

*Refer to parts breakdown drawing*

- 1) Drain oil from gear case.
- 2) Remove cover (Ref. 13) from gear support (Ref. 11).
- 3) Remove motor (Ref. 2) from planetary gear box (Ref. 8).
- 4) Carefully remove planetary gear box (Ref. 8) from gear support (Ref. 11).
- 5) Remove retaining ring (Ref. 12) from output shaft adapter (Ref. 9).
- 6) Remove output shaft (Ref. 24) and output shaft adapter (Ref. 9) assembly from gear support (Ref. 11).
- 7) Carefully remove retaining ring (Ref. 23) from output shaft (Ref. 24) and press output shaft adapter (Ref. 9) from output shaft.
- 8) Remove keys (Ref. 25) from output shaft (Ref. 24).
- 9) Remove ball bearings (Ref. 10) from gear support (Ref. 11).

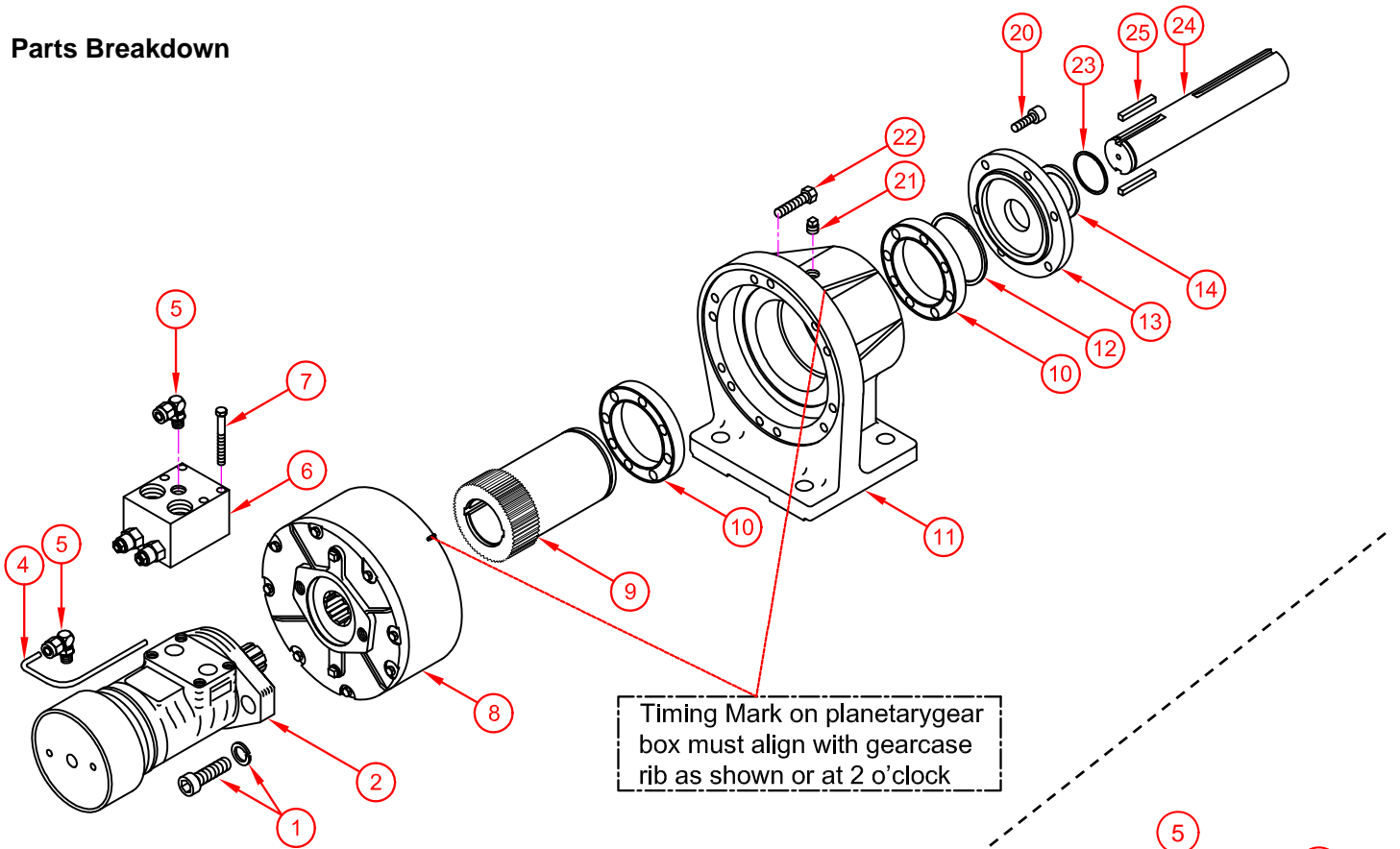
Assembly Instructions

2000 Series Speed Reducer

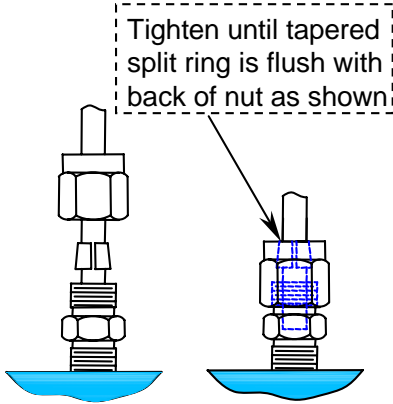
Refer to parts breakdown drawing

- 1) Clean gear case and all parts thoroughly, inspect all parts and replace if worn or scored.
- 2) Install ball bearings (Ref. 10) into gear support (Ref. 11).
- 3) Carefully press output shaft adapter (Ref. 9), keys (Ref. 25) onto output shaft (Ref. 24) and install retaining ring (Ref. 23) onto output shaft. Then install onto gear support (Ref. 11) and install retaining ring (Ref. 12).
- 4) Use silicon (form a gasket) onto gear support (planetary gear box side) (Ref. 11). Align timing mark on planetary gearbox with top-rib of the gear support or at two o'clock (as shown on parts breakdown).
Then carefully install planetary gear box (Ref. 8) onto gear support (Ref. 11) with (12) 3/8"-24NF x 1-3/4" Hex Head Cap Screws (Ref. 22). (being sure tighten the screws evenly)
- 5) If removed, install oil seal (Ref. 14) onto cover (Ref. 13).
- 6) Use silicon (form a gasket) onto gear support (Ref. 11) (gear support cover side).
Then install cover (Ref. 13) onto gear support (Ref. 11) with (6) 3/8"-16UNC x 1" Socket Head Cap Screws (Ref. 20). (being sure tighten the screws evenly).
- 7) Use silicon (form a gasket) onto planetary gearbox (Ref. 8), then install motor (Ref.2) onto gear box (Ref. 5) with 1/2"-13UNC x 1-1/4" Gr. 5 SHCS & lock washers (Ref. 1).
- 8) If removed, align both ends of hydraulic tube (Ref. 4) to the ports (Ref. 5 & 26 if Sun valve installed) (Ref. 5 & 5 if Eaton valve installed). Push hydraulic tube (Ref. 91) into installed fitting body (Ref. 90) on motor (Ref. 2) and fail-safe brake (Ref. 8) until it stops. Fasten nuts and tapered split rings to fittings. Turn nuts hand tight, then with wrench tighten one turn or until rear of tapered split ring is flush with the nut.
Do Not Overtighten.
- 8) Fill gear box with (4) pints (1.4 liters) Bloom ULLTRA-LUBE NO. 601 TRANS-WORM GEAR OIL.

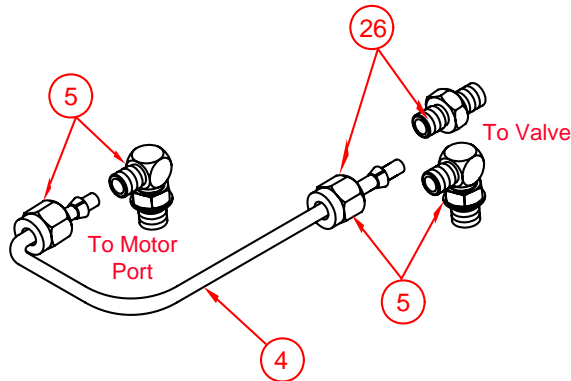
Parts Breakdown



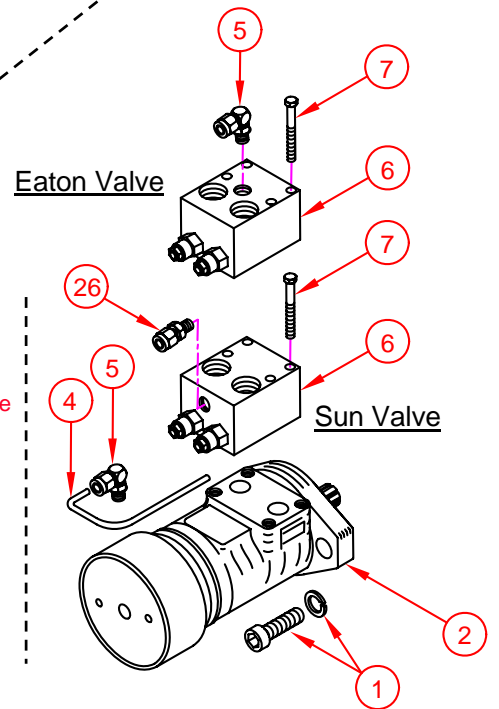
Hydraulic line assembly (Ref. 2, 4, 5, 6 & 26)



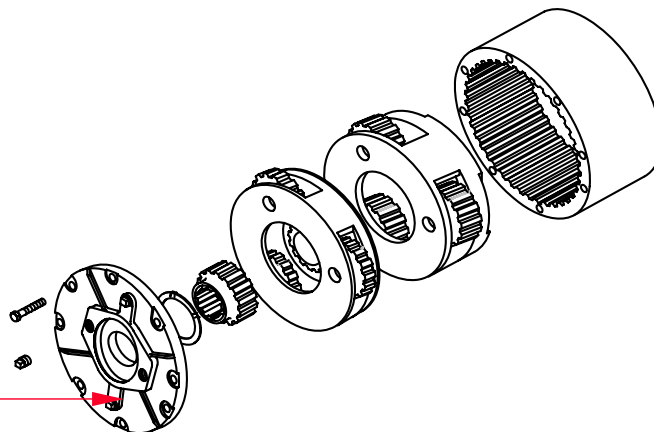
Tapered Split Rings



Hydraulic Tube & Fittings



Shown parts breakdown of planetary gear box (Ref. 8)



Magnet – pipe plug must install into lower drain hole