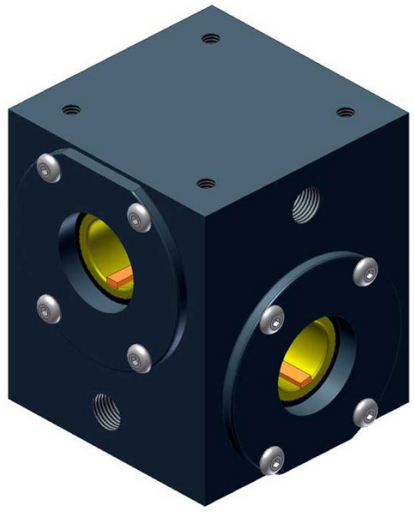
WC BRANHAM® SOLUTIONS IN MOTION

IAS® INSERT A SHAFT



Standard Model Shown

Maintenance Guide

Insert-A-Shaft® 10 1:1 Right Angle Gearbox
Standard & Foot Mount Models

A Bore: .500 | B Bore: .625 | Group C

Prod. #	Model
4304-0118	IAS101:1RHA.500B.625
4304-0119	IAS101:1LHA.500B.625
4304-0406	IAS10FM1:1RHA.500B.625
4304-0407	IAS10FM1:1LHA.500B.625

Shaft Requirements

- Diameter tolerance should be +.000/-.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.

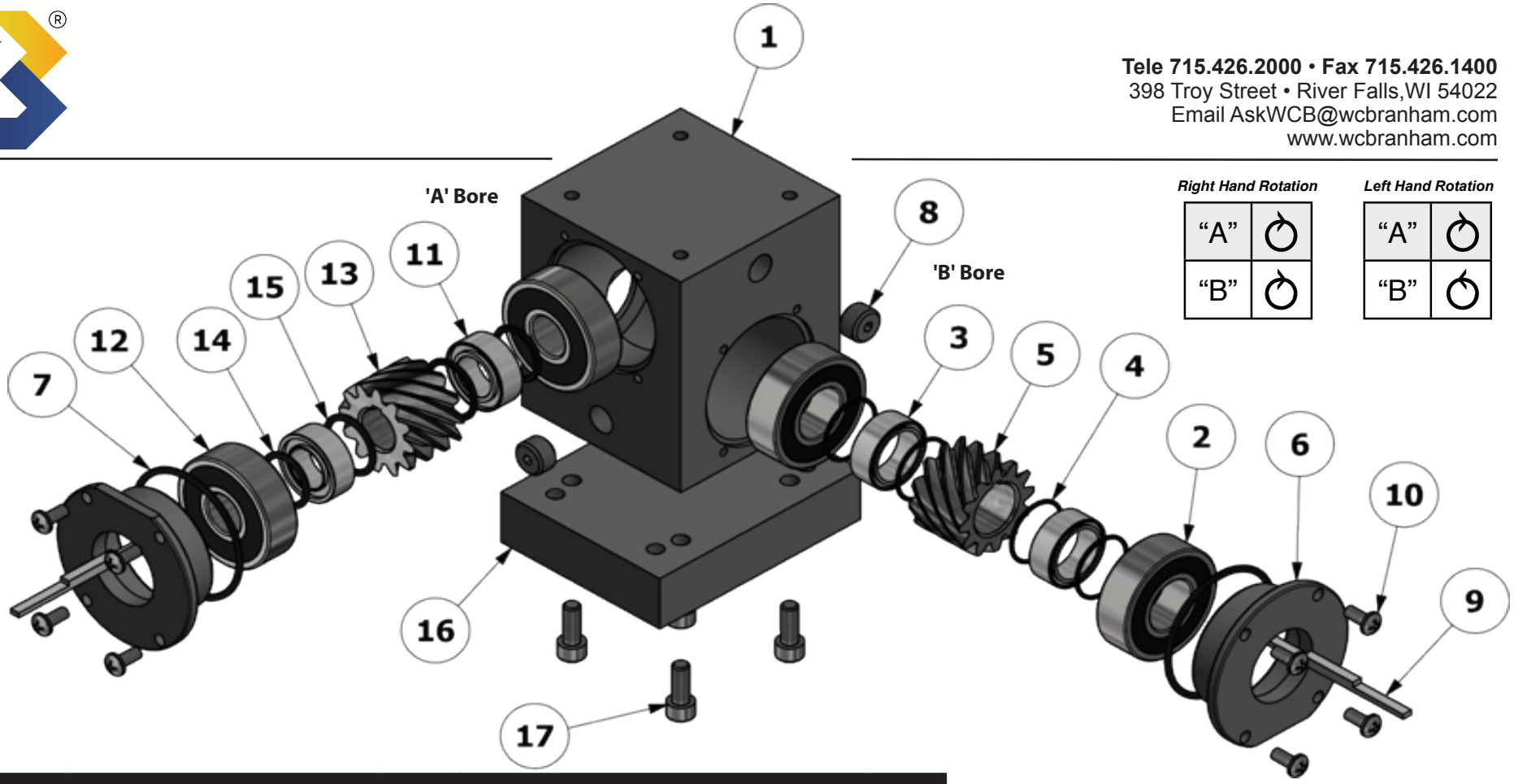
Lubrication amounts:
22/25 series = 1 oz (30ml), 20 series = .67 oz (20ml), 15 and 10 series = .50 oz (15ml)

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

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Right Hand Rotation

"A"	↻
"B"	↻

Left Hand Rotation

"A"	↻
"B"	↻

ITEM #	Description	QTY	ITEM #	Description	QTY
1	Housing	1	10	Screw, Bearing Cap	8
2!	Bearing	2	11*	Spacer, Bore	2
3*	Spacer, Gear	2	12!	Bearing, Bore	2
4*	Spacer, Bore	4	13!	Gear, Bore	1
5!	Gear, Bore	1	14*	O-Ring, Spacer/Bearing	2
6	Cap, Bearing	2	15*	O-Ring, Spacer/Gear	2
7*	O-Ring, Bearing Cap	2	16	FM-Adapter	1
8	Plug	2	17	FM-Screw, Adapter	4
9	Key	2			

IAS10 Group C Lubricant (3-oz.):

#4300-9102, Magnalube-G All Standard Non-FG, Non-CRL Models
#4300-9103*, Accrolube-FG Food Grade #2 For Non-CRL Food Grade
*Optional

Available Repair Kits:

* 4304-9102 Kit: Seals / Spacers
*! 4304-9100 Kit: Seals / Spacers / RH Gears / Bearings
*! 4304-9101 Kit: Seals / Spacers / LH Gears / Bearings

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