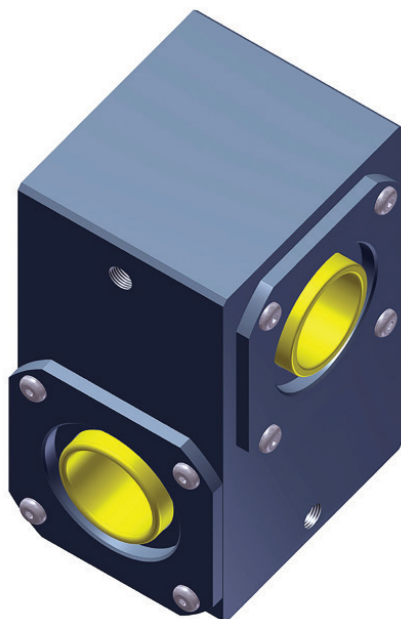




Standard Model Shown

Maintenance Guide

Insert-A-Shaft® 25 1:1 Right Angle Gearbox

Standard & Base Mount Models

A/B Bores: 30mm, 25mm, 20mm

Prod. #	Model	Prod. #	Model
4305-0030	IAS251:1RHA30B30	4305-0043	IAS251:1LHA20B30
4305-0031	IAS251:1LHA30B30	4305-0044	IAS251:1RHA20B25
4305-0032	IAS251:1RHA30B25	4305-0045	IAS251:1LHA20B25
4305-0033	IAS251:1LHA30B25	4305-0046	IAS251:1RHA20B20
4305-0034	IAS251:1RHA30B20	4305-0047	IAS251:1LHA20B20
4305-0035	IAS251:1LHA30B20	4304-0526	IAS25BM1:1RHA20B20
4305-0036	IAS251:1RHA25B30	4304-0527	IAS25BM1:1LHA20B20
4305-0037	IAS251:1LHA25B30	4304-0550	IAS25BM1:1RHA30B30
4305-0038	IAS251:1RHA25B25	4304-0556	IAS25BM1:1RHA25B25
4305-0039	IAS251:1LHA25B25	4304-0557	IAS25BM1:1LHA25B25
4305-0040	IAS251:1RHA25B20	4304-0559	IAS25BM1:1LHA30B25
4305-0041	IAS251:1LHA25B20	4304-0565	IAS25BM1:1LHA30B30
4305-0042	IAS251:1RHA20B30	4304-0582	IAS25BM1:1RHA30B25

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:

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

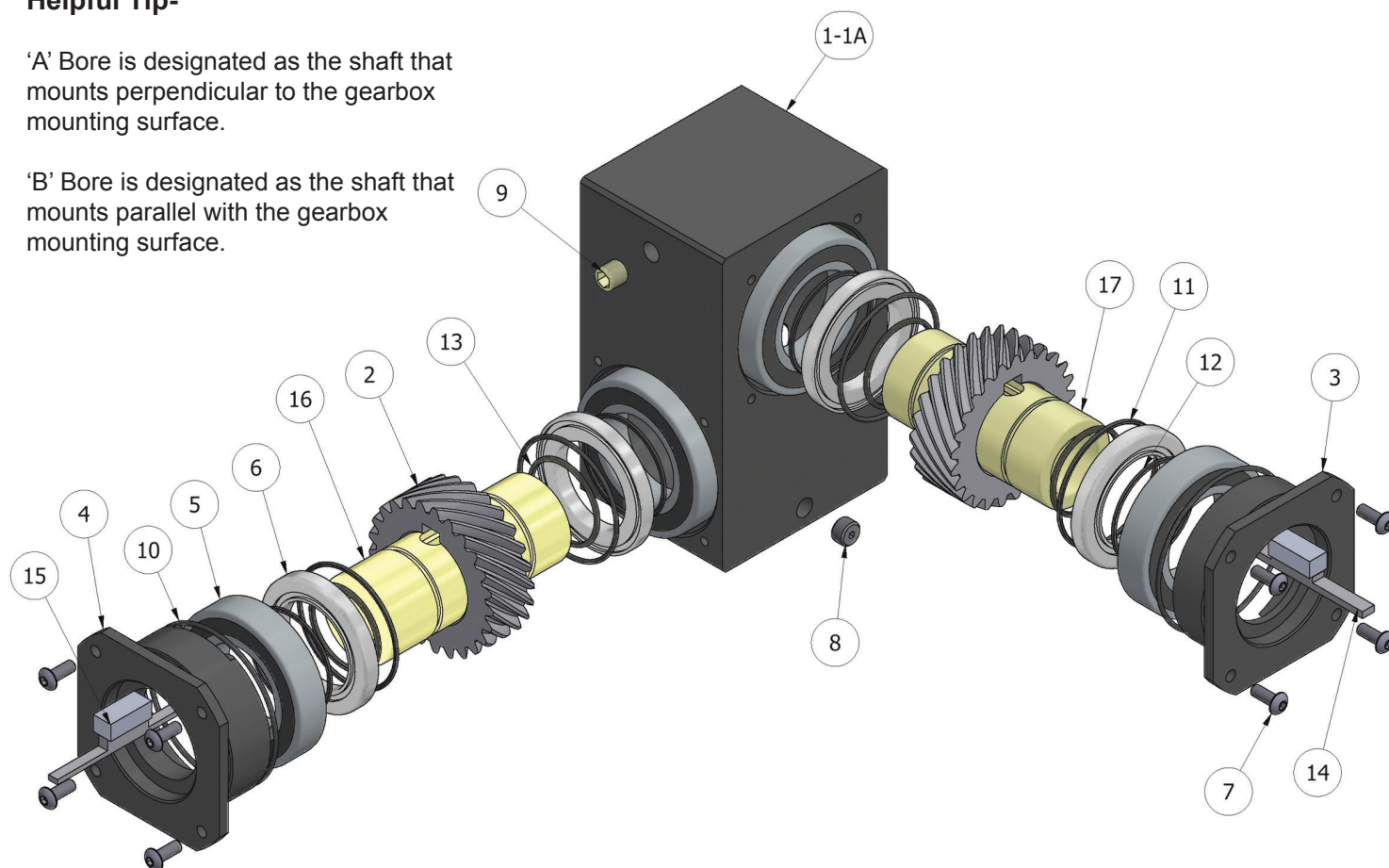
Note: Overfilling may result in leakage, excessive heat and reduced service life.



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	4
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	17	SHAFT (A) BORE	1

Available Repair Kits:

* 4304-9106 Kit: Seals / Spacers

*! 4304-9104 Kit: Seals / Spacers / RH Gears / Bearings

*! 4304-9105 Kit: Seals / Spacers / LH Gears / Bearings