

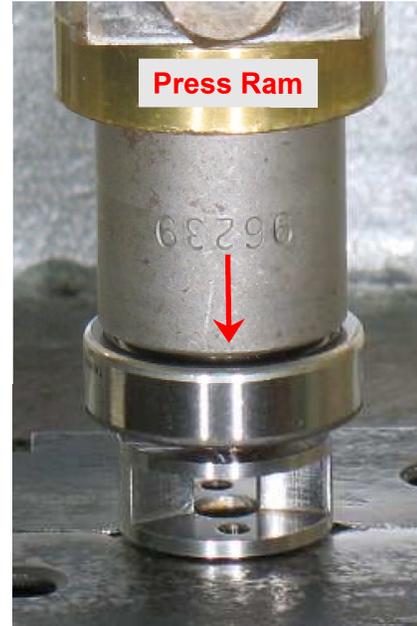
Assembly Instructions - 0.4 hp. Planetary Reduction Gears

Planetary Gear Assembly:

1. Use the **RAISED CENTER** of the **96239** Bearing Press Tool and the arbor press to install the **54520** Bearing onto the front of the planetary carrier.



← Thread at front of carrier.



Press Ram

2. Apply a small amount of Loctite #271 (or equivalent) to the adapter or pinion thread.



Carefully hold the planetary carrier in the vise with aluminum or bronze jaws and install the adapter or pinion onto the planetary carrier. (T to 17 N•m/~150 in. lbs.)

3. Apply the **95542** Grease (or equivalent) to the needle bearings in the planet gears.



(T to 17 N•m/~150 in. lbs.)

Install the planet gears and the **54472** Pins into the carrier.

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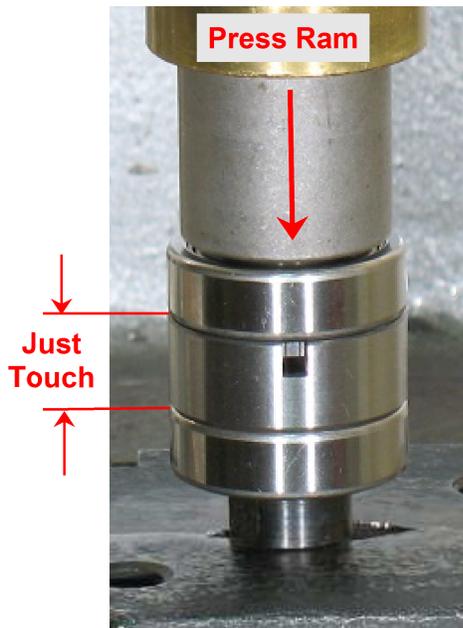
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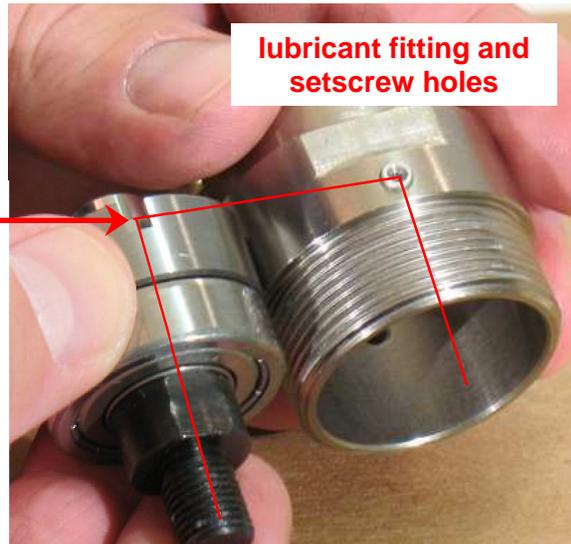
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Install the **54468** Ring Gear so that the notches will line-up with the lubricant and setscrew holes in the **53152** Adapter, **53153** Planetary Housing or gear case.

- Use the **RAISED CENTER** of the **96239** Bearing Press Tool and the arbor press to install the **54520** Bearing onto the planetary carrier. **IMPORTANT:** Carefully press the bearing to **just touch the ring gear**. This will establish a snug-fit between the bearings and the ring gear.



Notch



- Install the planetary reduction into the adapter and/or planetary housing or gear case. Apply Loctite #567 (or equivalent) to the **50784** Setscrew(s) and install.



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6. Apply Loctite #7649 Primer, and a small amount of Loctite #567 (or equivalent) to the threads of the adapter or gear case.



7. Fasten the wrench flats of the **53152** Adapter, **53153** Planetary Housing or gear case in the vise, and install the rear exhaust cover, planetary housing or lock nut onto the adapter. (T to 28 N•m/~250 in. lbs.)

8. Use the **95541** Lubricant Gun to supply 2 plunges of **95542** Grease (or equivalent) through the lubricant fitting(s). It is recommended to supply 2 plunges of grease after every 50-hours of use.



Planetary Gear Assembly Complete.

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