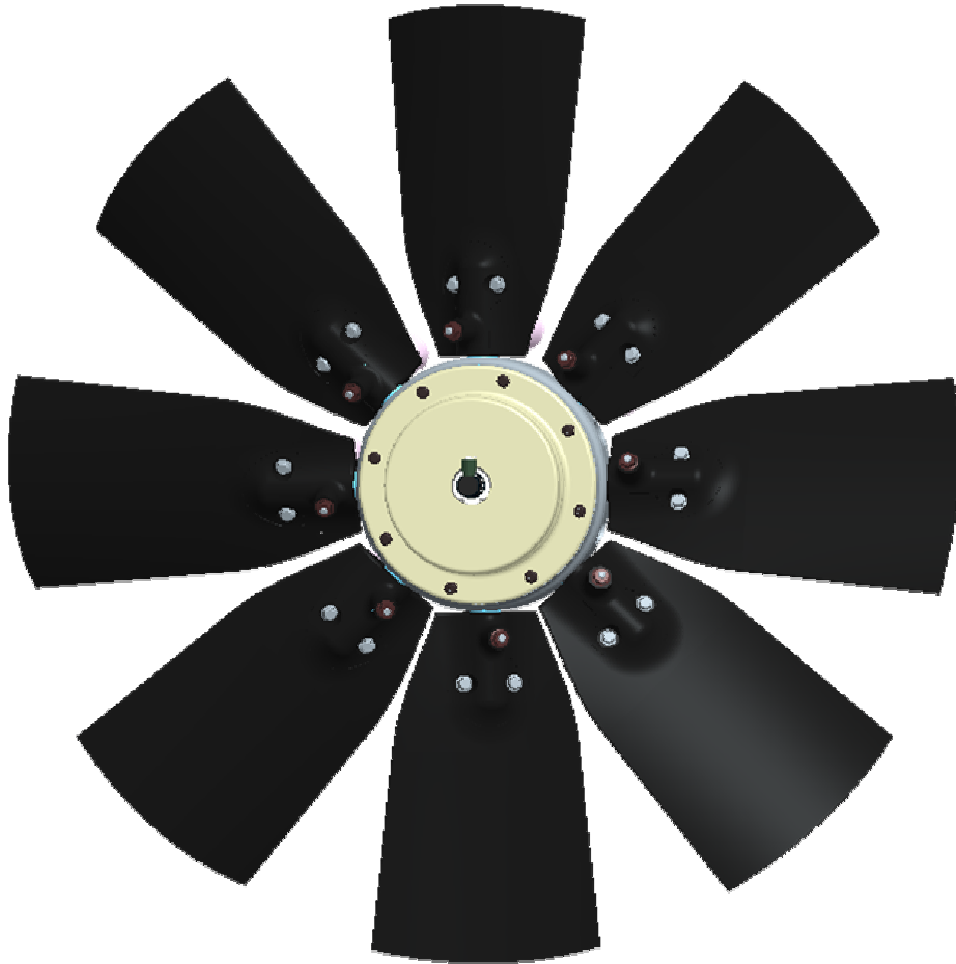




**INSTALLATION AND SERVICE MANUAL
FOR THE
TAC2000-P & TAC3000-P FAN SERIES
(PNEUMATIC CONTROL)
TAC2000-H & TAC3000-H FAN SERIES
(HYDRAULIC CONTROL)**



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Revision 10

Printed in Canada

1.1. INTRODUCTION

This manual (P/N 01524) is produced to assist in the installation, operation and maintenance of Flexxaire® TAC2000-P, TAC3000-P, TAC2000-H and TAC3000-H Series Fan Systems.

Flexxaire has made every effort to ensure that the information contained in this manual is correct and complete at the time of printing. Flexxaire will assume no responsibility for any errors or omissions. If you have any questions regarding this manual or any other document provided with your fan system, please contact:

**Flexxaire
Product Support Department
10430-180 Street
Edmonton, Alberta, Canada
T5S-1C3**

**Phone: 780-483-3267
Fax: 780-483-6099
Toll Free: 866-489-3267**

1.2. IMPORTANT SAFETY INFORMATION

The safety information in this publication is to be used in conjunction with the safety information supplied from the original machine manufacturer. Please refer to all safety information supplied, prior to doing any work on the fan assembly or any other component to assure safety.

Improper operation, maintenance or repair of this product can be dangerous and could result in injury or death.

Always use Flexxaire parts and components or Flexxaire approved parts and components. The use of unapproved parts and/or components will void the 1-year warranty.

Do not operate or perform any maintenance on this product until you have read and understand the operation and maintenance information. Please contact Flexxaire or an approved dealer for any information that you may require.

The person(s) servicing the product may be unfamiliar with many of the systems or components on the product. This makes it important to use caution when performing

any type of service work. A knowledge of the product and/or its components is important before the removal or disassembly of any component.

1.2.1. PROTECTIVE EQUIPMENT

Always wear protective glasses, protective shoes and any other protective equipment as required by job conditions when working around this product.

1.2.2. PRESSURIZED FAN HUB

The hub assembly is spring loaded. If disassembly of the hub is required, take caution that you are well protected from the hub's release which may be sudden and pose an impact related injury. Also make sure that the internal pressure is released. Consult the pneumatic or hydraulic control instructions.

1.2.3. HOT FLUIDS AND PARTS

To avoid burns, be alert for hot parts on the assembly or the machine that have just been stopped and have hot fluid in lines, tubes and compartments.

1.3. PRODUCT SUPPORT

The Flexxaire Product Support Department provides technical support, information on fan installation and maintenance, parts, instruction manuals, and is responsible for warranty administration. Contact the Product Support Department for any problems that this technical manual does not address.

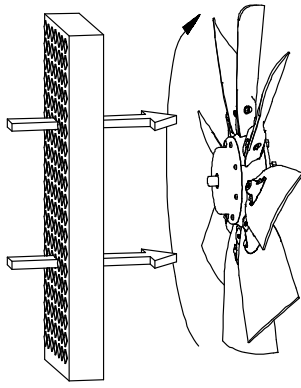
**Phone: 780-483-3267 or 780-930-6836
Monday to Friday 8:00 am to 4:00 pm MST**

1.4. FAN SPECIFICATIONS

The following needs to be considered prior to the installation of the Flexxaire Fan System. If your situation is listed in this section, **DO NOT INSTALL THE FAN.** Damage and/or injury may occur.

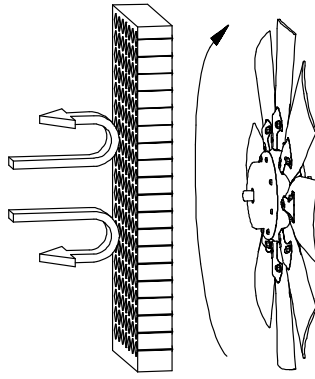
1.4.1. MOUNTING

WARNING: This fan is not designed to be mounted onto a crank shaft or crank shaft pulley. Torsional vibration from crankshafts will damage the fan and could result in machine damage and serious injury.



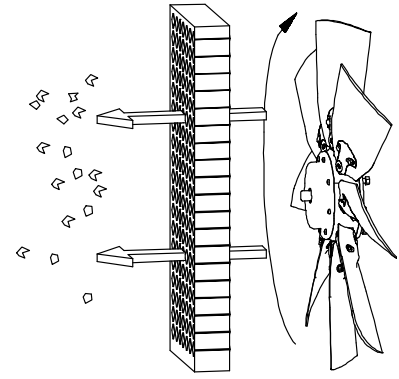
NORMAL OPERATION

EFFICIENT COOLING



NEUTRAL PITCH

STOP AIR FLOW
PREVENT OVERCOOLING
SAVE HORSEPOWER



PURGE

CLEAN RADIATOR
PREVENT OVERHEATING

1.4.2. FAN BLADE TIP SPEED

WARNING: The fan system must not exceed a blade tip speed of 20,000 feet/minute. Exceeding this speed may cause damage to and/or failure of the fan, which in turn may cause injury or death, or damage to the radiator and surrounding equipment.

To calculate the blade tip speed, use the following formula:

$$\frac{\text{Fan Diameter (Inches)} \times 3.14 \times \text{Fan RPM}}{12}$$

If your calculated tip speed exceeds 20,000 ft/min, contact Flexxaire directly, prior to installation. **It is important to use Fan RPM and NOT engine RPM.**

1.5. FAN OVERVIEW

Flexxaire's TAC2000/TAC3000 fan systems are designed to minimize overheating caused by debris plugged radiators, screens and guards, and reduce overcooling in low ambient temperatures. The blades of the TAC2000/TAC3000 vary pitch, not speed, to control air flow volume and direction.

How your TAC2000/TAC3000 works:

The TAC2000-P/TAC3000-P is a pneumatically actuated variable pitch fan. The TAC2000-H/TAC3000-H is a hydraulically actuated variable pitch fan. The blades are held in full pitch by a heavy spring. As pneumatic (or hydraulic) pressure is applied to the control line, the pitch of the blade is reduced and then reversed. When the pressure is released, the fan blades return to their default

position. The TAC2000/TAC3000 has a number of important features:

1. Fail Safe Operation: The blades are spring loaded into the default full pitch position. If the fan loses pressure, the fan will default to full pitch and act like a fixed pitch fan giving maximum cooling.
2. Depending on the control kit ordered (see Section 2.0), the fan can be run in a neutral pitch (or any pitch in between) to solve overcooling problems and save horsepower and fuel.
3. When purging, there are no horsepower spikes, in fact, the horsepower drops off as you pass through neutral pitch, then slowly builds as pitch increases.

2.0. CONTROL KITS

Due to the variability of machines that the TAC2000/TAC3000 fan may be installed on, the fan does not include any control components. Flexxaire has a number of different control kits available to suit a wide range of applications:

PNEUMATIC CONTROL:

- 2 Position kit (Manual Purge)
- 2 Position kit with timer (Manual and Auto Purge)
- 3 Position kit (Manual Purge with neutral capability)
- 3 Position kit with timer (Manual and Auto Purge with neutral capability)
- Full Variable Pitch Controller (Full fan control)
- Each kit is available with or without an air compressor.

HYDRAULIC CONTROL:

- 2 Position kit (Manual Purge)
- 2 Position kit with timer (Manual and Auto Purge)
- Full Variable Pitch Controller (Full fan control)

All of these pneumatic and hydraulic kits are available in 12V and 24V configurations. Contact Flexxaire or your dealer for details and availability.

2.1. MAJOR COMPONENTS

The TAC2000/TAC3000 Fan Assembly can be identified by several external components as shown in **Figure 1**. Use this diagram for terminology and major component identification. (This figure is of a TAC2000-H, but all the major components are the same between the TAC2000 and TAC3000 fans.)

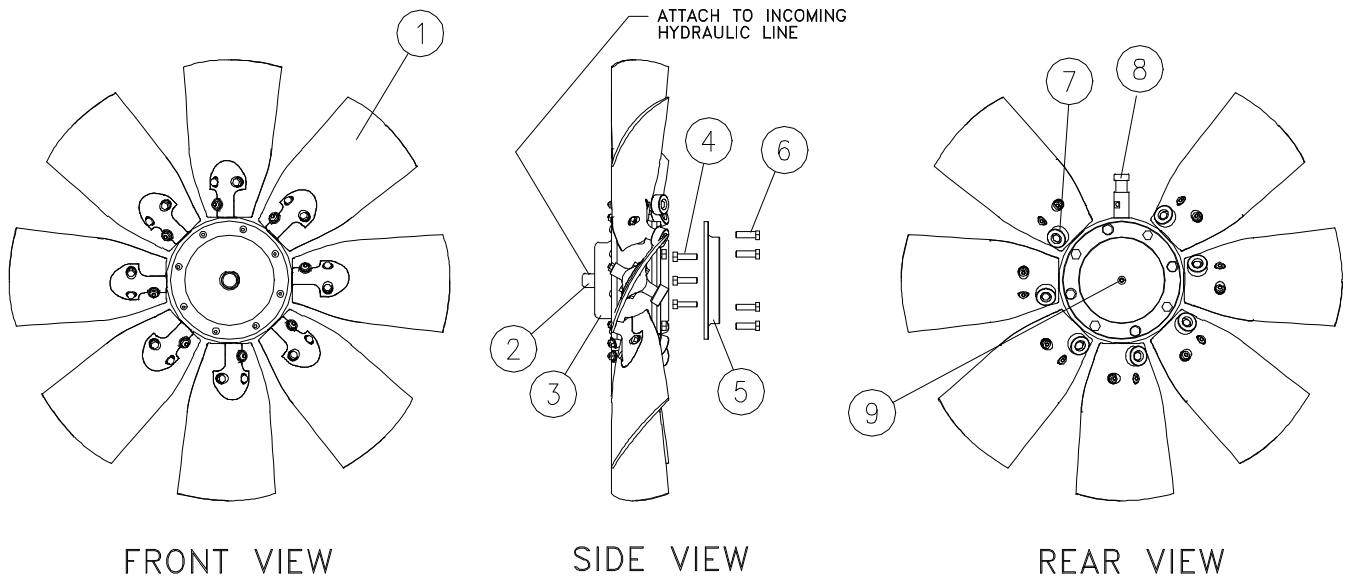


Figure 1: Fan Components

MAJOR COMPONENTS:

- | | | |
|-------------------|---------------------------|-------------------------|
| 1. Blade Assembly | 4. Mounting Adapter Bolts | 7. Blade Counter Weight |
| 2. Rotary Union | 5. Mounting Adapter | 8. Blade Mounting Shaft |
| 3. Hub Assembly | 6. Hub Mounting Bolts | 9. Fan Pilot |

2.2. EXISTING FAN REMOVAL

The following is a general description for the removal of an existing fan and the installation of a Flexxaire TAC2000/TAC3000 Fan.

- Remove fan guards and safety equipment to gain access to the existing fan.
- Loosen belt(s) and remove existing fan hardware as required.
- Clean mounting surface of the fan drive.

2.3. INSTALLATION

Mounting Adapters

The TAC2000/TAC3000 fan is supplied with either a pre-machined mounting adapter or a generic mounting adapter. Pre-machined mounting adapters are machined for your pilot and bolt circle.

Generic mounting adapters require a pilot and bolt circle machined into them to match the pilot and bolt circle of your fan drive. Contact Flexxaire for machining instructions if you are using a generic mounting adapter. For some applications, a wider 2-piece adapter may be used, and the necessary hardware for assembling the 2 parts together will be included. This 2-piece adapter may be pre-assembled.

Fan Position

Ideally the fan should be centered in the shroud (30-70% immersion is acceptable). This may require modification or removal of the fan spacer or modification of the shroud. See **Figure 2**.

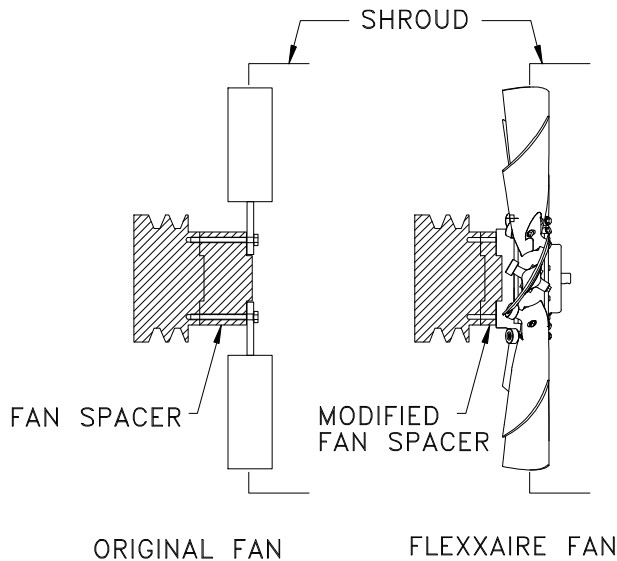


Figure 2

- A.** Install the Flexxaire supplied mounting adapter using bolts from the original fan. If the bolt length needs to be changed, use an equivalent or better grade of bolt. Follow original equipment manufacturer's torque and thread locking specifications when installing the mounting adapter to the fan drive. Refer to **Figure 3**.

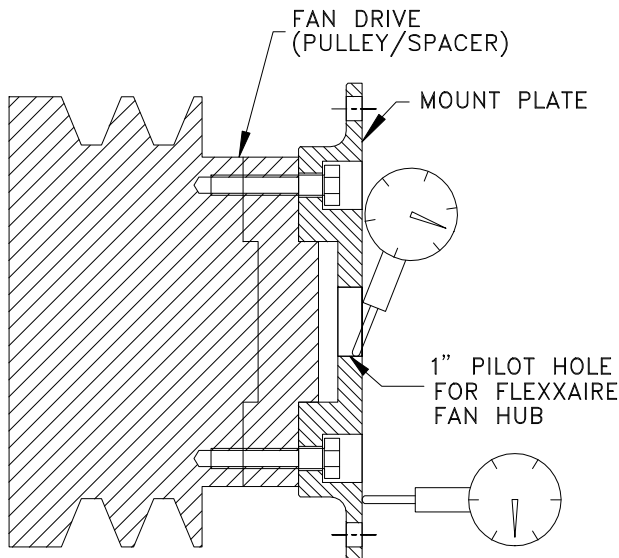


Figure 3: Adapter Plate Mounting

- B.** Set up dial gauge to measure axial deviation of the mounting adapter on the fan mounting surface. Deviation should not exceed 0.005". Refer to **Figure 3**.
- C.** Set up dial gauge to measure radial deviation of the mounting adapter on the 1" pilot hole surface. Deviation should not exceed 0.005". Refer to **Figure 3**.
- D.** Remove the silicon shipping plugs from the rear of the fan. Place the TAC2000/ TAC3000 fan onto the mounting adapter, and torque the 3/8" bolts to 40 Ft-Lbs (54 N.m). Do not use loctite. Refer to **Figure 4**.

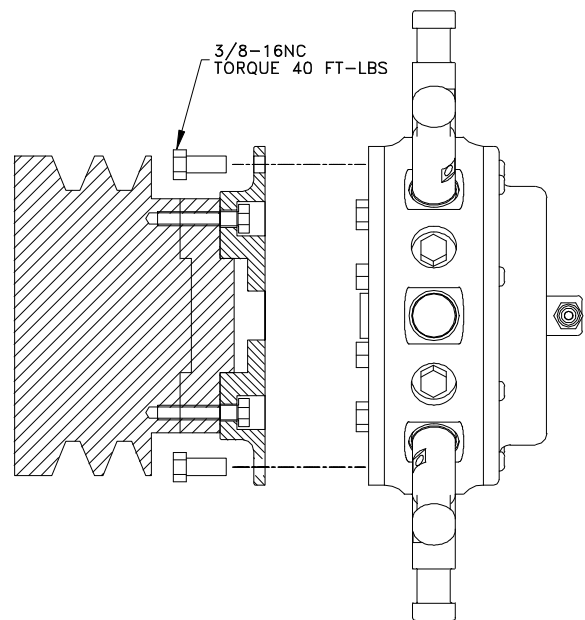
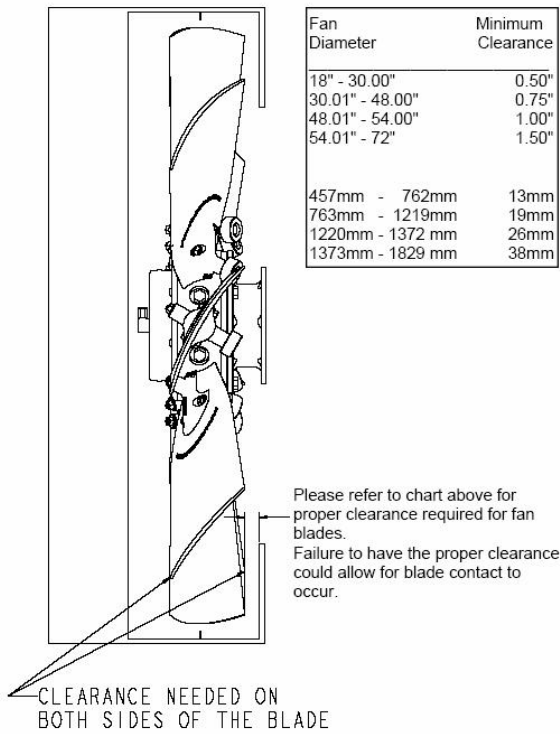


Figure 4

3.0. ATTACHING THE BLADES

Your Flexxaire fan shipped with the fan blades unattached. Care must be taken to ensure the blades are attached correctly. If the primary operation of the fan is to "pull" air towards the engine, the blades must be mounted with the concave surface towards the engine (assuming the fan rotates counter clockwise, as viewed from the engine towards the fan). If the primary operation of the fan is to "push" air away from the engine, the blades must be mounted with the concave surface away from the engine. Refer to **Figure 6**

BLADE CLEARANCE FOR ALL TAC FAN SERIES



ROTARY UNION CLEARANCE FOR TAC P OR H

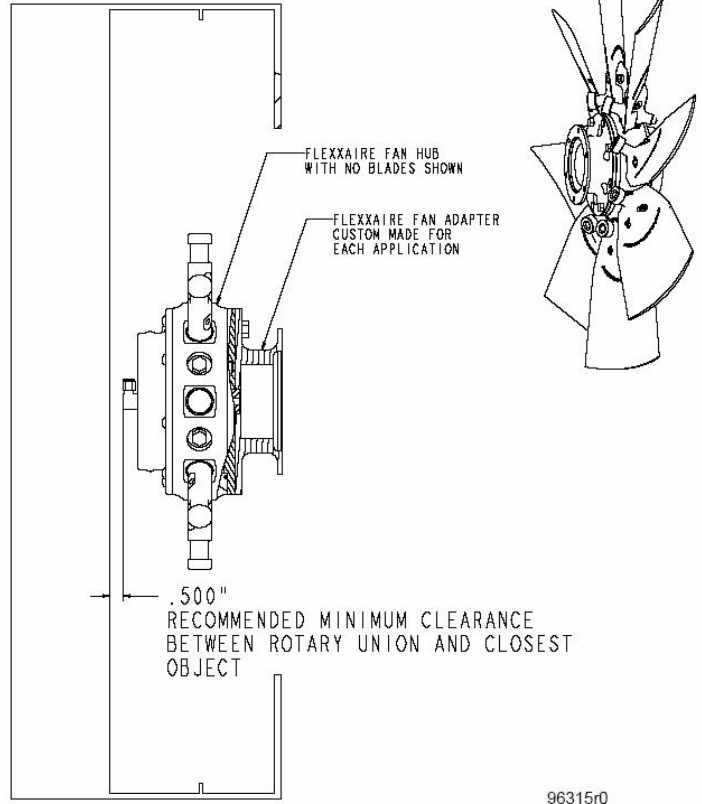


Figure 5

WARNING – SEE FIGURE ABOVE FOR BLADE AND ROTARY UNION CLEARANCES

BLADES MOUNTED FOR BLOWER FAN (PUSH)

BLADES MOUNTED FOR SUCKER FAN (PULL)

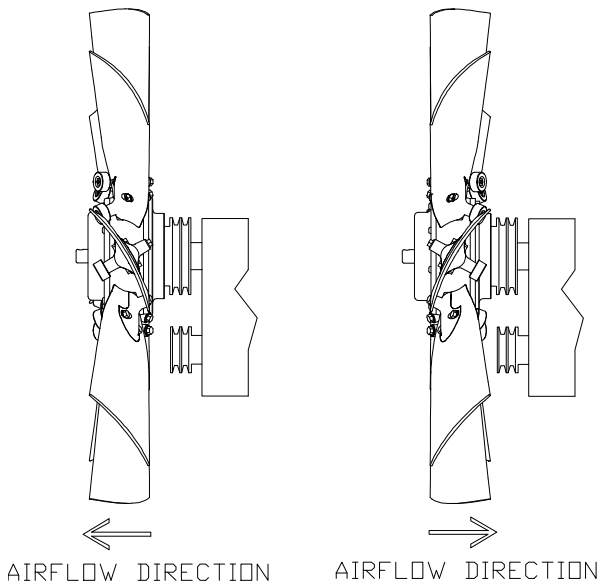


Figure 6

A. TAC2000/TAC3000 fans are supplied with either 1 or 2 counterweights per blade. If

two counterweights per blade are supplied, install one weight on each side. If only one counterweight is supplied, then the counterweight can be installed on either side, as long as they are all on the same side. Insert the supplied 1/4"NC long hex bolt through the counterweight then the lower hole in the blade or cap. The head of the bolt should be on the side with the counterweight when only one counterweight is being used. Tighten the assembly with the supplied 1/4"NC lock nut. See Figure 7.

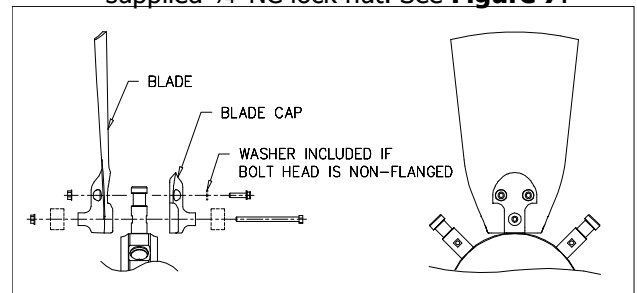


Figure 7

B. Insert the 1/4" NC short bolts through the upper holes in the blade caps and blades. Tighten the assembly to the blade shaft and the blade. Regular hex head bolts with washers may be substituted for the flange headed bolts.

- C. Carefully torque the blade bolts with a certified torque wrench to the following specification:

1/4"–20NC to 9 ft./lbs

WARNING – DO NOT OVER TORQUE

NOTE: If any of the supplied flanged lock nuts are lost, they may be replaced with grade 8 flanged lock nuts. **Loctite 242 or equivalent must be applied to the bolt if lock nuts are not used.**

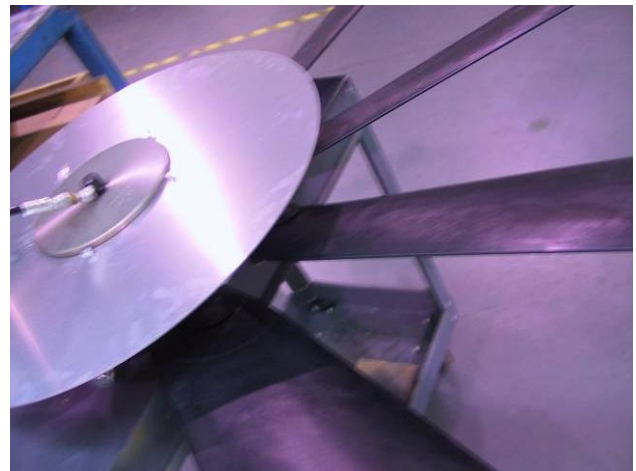
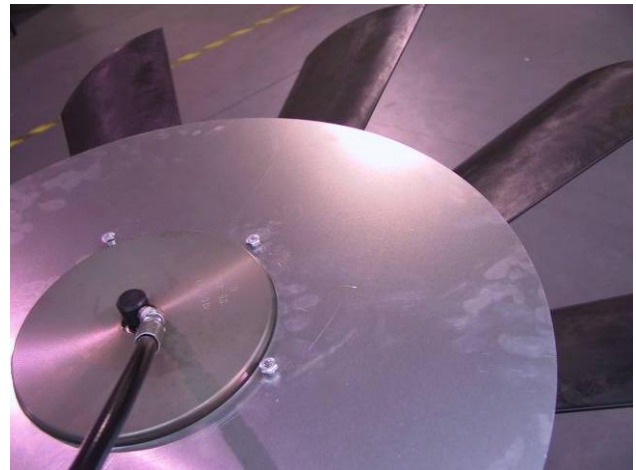
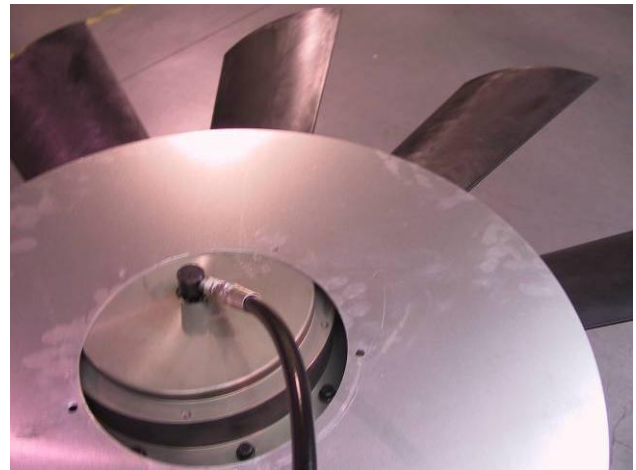
- D. Rotate the fan by hand and check for obstructions. A final check will be required once the pneumatic or hydraulic hose has been connected to the fan. (See Page 7 for a list of required pressures for each fan model.) Spin the fan by hand with the blade pitch reversed and check for obstructions.
- E. Ensure you have the correct blade clearance. See **Figure 5** on page 5 for a list of recommended minimum clearances based on fan diameter.
- F. Tighten the fan belts and replace all the fan guards and safety equipment.
- G. Attach the "WARNING" label to the machine, on a housing, guard, or any location near the fan where it can be easily seen.

WARNING: Failure to have the correct blade clearance could result in blade contact that can cause extensive damage to people and equipment.

3.1. TAC3000 AIR DAM

TAC3000 fans above 54" in diameter have extended blade shafts, and an aluminum air dam/air seal is mounted to the front of the hub. This air dam is necessary to prevent reverse airflow between the bottom of the blades and the hub diameter.

The air dam is mounted with 5 bolts, on the front shoulder of the TAC3000 hub assembly. See Pictures.



4.0. PNEUMATIC SPECIFICATIONS

Flexxaire supplies a number of pneumatic control options, but the TAC2000-P/TAC3000-P can be operated using any air source that meets the general specifications listed below. If your machine has air on board then this source will be available. If not, then a compressor kit will be required.

TAC2000-P General Specifications:

Full Pitch (default position): **0 psi**
Neutral Pitch (Stop air position): **35-40 psi**
Reverse Pitch (Purge position): **70-90 psi**
Max intermittent pressure: **110 psi**
Max continuous pressure: **90 psi**
(extended operation at higher pressure will reduce the life of the rotary union seal).

TAC3000-P General Specifications:

Full Pitch (default position): **0 psi**
Neutral Pitch (Stop air position): **40-45 psi**
Reverse Pitch (Purge position): **90-100 psi**
Max intermittent pressure: **110 psi**
Max continuous pressure: **90 psi**

Recommended minimum flow rate: .35cfm @ 70 psi. (The lower the flow rate, the longer it takes to purge the fan. –at .35cfm @ 70psi it takes approximately 7 seconds to fully reverse pitch).

4.1. PNEUMATIC LINE INSTALL

- A.** Drill a hole in your fan shroud to allow the flexible hose to be routed into the engine compartment. Secure the hose using hose clamps or tie wraps. Be sure that the air line is properly secured so it cannot interfere with the fan blades.
- B.** Attach the incoming air line to the push-in fitting on the front of the fan. If you did not purchase one of Flexxaire's control kits you will need to source flexible hose and fittings that will attach to the 1/8-NPT female fitting on the front of the fan. The hose should be robust enough to withstand abrasion from air flow, and temperature and vibration inherent from engines. Failure of the hose could lead to fan damage if the hose comes in contact with the blades.

WARNING: Do not secure the air lines in any way that will cause leverage to be applied to the

rotary union. Failure of the rotary union could result.

5.0. HYDRAULIC SPECIFICATIONS

Flexxaire supplies a number of hydraulic control options, but the TAC2000-H/TAC3000-H can be operated using any hydraulic source that meets the general specifications listed below. If your machine has hydraulics on board then this source should be available.

TAC2000-H General Specifications:

Full Pitch (default position): **0 psi**
Neutral Pitch (Stop air position): **~300 psi**
Reverse Pitch (Purge position): **450 psi**
Maximum allowable pressure: **1000 psi**

TAC3000-H General Specifications:

Full Pitch (default position): **0 psi**
Neutral Pitch (Stop air position): **~275 psi**
Reverse Pitch (Purge position): **550 psi**
Maximum allowable pressure: **1000 psi**

5.1. HYDRAULIC LINE INSTALL

- A.** Drill a hole in your fan shroud to allow the flexible hose to be routed into the engine compartment. Secure the hose using hose clamps.
- B.** No exterior bracing should be used to prevent the rotary union from rotating. It is imperative that a flexible connection be used. DO NOT PIPE SOLID.
- C.** Ensure that the hose clears all parts of the fan. If possible, secure the hose away from the fan. Common ways to do this are zip tie the hose to the radiator core, or to attach it to the radiator frame or the bolted flanges between the radiator cores.

WARNING: Do not secure the hydraulic hose so tight as to cause a side load on the rotary union. Failure of the bearings could result.

WARNING: Do not secure the hydraulic hose so loose that the hose could contact the blades due to sudden air reversal, vibration, etc....

WARNING: Ensure that you have the minimum clearance between the rotary union and closest obstruction as per Figure 5 on page 5.

- D. The fan is shipped with a default hose assembly attached to the hub assembly. Contact Flexxaire if you want a different hose length of different fittings for future orders. The hose is attached at the Flexxaire factory to avoid unnecessary side loads to the bearings of the rotary union that can be applied every time the hose is attached or detached from the rotary union.

5.2. HYDRAULIC LINE SPECIFICATIONS

A. TAC2000-H

- The connection on the rotary union is a 1/8NPT female thread.
- The fitting on the end of the default hose is a male 1/8NPT. An adapter is used to mate to the #6 ORB port on the manifold.
- If supplying your own hose, it is recommended to use a hose that is as small as possible. The potential exists that a large, heavy hose with bulky fittings could create a side load on the rotary union, just due to the weight of the hose. Side loads can drastically reduce the life of the rotary union.
- Maximum allowable working hydraulic pressure is 1000 psi

B. TAC3000-H

- The connection on the rotary union is a 1/8NPT female thread
- The fitting on the end of the default hose is a flare 37 deg #4. An adapter is used to mate to the #6 ORB port on the manifold.
- If supplying your own hose, it is recommended to use a hose that is minimum 1/4" inside diameter. Smaller hoses can cause a problem with the fan performance as the small hose will slow down the actuation speed of the fan blades while changing pitch or purging.
- Maximum allowable working hydraulic pressure is 1000 psi

6.0. SERVICE AND MAINTENANCE

Flexxaire's TAC2000/TAC3000 fan hub is fully sealed with o-rings, and contains a small amount of oil. As a result, the fan should not require any maintenance.

6.1. VISUAL INSPECTIONS

Under normal operating conditions TAC2000/TAC3000 fans do not require any scheduled maintenance and are built to provide thousands of hours of trouble free service. In moderate to extreme operating conditions a visual inspection of the moving parts is recommended from time to time to safeguard against fan blade damage which could lead to equipment downtime and/or other damages.

6.2. MECHANICAL REVIEW

Ensure that the fan fully reverses pitch. Check for leaks in the rotary union. Check that the rotary union bearings rotate smoothly. Verify that you have the correct blade clearance as per **Figure 5** on page 5.

CHECK	YES	NO
Does fan rotate in default and full reverse pitches without obstruction?	<input type="checkbox"/>	<input type="checkbox"/>
Are blade fasteners torqued to 9 ft-lbs?	<input type="checkbox"/>	<input type="checkbox"/>
Are blades installed in the correct orientation (blower /sucker)? See Fig 6	<input type="checkbox"/>	<input type="checkbox"/>
Has the side load on the pressure line been minimized?	<input type="checkbox"/>	<input type="checkbox"/>
Has the pressure line been constrained to prevent contact with the blades?	<input type="checkbox"/>	<input type="checkbox"/>
Is the pressure line flexible enough to accommodate relative movement between the radiator and engine?	<input type="checkbox"/>	<input type="checkbox"/>
Are any of the blades damaged?	<input type="checkbox"/>	<input type="checkbox"/>
Does the rotary union rotate freely?	<input type="checkbox"/>	<input type="checkbox"/>
Are there any pressure leaks in the system?	<input type="checkbox"/>	<input type="checkbox"/>
Are all screens and guards secured?	<input type="checkbox"/>	<input type="checkbox"/>
Have you recorded the fan S/N for future reference? S/N _____	<input type="checkbox"/>	<input type="checkbox"/>

6.3. ROTARY UNION

The rotary union used in the fan hub is lubricated for life and requires no additional maintenance other than periodic inspection to determine if normal wear has caused the union to leak.

6.4. TAC2000-H/TAC3000-H ROTARY UNION REPLACEMENT



1. Shown above is the rotary union installed in the hub of the Flexxaire TAC2000-H fan. This rotary union is held in place by a snap ring as shown.



2. Using snap ring pliers, the snap ring can be easily removed.



3. The rotary union assembly can then be removed. Applying air pressure can assist in removing the rotary union from the hole.



4. For re-assembly of the rotary union, care should be taken to ensure the o-rings are in good condition and are not damaged during the installation process as the o-rings slide past the snap ring groove.

5. Please ensure that any side-load placed on the rotary union by the hydraulic line is minimized. Excessive side-load will affect the life of the rotary union.

The rotary union used in the fan hub is lubricated for life and requires no additional maintenance other than periodic inspection to determine if normal wear has caused the union to leak.

Note: The TAC2000-H/TAC3000-H rotary union can be replaced without removing the fan from the fan-drive if there is at least 3" of clearance between the front face of the rotary union and the nearest obstruction.