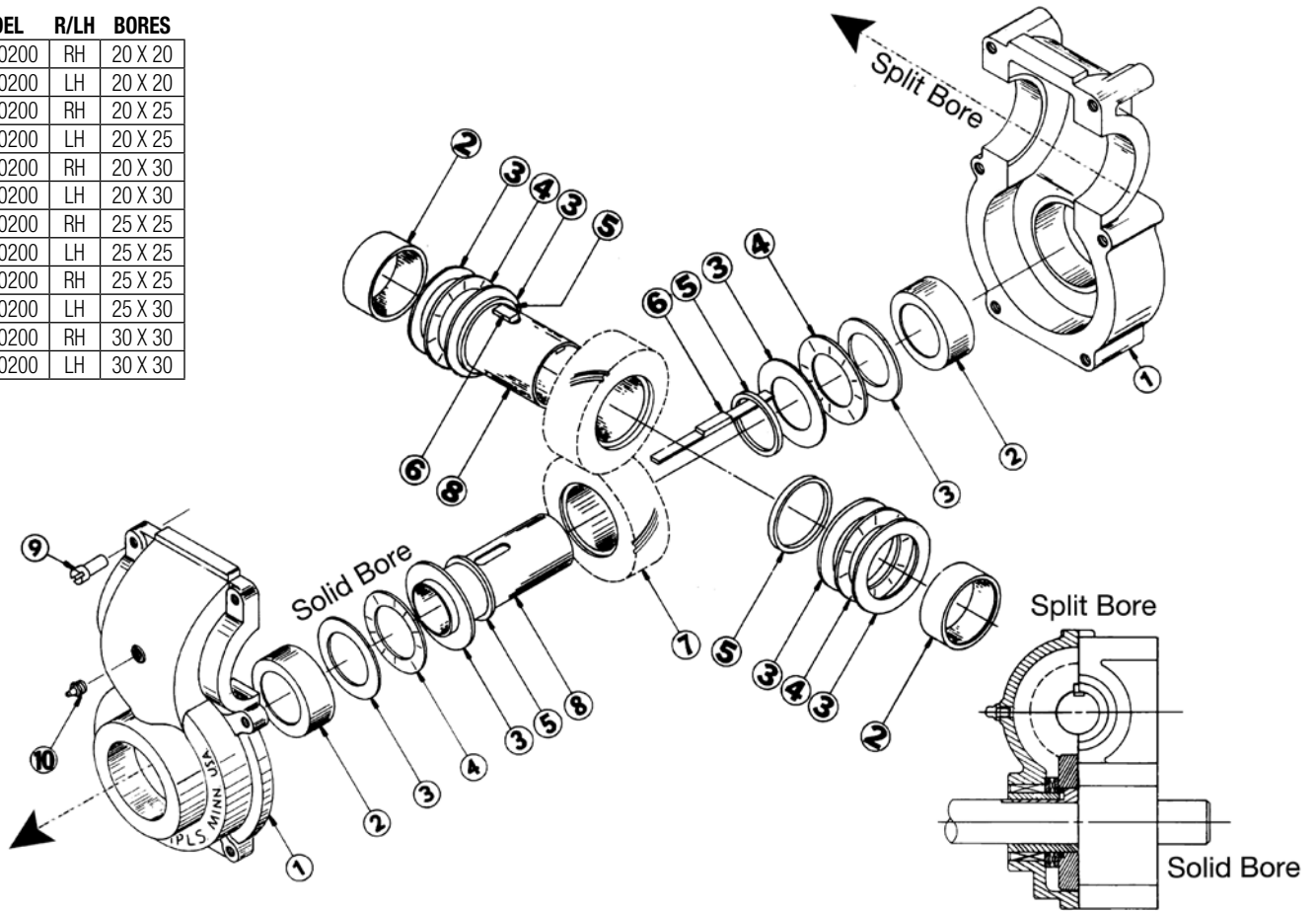


### FLOAT-A-SHAFT® Standard Series – 1:1 Ratio - METRIC

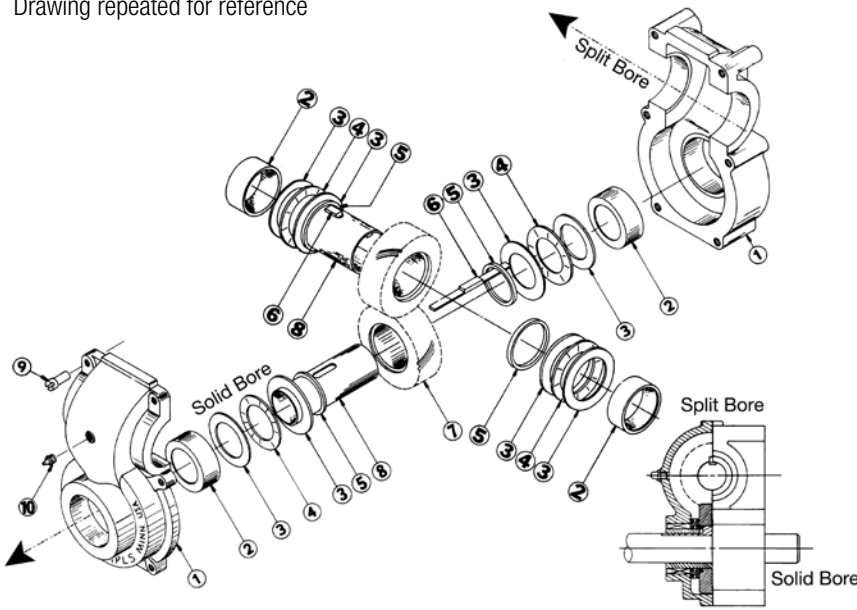
Flat Base - High Torque - Roller Bearing

MODEL	R/LH	BORES
0328-0200	RH	20 X 20
0329-0200	LH	20 X 20
0330-0200	RH	20 X 25
0331-0200	LH	20 X 25
0332-0200	RH	20 X 30
0333-0200	LH	20 X 30
0334-0200	RH	25 X 25
0335-0200	LH	25 X 25
0336-0200	RH	25 X 25
0337-0200	LH	25 X 30
0338-0200	RH	30 X 30
0339-0200	LH	30 X 30

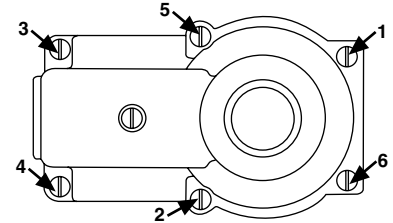


ITEM	PART NO.	DESCRIPTION	QUANTITY														
			0328-0200	0329-0200	0330-0200	0331-0200	0332-0200	0333-0200	0334-0200	0335-0200	0336-0200	0337-0200	0338-0200	0339-0200			
1	0275-9205	GEAR CASE HOUSING, FLAT BASE	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
2	0200-1526	BEARING, NEEDLE, ROLLER	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4
3	0200-1326	WASHER, THRUST	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8
4	0200-1222	BEARING, THRUST	4	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	4
6	0200-1537	KEY, STEP, 8MM X 9.53MM					1	1					1	1	2	2	
	0200-1536	KEY, STEP, 8MM X 11.89MM			1	1				2	2	1	1				
	0200-1535	KEY, STEP, 6MM X 13.36MM	2	2	1	1	1	1									
7	0200-1143	GEAR, 25 T, LH, 8MM BORE				1		1		2		2					2
	0200-2143	GEAR, 25 T, RH, 8MM BORE			1		1		1		2			2			
	0200-1142	GEAR, 25 T, LH, 6MM BORE		2		1		1									
	0200-2142	GEAR, 25 T, RH, 6MM BORE	2		1		1										
8	0200-3547	BUSHING, SLEEVE, STEEL, 20MM BORE	2	2	1	1	1	1									
	0200-3548	BUSHING, SLEEVE, STEEL, 25MM BORE			1	1				2	2	1	1				
	0200-3549	BUSHING, SLEEVE, STEEL, 30MM 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	6
10	0100-1601	ZERK GREASE FITTING, 1/4-28	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1

Drawing repeated for reference

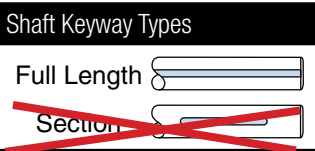


Plastic Spacer (5) on both sides of gear. Lubricate all bearings and the gear manually (See "Lubrication"). Install a Thrust Washer (3), Thrust Bearing (4), and Thrust Washer (3) on each side of gear. Insert a Roller Bearing (2) on each side of gear. Lay the completed assembly into the split bore of 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 (9) in the order shown here. In case of shaft



**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

binding, check for possible misalignment of the shafts or for oversized shaft diameters. Insert Zerk Grease Fitting (10).

**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.



COMPANY WITH  
QUALITY SYSTEM  
CERTIFIED BY DNV  
= ISO 9001 =

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