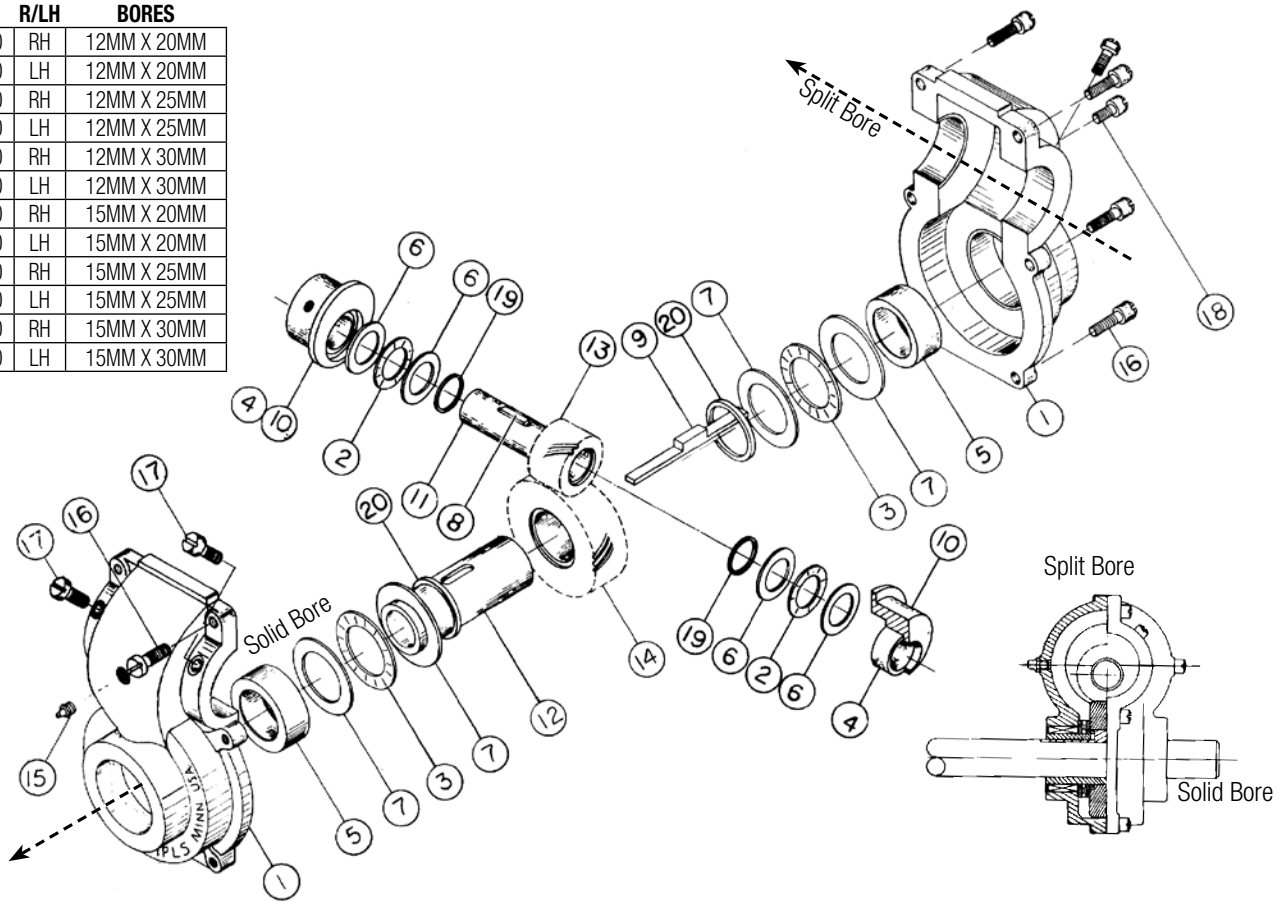
FLOAT-A-SHAFT® Standard Series – 2:1 Ratio - METRIC

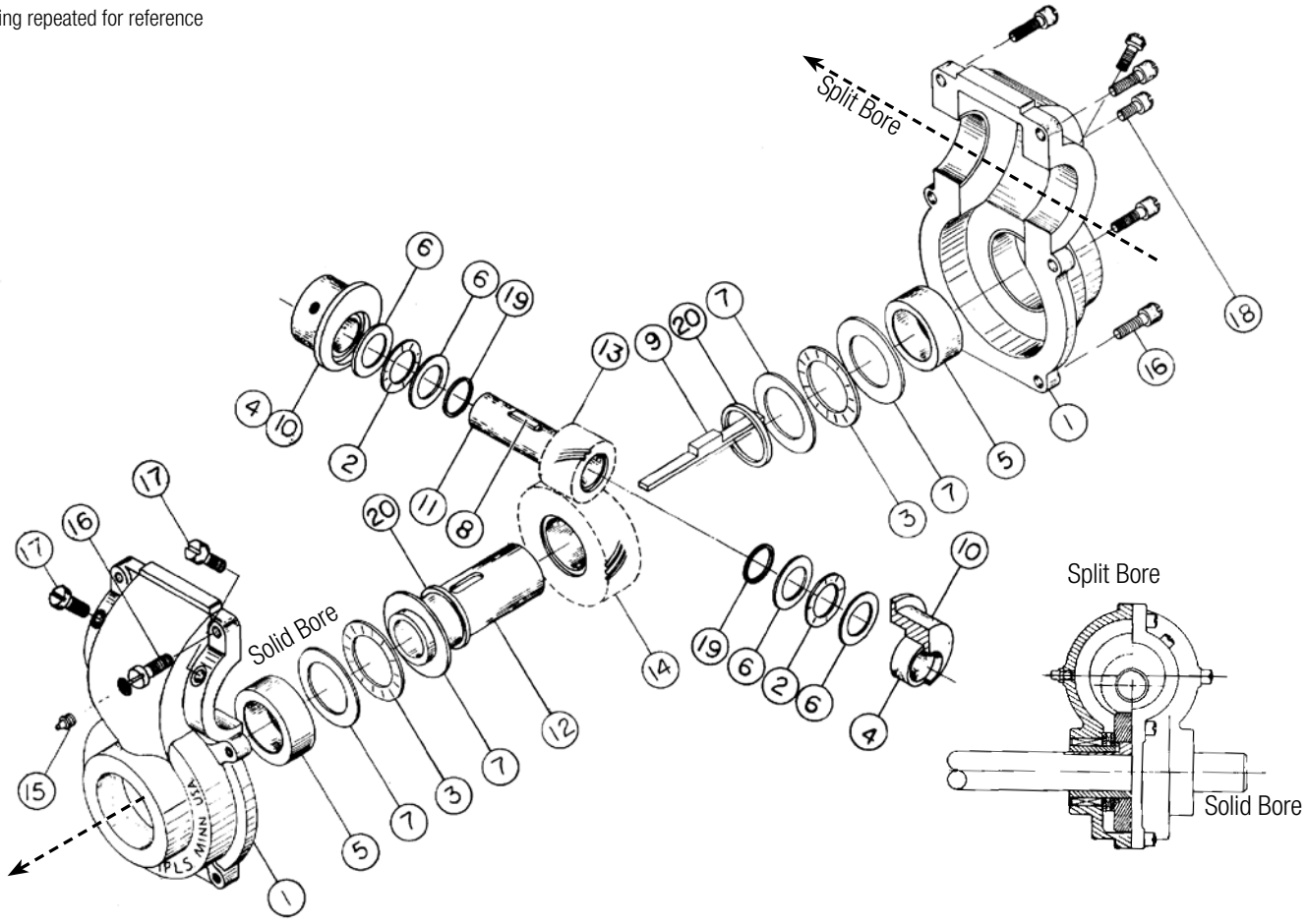
Standard – High Torque, Roller Bearing

MODEL	R/LH	BORES
0382-0200	RH	12MM X 20MM
0383-0200	LH	12MM X 20MM
0384-0200	RH	12MM X 25MM
0385-0200	LH	12MM X 25MM
0386-0200	RH	12MM X 30MM
0387-0200	LH	12MM X 30MM
0390-0200	RH	15MM X 20MM
0391-0200	LH	15MM X 20MM
0392-0200	RH	15MM X 25MM
0393-0200	LH	15MM X 25MM
0394-0200	RH	15MM X 30MM
0395-0200	LH	15MM X 30MM



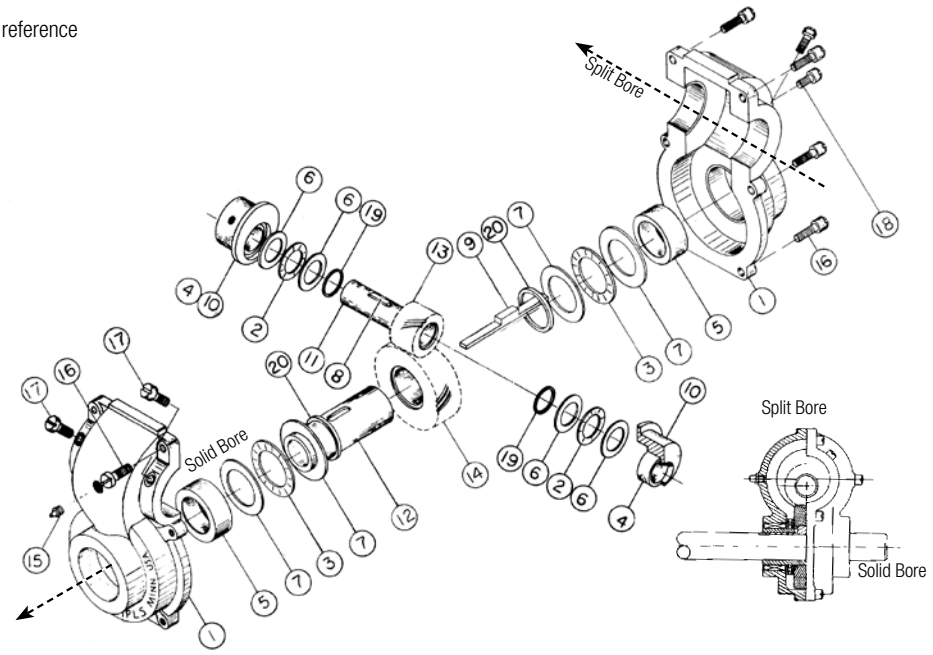
ITEM	PART NO.	DESCRIPTION	QUANTITY											
			0382-0200	0383-0200	0384-0200	0385-0200	0386-0200	0387-0200	0390-0200	0391-0200	0392-0200	0393-0200	0394-0200	0395-0200
1	0240-9003	GEAR CASE HOUSING	1	1	1	1	1	1	1	1	1	1	1	1
2	0200-1214	BEARING, THRUST	2	2	2	2	2	2	2	2	2	2	2	
3	0200-1222	BEARING, THRUST	2	2	2	2	2	2	2	2	2	2	2	2
4	0200-1527	BEARING, NEEDLE, ROLLER	2	2	2	2	2	2	2	2	2	2	2	2
5	0200-1526	BEARING, NEEDLE, ROLLER	2	2	2	2	2	2	2	2	2	2	2	2
6	0200-1317	WASHER, THRUST	4	4	4	4	4	4	4	4	4	4	4	4
7	0200-1326	WASHER, THRUST	4	4	4	4	4	4	4	4	4	4	4	4
8	0200-1537	KEY, STEP, 8MM X 9.53MM					1	1					1	1
	0200-1536	KEY, STEP, 8MM X 11.89MM			1	1					1	1		
	0200-1535	KEY, STEP, 6MM X 13.36MM	1	1					1	1				
9	0200-1531	KEY, STEP, 5MM X 8.53MM							1	1	1	1	1	1
	0200-1530	KEY, STEP, 4MM X 9MM	1	1	1	1	1	1						
10	0275-7709	BUSHING, STEEL, ECCENTRIC	2	2	2	2	2	2	2	2	2	2	2	2
11	0200-3542	BUSHING, STEEL, 12MM BORE	1	1	1	1	1	1						
	0200-3543	BUSHING, STEEL, 15MM BORE							1	1	1	1	1	1
12	0200-3547	BUSHING, SLEEVE, STEEL, 20MM BORE	1	1					1	1				
	0200-3548	BUSHING, SLEEVE, STEEL, 25MM BORE			1	1					1	1		
	0200-3549	BUSHING, SLEEVE, STEEL, 30MM BORE					1	1					1	1

Drawing repeated for reference



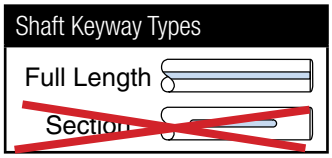
ITEM	PART NO.	DESCRIPTION	QUANTITY											
			0382-0200	0383-0200	0384-0200	0385-0200	0386-0200	0387-0200	0390-0200	0391-0200	0392-0200	0393-0200	0394-0200	0395-0200
13	0200-1138	GEAR, 15 T, LH		1		1		1		1		1		1
	0200-2138	GEAR, 15 T, RH	1		1		1		1		1		1	
14	0200-1144	GEAR, 30 T, LH		1						1				
	0200-2144	GEAR, 30 T, RH	1						1					
	0200-1145	GEAR, 30 T, LH				1		1				1		1
	0200-2145	GEAR, 30 T, RH			1		1				1		1	
15	0100-1601	ZERK GREASE FITTING, 1/4-28	1	1	1	1	1	1	1	1	1	1	1	1
16	0200-1812	SCREW, FILL HD, 1/4-20	6	6	6	6	6	6	6	6	6	6	6	6
17	0200-1557	SCREW, FILL HD, 1/4-20	2	2	2	2	2	2	2	2	2	2	2	2
18	0100-2604	SCREW, FILL HD, 1/4-28	1	1	1	1	1	1	1	1	1	1	1	1
19	0200-1331	SPACER, PL, NYLON RING, .09" THICK	2	2	2	2	2	2	2	2	2	2	2	2
20	0200-1332	SPACER, PL, CELCON RING, .09" THICK	2	2	2	2	2	2	2	2	2	2	2	2

Drawing repeated for reference



Installation

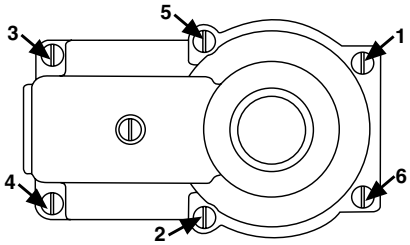
Keyway MUST extend to end of shaft. IT IS NOT POSSIBLE TO USE A SECTIONED SHAFT WITH A ROLLER BEARING FLOAT-A-SHAFT. Without removing the plastic tubes, align the Float-A-Shaft® with the shaft on which it is to be used and gently press it on. Be sure the key is properly aligned with the keyway. The plastic 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 (5) 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 (9) into slot of Sleeve Bushing (12) and insert the plastic tube to hold it in place. Install Gear (14) over the Sleeve Bushing (12) positioning it over Key (9). Install Plastic Spacer (20) on both sides of gear. Lubricate Roller Bearing (5), Thrust Bearing (3), and Gear (14) manually (See "Lubrication"). Install a Thrust Washer (7), Thrust Bearing (3), and Thrust Washer (7) 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 (8) into slot of Sleeve Bushing (11) and insert the plastic tube to hold it in place. Install Gear (13) over the Sleeve Bushing (11) positioning it over Key (8). Install Plastic Spacer (19) on both sides of gear. Lubricate all bearings and the gear manually (See "Lubrication"). Install a Thrust Washer (6), Thrust Bearing (2), and Thrust Washer (6) on each side of gear. Insert a Roller Bearing (4) into the Eccentric Bushing (10) and install on each side of gear. 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 (16) in the order shown here. In case of shaft binding, check for possible misalignment of the shafts or for oversized shaft diameters.



Lubrication: All Float-A-Shaft® gear boxes have been lubricated at the factory with Mobilith® SHC 460. 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

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.

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