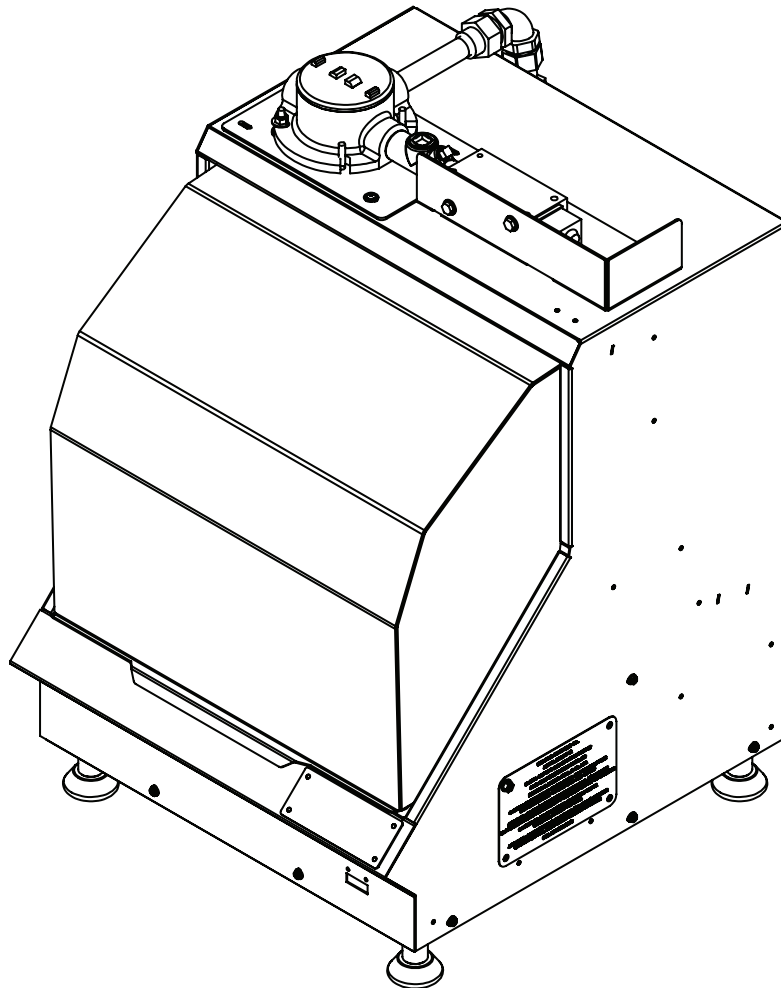


# Owner's Manual: 1025-X1

## One-Gallon Gyro Mixer

Models 01025-Explosion Proof






# Table of Contents

<b>1. Safety Information</b>	<b>3</b>	<b>6. Trouble Shooting</b>	<b>10</b>
1.1 Safety Precaution Labels	4		
1.2 Safety Precaution Summary	5	<b>7. Wiring Diagram</b>	<b>11</b>
<b>2. Introduction</b>	<b>6</b>	<b>8. Exploded Views</b>	<b>12</b>
2.1 Application	6	8.1 Frame and Drive	12
2.2 Specifications	6	8.2 Rotating Frame	13
<b>3. Unpacking &amp; Install</b>	<b>7</b>	8.3 Clamp Handle	14
3.1 Specifications	7	8.4 Enclosure	15
		8.5 Control Panel	16
<b>4. Operation</b>	<b>7</b>	<b>9. Ordering</b>	<b>17</b>
4.1 Control Panel	7	Replacement Parts	17
4.2 Install a Container	7		
4.3 6784604 Quart Adapter	8	<b>10. Warranty</b>	<b>18</b>
<b>5. Care and Maintenance</b>	<b>9</b>	<b>11. Notes</b>	<b>19</b>
5.1 Cleaning	9		
5.2 Maintenance	9		

## 1. Safety Information

**Review this owner's manual and read all warning labels on the machine prior to use.**

The three main safety notifications used in this manual and on the warning labels are **WARNING**, **CAUTION** and **NOTICE**. They have specific meanings and indicate the potential dangers from misuse of the machine.


	<p><b>"WARNING!"</b> indicates a hazardous situation, which, if not avoided, could result in death or serious injury. These serious injuries could include permanent loss of function or significant disfigurement, disability, considerable pain and suffering, amputations, severe burns, and loss or impairment of vision or hearing. Take all necessary precautions to avoid unnecessary</p>
	<p><b>"CAUTION!"</b> indicates a hazardous situation, which, if not avoided, could result in minor or moderate injury.</p>
	<p><b>"NOTICE"</b> indicates practices that do not involve physical injury but may damage the machine.</p>

Safety Information, Continued..

## 1.1 Safety Precaution Labels

 <p><b>WARNING</b> <b>ADVERTENCIA</b> <b>AVERTISSEMENT</b></p>	<p><b>MOVING PARTS INSIDE</b> <b>PARTES EN MOVIMIENTO</b> <b>PIE'CES EN MOVEMENT</b></p>
<p>-Do not open door until machine comes to complete stop; moving parts inside could cause serious injury.</p> <p>-No abra la puerta hasta que la maquina se detenga completamente, las partes internas en movimiento pueden causar heridas graves.</p> <p>- Ne pas ouvrez la porte jusqu'a'ce que la machine esta comple'tement arre'te'; pi'eces en mouvement a l'int'erieur pourrait provoquer des blessures grave.</p>	

Part No. 1784963

	<p><b>WARNING</b> <b>ADVERTENCIA</b> <b>AVERTISSEMENT</b></p>
<p>- Machine must be properly grounded before use; improper grounding could cause electric shock and injury.</p> <p>-Disconnect power cord before servicing, cleaning or removing any cover, and follow lockout/ tagout procedures in owner manual; failure to disconnect power could cause electric shock and injury.</p> <p>-Review Owners Manual before installing or operating.</p> <p>- La maquinaria debe ser apoyada correctamente en el suelo antes de usar, el no apoyarla puede causar choque el'ctrico y da'os.</p> <p>-Desconecte la energ'a antes de dar mantenimiento, limpiar o quitar cualquier cubierta, y siga los procedimientos de bloqueo/etiquetado del manual, Fallar en desconectar puede causar choque el'ctrico y da'os.</p> <p>- La machine doit e'tre correctement mis a' la terre avant de les utiliser mise a' la terre incorrecte peut provoquer un choc e'lectrique et de blessure.</p> <p>- De'branchez le cordon d'alimentation avant de proce'der a l'entretien, le nettoyage ou le retrait des capots: suivez la proce'dure d'isolation/ consignation proce'dures dans le manul de l'opre'rateur; E'chec de</p>	










Part No. 1781570


Safety Information, Continued..

Safety Information, Continued..






## 1.2 Safety Precaution Summary

### **WARNING!**

-  **BE SURE** that the remote power switch is installed by a qualified electrician. Refer to local codes for proper placement of the remote power switch.
-  **DO NOT** attempt to replace any damaged electrical wire or components. Improper replacement could result in electric shock and serious injury. Only a qualified service representative should attempt to repair or replace any damaged electrical components.
-  Review this owner's manual before installing or operating.
-  The machine must be properly grounded prior to use. In the case of an electrical short circuit, grounding reduces the risk of electric shock by providing an escape wire for the electric current.
-  Check with a qualified electrician if you don't completely understand these grounding instructions, or if you are not sure whether the machine is properly grounded. Do not modify the plug provided; if it won't fit in the outlet, have a proper outlet installed by a qualified electrician.
-  Follow the lockout/tagout procedures of your company.
-  Do not open the door until the machine comes to a complete stop.
-  Review product label, Material Safety Data Sheet, and HMIS rating of materials prior to mixing to determine potential hazards.
-  Machine is rated for Class I, Divisions 1 & 2, Groups C & D; Class II, Divisions 1 & 2, Groups E, F, & G locations.

 “WARNING: This product may expose you to chemicals including DEHP, which is known to the State of California to cause cancer. For more information, go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov)

### **CAUTION!**

-  Keep the work area free of clutter and electrical cords.
-  **DO NOT** disable the limit switch. This switch interrupts power when the mixer door is opened.
-  Use the proper power source. Refer to the machine data plate on the right side panel or section 2.2, Specifications, in this manual.
-  Keep customers away from the work area. The machine should be used only by properly trained individuals.
-  Clamp the can carefully to ensure that it is held securely during the mixing cycle.

**Product safety labels should be inspected and cleaned periodically to maintain good legibility. Replace any labels that are no longer legible.**

## 2. Introduction

### 2.1 Application

Congratulations on your purchase of the 1025 Red D Mix one gallon gyro mixer. This machine is designed to accommodate standard plastic or metal 1-gallon paint cans weighing up to 25 lbs. (11.3 kg)

Understand your machine's features and proper operation to take full advantage of its capabilities.

Read this entire manual completely before operating the machine. Practice installing and removing a container before mixing for the first time.

Keep this manual for future reference.

**Always follow all safety instructions!**

### 2.2 Specifications

**Unit Size:** **W** 21.3 in. (54 cm) **D** 26.3 in. 66.8 cm) **H** 30.3 in. (76.8 cm)

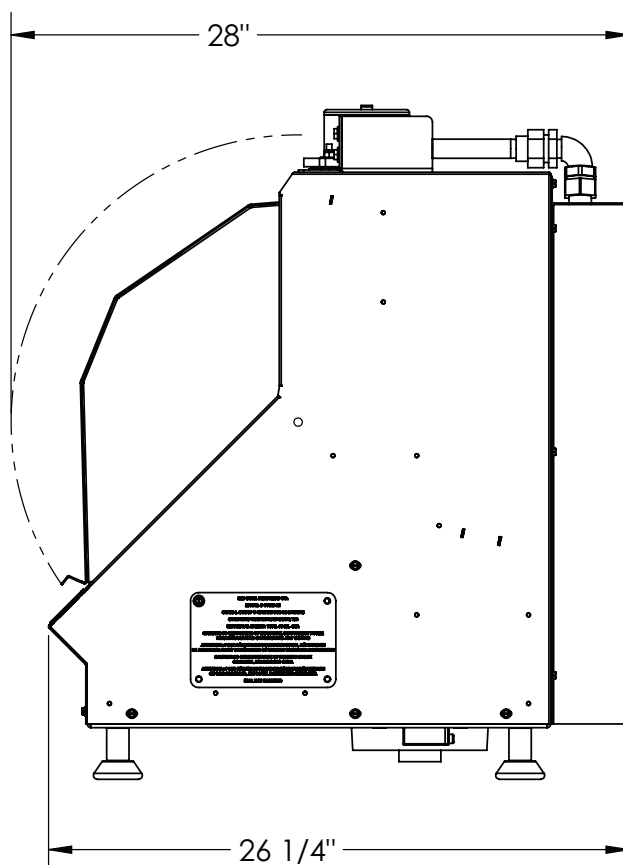
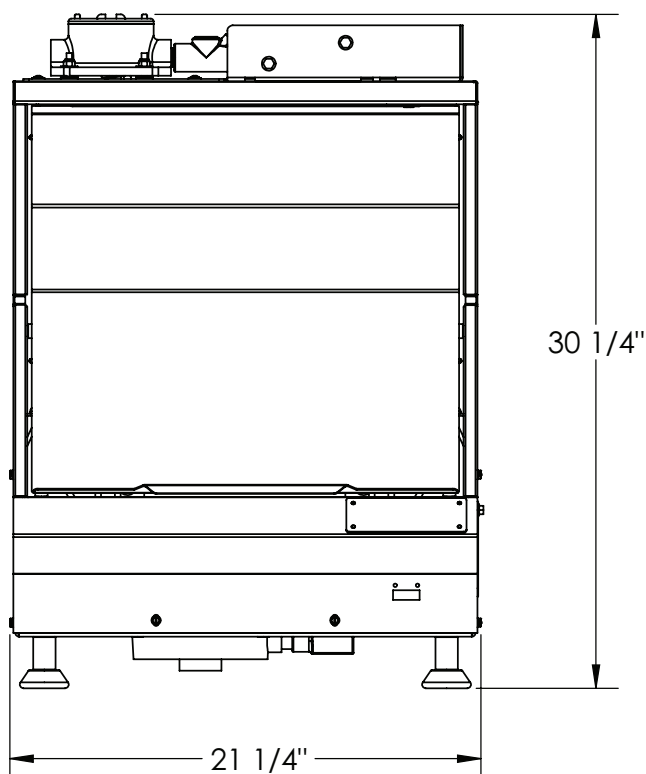
Machine Weight: 127 lb. 57.6 kg)

Electric Service: 110 V 60 Hz

Capacity: 25 lb. (11.3 kg)

Sizes Mixed: one gallon, one qt.,

Machines rated at 110 V, 60 Hz are for use with a nominal 120 V circuit.



## 3. Unpacking & Installation

**IMPORTANT:** Before attempting to operate the machine:

1. Remove all packing material.
2. Position the machine on a firm, level surface.
3. Follow the electrical connection instructions described in Sections 1.2 & 2.2.

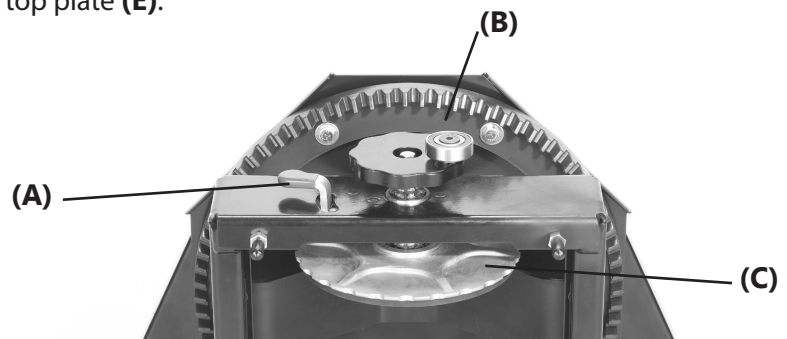
## 4. Operation

### 4.1 Install a Container

1. Open the cabinet door.
2. Use the rotate-assist pins to rotate the mixer to the upright position when loading and unloading.
3. Pull the ratchet lever **(A)** toward you and turn the handle on the top of clamp **(B)** counterclockwise to raise the plate.
4. Slide the container under the clamping (top) plate **(C)**.
5. Position the can in the grooves on the bottom plate **(D)**. The grooves on the plate keep the pail in place during mixing.
6. Lower the clamping plate **(C)** by turning the handle clockwise. Once the plate makes contact with the pail, tighten an additional 1 - 2 clicks for metal cans. 3 clicks for plastic cans.
7. Secure the handle by locking it in the grooves on the top plate **(E)**.
8. Close the door and start the machine.

**Notice:** Avoid damage to the machine.

- A safety interlock interrupts machine operation if the door is open.
- Do not operate the machine without a can installed.



### 4.2 Remove a Container

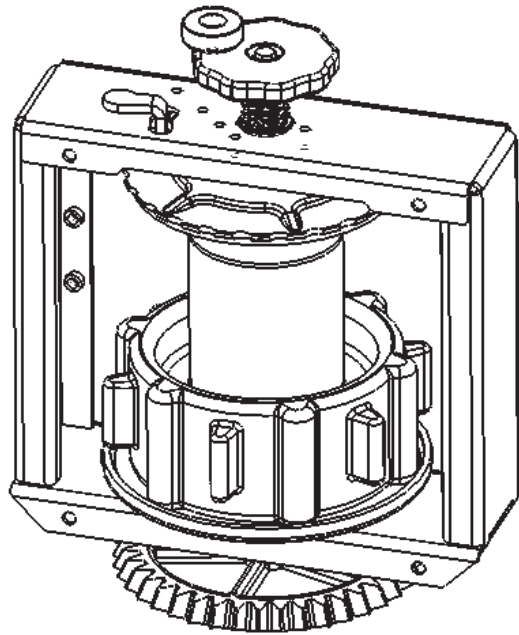
**WARNING!** Avoid serious personal injury. Do not open the door until the machine comes to a complete stop; moving parts inside could cause serious injury.

1. Unfasten the handle.
2. Raise the clamp all the way to the top by holding the ratchet lever **(A)** open while turning the crank handle counter-clockwise.
3. Remove the container:

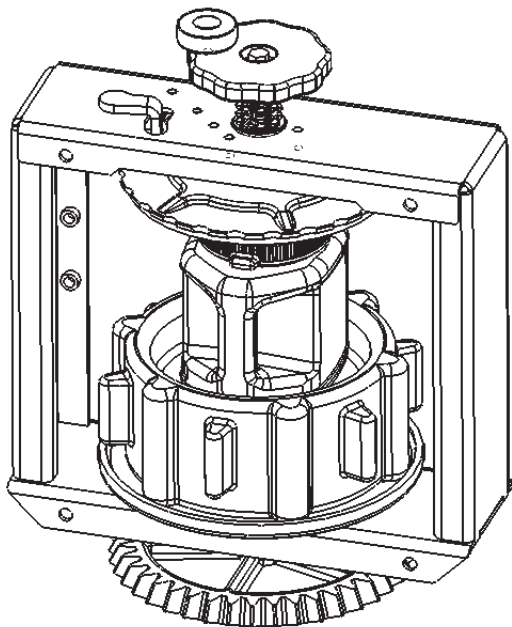


....Operation, Continued

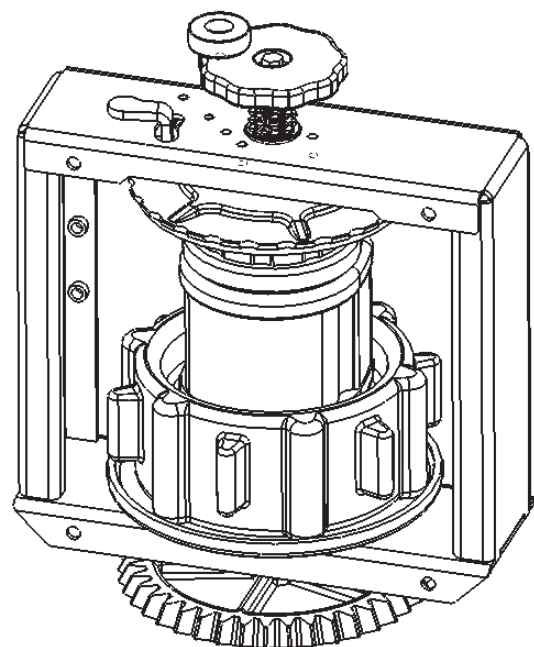
## 4.3 6784604 Quart Adapters



**Round Quarts:** Load as shown,  
place in mixer lid side up.



**Square Quarts:** Load as shown,  
place in mixer lid side up.



**D-shaped Quarts:** Load as shown,  
place in mixer lid side up.



## 5. Care and Maintenance

**⚠ WARNING!** Avoid serious personal injury. Always unplug the power cord before performing maintenance tasks.

### 5.1 Cleaning

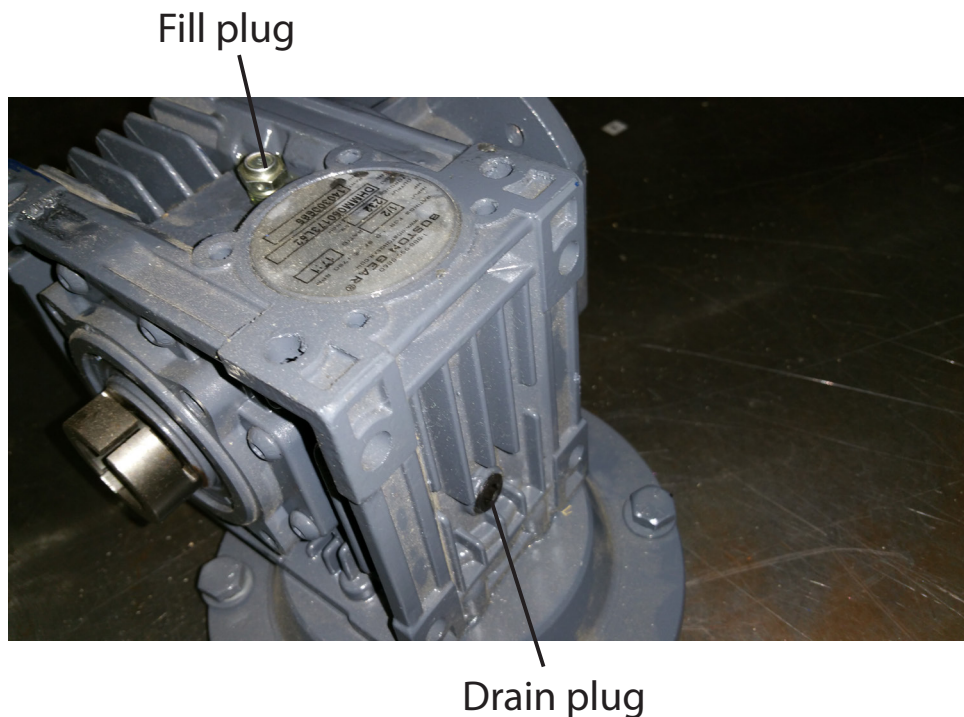
**⚠** Avoid serious personal injury! **DO NOT** use solvent-based cleaners or thinners, or other combustible cleaners.

- Remove water-based/glycol colorants or base paints spilled on machine surfaces using lukewarm water and mild detergent.
- Do not use abrasives to clean machine surfaces. Doing so may damage the appearance of the machine,
- Keep the machine clean for reliable operation.

### 5.2 Maintenance

#### Lubrication:

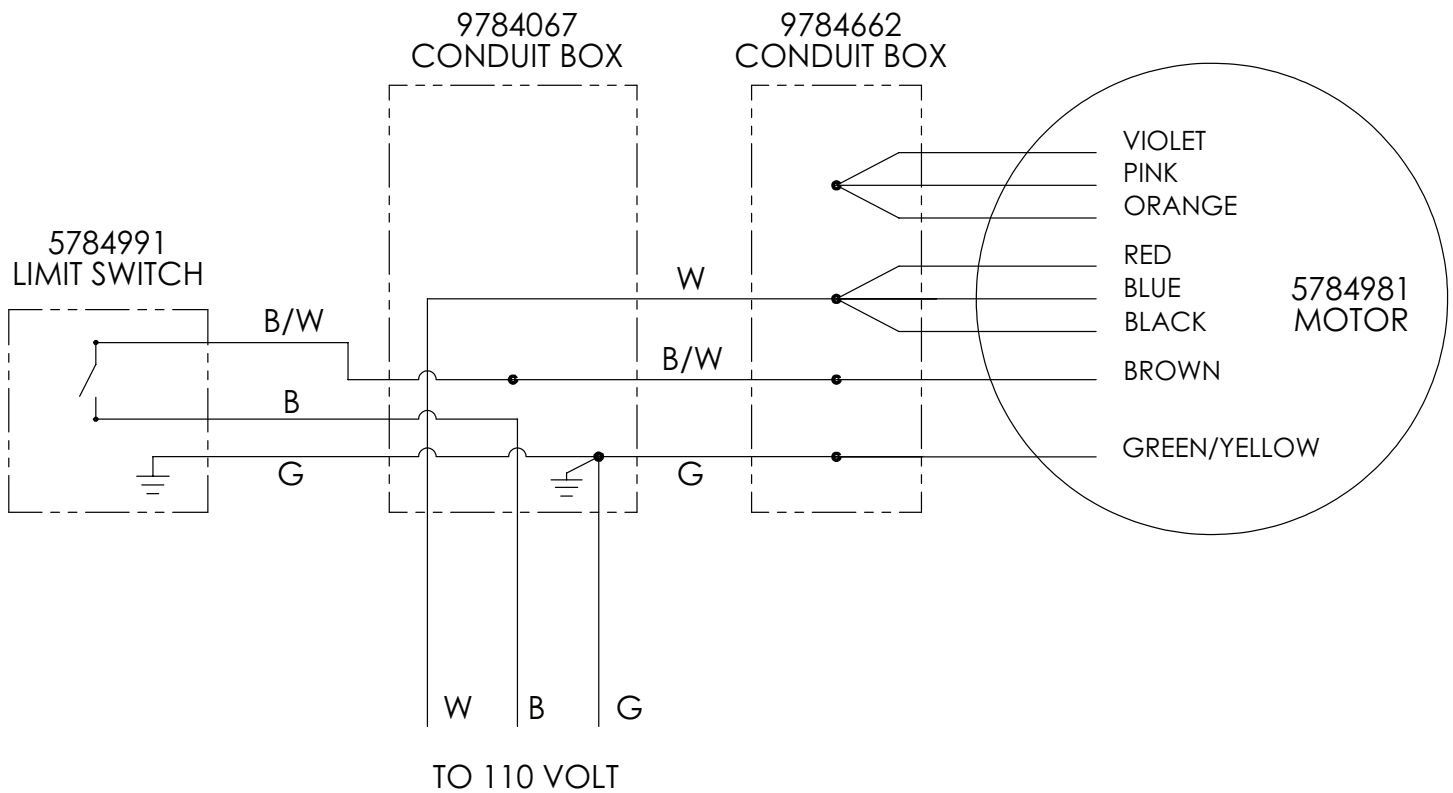
1. **Speed Reducer:** Maintenance is not required. If an oil change is necessary due to debris build-up:
  - a. Remove the oil drain plug on the bottom side of the machine and drain the oil from the gearbox. Replace the plug.
  - b. Remove the oil level plug and fill only up to that level with Mobil SHC 634 Synthetic oil. Do not overfill or underfill. Replace the plug
2. **Clamp:** Lubricate the clamping screw threads and thrust bearing as needed with 3-in-1 oil.
3. **Ratchet Lever:** Lubricate the shaft as needed with 3-in-1 oil.



## 6. Troubleshooting

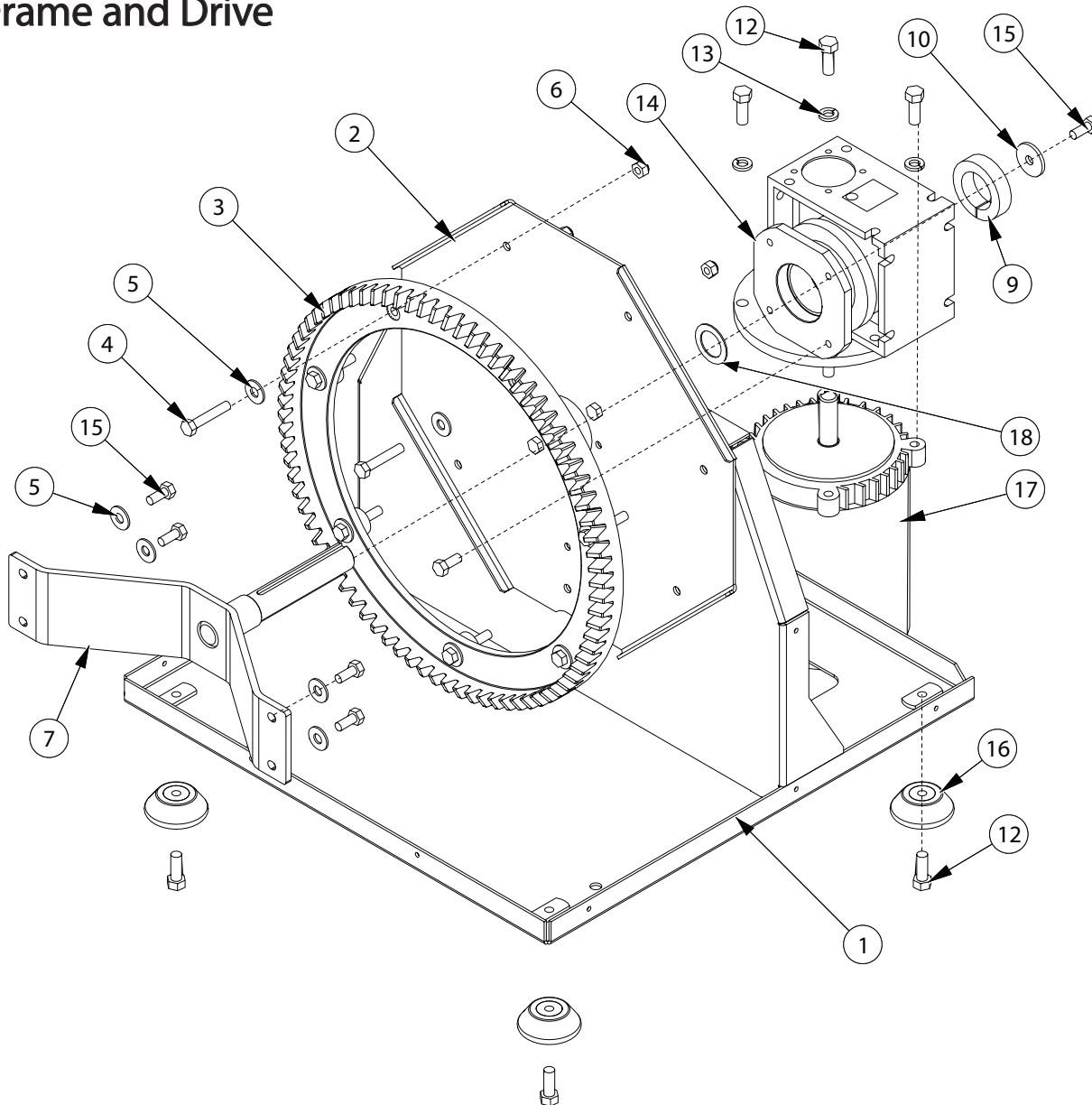
PROBLEM	CAUSE	REMEDY
Machine won't operate	Not connected to power source	Connect to power source
	Building circuit breaker	Reset breaker
	Machine door does not make contact with limit switch	Re-adjust switch to make contact with limit switch screw when door is closed
	Motor thermal protector activated	Allow to cool, then restart
	Faulty motor	Contact Radia's Customer Care
Container won't fit properly into clamping plates	Container damaged	Fix or replace container
Machine doesn't shut off when door is opened	Faulty door limit switch	Contact Radia's Customer Care
Increasing mechanical noise	Bearings worn or damaged	Contact Radia's Customer Care
Pail rotates inside the clamping plates	top clamp not secure	Turn the crank handle down until top plate is snug on container
	Top clamp pad worn	Replace top plate

## 7. Wiring Diagrams



## 8. Exploded Views

### 8.1 Frame and Drive



ID	Description
1	9784393 FRAME WELDMENT - 1025
2	9784397 Mount, Large Gear - 1025
3	9784442 Gear, Large Bevel
4	9784398 Screw Hex 5_16-18 X 1.75
5	9100023 WASHER, FLAT 5_16 USS
6	9780182 Nut, Nylock 5_16-18
7	9784396 Shaft, Tumble - 1025
9	9782318 CLAMP COLLAR, 1.438 ID
10	9784441 Washer, Fender 5_16

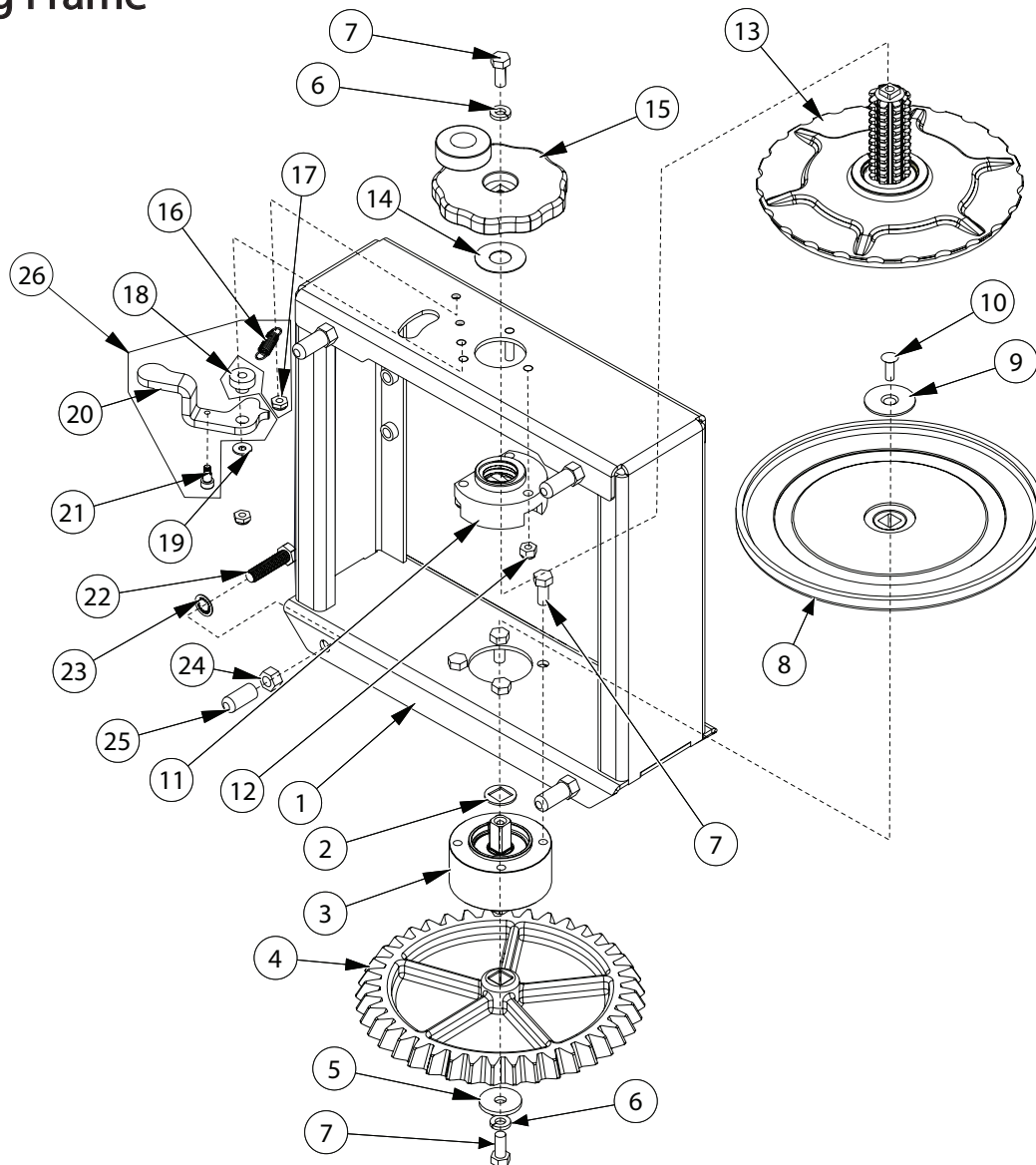
ID	Description
12	9780886 SCREW HEX 3_8-16 X 1.00
13	9780402 Washer 3_8 split lock
14	9784394 GEARBOX, WORM
15	9782407 Screw Hex 5_16 X 3_4
16	9782044 Foot, Floor Stand
17	5784981 MOTOR, 1_3HP, 1725 RPM, HAZ LOC
18	9784504 WASHER, SHIM, 1.50 OD x 1.00 ID x .048 THK

**PART NUMBERS LISTED MAY ONLY BE AVAILABLE IN KIT FORM OR AS AN ASSEMBLY**

Exploded Views, Continued..

...Exploded Views, Continued

## 8.2 Rotating Frame



ID	Description
1	9784400 Rotating Frame Weldment - 1025
2	9784420 Washer, Square Hole .517
3	6786023 BEARING HOUSING ASSEMBLY - 1025
4	9784405 GEAR, SMALL BEVEL
5	9784441 Washer, Fender 5_16
6	9760521 Washer 5_16 Lock, Split
7	9782407 Screw Hex 5_16 X 3_4
8	9784407 Plate, Bottom Clamp - 1025
9	9782533 WASHER, FLAT 1.50 DIA CSNK
10	9782535 SCR, 100 CSNK 1_4-20 X .75 FLAT HD
11	9784410 NUT, SPLINED ACME - 1025
12	9780343 Nut 1_4-20 Nylon Lock
13	6786052 Top Plate and Screw Assembly - 1025

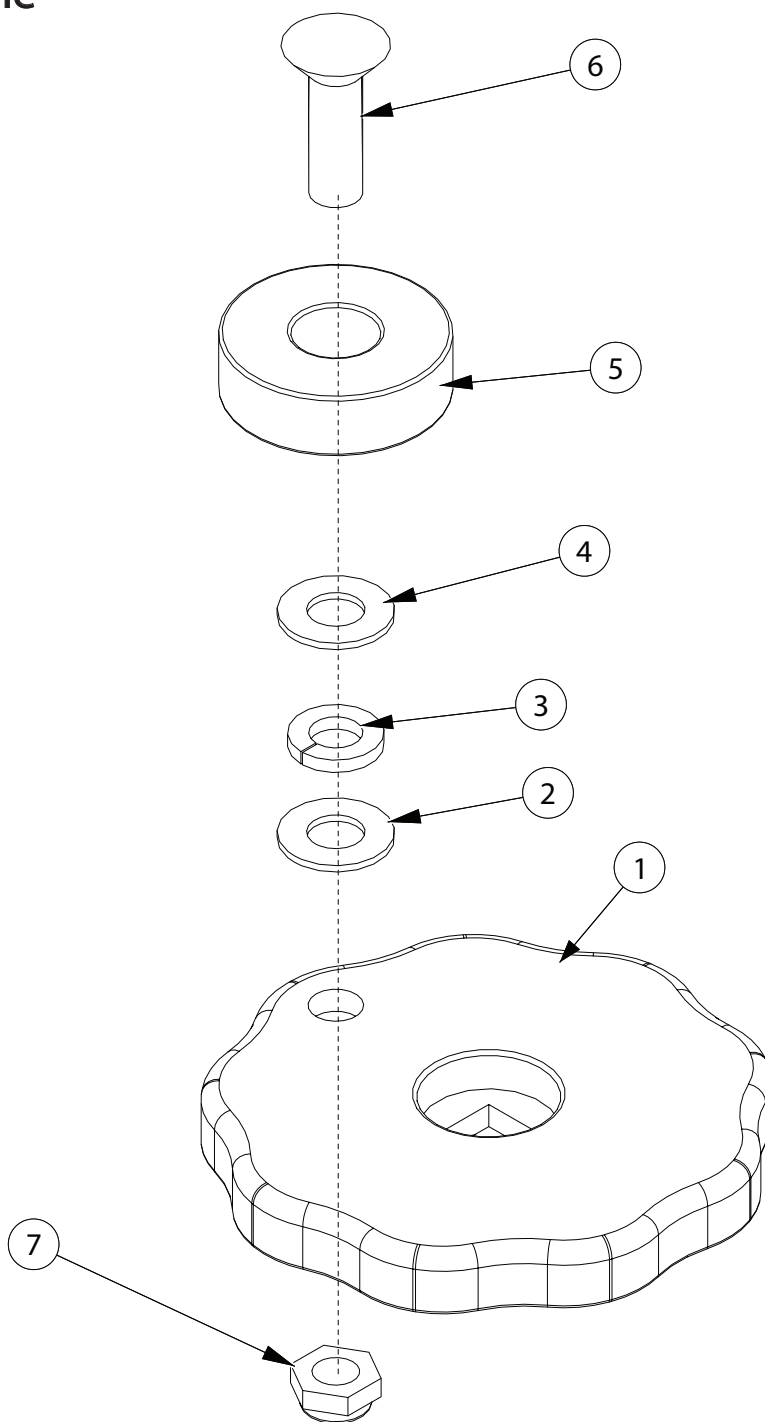
ID	Description
14	9785008 Washer, Nylon
15	6784417 CLAMP HANDLE ASSEMBLY - 1025
16	9784419 Spring, Extension
17	9783893 Nut 1_4-20 Nylon Lock Thin Jam
18	9784409 BUSHING, RATCHET - 1025
19	9780749 Washer, Flat #10
20	9784408 LEVER, RATCHET - 1025
21	9785266 Shoulder Bolt .25 DIA X .25 LG
22	9784439 Screw Hex 3_8-16 X 1.50 Full Thd
23	9163000 WASHER, LOCK, INT TOOTH, Ø.375
24	9389500 Nut, Hex 3_8-16
25	9784440 Cap, Vinyl
26	6785632 Ratchet Spring Kit

**PART NUMBERS LISTED MAY ONLY BE AVAILABLE IN KIT FORM OR AS AN ASSEMBLY**

Exploded Views, Continued..

...Exploded Views, Continued

## 8.3 Clamp Handle



ID	Description
1	9784418 Handle, Lobed - 1025
2	9100731 WASHER, FLAT 3_8 X .82 OD
3	9780402 Washer 3_8 split lock
4	9100731 WASHER, FLAT 3_8 X .82 OD

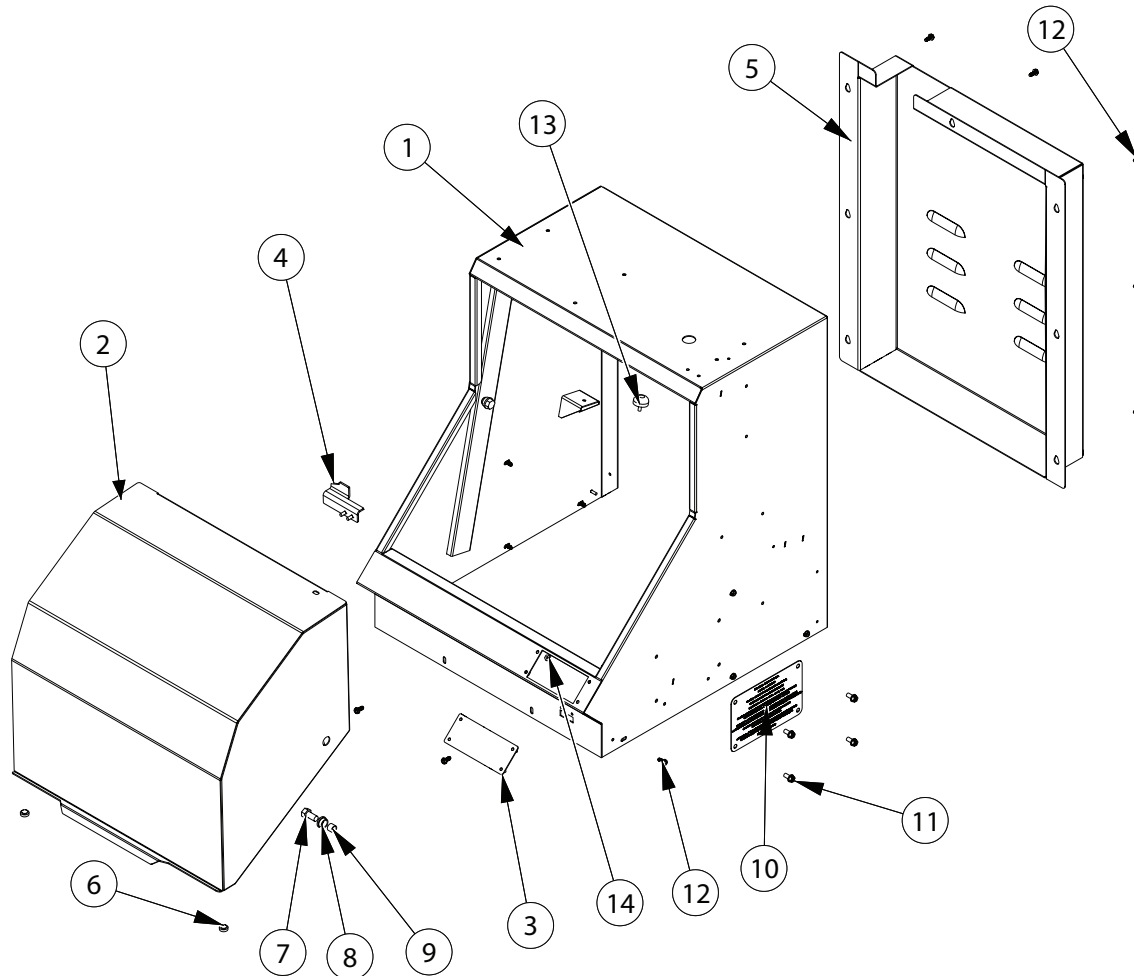
ID	Description
5	9781903
6	9783964 Screw flat head 3_8-16 X 1_25
7	9783951 Nut, 3_8-16 Jam Nylon Lock

**PART NUMBERS LISTED MAY ONLY BE AVAILABLE IN KIT FORM OR AS AN ASSEMBLY**

Exploded Views, Continued..

...Exploded Views, Continued

## 8.4 Enclosure



ID	Description
1	9787228 Enclosure Weldment - 1025
2	9787230 Door Weldment - 1025
3	9787231 COVER, CONTROL PANEL - 1025 X1
4	9787237 ACTUATOR, LIMIT SWITCH - 1025 X1
5	9787229 PANEL, BACK - 1025 X1
6	9780789 BUMPER, PAD
7	9780144 Screw Hex 3_8-16 x .75
8	9784425 Bearing, Bronze Flanged

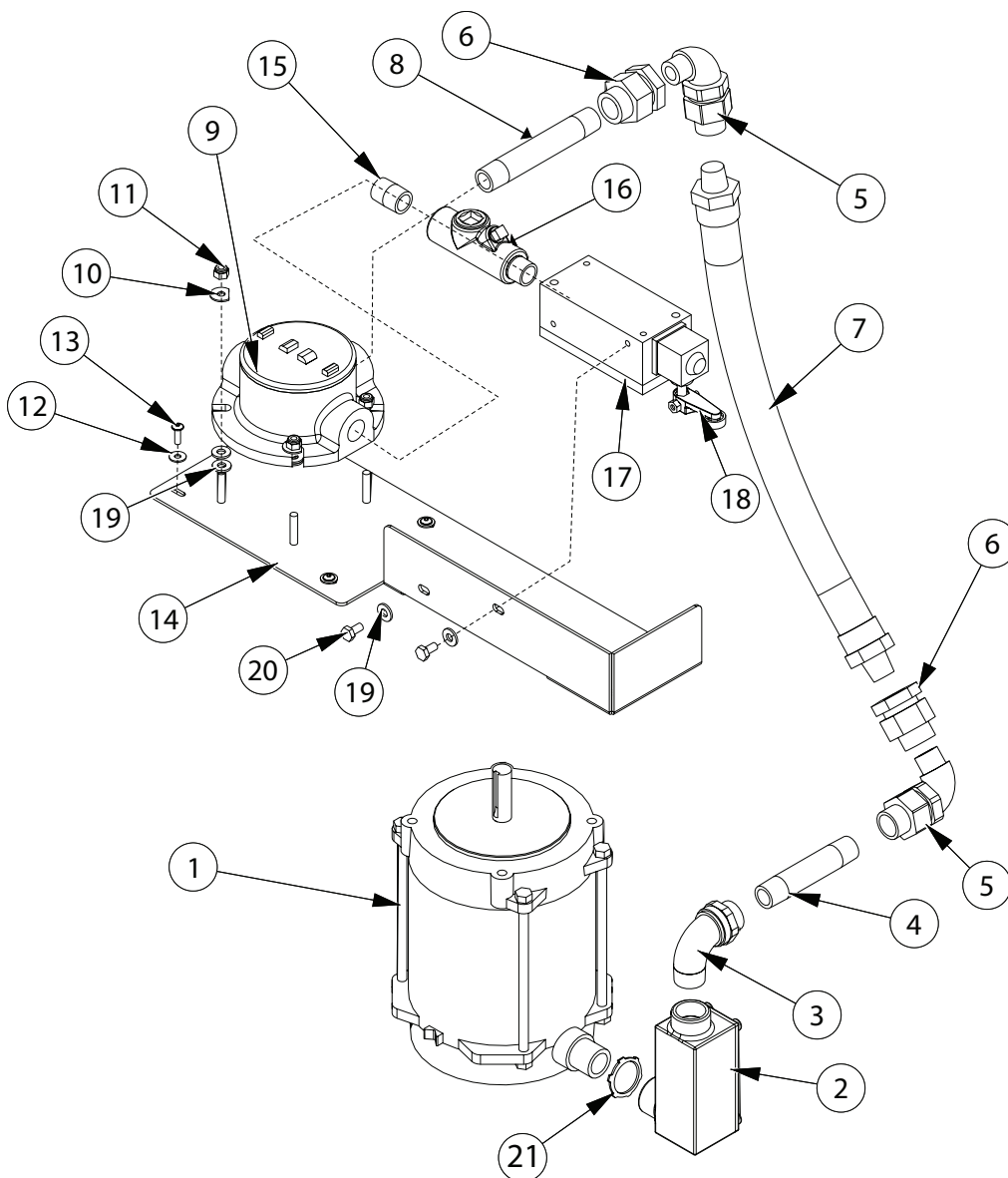
ID	Description
9	9784426 Sleeve, Steel
10	1784994 NAMEPLATE, METAL - 1025-X1
11	9780366 SCREW HEX THD CUT 1_4-20 X .50
12	9783385 Screw, #10-32 SHWH Tap
13	9784048 Bumper, Threaded Rubber
14	9781840 Nut, Keps #8-32

**PART NUMBERS LISTED MAY ONLY BE AVAILABLE IN KIT FORM OR AS AN ASSEMBLY**

Exploded Views, Continued..

...Exploded Views, Continued

## 8.4 Electrical



ID	Description
1	5784981 MOTOR, 1_3HP, 1725 RPM, HAZ LOC
2	9784662 conduit body, I - .75 npt
3	9784909 ELBOW, UNION, .75M-.50F
4	9784985 NIPPLE, 1_2 NPT X 4.00
5	9784659 ELBOW, 90° UNION, .50NPT, M-F
6	9784986 UNION, .50 NPT F-F
7	9784987 CONDUIT, FLEXIBLE - .50NPT, 15 LG, M-M
8	9784988 NIPPLE, 1_2 NPT X 5.00
9	9784067 Conduit Box, T 0.50
10	9785015 WASHER, FLAT D, 1_4
11	9780343 Nut 1_4-20 Nylon Lock

ID	Description
12	9780749 Washer, Flat #10
13	9785014 SCREW, BUTTON HD CAP #10-32 X .625
14	9787232 MOUNT, LIMIT SWITCH - 1025-0X
15	9784115 Nipple, Close - .5 NPT
16	9784989 FITTING, SEALING, .50NPT
17	5784991 SWITCH, LIMIT - EXP. PROOF
18	9784992 ROLLER LEVER, LIMIT SWITCH
19	9760514 Washer 1_4 SAE .281 ID
20	9784698 SCREW, HEX 1_4-20 X .50
21	9787340 Conduit Lock Nut

**PART NUMBERS LISTED MAY ONLY BE AVAILABLE IN KIT FORM OR AS AN ASSEMBLY**



## 9. Ordering

### Replacment Parts

#### HOW TO ORDER REPLACEMENT PARTS

Replacement parts can be ordered from Radia by telephone, fax, or email:

#### **RADIA**

800-221-1083  
763-533-2969  
763-533-0015 (FAX)  
orders@radiaproducts.com

If you need help in determining the proper part(s) to order, please call Customer Care. at 1-800-221-1083. Always indicate the Model and Serial numbers of the machine when ordering replacement parts.

#### GENERAL PARTS REPLACEMENT POLICIES

While your machine is under warranty, do not attempt on-site repair or parts replacement without first contacting RADIA. (to protect your warranty). After the warranty expires, replacement parts and recommendations for on-site servicing are available from RADIA. Please contact Customer Care for assistance.

#### RESTOCKING FEE

A restocking fee will be charged on all unused parts which are returned.



For instructional "How To" videos please visit:  
[www.radiaproducts.com](http://www.radiaproducts.com)



## 10. Warranty

### Equipment Covered Under This Warranty

**Models 1025X1**

### Warranty

Radia warrants equipment manufactured by it and bearing its name to be free from defects in material and workmanship.

**EXCEPT FOR THE WARRANTY SET FORTH HEREIN, RADIA MAKES NO WARRANTY WHATSOEVER WITH RESPECT TO THE EQUIPMENT, INCLUDING ANY (a) WARRANTY OF MERCHANTABILITY; (b) WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE; OR (c) WARRANTY AGAINST INFRINGEMENT OF INTELLECTUAL PROPERTY RIGHTS OF A THIRD PARTY; WHETHER EXPRESS OR IMPLIED BY LAW, COURSE OF DEALING, COURSE OF PERFORMANCE, USAGE OF TRADE OR OTHERWISE.**

This warranty applies only when the equipment is installed, operated and maintained in accordance with written Radia instructions as appearing in the owners' manuals.

This warranty does not cover, and Radia shall not be liable for, any malfunction, damage, or wear caused by faulty installation, misapplication, abrasion, corrosion, inadequate or improper maintenance, negligence, accident, tampering or substitution of non-Radia component parts, modification or use for non-intended purposes. Nor shall Radia be liable for malfunction, damage or wear caused by the incompatibility of Radia equipment with structures, accessories, equipment, or materials not supplied by Radia.

Subject to the limitations set forth above, Radia shall (i) repair or replace the equipment (or the defective part) or (ii) credit or refund the price of such equipment. Costs of labor and transportation for service of machines under this warranty will also be covered during the warranty period if Radia elects to repair or replace the equipment. Normal ground freight will be covered for replacement parts sent within the warranty period. For customers outside of the US and Canada, the warranty is for parts only. Ground or common carrier ground freight will be covered for the return of defective items only. In no case shall Radia's liability exceed the amount of the purchase price.

\*All warranty repairs must be executed by a Radia Authorized Service Center or warranty will be voided.

**THE REMEDIES SET FORTH HEREIN ARE PURCHASER'S SOLE AND EXCLUSIVE REMEDY and RADIA'S ENTIRE LIABILITY FOR ANY BREACH OF THE LIMITED WARRANTY SET FORTH HEREIN.**

Please contact your Radia Relationship Manager at 800-221-1083 for specific questions regarding specific questions regarding warranty terms.

## 11. Notes

For sales or service, please contact

RADIA  
Attn: Customer Service Department  
14900 21st Ave N  
Plymouth, Mn 55447  
USA

**U.S. Telephone:** 800.221.1083  
**International Telephone:** 763.533.2969  
**Fax:** 763.533.0015  
**E-mail:** [info@radiaproducts.com](mailto:info@radiaproducts.com)

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



For instructional "How To" videos please visit:  
[www.radiaproducts.com](http://www.radiaproducts.com)

