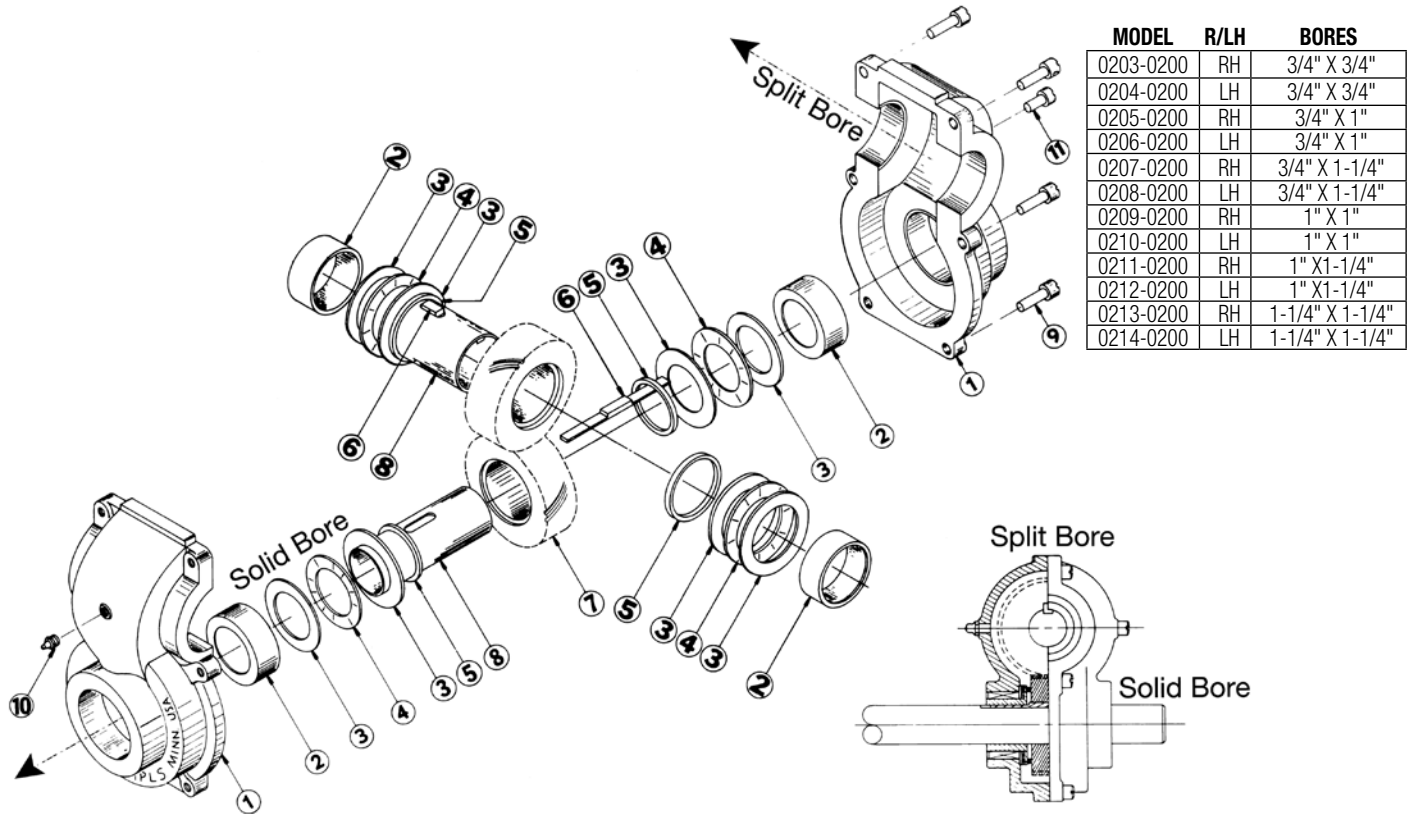


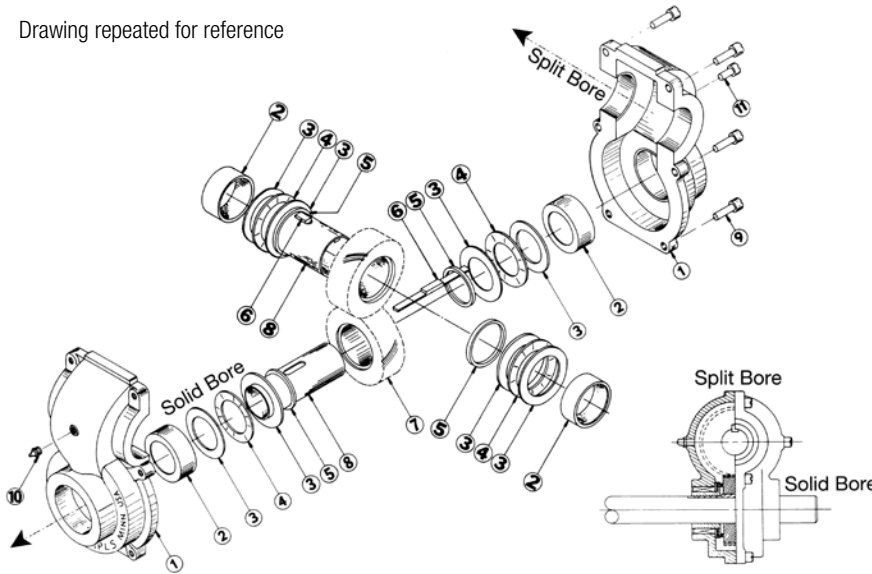
FLOAT-A-SHAFT® Standard Series – 1:1 Ratio

Standard - High Torque - Roller Bearing

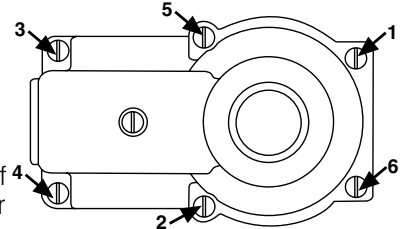


ITEM	PART NO.	DESCRIPTION	QUANTITY													
			0203-0200	0204-0200	0205-0200	0206-0200	0207-0200	0208-0200	0209-0200	0210-0200	0211-0200	0212-0200	0213-0200	0214-0200		
1	0226-9026	GEAR CASE HOUSING	1	1	1	1	1	1	1	1	1	1	1	1	1	1
2	0200-1526	BEARING, NEEDLE, ROLLER, 1-3/8" BORE	4	4	4	4	4	4	4	4	4	4	4	4	4	4
3	0200-1326	WASHER, THRUST, 1-3/8" BORE	8	8	8	8	8	8	8	8	8	8	8	8	8	8
4	0200-1222	BEARING, THRUST, 1-3/8" BORE	4	4	4	4	4	4	4	4	4	4	4	4	4	4
5	0200-1332	SPACER, PL, CELCON RING, .09" THICK	4	4	4	4	4	4	4	4	4	4	4	4	4	4
6	0200-1500	KEY, STEP, 1/4" X 5/16"					1	1				1	1	2	2	
	0200-1501	KEY, STEP, 1/4" X 7/16"			1	1				2	2	1	1			
	0200-1502	KEY, STEP, 3/16" X 1/2"	2	2	1	1	1	1								
7	0200-1113	GEAR, 25 T, LH				1	1	1		2		2		2		2
	0200-2113	GEAR, 25 T, RH			1		1		2		2		2		2	
	0200-1111	GEAR, 25 T, LH		2		1		1								
	0200-2111	GEAR, 25 T, RH	2		1		1									
8	0200-3525	BUSHING, SLEEVE, STEEL, 3/4" BORE	2	2	1	1	1	1								
	0200-3526	BUSHING, SLEEVE, STEEL, 1" BORE			1	1			2	2	1	1				
	0200-3519	BUSHING, SLEEVE, STEEL, 1-1/4" BORE					1	1				1	1	2	2	
9	0200-1812	SCREW, FILL HD, 1/4-20	6	6	6	6	6	6	6	6	6	6	6	6	6	6
10	0100-1601	ZERK GREASE FITTING, 1/4-28	1	1	1	1	1	1	1	1	1	1	1	1	1	1
11	0100-2604	SCREW, FILL HD, 1/4-28	1	1	1	1	1	1	1	1	1	1	1	1	1	1

Drawing repeated for reference

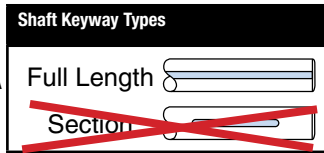


Plastic Spacer (5) on both sides of gear. Lubricate all bearings and the Gear (7) manually (See “Lubrication”). Install a Thrust Washer (3), Thrust Bearing (4), and Thrust Washer (3) on each side of gear. Install a Roller Bearing (2) on each side of Gear (6). Lay the completed assembly into the split bore of the Gear Case Housing (1), making sure the teeth of the gears mesh. **CAUTION:** When trying to get the gears to mesh, rotate the gears to prevent possible damage to the teeth. Next, cover gears and bearings with approximately 3 oz. of lubricant. To complete assembly, install the other half of the Gear Case Housing (1) and tighten the Screws (9) in the order shown here. In case of shaft binding, check for possible misalignment of the shafts or for oversized shaft diameters.



Installation

Keyway MUST extend to end of shaft. IT IS NOT POSSIBLE TO USE A SECTIONED SHAFT WITH A ROLLER BEARING FLOAT-A-SHAFT. Without removing the plastic tubes, align the Float-A-Shaft® with the shaft on which it is to be used and gently press it on. Be sure the key is properly aligned with the keyway. The plastic tubes will fall out as the shaft extends through the unit. Save the plastic tubes for removal of the Float-A-Shaft® for maintenance or repair. Be sure to reinsert the plastic tubes as the shaft is withdrawn, otherwise the internal parts will slip out of position and disassembly may be required to restore proper alignment.



Reassembly: Reference the numbering diagram on page 1 to complete the following instructions, matching the numbers with corresponding bores.

SOLID BORE REASSEMBLY: Lay Gear Case Housing (1) horizontal, with inside surface facing up. Install Roller Bearing (2) in solid bores of Gear Case Housing (1). Press from inside to outside. Inside face of roller bearing must be flush with inside machined surface of gear case housing. Next, Insert Key (6) into slot of Sleeve Bushing (8) and insert the plastic tube to hold it in place. Install Gear (7) over the Sleeve Bushing (8) positioning it over Key (6). Install Plastic Spacer (5) on both sides of gear. Lubricate Roller Bearing (2), Thrust Bearing (4), and Gear (7) manually (See “Lubrication”). Install a Thrust Washer (3), Thrust Bearing (4), and Thrust Washer (3) on each side of gear. Lay the Gear Case Housing (1) horizontal, with the solid bore vertical and inside surface facing up. Install gear, sleeve and bearing assembly into the solid bore.

SPLIT BORE REASSEMBLY: Insert Key (6) into slot of Sleeve Bushing (8) and insert the plastic tube to hold it in place. Install Gear (7) over the Sleeve Bushing (8) positioning it over Key (6). Install

Shaft Requirements: Shafts should be made of power transmission steel grade 4140 or better. A tolerance of +.000/- .002 is recommended for the shaft diameters. The shaft surfaces should be 32 RMS maximum for stationary applications, and 16 RMS maximum for traversing applications. Shaft straightness should be .0015 TIR per foot.

LUBRICATION AND MAINTENANCE SCHEDULE: All Float-A-Shaft® gear boxes have been lubricated at the factory with Mobilith® SHC 460. Standard Float-A-Shaft® gear boxes are initially filled with 2.8 oz. (82.8 ml) of grease to achieve 54% fill on the units. However, units require more lubrication prior to operation. Periodic re-lubrication is also necessary for optimum performance. When re-lubricating, inject Mobilith® SHC 460 (maximum operating temperature of 300°F or higher and EP rated) into gear case, as required, via the grease zerk provided. *Mobilith® SHC 460 - 14 oz grease cartridge • P/N 0100-1605*

Lubrication and maintenance schedules are dependent on the application. General guidance is provided below and a maintenance plan can be developed based on the use case.

MAINTENANCE	USE CASE		
	Continuous/ Heavy Duty	Intermittent/ Light Duty	Minimal
Inject 1/4 oz. of Mobilith SHC460 into gear housing	1 ½ Months	3 Months	6 Months
Disassemble and purge unit. Hand lubricate all bearings and gears with 3 oz. of Mobilith SHC460	6 Months	1 Year	1 Year

Mobilith® SHC 460 is a registered trademark of Exxon Mobil Corporation, www.mobil.com
Float-A-Shaft® is a registered trademark of Tolomatic, Inc.



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