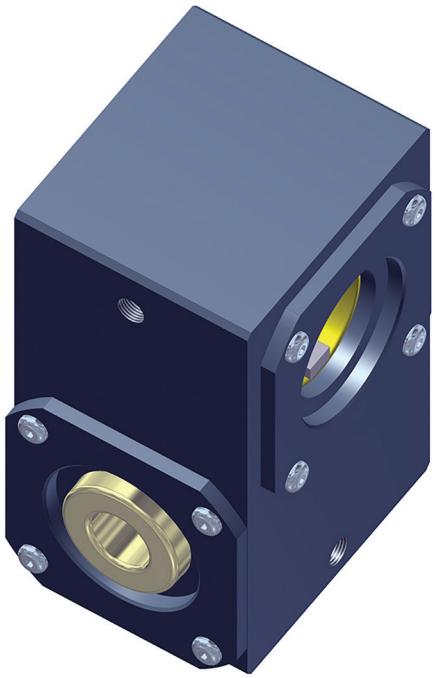
WC BRANHAM®
SOLUTIONS IN MOTION

Tele 715.426.2000 • Fax 715.426.1400
398 Troy Street • River Falls,WI 54022
Email AskWCB@wcbranham.com
www.wcbranham.com



Standard Model Shown

Maintenance Guide

Insert-A-Shaft® 25 1:1 Right Angle Gearbox
Standard & Base Mount Models

A Bore: 1.50 | B Bores: 1.25, 1.00, .750, .625

Prod. #	Model
4304-0222	IAS251:1RHA1.50B1.25
4304-0223	IAS251:1LHA1.50B1.25
4304-0312	IAS251:1RHA1.50B.625
4304-0313	IAS251:1LHA1.50B.625
4304-0314	IAS251:1RHA1.50B.750
4304-0315	IAS251:1LHA1.50B.750
4304-0316	IAS251:1RHA1.50B1.00
4304-0317	IAS251:1LHA1.50B1.00
4304-0392	IAS25BM1:1RHA1.50B1.25
4304-0393	IAS25BM1:1LHA1.50B1.25

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

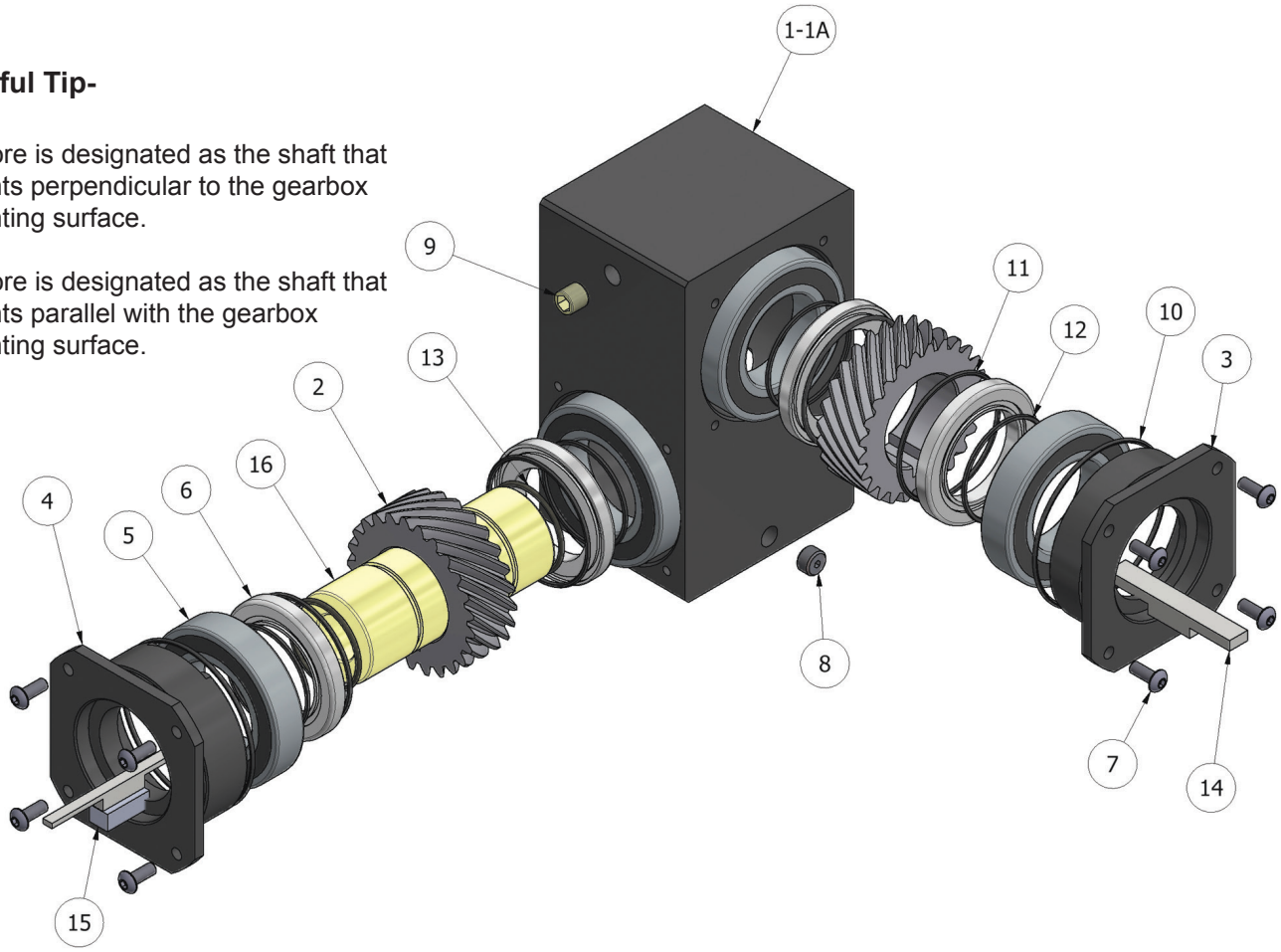
Note: Overfilling may result in leakage, excessive heat and reduced service life.

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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.



ITEM #	DESCRIPTION	QTY	ITEM #	DESCRIPTION	QTY
1	HOUSING, STANDARD	1	9	BREATHER PLUG	1
1A	HOUSING, BASE MOUNT	1	10*	O-RING BEARING CAP	2
2!	GEAR	2	11*	O-RING SPACER/GEAR (L)	4
3	BEARING CAP (A) BORE	1	12*	O-RING SPACER/BEARING (S)	4
4	BEARING CAP (B) BORE	1	13*	O-RING SHAFT	2
5!	BEARING	4	14	SHAFT KEY	2
6*	SPACER	4	15	GEAR KEY	2
7	BH SCREWS	8	16	SHAFT (B) BORE	1
8	HEX PORT PLUG	1			

Available Repair Kits:

* 4304-9120 Kit: Seals / Spacers

*! 4304-9122 Kit: Seals / Spacers / RH Gears / Bearings

*! 4304-9121 Kit: Seals / Spacers / LH Gears / Bearings

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