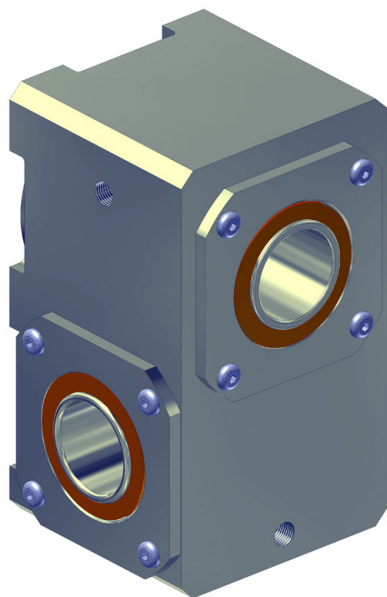


Maintenance Guide

Insert-A-Shaft[®] WDCRL25 1:1 Right Angle Gearbox
Standard & Base Mount Models
A/B Bores: 1.25, 1.00, .750, .625



Base Mount Model Shown

Prod. # Model

4304-0710	WDCRL25BM1:1RHA1.25B1.25
4304-0711	WDCRL25BM1:1LHA1.25B1.25
4304-0712	WDCRL25BM1:1RHA1.25B1.00
4304-0713	WDCRL25BM1:1LHA1.25B1.00
4304-0714	WDCRL25BM1:1RHA1.25B.750
4304-0715	WDCRL25BM1:1LHA1.25B.750
4304-0716	WDCRL25BM1:1RHA1.25B.625
4304-0717	WDCRL25BM1:1LHA1.25B.625
4304-0718	WDCRL25BM1:1RHA1.00B1.00
4304-0719	WDCRL25BM1:1LHA1.00B1.00
4304-0720	WDCRL25BM1:1RHA1.00B.750
4304-0721	WDCRL25BM1:1LHA1.00B.750
4304-0722	WDCRL25BM1:1RHA1.00B.625
4304-0723	WDCRL25BM1:1LHA1.25B.625
4304-0724	WDCRL25BM1:1RHA.750B.750
4304-0725	WDCRL25BM1:1LHA.750B.750
4304-0726	WDCRL25BM1:1RHA.750B.625
4304-0727	WDCRL25BM1:1LHA.750B.625
4304-0728	WDCRL25BM1:1RHA.625B.625
4304-0729	WDCRL25BM1:1LHA.625B.625

Prod. # Model

4304-0730	WDCRL251:1RHA1.00B1.00
4304-0731	WDCRL251:1LHA1.00B1.00
4304-0732	WDCRL251:1RHA1.00B.750
4304-0733	WDCRL251:1LHA1.00B.750
4304-0734	WDCRL251:1RHA1.00B.625
4304-0735	WDCRL251:1LHA1.00B.625
4304-0736	WDCRL251:1RHA.750B.750
4304-0737	WDCRL251:1LHA.750B.750
4304-0738	WDCRL251:1RHA.750B.625
4304-0739	WDCRL251:1LHA.750B.625
4304-0740	WDCRL251:1RHA.625B.625
4304-0741	WDCRL251:1LHA.625B.625
4304-0742	WDCRL251:1RHA1.25B1.25
4304-0743	WDCRL251:1LHA1.25B1.25
4304-0746	WDCRL251:1RHA1.25B1.00
4304-0747	WDCRL251:1LHA1.25B1.00
4304-0748	WDCRL251:1RHA1.25B.750
4304-0749	WDCRL251:1LHA1.25B.750
4304-0750	WDCRL251:1RHA1.25B.625
4304-0751	WDCRL251:1LHA1.250B.625

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.



WDCRL25 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

