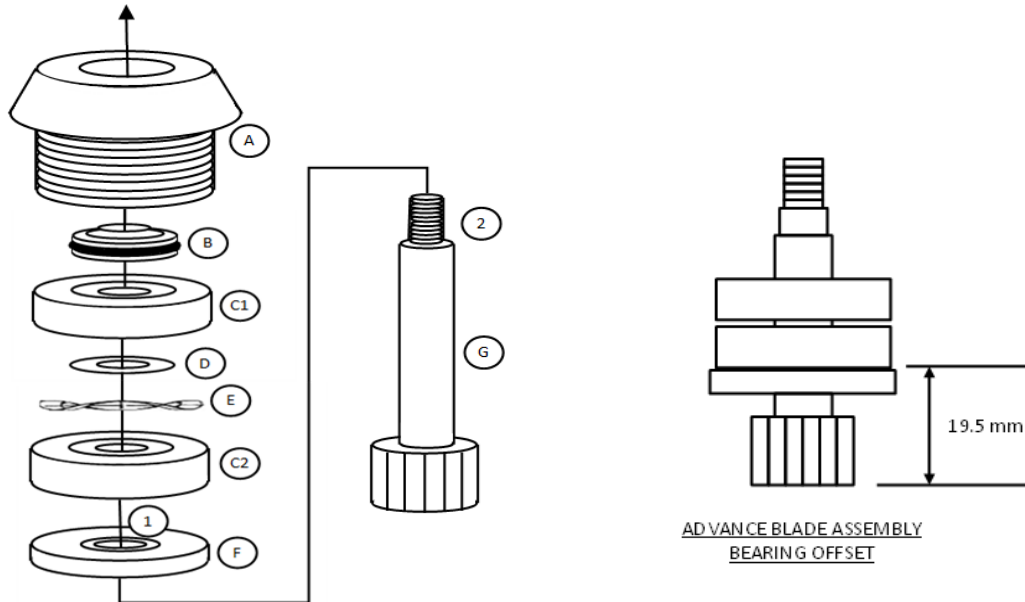


## DIAGRAM OF VITAMIX BLADE ASSEMBLY



### **INSTRUCTIONS**

- 1) DISASSEMBLE BLADE ASSEMBLY PER DETAILED INSTRUCTIONS BELOW
- 2) DISCARD BEARINGS, SEALS, WAVE SPRING. REUSE BEARING SPACER (D)
- 3) CLEAN BLADE ASSEMBLY COMPONENTS
- 4) INSTALL BOTTOM SEAL ON SHAFT (F) (ADVANCE BLADE ONLY)
- 5) APPLY LUBRICANT TO AREA (1) NOTED (ADVANCE BLADE ONLY)
- 6) PRESS BEARING (C1) ON SHAFT (G)
- 7) INSTALL BEARING SPACER (D)
- 8) INSTALL WAVE SPRING (E) DO NOT EXTEND PAST EDGE OF BEARINGS
- 9) PRESS BEARING (C2) ON SHAFT (G)
- 10) INSTALL TOP SEAL (B) IN HOUSING (A)
- 11) APPLY NSF GREASE TO SHAFT AREA (2) NOTED
- 10) APPLY LOCTITE EVENLY TO INNER SIDES OF HOUSING (A)
- 11) INSTALL COMPLETE ASSEMBLY INTO HOUSING (A) APPLY LOCTITE TO OUTER EDGE OF BEARING (C2) PRIOR TO SEATING IN HOUSING
- 12) ALLOW ASSEMBLY TO CURE 24 HOURS IN AN UPRIGHT POSITION
- 13) INSTALL BLADE AND SECURELY TIGHTEN

### **ASSEMBLY COMPONENTS**

- A) ASSEMBLY HOUSING
- B) TOP SHAFT SEAL
- C) SEALED BEARINGS (2)
- D) BEARING SPACER
- E) WAVE SPRING
- F) BOTTOM SEAL (ADVANCE BLADE ONLY)

**NOTE: FOR BEST RESULTS USE A 1/2 TON ARBOR PRESS TO PRESS BEARINGS**



Remove blade from housing assembly.



Place housing on vise and carefully remove shaft with a brass mallet.



Using a center punch, remove shaft from housing. Be careful not to damage housing assembly or shaft.



Finish removing bearings with a large punch. Using a 27mm 12 point socket will prevent damage to housing.



Thoroughly clean blade assembly components.



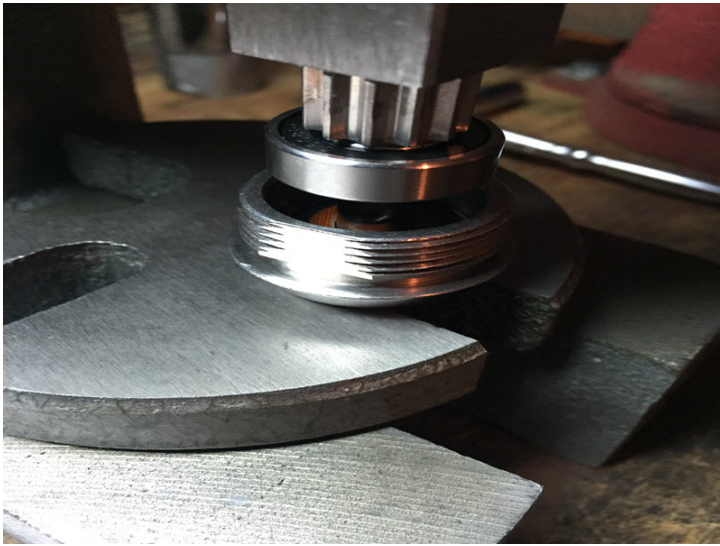
Remove all Loctite adhesive from inside of housing. Note: Bearings must insert and remove freely.



Press first bearing down to the drive gear.  
(for Advance blade assembly see diagram)



Insert second bearing wave spring and spacer into housing. (keep's everything aligned during pressing)



Press second bearing onto shaft. Make sure that the wave spring and spacer are centered between bearings.



Shows the bearings pressed all the way into the housing assembly.



Install seal in housing. Make sure the o-ring is properly seated in seal. Seal should not spin freely in housing.



Apply grease around edge of shaft. This helps prevent damage to seal when pressing bearings into housing.



Apply Loctite to inside of housing. Only requires a drop about 3/8 of an inch in size.



Spread Loctite evenly inside the housing. A tooth-pick or cut off Q-Tip works fine for this.



Partially insert bearing assembly into housing to allow for Loctite to be applied to the second bearing.



Apply an even coat of Loctite to second bearing before pressing into housing.



Press bearing assembly into housing slowly to prevent damage to the seal.



Shows bearings fully pressed into housing.



Wipe excess Loctite from bottom of housing.



Clean excess grease from shaft and seal. Allow 24 hours cure time before replacing blade and putting into use.

### **Items needed to perform the rebuild:**

\*\*\* Not included in the kit \*\*\*

- (1) Safety Glasses
- (1) Gloves
- (1) Vise
- (1) ½ Arbor Press
- (1) 10mm socket with ratchet
- (1) 27mm 12 point socket
- (1) Brass mallet
- (1) Small hammer
- (1) Hardened steel center punch
- (1) 10mm diameter punch or equivalent
- (1) Emory Cloth or 120 grit sandpaper
- (1) Cotton swab or tooth-pick

### **Kit ordering information:**

[www.blendermart.com](http://www.blendermart.com)

email: [sales@blendermart.com](mailto:sales@blendermart.com)