

0108

1 GENERAL INFORMATION

The following instructions will help you achieve a satisfactory installation of your Textron Power Transmission Series B unit, ensuring the best possible conditions for a long and trouble free operation.

All units are tested and checked prior to shipment, a great deal of care is taken in packing and shipping arrangements to ensure that the unit arrives at the customer in the approved condition.

Optimum performance is best achieved by a process of gradual load increments, up to the full value, over the first 50 hours or so of their working life. During these early stages of running, sensible precautions should be taken to avoid overloads.

The gear unit operating temperature may be higher during this period of run-in. A progressive reduction in temperature may occur over many hours until the unit has reached its highest efficiency.

2 MOUNTING OF COMPONENTS TO EITHER THE UNIT INPUT OR OUTPUT SHAFT

Shaft dimensions and tolerances are on page 9.

- Items (such as gears, sprockets, couplings etc) should not be hammered onto these shafts since this would damage the shaft support bearings.
- The item should be pushed onto the shaft using a screw jack device fitted into the threaded hole.
- Items being fitted may be heated to 80/100°C (176/212°F) to aid assembly further.

3 WEATHER PROTECTION OF UNIT

All Series B units are provided with protection against normal weather conditions. Where units are to operate in extreme conditions, or where they are to stand for long periods without running, e.g. during plant construction, we should be notified when ordering so that arrangements for adequate protection can be made.

4 INSTALLATION**4.1 MOTORIZED AND REDUCERS**

All sizes are factory filled with a high quality synthetic lubricant. They are 'Lubricated for Life' and require no routine maintenance in service

4.2 MOUNTING TO CUSTOMER EQUIPMENT

Mounting the gearhead flange facing or feet to the customer equipment use screws to ISO grade 8.8 minimum.

Torque tighten to:

Screw Size	Tightening Torque	Tightening Torque
M6	88 lb-ins	7.3 lb-ft
M8	220 lb-ins	18.3 lb-ft
M10	450 lb-ins	37.5 lb-ft
M12	750 lb-ins	62.5 lb-ft
M16	1770 lb-ins	147.5 lb-ft
M20	3100 lb-ins	258.3 lb-ft
M24	5400 lb-ins	450.0 lb-ft

4.3 MOTOR CONNECTIONS TO MAINS

Connection of the electric motor to the mains supply should be made by a qualified person. The current rating of the motor will be identified on the motor plate, and correct sizing of the cables to electrical regulations is essential.

