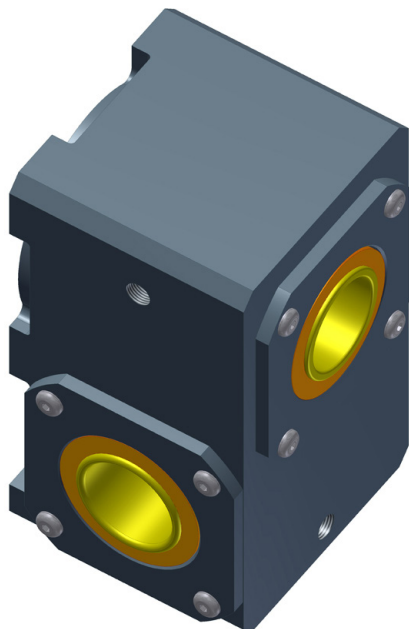


Maintenance Guide

Insert-A-Shaft® CRL25 1:1 Right Angle Gearbox

Standard & Base Mount Models

A/B Bores: 1.25, 1.00, .750, .625



Base Mount Model Shown

Prod. # Model

4304-0631	CRL25BM1:1RHA1.25B1.25
4304-0632	CRL25BM1:1LHA1.25B1.25
4304-0633	CRL25BM1:1RHA1.25B1.00
4304-0634	CRL25BM1:1LHA1.25B1.00
4304-0637	CRL25BM1:1RHA1.25B.750
4304-0638	CRL25BM1:1LHA1.25B.750
4304-0639	CRL25BM1:1RHA1.25B.625
4304-0642	CRL25BM1:1LHA1.25B.625
4304-0643	CRL25BM1:1RHA1.00B1.00
4304-0644	CRL25BM1:1LHA1.00B1.00
4304-0645	CRL25BM1:1RHA1.00B.750
4304-0646	CRL25BM1:1LHA1.00B.750
4304-0647	CRL25BM1:1RHA1.00B.625
4304-0648	CRL25BM1:1LHA1.00B.625
4304-0649	CRL25BM1:1RHA.750B.750
4304-0650	CRL25BM1:1LHA.750B.750
4304-0651	CRL25BM1:1RHA.750B.625
4304-0652	CRL25BM1:1LHA.750B.625
4304-0653	CRL25BM1:1RHA.625B.625
4304-0654	CRL25BM1:1LHA.625B.625

Prod. # Model

4304-0660	CRL251:1RHA1.25B1.00
4304-0661	CRL251:1LHA1.25B1.00
4304-0662	CRL251:1RHA1.25B.750
4304-0663	CRL251:1LHA1.25B.750
4304-0664	CRL251:1RHA1.25B.625
4304-0665	CRL251:1LHA1.25B.625
4304-0677	CRL251:1RHA1.00B1.00
4304-0678	CRL251:1LHA1.00B1.00
4304-0679	CRL251:1RHA1.00B.750
4304-0680	CRL251:1LHA1.00B.750
4304-0681	CRL251:1RHA1.00B.625
4304-0682	CRL251:1LHA1.00B.625
4304-0683	CRL251:1RHA.750B.750
4304-0684	CRL251:1LHA.750B.750
4304-0685	CRL251:1RHA.750B.625
4304-0686	CRL251:1LHA.750B.625
4304-0687	CRL251:1RHA.625B.625
4304-0688	CRL251:1LHA.625B.625
4304-0691	CRL251:1RHA1.25B1.25
4304-0692	CRL251:1LHA1.25B1.25

Shaft Requirements

- Diameter tolerance should be $+.000/-0.002$ in. For traversing applications it is recommended to be $.001/.002$ in. under nominal.
- Runout should be within $.002$ in.
- Straightness should be within $.002$ in. TIR. Per foot.
- Material should be suitable for the particular application. Carbon, alloy or stainless steel shafting may be used.
- Shaft finish should be 64 RMS or better for stationary applications and 32 RMS or better for traversing applications.
- Keyway should be made $0.001/0.002$ in. over nominal Edges should be de-burred.

Shaft Support

Shafting should be supported on all sides of gearbox with external bearing blocks. The internal gearbox bearings are designed to handle the internal loads and are not suitable to support additional, external radial or thrust loads. Failure to support external loads will reduce the gearbox efficiency and service life.

Lubrication

CAUTION: DO NOT FILL GEARBOX WITH GREASE!

Insert-A-Shaft gearboxes are pre-lubricated and ready for service. For light and moderate duty applications they may be considered lubed for life and no further service is required.

For continuous and severe duty use, periodic maintenance may be required. It is recommended to purge grease and re-lubricate every 1,500 hrs of service.

For standard IAS models, lubricate with Magnalube-G® NLGI Grade 2 grease. For Food Grade application, use ACCROLUBE®-FG grease.

For CRL models, lubricate with Lubriplate® 1500 Grade 00 grease. For Food Grade applications use Lubriplate®, FGL-00 grease.

When lubricating remove the lower most port plug and inject new grease into zerk fitting in upper most port purging old grease out lower port. Re-install port plug.

Lubrication amounts:

22/25 series = 1 oz (30ml), 20 series = .67 oz (20ml),
15 and 10 series = .50 oz (15ml)

Note: Overfilling may result in leakage, excessive heat and reduced service life.



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Email AskWCB@wcbranham.com
www.wcbranham.com

CRL25 Group A Lubricant (3-oz.):

#4300-9100, FGL-00 FG For CRL and All Standard SSCRL
#4300-9101, Lubriplate 1500 For all CRL Non-FG

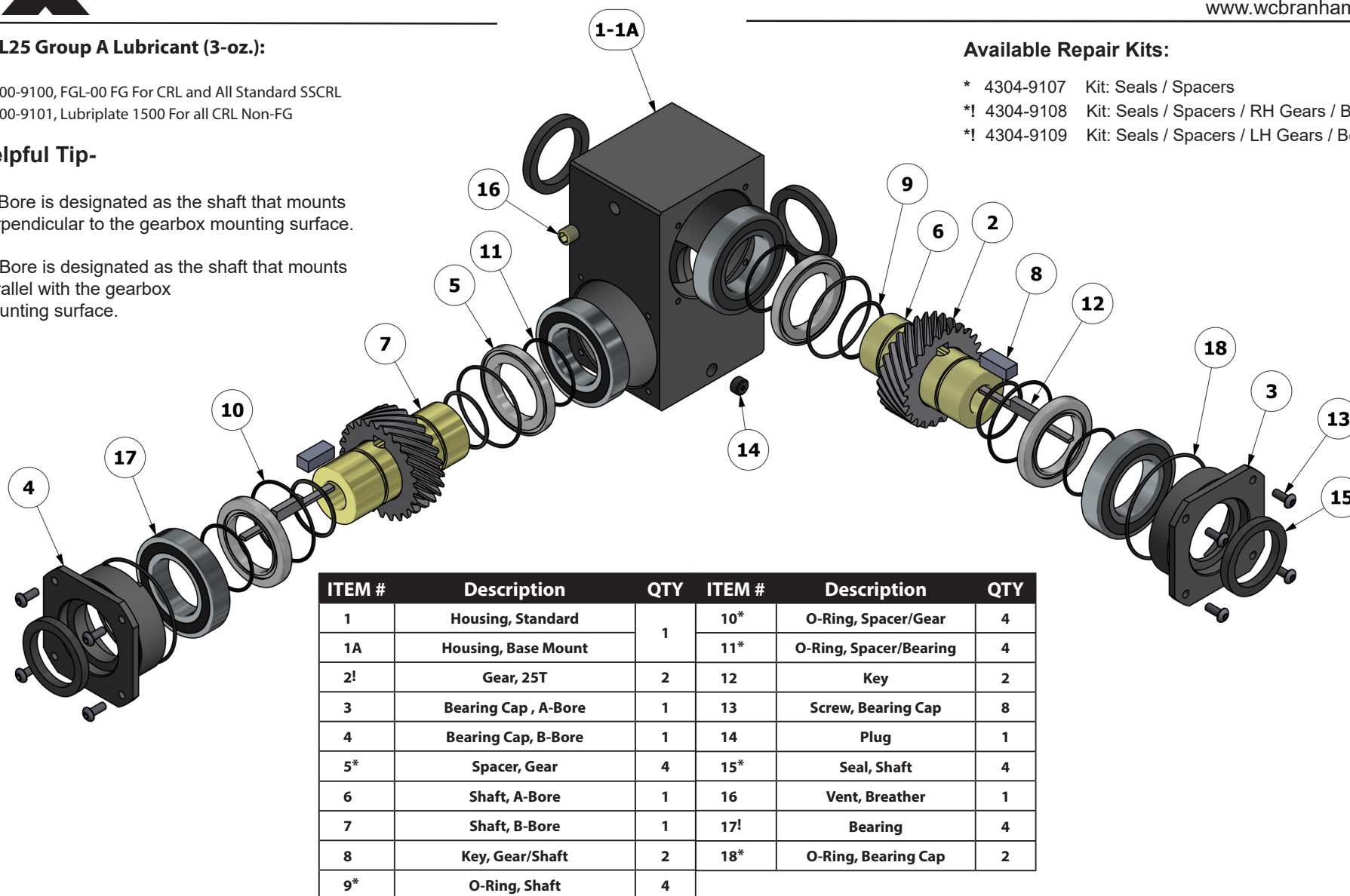
Helpful Tip-

'A' Bore is designated as the shaft that mounts perpendicular to the gearbox mounting surface.

'B' Bore is designated as the shaft that mounts parallel with the gearbox mounting surface.

Available Repair Kits:

- * 4304-9107 Kit: Seals / Spacers
- *! 4304-9108 Kit: Seals / Spacers / RH Gears / Bearings
- *! 4304-9109 Kit: Seals / Spacers / LH Gears / Bearings



ITEM #	Description	QTY	ITEM #	Description	QTY
1	Housing, Standard	1	10*	O-Ring, Spacer/Gear	4
1A	Housing, Base Mount		11*	O-Ring, Spacer/Bearing	4
2!	Gear, 25T	2	12	Key	2
3	Bearing Cap, A-Bore	1	13	Screw, Bearing Cap	8
4	Bearing Cap, B-Bore	1	14	Plug	1
5*	Spacer, Gear	4	15*	Seal, Shaft	4
6	Shaft, A-Bore	1	16	Vent, Breather	1
7	Shaft, B-Bore	1	17!	Bearing	4
8	Key, Gear/Shaft	2	18*	O-Ring, Bearing Cap	2
9*	O-Ring, Shaft	4			