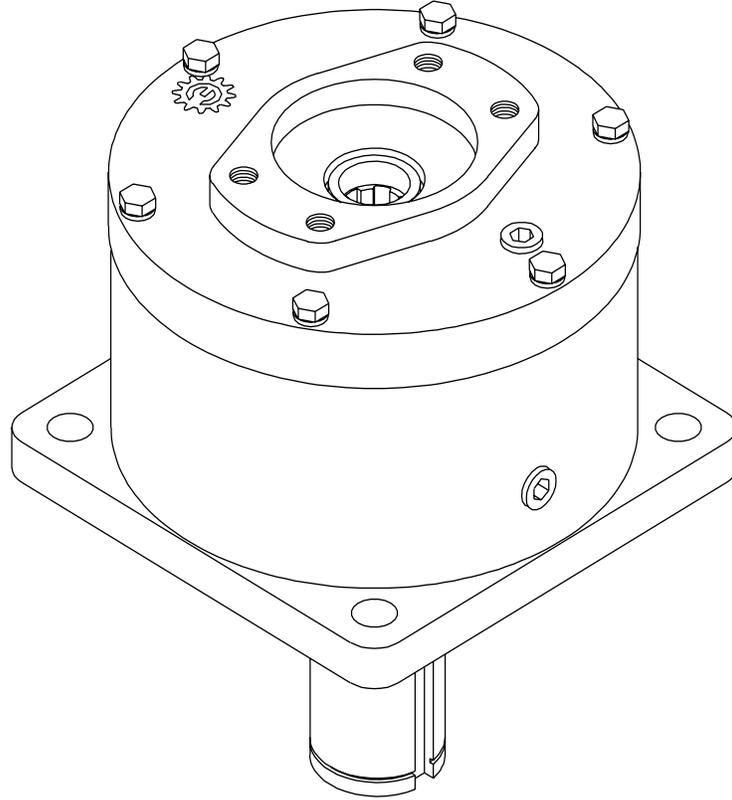
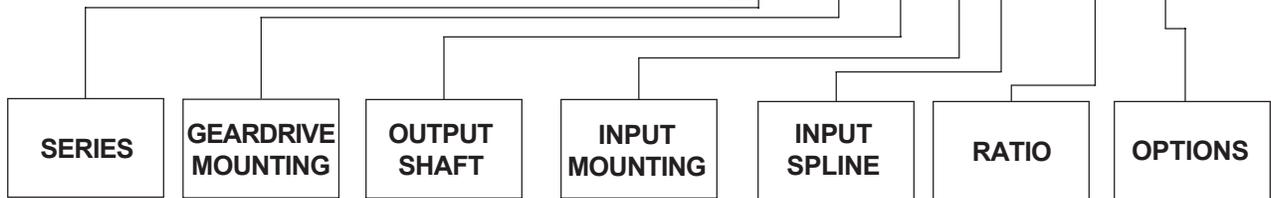


ESKRIDGE



EXAMPLE PART NUMBER: 20 B D1 C 3 - 20 Z



20B/20P PLANETARY GEAR DRIVE SERVICE & REPAIR MANUAL

THIS SERVICE MANUAL IS EFFECTIVE
FROM: S/N 16401, JULY 1993
TO: CURRENT
REF: SM20B20PD2-AC

20B/20P SERVICE MANUAL

SINGLE AND DOUBLE STAGE PLANETARY GEAR DRIVE

This manual will assist in disassembly and assembly of the above series 20 planetary gear drives. Item numbers, indicated in parentheses throughout this manual, refer to the exploded parts breakdown drawing. Individual customer specifications (mounting case, output shaft, brake assembly, etc.) may vary from exploded drawing and standard part numbers shown. If applicable, refer to individual customer drawing for details.

For any spare or replacement parts, contact your distributor or equipment manufacturer. Always try to have available the gear drive unit part number, serial number and date code on the serial tag. This information may be necessary for verification of any component part numbers. Component part numbers and/or manufacturing lot numbers may be stamped on individual parts. This information may also be helpful in identifying replacement components.

LUBRICATION & MAINTENANCE

Change the oil after the first 50 hours of operation. Oil should be changed at 500 hour intervals thereafter. Use a GL-5 grade EP 80/90 gear oil (EP = "Extreme Pressure"). The gear drive should be partially disassembled to inspect gears and bearings at 1000 hour intervals.

If your unit was specified "shaft up" or with a "-Z" option, a grease zerk was provided in the base housing. For shaft-up operation, the output bearing will not run in oil and must be grease lubricated. Use a lithium base or general purpose bearing grease sparingly every 50 operating hours or at regular maintenance intervals. Over-greasing the output bearing tends to fill the housing with grease and thicken the oil.

<u>OPERATING POSITION</u>	<u>STAGE</u>	<u>OIL CAPACITY</u>	<u>OIL LEVEL</u>
Horizontal Shaft	SINGLE	0.75 pints (0.35 liters)	To horizontal centerline of gear drive
Vertical Shaft	SINGLE	1 pints (0.47 liters)	To midway on upper/primary gearset
Horizontal Shaft	DOUBLE	1 pints (0.47 liters)	To horizontal centerline of gear drive
Vertical Shaft	DOUBLE	1.25 pints (0.59 liters)	To midway on upper/primary gearset



WARNING: While working on this equipment, wear adequate protective clothing, hearing, eye, and respiratory protection. Use safe lifting procedures.

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Before Disassembly

In the 20B/20P series, there are two types of units: single planetaries **without** a primary carrier, and double planetaries which have a primary planet carrier. Steps with an asterisk (*) apply only to the double planetary model.

Unit Disassembly

Refer to exploded view drawings on pages 6-9.

All parts should be carefully inspected as they are removed from unit. Scribe across mounting case (1) and cover (2) joint on outside of gearbox to assure proper orientation of oil fill and drain plugs, motor mounting, etc., as unit is reassembled.

- 1) Remove hydraulic motor and Eskridge Brake from gearbox. Drain oil.
- 2) Remove the six 5/16 x 1 1/2" hex cap screws (22) and 5/16 lockwashers (26), which retain cover (2) to mounting case (1).
- 3) Lift cover (2) off of unit and remove input gear (11) and input thrust washer (21).
- *4) Primary planetary assembly is now ready for removal (includes items 5,7,13,16,20 & 24). Secondary sun gear (10) is splined to primary carrier (5) and may come out when removing planetary assembly. If not, remove sun gear.
- 5) The secondary planetary assembly (includes items 4,6,12,14,15,19, & 23) is splined to the output shaft (3). It may now be lifted, by hand, from output shaft spline.
- 6) Place unit on a press table with the output shaft (3) protruding downward through a hole in the table. Unit should be supported only by mounting case (1). The only thing retaining output shaft (3) is the retaining ring. Remove retaining ring (25) from output shaft, followed by support washer (8) and bearing shims (9).

CAUTION: Retaining ring is no longer retaining output shaft. Take precautions if moving unit. Shaft may fall out.

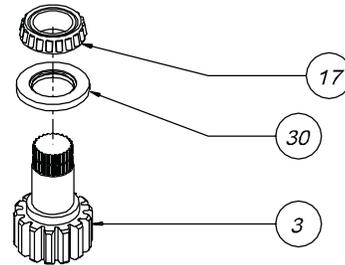
- 7) With output shaft down through centerhole in press table and unit supported by case, press shaft out by applying press load to top end of shaft (internal end) until it passes through inner bearing cone (17). Outer bearing cone (17) will come out of unit attached to shaft.

CAUTION: Care should be taken not to injure feet or damage output shaft during this procedure. Once shaft has been pressed through inner shaft bearing, it will drop from unit.

The unit is now disassembled into groups of parts and/or subassemblies. The area requiring repair or service should be identified by thorough inspection of the parts after they have been washed in solvent. If repair is necessary, refer to the individual repair section to follow.

Output Shaft Subassembly

(Items 3,17,30)

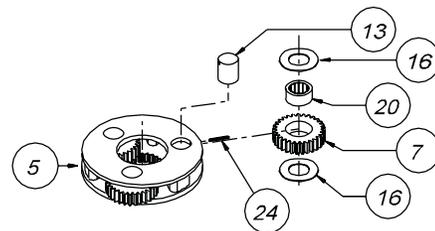


- 1) If outer bearing cone (17) needs replacing, it will need to be pressed off of output shaft (3). Also inspect inner bearing cone (17). Shaft was pressed through inner bearing cone during shaft removal procedure, so find bearing in mounting case seated inside the inner bearing cup (18). In some instances, outer bearing cone (17) may need to be removed if shaft seal (30) is to be replaced. If outside diameter of output shaft (external end opposite bearing) is smaller than inside diameter of seal, then shaft seal may be replaced without removing bearing cone.
- 2) Lubricate inner lip of new shaft seal (30) and turn so that open side of seal is up. Slide seal onto output shaft until it fits snug over shaft seal diameter.
- 3) With small end of outer bearing cone (17) pointed upward, place it onto the internal end of the output shaft (3). Press until bearing is seated tightly against shoulder. If the original bearing was removed only to replace shaft seal, it may be reused.

NOTE: Press only on inner race of bearing cone. DO NOT press on outer roller cage of bearing or it will damage bearing.

*Primary Planetary Subassembly

(Items 5, 7, 13, 16, 20 & 24)



Rotate primary planet gears (7) to check for any abnormal noises or roughness in the primary planet bearings (20).

At the same time, inspect planet gears for any damage or worn teeth. If replacement or further inspection is required, proceed as follows.

- 1) Drive the spring pins (or roll pins) (24) completely into the planet shafts (13) using a pin punch. Press planet shafts out of carrier (5).

NOTE: Only support primary carrier (5) while pressing planet shafts out.

- 2) Remove planet gears (7) and primary planet washers (16) from carrier (5).

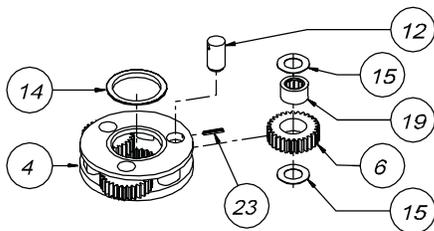
(* Applies only to the double planetary model.)

- 3) If any of the primary planet bearings (20) need replacing, press them out of planet gears.
- 4) Check primary planet shafts (13) for any abnormal wear, especially ones in which bearings needed to be replaced. If any abnormal wear is found, replace planet shaft.
- 5) Using a punch, drive roll pins out of planet shafts.
- 6) If required, press new primary planet bearings (20) into planet gears.
- 7) With a primary planet washer (16) on both sides of planet gear, with bearing installed, slide gear into carrier (5). Insert primary planet shaft (13) through the carrier, planet gear, and washers. During planet shaft installation, align roll pin hole in planet shaft, to the roll pin hole in outside diameter of carrier.

NOTE: Inserting a 1/8" diameter punch in the roll pin hole of planet shaft will help in the alignment of holes between planet shaft and carrier during step #7.

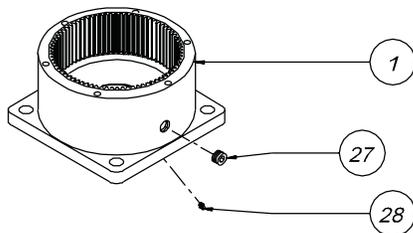
- 8) Once holes are properly aligned, drive a roll pin (24) through primary carrier and into planet shaft to retain parts. Use a drift to drive roll pin flush to carrier and to prevent striking planet gear teeth.
- 9) Repeat the same process for remaining gears.

Secondary Planetary Subassembly (Items 4, 6, 12, 14, 15, 19 & 23)



Follow same procedures as that for the Primary Planetary Subassembly, only substitute item numbers as indicated; Secondary carrier (4), secondary planet gear (6), secondary planet shaft (12), carrier thrust washer (14), secondary planet washer (15), secondary planet bearing (19), secondary roll pin (23).

Case Subassembly (Items 1, 18, 27 & 28)



- 1) Inspect inner and outer bearing cups (18). If cups are damaged, the cups and case (1) may need replacement. Contact Eskridge, inc. if you have questions.

- 2) Clean all foreign material from magnetic oil plug (27) located inside of mounting case (1). Add a small amount of pipe thread compound to pipe plug before installing back into case.

Unit Assembly

Refer to exploded view drawings on pages 6-9.

- 1) Start with case assembly (1). Turn case upside down and position it so that the side with the threaded holes is resting on the press table. Case pilot diameter should be pointed upward with outer bearing cup (18) exposed. Apply a layer of lithium bearing grease to outer bearing cup surface.
- 2) Invert the output shaft assembly (3) (retaining ring groove down) and carefully lower into the case (1) until the shaft's outer bearing cone (17) is seated against the outer bearing cup (18).
- 3) Press shaft seal (30) into case until it is flush with bottom of pilot diameter. Use a press fixture, if possible, to eliminate distorting seal. If press fixture is not available, a hammer and flat-ended drift may be used by tapping outer edge of seal lightly and alternating sides.
- 4) Stand unit assembly upright on output shaft (3).

CAUTION: The only thing retaining output shaft and case together at this point is the tightness in fit of the shaft seal. Securely and cautiously turn unit upright, not allowing case and shaft to separate.

- 5) While holding output shaft (3) with one hand, rotate case (1) to be certain it turns freely and smoothly. The slight resistance felt, if any, is due to shaft seal load (drag) on output shaft.
- 6) Apply a layer of lithium grease to inner bearing cup (18) and surface.
- 7) Install inner bearing cone (17) (small end down) over internal end of output shaft. Press bearing down slowly until it is just seated against inner bearing cup (18). With a slight press load still applied, rotate case (1) by hand to ensure that the roller bearings are rotating evenly and smoothly. Slide bearing shims (9) over output shaft and down onto inner bearing cone (17). The same number (quantity) of shims which were removed from unit during Disassembly Procedure should be returned.
- 8) Install support washer (8) over shims and a new retaining ring (25) above support washer into groove provided in output shaft. Inner bearing cone (17) may require additional press load to expose retaining ring groove. Apply only enough press load to allow retaining ring to engage into groove.

NOTE: Quantity of shims (9) may vary from unit to unit. Always use the same quantity of shims when reassembling.

- 9) Install secondary carrier (4) assembly into unit. Carrier assembly should be installed with hub side down (24 tooth spline). Rotate carrier assembly back and

(* Applies only to the double planetary model.

forth to mesh secondary planet gear teeth (6) with case (1) teeth. Once teeth mesh, let secondary carrier slide down until it makes contact with the output shaft spline. The carrier splined hub (4) should spline onto output shaft (3). Carrier hub will rest on top of retaining ring (25) when splines are fully engaged. Install carrier thrust washer (14).

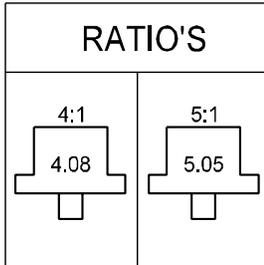
- *10) Turn primary carrier assembly upside down so that splined end of carrier (5) is up. Insert splined end of secondary sun gear (10) into carrier spline until fully engaged. Install carrier assembly into unit, sun gear down. Sun gear teeth will mesh with the secondary planet gears, and the primary planet gear teeth (7) will mesh with the mounting case (1).
- 11) Put input thrust washer (21) over step of input gear (11). Insert input gear into unit so that teeth mesh with planet gears.
- 12) Fill unit with proper level (see page 2) of a GL-5 grade EP 80/90 gear oil. Proper oil level will measure to middle of primary planet gears (7).
- 13) Grease a new o-ring (29) and install into bottom of cover (2). Refer back to scribe marks made across external joint prior to Disassembly Procedure. Line up scribe marks between cover and case (1) so that orientation of motor mount holes and oil plugs are back to their original positions.

NOTE: Be certain o-ring (29) stays seated in cover during step #12.

- 14) Install all six of the 5/16 lockwashers (26) and the 5/16 hex capscrews (22) and torque them to 20 ft-lbs.

THE GEAR DRIVE IS NOW READY FOR USE.

20B Single Stage Exploded View Drawing



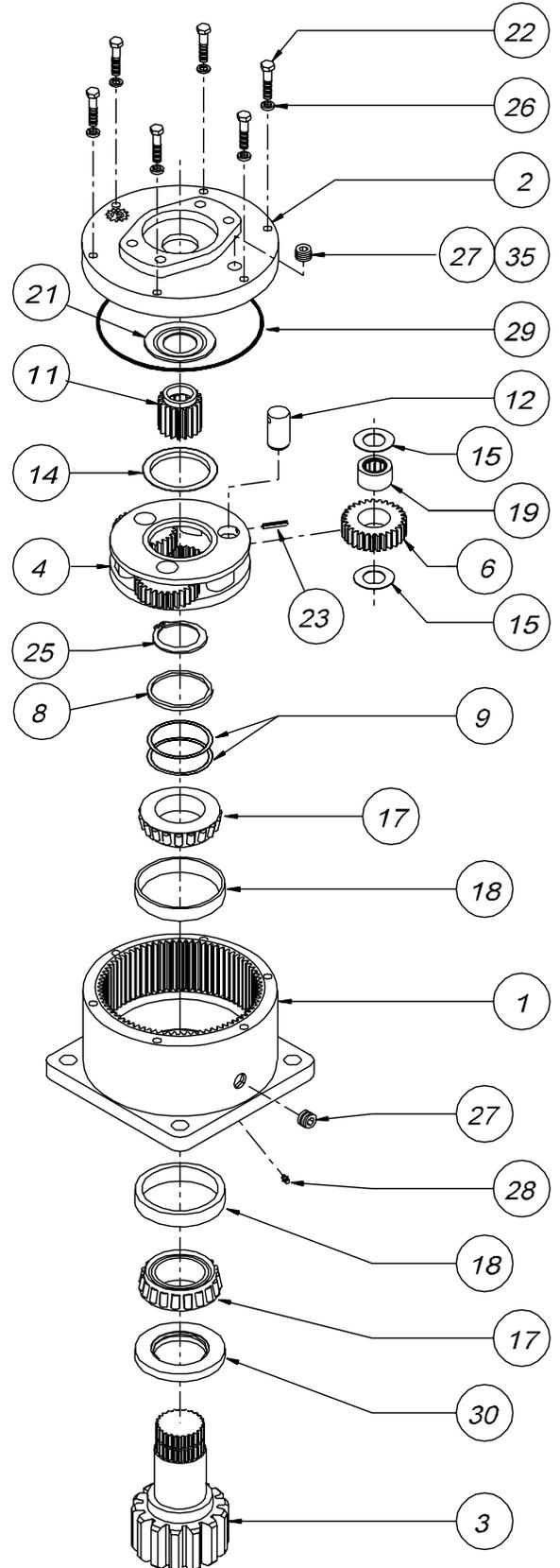
MODEL B20 SINGLE PLANETARY



EFFECTIVE
FROM: S/N 16401 07-01-93
TO: (CURRENT)

PART NUMBER	PART NUMBER	QTY.	ITEM	C O D E	DESCRIPTION
←	20-004-3024	1	1		B20 CASE-SQUARE- (NO ZERK)
←	20-004-3024Z			B20 CASE-SQUARE- W/ZERK	
-	-			CB20 CASE-CUSTOM PER CUSTOMER SPECS.	
←	85-004-1513	1	2	A	COVER-SAE 'A'
←	85-004-1503			B	COVER-SAE 'B' 2-BOLT
←	28-004-1013			C	COVER-SAE 'C' 4-BOLT
←	20-004-4022	1	3	D1	2" DIA SHAFT-3/8" KEYWAY
←	20-004-4032			D2	SHAFT 23T, 12/24 D.P. SPLINE
←	20-004-4042			D3	2" DIA.SHAFT-1/2"KEYWAY
←	28-004-4202			D4	2.25"D.SHAFT-1/2"KEYWAY
-	-			C1	SHAFT-CUSTOM PER CUSTOMER SPECS.
←	20-004-1282	1	4		CARRIER-SECONDARY
←	20-004-1041	3	6		PLANET GEAR-SEC.
←	20-004-1031	1	8		SUPPORT WASHER
←	20-004-1091	*	9		SHIM
←	20-004-1302	1	11	1	INPUT GEAR 21T,20/40 D.P.SPLINE
←	20-004-1122			2	INPUT GEAR 13T,16/32 D.P.SPLINE
←	20-004-1102			3	INPUT GEAR SAE 1"-6B SPLINE
←	20-004-1192			4	INPUT GEAR 14T,12/24 D.P.SPLINE
←	20-004-1322			5	INPUT GEAR 15T,16/32 D.P.SPLINE
←	20-004-1142			6	INPUT GEAR 1"DIA X .25" KEY
←	20-004-1081	3	12		PLANET SHAFT-SECONDARY
←	50-004-1011	1	14		THRUST WASHER-SEC.CUP
←	85-004-1181	6	15		THRUST WASHER - (SEC. PLANET GEAR)
←	01-102-0160	2	17		BEARING CONE
←	01-103-0160	2	18		BEARING CUP
←	01-105-0010	3	19		BEARING-SEC.PLANET
←	50-004-1091	1	21		THRUST WASHER-INPUT
←	01-150-1400	6	22		HEX CAPSCREW 5/16-18 X 1.5, GR8
←	01-153-0210	3	23		ROLLPIN-SECONDARY 3/16 X 7/8
←	01-160-0250	1	25		RETAINING RING (NO.N5100-206)
←	01-166-0110	6	26		LOCKWASHER 5/16 MED
←	01-207-0070	2	27		PIPE PLUG-MAG. 3/8 NPT-SOC HD
←	01-215-0050	(1)	28		GREASE FITTING (OPTIONAL)
←	01-402-0560	1	29		O-RING 167 MM X 3 MM
←	01-405-0550	1	30		SEAL-SHAFT
←	01-216-0070	(1)	35		AIR VENT 3/8 NPT (OPTIONAL)
-	-	-	-	-	-

NOTE * BEARING PRELOAD DETERMINES QUANTITY OF SHIMS.
SEAL KIT; P/N 20-016-0501; INCLUDES ITEMS 29 AND 30.

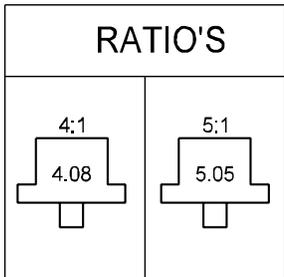


20P Single Stage Exploded View Drawing

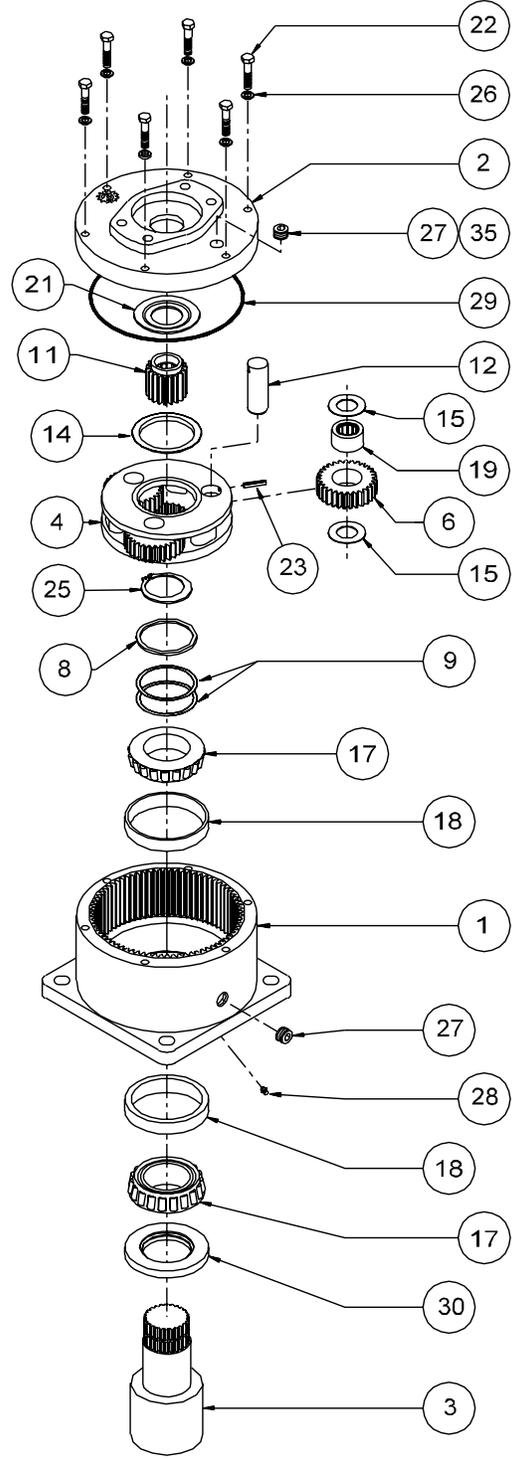
MODEL P20 SINGLE PLANETARY



EFFECTIVE
FROM: S/N 16401 07-01-93
TO: (CURRENT)



PART NUMBER	PART NUMBER	QTY.	ITEM	C O D E	DESCRIPTION
←	20-004-3074	1	1		P20 CASE-SQUARE-SINGLE PLT.(NO ZERK)
←	20-004-3074Z			P20 CASE-SQUARE-SINGLE PLT. W/ZERK	
-	-				CP20 CASE-CUST.MTG PER CUSTOMER SPECS.
←	85-004-1513	1	2	A	COVER-SAE 'A'
←	85-004-1503			B	COVER-SAE 'B' 2-BOLT
←	28-004-1013			C	COVER-SAE 'C' 4-BOLT
←	20-004-4122	1	3	F1	SHAFT-1.5" KEYED
←	20-004-4112			F2	SHAFT-2" KEYED
-	-			C1	SHAFT-CUSTOM PER CUSTOMER SPECS.
20-004-1282	20-004-1292	1	4		CARRIER-SECONDARY
20-004-1041	20-004-1051	3	6		PLANET GEAR-SEC.
←	20-004-1031	1	8		SUPPORT WASHER
←	20-004-1091	*	9		SHIM
20-004-1302	N/A	1	11	1	INPUT GEAR 21T,20/40 D.P.SPLINE
20-004-1122	20-004-1132			2	INPUT GEAR 13T,16/32 D.P.SPLINE
20-004-1102	20-004-1112			3	INPUT GEAR SAE 1"-6B SPLINE
20-004-1192	N/A			4	INPUT GEAR 14T,12/24 D.P.SPLINE
20-004-1322	20-004-1312			5	INPUT GEAR 15T,16/32 D.P.SPLINE
20-004-1142	N/A			6	INPUT GEAR 1"DIA X .25" KEY
←	20-004-1081	3	12		PLANET SHAFT-SECONDARY
←	50-004-1011	1	14		THRUST WASHER-SEC.CUP
←	85-004-1181	6	15		THRUST WASHER- (SEC. PLANET GEAR)
←	01-102-0160	2	17		BEARING CONE
←	01-103-0160	2	18		BEARING CUP
←	01-105-0010	3	19		BEARING-SEC.PLANET
←	50-004-1091	1	21		THRUST WASHER-INPUT
←	01-150-1400	6	22		HEX CAPSCREW 5/16-18 X 1.5, GR8
←	01-153-0210	3	23		ROLLPIN-SECONDARY 3/16 X 7/8
←	01-160-0250	1	25		RETAINING RING
←	01-166-0110	6	26		LOCKWASHER 5/16 MED
←	01-207-0070	2	27		PIPE PLUG-MAG. 3/8 NPT-SOC HD
←	01-215-0050	(1)	28		GREASE FITTING (OPTIONAL)
←	01-402-0560	1	29		O-RING 167 MM X 3 MM
←	01-405-0610	1	30		SEAL-SHAFT
←	01-216-0070	(1)	35		AIR VENT 3/8 NPT (OPTIONAL)
-	-	-	-	-	-



NOTE * BEARING PRELOAD DETERMINES QUANTITY OF SHIMS.
SEAL KIT; P/N 20-016-0511; INCLUDES ITEMS 29 AND 30.

ECN 1083
X20PD1-BD DATE 05-08-00

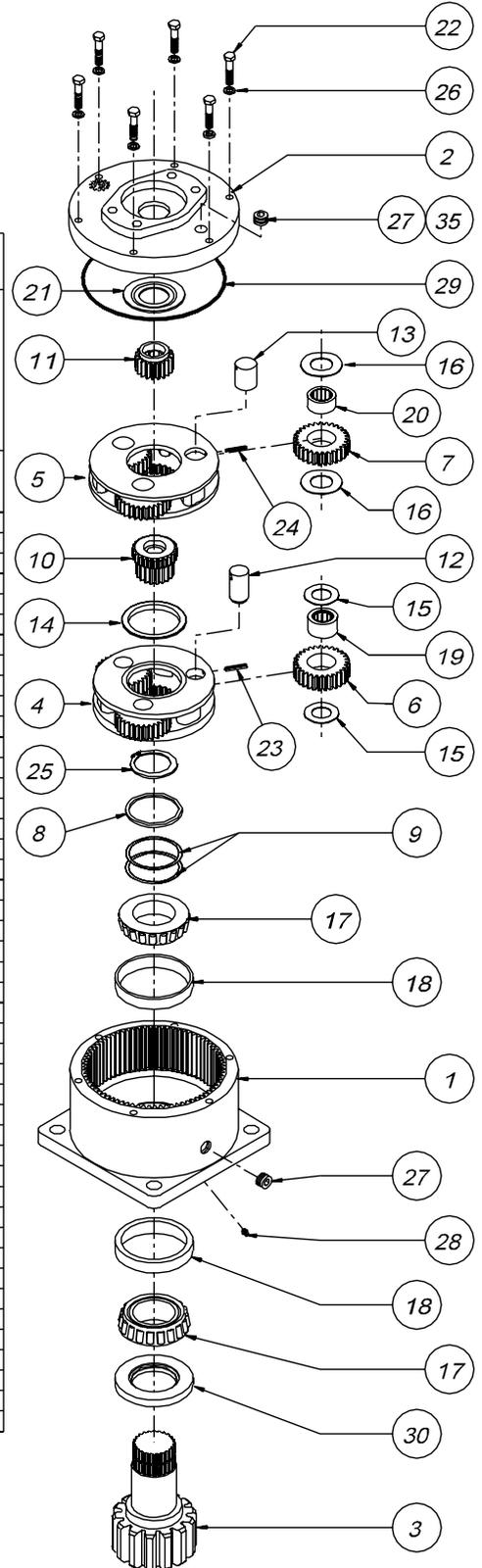
20B Double Stage Exploded View Drawing



MODEL B20
DOUBLE PLANETARY
EFFECTIVE
FROM: S/N 16401 07-01-93
TO: (CURRENT)

RATIO'S			
16.65:1 4.08 4.08	20.62:1 5.05 4.08	20.62:1 4.08 5.05	25.53:1 5.05 5.05
		INVERTED	

CODE	DESCRIPTION	ITEM	QTY.	PART NUMBER	PART NUMBER	PART NUMBER	PART NUMBER
	B20 CASE-SQUARE-DOUBLE PLT.(NO ZERK)	1	1	20-004-3014			
	B20 CASE-SQUARE-DOUBLE PLT. W/ZERK			20-004-3014Z			
	C20 CASE-CUSTOM PER CUSTOMER SPECS.			-	-	-	-
A	COVER-SAE 'A'			85-004-1513			
B	COVER-SAE 'B' 2-BOLT	2	1	85-004-1503			
C	COVER-SAE 'C' 4-BOLT			28-004-1013			
D1	2" DIA SHAFT-3/8" KEYWAY			20-004-4022			
D2	SHAFT 23T, 12/24 D.P. SPLINE			20-004-4032			
D3	2" DIA.SHAFT-1/2"KEYWAY	3	1	20-004-4042			
D4	2.25"D.SHAFT-1/2"KEYWAY			28-004-4202			
C1	SHAFT-CUSTOM PER CUSTOMER SPECS.			-	-	-	-
	CARRIER-SECONDARY	4	1	20-004-1282	20-004-1282	20-004-1292	20-004-1292
	CARRIER-PRIMARY	5	1	50-004-1082	50-004-1072	50-004-1082	50-004-1072
	PLANET GEAR-SEC.	6	3	20-004-1041	20-004-1041	20-004-1051	20-004-1051
	PLANET GEAR-PRI.	7	3	85-004-1031	85-004-1021	85-004-1031	85-004-1021
	SUPPORT WASHER	8	1	20-004-1031			
	SHIM	9	*	20-004-1091			
	SUN GEAR-SECONDARY	10	1	20-004-1332	20-004-1062	20-004-1072	20-004-1072
1	INPUT GEAR 21T, 20/40 D.P. SPLINE			85-004-1402		85-004-1402	N/A
2	INPUT GEAR 13T, 16/32 D.P. SPLINE			85-004-1102	85-004-1062		85-004-1062
3	INPUT GEAR SAE 1"-6B SPLINE			85-004-1122	85-004-1112		85-004-1112
4	INPUT GEAR 14T, 12/24 D.P. SPLINE			85-004-1533		85-004-1533	N/A
5	INPUT GEAR 15T, 16/32 D.P. SPLINE			85-004-1542	85-004-1422		85-004-1422
6	INPUT GEAR 1"DIA X .25" KEY			85-004-1582		85-004-1582	N/A
	PLANET SHAFT-SECONDARY	12	3	20-004-1081			
	PLANET SHAFT-PRIMARY	13	3	81-004-0071			
	THRUST WASHER-SEC.CUP	14	1	50-004-1011			
	THRUST WASHER-(SEC. PLANET GEAR)	15	6	85-004-1181			
	THRUST WASHER-(PRI. PLANET GEAR)	16	6	81-004-1561			
	BEARING CONE	17	2	01-102-0160			
	BEARING CUP	18	2	01-103-0160			
	BEARING-SEC.PLANET	19	3	01-105-0010			
	BEARING-PRI.PLANET	20	3	01-105-0410			
	THRUST WASHER-INPUT	21	1	50-004-1091			
	HEX CAPSCREW 5/16-18 X 1.5, GR8	22	6	01-150-1400			
	ROLLPIN-SECONDARY 3/16 X 7/8	23	3	01-153-0210			
	ROLLPIN-PRIMARY 1/8 X 1	24	3	01-153-0080			
	RETAINING RING (NO.N5100-206)	25	1	01-160-0250			
	LOCKWASHER 5/16 MED	26	6	01-166-0110			
	PIPE PLUG-MAG. 3/8 NPT-SOC HD	27	2	01-207-0070			
	GREASE FITTING (OPTIONAL)	28	(1)	01-215-0050			
	O-RING 167 MM X 3 MM	29	1	01-402-0560			
	SEAL-SHAFT	30	1	01-405-0550			
	AIR VENT 3/8 NPT (OPTIONAL)	35	(1)	01-216-0070			
	-	-	-	-	-	-	-



NOTE * BEARING PRELOAD DETERMINES QUANTITY OF SHIMS.

SEAL KIT; P/N 20-016-0501; INCLUDES ITEMS 29 AND 30.

▷ FOR 20:1 RATIO, INPUT CODES 1, 4 AND 6 REQUIRE "INVERTED" RATIO CARRIER ASSEMBLIES.

ECN 1803
X20B02-BE DATE 04-04-02

20P Double Stage Exploded View Drawing

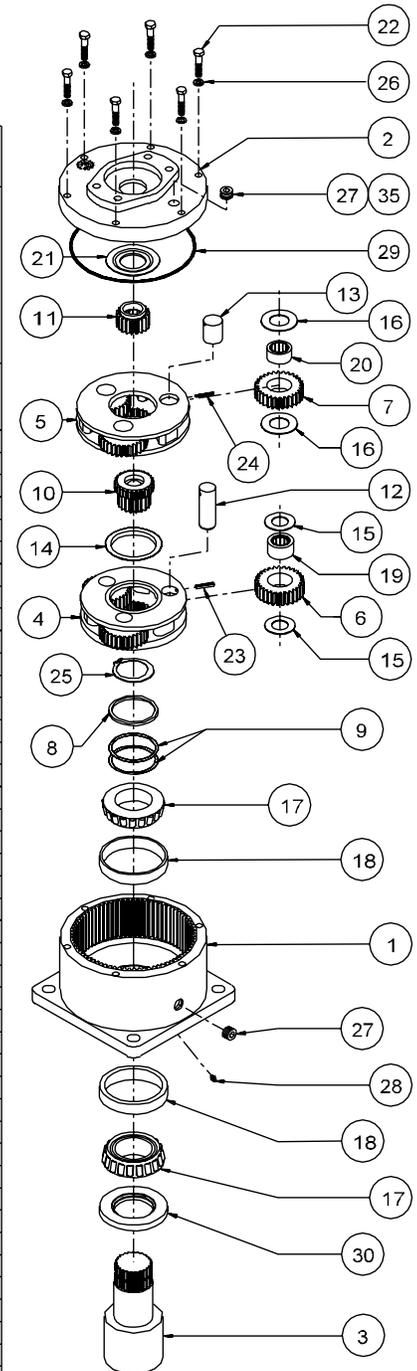
MODEL P20
DOUBLE PLANETARY



EFFECTIVE
FROM: S/N 16401 07-01-93
TO: (CURRENT)

RATIO'S			
16.65:1 4.08 4.08	20.62:1 5.05 4.08	20.62:1 4.08 5.05	25.53:1 5.05 5.05
		INVERTED	

CODE	DESCRIPTION	ITEM	QTY.	PART NUMBER	PART NUMBER	PART NUMBER	PART NUMBER
	P20 CASE-SQUARE-DOUBLE PLT.(NO ZERK)	1	1	20-004-3064			
	P20 CASE-SQUARE-DOUBLE PLT. W/ZERK			20-004-3064Z			
	CP20 CASE-CUST.MTG PER CUSTOMER SPECS.			-	-	-	-
A	COVER-SAE 'A'			85-004-1513			
B	COVER-SAE 'B' 2-BOLT	2	1	85-004-1503			
C	COVER-SAE 'C' 4-BOLT			28-004-1013			
F1	SHAFT-1.5" KEYED			20-004-4122			
F2	SHAFT-2" KEYED	3	1	20-004-4112			
C1	SHAFT-CUSTOM PER CUSTOMER SPECS.			-	-	-	-
	CARRIER-SECONDARY	4	1	20-004-1282	20-004-1282	20-004-1292	20-004-1292
	CARRIER-PRIMARY	5	1	50-004-1082	50-004-1072	50-004-1082	50-004-1072
	PLANET GEAR-SEC.	6	3	20-004-1041	20-004-1041	20-004-1051	20-004-1051
	PLANET GEAR-PRI.	7	3	85-004-1031	85-004-1021	85-004-1031	85-004-1021
	SUPPORT WASHER	8	1	20-004-1031			
	SHIM	9	*	20-004-1091			
	SUN GEAR-SECONDARY	10	1	20-004-1332	20-004-1062	20-004-1072	20-004-1072
1	INPUT GEAR 21T,20/40 D.P.SPLINE			85-004-1402		85-004-1402	N/A
2	INPUT GEAR 13T,16/32 D.P.SPLINE			85-004-1102	85-004-1062		85-004-1062
3	INPUT GEAR SAE 1"-6B SPLINE			85-004-1122	85-004-1112		85-004-1112
4	INPUT GEAR 14T,12/24 D.P.SPLINE			85-004-1533		85-004-1533	N/A
5	INPUT GEAR 15T,16/32 D.P.SPLINE			85-004-1542	85-004-1422		85-004-1422
6	INPUT GEAR 1"DIA X .25" KEY			85-004-1582		85-004-1582	N/A
	PLANET SHAFT-SECONDARY	12	3	20-004-1081			
	PLANET SHAFT-PRIMARY	13	3	81-004-0071			
	THRUST WASHER-SEC.CUP	14	1	50-004-1011			
	THRUST WASHER-(SEC. PLANET GEAR)	15	6	85-004-1181			
	THRUST WASHER-(PRI. PLANET GEAR)	16	6	81-004-1561			
	BEARING CONE	17	2	01-102-0160			
	BEARING CUP	18	2	01-103-0160			
	BEARING-SEC.PLANET	19	3	01-105-0010			
	BEARING-PRI.PLANET	20	3	01-105-0410			
	THRUST WASHER-INPUT	21	1	50-004-1091			
	HEX CAPSCREW 5/16-18 X 1.5, GR8	22	6	01-150-1400			
	ROLLPIN-SECONDARY 3/16 X 7/8	23	3	01-153-0210			
	ROLLPIN-PRIMARY 1/8 X 1	24	3	01-153-0080			
	RETAINING RING	25	1	01-160-0250			
	LOCKWASHER 5/16 MED	26	6	01-166-0110			
	PIPE PLUG-MAG. 3/8 NPT-SOC HD	27	2	01-207-0070			
	GREASE FITTING (OPTIONAL)	28	(1)	01-215-0050			
	O-RING 167 MM X 3 MM	29	1	01-402-0560			
	SEAL-SHAFT	30	1	01-405-0610			
	AIR VENT 3/8 NPT (OPTIONAL)	35	(1)	01-216-0070			
-		-	-	-	-	-	-



NOTE * BEARING PRELOAD DETERMINES QUANTITY OF SHIMS.
SEAL KIT: P/N 20-016-0511; INCLUDES ITEMS 29 AND 30.

▷ FOR 20:1 RATIO, INPUT CODES 1, 4 AND 6 REQUIRE "INVERTED" RATIO CARRIER ASSEMBLIES.

ECN 1803
X20PD2-BE DATE 05-8-00

Eskridge Product Warranty

ESKRIDGE, INC. ("Eskridge") warrants to its original purchaser ("Customer") that new component parts/units ("Units") sold by Eskridge will be free of defects in material and workmanship and will conform to standard specifications set forth in Eskridge sales literature current at the time of sale or to any custom specifications acknowledged by written Customer approval of drawings, SUBJECT TO THE FOLLOWING QUALIFICATIONS AND LIMITATIONS:

1. Prior to placing Units in service, the Customer shall provide proper storage such that foreign objects (e.g., rain or debris) cannot enter any Units via entry ports which are normally closed during operation.
2. The Customer must notify Eskridge in writing of any claim for breach of this warranty promptly after discovery of a defect. The warranty period shall commence when a unit is placed in service and shall expire upon the earlier of
 - a. the expiration of twelve (12) months from the date of Commencement of Service (as defined in Paragraph 4)
 - b. the completion of one thousand (1000) hours of service of the Units
 - c. the expiration of six (6) months after the expiration of any express warranty relating to the first item of machinery or equipment in which the Units are installed or on which it is mounted, or
 - d. the installation or mounting of the Units in or on an item of machinery or equipment other than the first such item in which the Units are installed or on which the Units are mounted.
3. Units shall be deemed to have been placed in service (the "Commencement of Service") at the time the machinery or equipment manufactured or assembled by the Customer and in which the Units are installed or on which the Units are mounted is delivered to the Customer's dealer or the original end-user, whichever ever receives such machinery or equipment first.
4. This warranty shall not apply with respect to Units which, upon inspection by Eskridge, show signs of disassembly, rework, modifications, lack of lubrication or improper installation, mounting, use or maintenance.
5. Eskridge makes no warranty in respect to hydraulic motors mounted on any Units. Failure of any such motor will be referred to the motor manufacturer.
6. Claims under this warranty will be satisfied only by repair of any defect(s) or, if repair is determined by Eskridge in its sole, absolute and uncontrolled discretion to be impossible or impractical, by replacement of the Units or any defective component thereof. No cash payment or credit will be made for defective materials, workmanship, labor or travel. IN NO EVENT SHALL ESKRIDGE BE LIABLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES OF ANY KIND OR NATURE, FOR WHICH DAMAGES ARE HEREBY EXPRESSLY DISCLAIMED.
7. From time to time, Eskridge may make design changes in the component Units manufactured by it without incorporating such changes in the component Units previously shipped. Such design changes shall not constitute an admission by Eskridge of any defects or problems in the design of previously manufactured component Units.
8. All freight charges on Units returned for warranty service are the responsibility of the Customer.

Warranty Return Policy

1. Any part/Unit(s) returned to Eskridge must be authorized by Eskridge with an assigned return (CSR) number.
2. All Units shall be returned freight prepaid.
3. Any Units qualifying for warranty will be repaired with new parts free of charge (except for freight charges to Eskridge as provided above).
4. If Units are found to be operable, you have two options:
 - a. The Units can be returned to you with a service charge for inspection, cleaning, and routine replacement of all rubber components and any other Units that show wear;
 - b. We can dispose of the Unit(s) at the factory if you do not wish it to be returned.

NOTE: Any order of Units by customer shall only be accepted by Eskridge subject to the terms stated herein. Any purchase order forms used by Customer (to accept this offer to sell) which contain terms contrary to, different from, or in addition to the terms herein shall be without effect, and such terms shall constitute material alteration of the offer contained herein under K.S.A 84-2-207 (2)(b), and shall not become part of the contract regarding the sale of the Units.

The foregoing warranty is the sole warranty made by Eskridge with respect to any Units and is in lieu of any and all other warranties, expressed or implied. There are no warranties which extend beyond the description on the face hereof without limiting the generality of the foregoing, Eskridge expressly disclaims any implied warranty of merchantability or fitness for any particular purpose, regardless of any knowledge Eskridge may have of any particular use or application intended by the purchaser. The suitability or fitness of the Units for the customer's intended use, application or purpose and the proper method of installation or mounting must be determined by the customer.

OTHER ESKRIDGE PRODUCTS

Planetary Gear Drives

<u>SERIES</u>	<u>TORQUE RATING</u>
20/28 SERIES	MAX. INTERMITTENT 20,000 - 28,000 IN-LB
50 SERIES	50,000 IN-LB
65 SERIES	60,000 IN-LB
100 SERIES	100,000 IN-LB
130 SERIES	130,000 IN-LB
150 SERIES	150,000 IN-LB
250 SERIES	250,000 IN-LB
600 SERIES	600,000 IN-LB
1000 SERIES	1,000,000 IN-LB

Multiple Disc Brakes

<u>SERIES</u>	<u>TORQUE RATING</u>
90B SAE B	TO 4,800 IN-LB
90BA SAE B ADJUSTABLE TORQUE	TO 4,800 IN-LB
92B SAE B LOW PROFILE	TO 2,800 IN-LB
93 FOR NICHOLS MOTORS	TO 6,100 IN-LB
95C SAE C	TO 12,000 IN-LB
95W SAE C WHEEL MOUNT	TO 21,000 IN-LB
98D SAE D	TO 25,000 IN-LB

Diggers (Planetary Auger Drives)

<u>SERIES</u>	<u>TORQUE RATING</u>
D50 MODELS 1500, 2500 & 5000	1,500 - 5,000 FT-LB
76 MODELS BA & BC, TWO SPEED	8,000 - 12,500 FT-LB
77 MODELS BA, BC & BD	6,000 - 12,500 FT-LB
78 MODELS 35 & 48, TWO SPEED	9,000 - 12,500 FT-LB
75 MODELS 38 & 51, TWO SPEED	16,500 - 20,000 FT-LB

