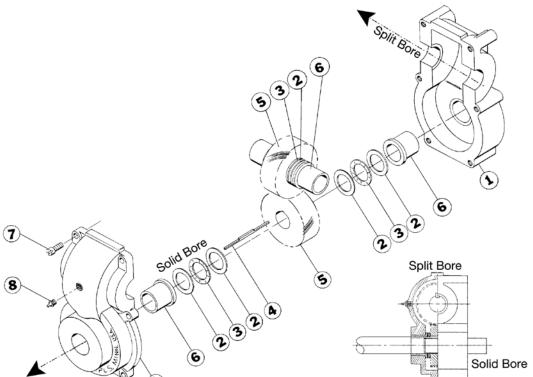


0100-0207_07

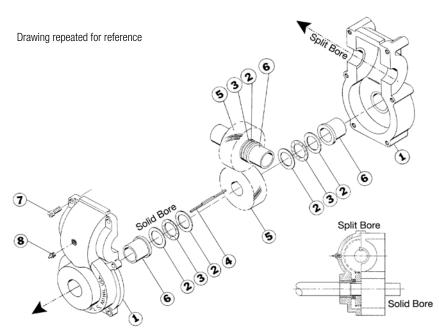
FLOAT-A-SHAFT® Standard Series – 1:1 Ratio

Flat Base - Low Torque - Journal Bearing



MODEL	R/LH	BORES
0246-0000	LH	3/4" X 3/4"
0245-0000	RH	3/4" X 3/4"
0248-0000	LH	3/4" X 1"
0247-0000	RH	3/4" X 1"
0250-0000	LH	3/4" X 1-1/4"
0249-0000	RH	3/4" X 1-1/4"
0252-0000	LH	3/4" X 1-1/2"
0251-0000	RH	3/4" X 1-1/2"
0254-0000	LH	1" X 1"
0253-0000	RH	1" X 1"
0256-0000	LH	1" X 1-1/4"
0255-0000	RH	1" X 1-1/4"
0258-0000	LH	1" X 1-1/2"
0257-0000	RH	1" X 1-1/2"
0270-0000	LH	1-1/4" X 1-1/4"
0269-0000	RH	1-1/4" X1-1/4"
0272-0000	LH	1-1/4" X 1-1/2"
0271-0000	RH	1-1/4" X 1-1/2"
0274-0000	LH	1-1/2" X 1-1/2"
0273-0000	l RH	1-1/2" X 1-1/2"

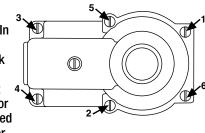
			QUANTITY																			
1754	DART NO	DECODIDEION	0246-0000	0245-0000	0248-0000	0247-0000	0250-0000	0249-0000	0252-0000	0251-0000	0254-0000	0253-0000	0256-0000	0255-0000	0258-0000	0257-0000	0270-0000	0269-0000	0272-0000	0271-0000	0274-0000	0273-0000
ITEM	PART NO.	DESCRIPTION LOND CASE HOLICING FLAT DAGE	0	0	0	0	-	0	-	0	0	0	0	0	0	0	•	0	0		-	_
'	0275-9300	GEAR CASE HOUSING, FLAT BASE	I		-	ı	1	4	1	1	l	ı	4	4	4	4				$\vdash \vdash$	\vdash	
	0275-9200 0275-9400	GEAR CASE HOUSING, FLAT BASE GEAR CASE HOUSING, FLAT BASE											ı	- 1	- 1	- 1	4	4	1	H		_
2.	0100-1312	WASHER, THRUST, 3/4" BORE	8	8	4	4	4	4	4	4									1	┝┷┩		
۷.	0200-1312	WASHER, THRUST, 1" BORE	0	0	4	4	4	4	4	4	8	8	1	4	4	4				$\vdash \vdash$	\vdash	_
	0200-1334	WASHER, THRUST, 1-1/4" BORE			4	4	1	1			0	0	4	4	4	4	8	8	4	4	\longrightarrow	_
	0200-1337	WASHER, THRUST, 1-1/4" BORE					4	4	4	4			4	4	4	4	0	0	4	4	8	8
3.	0200-1337	BEARING, THRUST, 3/4" BORE	4	4	2	2	2	2	2	2					4	4			4	4	0	0
J 3.	0200-1216	BEARING, THRUST, 1" BORE	7	-	2	2					4	4	2	2	2	2				H	\Box	
	0200-1210	BEARING, THRUST, 1-1/4" BORE					2	2			7		2	2			4	4	2	2	\Box	
	0200-1224	BEARING, THRUST, 1-1/2" BORE					-	-	2	2			_	_	2	2	H.		2	2	4	4
4.	0200-1503	KEY, STEP, 3/16" X 3/16"	2	2	1	1	1	1	1	1					_	_			_	ı	$\overline{}$	
	0200-1504	KEY, STEP, 1/4" X 1/4"			1	1	1	1			2	2	2	2	1	1	2	2	1	1		
	0200-1506	KEY, STEP, 3/8" X 3/8"							1	1					1	1			1	\Box	2	2
5.	0200-1112	GEAR, 25 T, LH, 3/4" BORE	2		1		1		1											\Box		
	0200-2112	GEAR, 25 T, RH, 3/4" BORE		2		1		1		1												
	0200-1116	GEAR, 25 T, LH, 1" BORE			1						2		1		1							
	0200-2116	GEAR, 25 T, RH, 1" BORE				1						2		1		1						
	0200-1120	GEAR, 25 T, LH, 1-1/4" BORE					1						1				2		1			
	0200-2120	GEAR, 25 T, RH, 1-1/4" BORE						1						1				2		1		
	0200-1124	GEAR, 25 T, LH, 1-1/2" BORE							1						1				1	لبا	2	
	0200-2124	GEAR, 25 T, RH, 1-1/2" BORE	<u> </u>							1						1				$\lfloor 1 \rfloor$		2
6.	0200-3512	BUSHING, BRONZE, FLANGED, 3/4" BORE	4	4	2	2	2	2	2	2										igspace		
	0200-1516	BUSHING, BRONZE, FLANGED, 1" BORE			2	2					4	4	2	2	2	2	L.			\sqcup	\vdash	
	0200-3520	BUSHING, BRONZE, FLANGED, 1-1/4" BORE					2	2					2	2	0	0	4	4	2	2		
-	0200-3524		-			C			2	2					2	2	_		2	2	4	4
/.	0200-1812		6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6
8.	0100-1601	ZERK GREASE FITTING, 1/4-28																				



Gear (5) onto the shaft over the key. On the opposite side of the gear, place a Thrust Washer (2), a Thrust Bearing (3), another Thrust Washer (2), and the other Flanged Bushing (6). Position this assembly into the Gear Case Housing (1), making sure the teeth of the gears mesh. CAUTION: When trying to get the gears to mesh, rotate the gears to prevent possible damage to the teeth. Next, make sure the Flanged Bushings (6) are pushed all the way into the casting to allow maximum clearance between the gear and the bushings.

To complete the assembly, install the other half of the Gear Case Housing (1) with the Flanged Bushing (6) already inserted, and tighten the

Screws (7) in the order shown here. In case of shaft binding, check for possible misalignment of the shafts or for an oversized shaft diameter.



Installation

Full Length Shaft Keyway: Keyway extends to end of shaf

Keyway extends to end of shaft. In this case, it is not necessary to disassemble the Float-A-Shaft[®]. Without removing the plastic

Shaft Keyway Types							
Full Length							
Section S							
<u> </u>							

tubes, align the Float-A-Shaft[®] with the shaft on which it is to be used and gently press it on. Be sure the key is properly oriented with the keyway. The plastic tubes will fall out as the shaft extends through the unit. The plastic tubes should be saved if removal of the Float-A-Shaft[®] is required. Be sure the plastic tubes are inserted as the shaft is withdrawn, otherwise the internal parts will slip out of position and disassembly may be required to restore proper alignment.

Section Keyway: Keyway does not extend to end of shaft. The Float-A-Shaft[®] must be disassembled for installation.

Reassembly: Reference the numbering diagram on page 1 to complete the following instructions, matching the numbers with corresponding bores.

Solid Bore Reassembly: Slide one end of the Gear Case Housing (1), which has the Flanged Bushing (6) already inserted onto the most accessible end of one shaft. Then install a Thrust Washer (2), a Thrust Bearing (3), and another Thrust Washer (2). Next, place the Key (4) in the keyway and slide the Gear (5) onto the shaft over the key. On the opposite side of the gear, place a Thrust Washer (2), a Thrust Bearing (3), and another Thrust Washer (2).

Split Bore Reassembly: Slide the following parts onto the shaft, which is positioned at a 90° angle: a Flanged Bushing (6)—Flanged end toward gear, a Thrust Washer (2), a Thrust Bearing (3), and another Thrust Washer (2). Place the Key (4) in the keyway and slide the

Shaft Requirements: Shafts should be made of power transmission steel grade 4140 or better. A tolerance of

+.000/- .002 is recommended for the shaft diameters. The shaft surfaces should be 32 RMS maximum for stationary applications, and 16 RMS maximum for traversing applications. Shaft straightness should be .0015 TIR per foot.

LUBRICATION AND MAINTENANCE SCHEDULE: All Float-A-Shaft® gear boxes have been lubricated at the factory with Mobilith® SHC 460. Standard Float-A-Shaft® gear boxes are initially filled with 2.8 oz. (82.8 ml) of grease to achieve 54% fill on the units. However, units require more lubrication prior to operation. Periodic re-lubrication is also necessary for optimum performance. When re-lubricating, inject Mobilith® SHC 460 (maximum operating temperature of 300°F or higher and EP rated) into gear case, as required, via the grease zerk provided. *Mobilith® SHC 460 - 14 oz grease cartridge ● P/N 0100-1605*

Lubrication and maintenance schedules are dependent on the application. General guidance is provided below and a maintenance plan can be developed based on the use case.

	USE CASE					
MAINTENANCE	Continuous/ Heavy Duty	Intermittent/ Light Duty	Minimal			
Inject 1/4 oz. of Mobilith SHC460 into gear housing	1 ½ Months	3 Months	6 Months			
Disassemble and purge unit. Hand lubricate all bearings and gears with 3 oz. of Mobilith SHC460	6 Months	1 Year	1 Year			

Mobilith® SHC 460 is a registered trademark of Exxon Mobil Corporation, www.mobil.com Float-A-Shaft® is a registered trademark of Tolomatic, Inc.



COMPANY WITH QUALITY SYSTEM CERTIFIED BY DNV = ISO 9001 =

3800 County Road 116, Hamel, MN 55340 USA http://www.Tolomatic.com • Email: Help@Tolomatic.com Phone: (763) 478-8000 • Fax: (763) 478-8080 • Toll Free: 1-800-328-2174 All brand and product names are trademarks or registered trademarks of their respective owners. Information in this document is believed accurate at time of printing. However, Tolomatic assumes no responsibility for its use or for any errors that may appear in this document. Tolomatic reserves the right to change the design or operation of the equipment described herein and any associated motion products without notice. Information in this document is subject to change without notice.