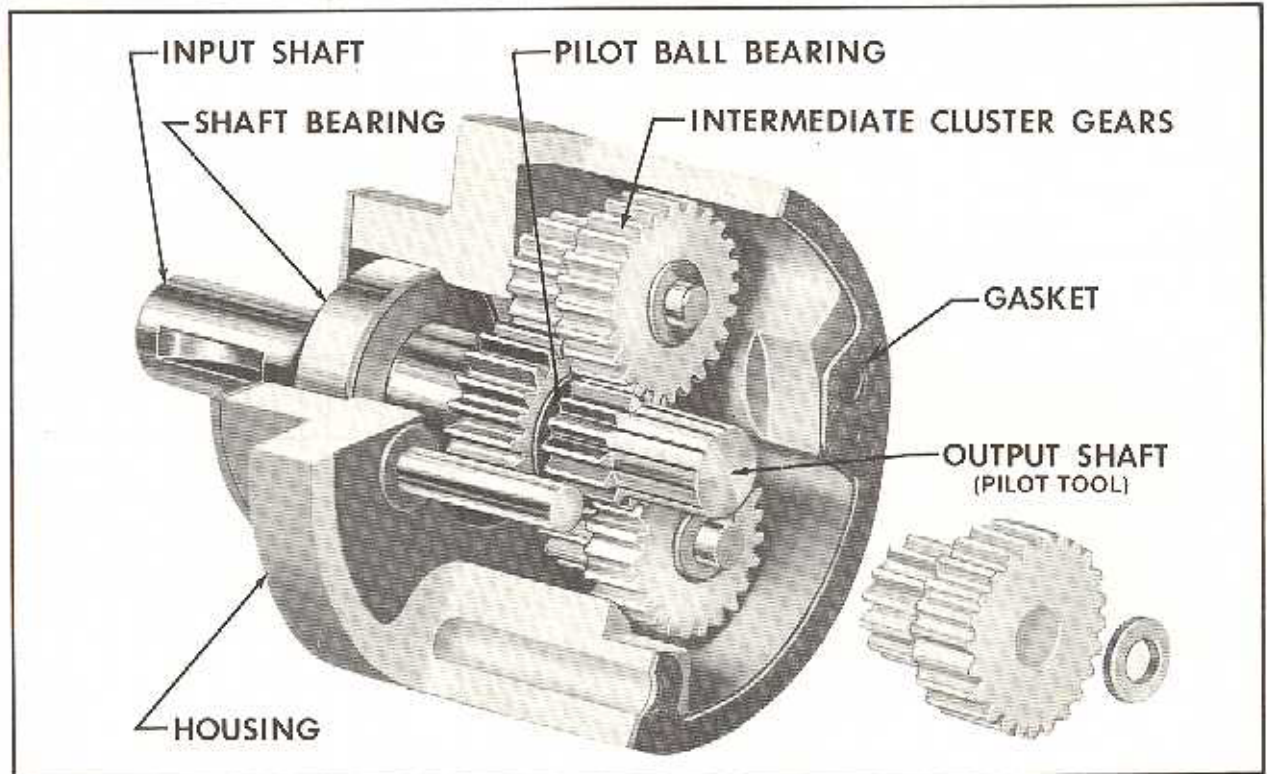




EUCLID SPEED INCREASER ASSEMBLY

SPEED INCREASER
(Cutaway view)



Intermediate gears can only operate at four positions in relation to driver and pilot gear because of the relationship of the 14 tooth to the 24 tooth gears.

A PILOT TOOL (#25854) (14 tooth .583" P.S. 20° pressure angle) must be used to install cluster gears.

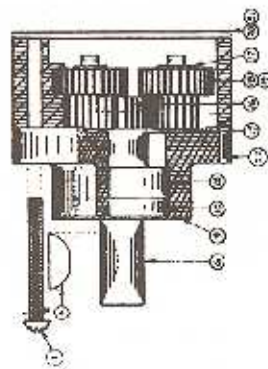
Determine by trial and error method the placing of intermediate gears so that they have the maximum amount of free tooth play in relation to driver gear and pilot tool.

Remove pilot tool and assemble gear housing to switch.

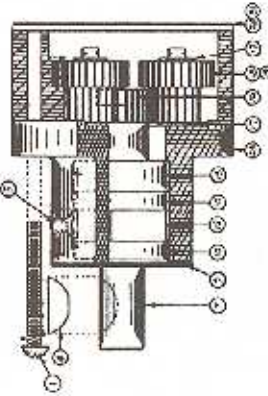
Add 1 oz. of a Lithium base non-fibrous grease with 5% Molybdenum DiSulfide additive.

Supply grease for both metal and nylatron gears.

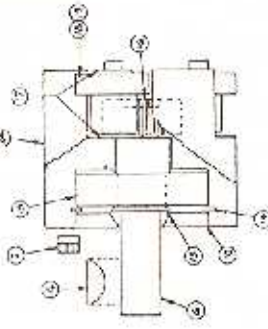
SINGLE SPEED INCREASER NEMA 7, 10 & 13



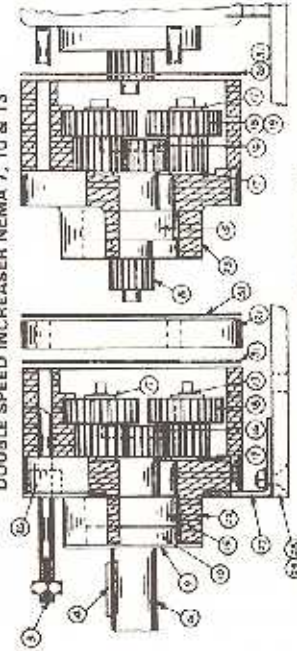
SINGLE SPEED INCREASER NEMA 4 & 9



INTERNAL SPEED INCREASER NEMA 13

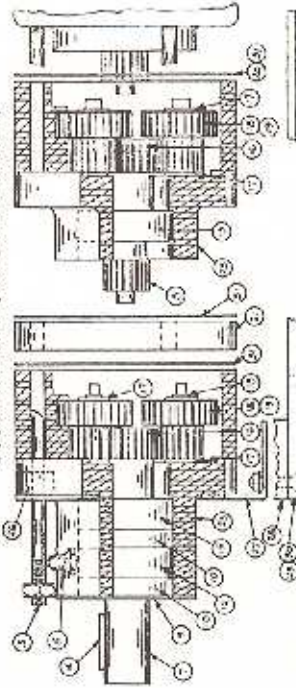


DOUBLE SPEED INCREASER NEMA 7, 10 & 13



NOTE: X-RAY GRADE AL SEALING PLATE. ORDER BY PART NAME AND NUMBER AS SHOWN ON THIS DRAWING.

DOUBLE SPEED INCREASER NEMA 4 & 9



NOTE: A PILOT TOOL, PART NUMBER 25825, MUST BE USED TO INSTALL SPACER GEARS. SEE FIG. 20 FOR ENSEMBLY.

REF. NO.	PART NUMBER	NO. REQ'D	PART NAME	REF. NO.	PART NUMBER	NO. REQ'D	PART NAME
1	47241-200	3	SCREW (1/4" - 20 x 2" RHMS)	* 18	25825	3-6	NYLATRON GEARS
2	47100-081	3	SCREW (1/4" - 20 x 2 1/4" SHS)	* 19	55090	3-6	STEEL GEARS
3	30140	3	ASSEMBLY BOLTS	* 20	25855-001	1	GASKET (STD. HOUSING)
4	57458-002	1	WOODRUFF KEY NO. 11	21	30142	1	HOUSING SPACER
5	57353-004	1	ZERK FITTING	22	25829	1	SFD. INC. HOUSING
6	25824	1	INPUT SHAFT	23	30598	1	SFD. INC. HOUSING
7	30236	1	INPUT SHAFT	24	30357	1	SFD. INC. HOUSING
8	30386	1	SECONDARY SHAFT	25	30148	1	SFD. INC. HOUSING
9	25812	1	SEAL RETAINER PLATE	26	30139	3	ROD SPACER
* 10	57497-001	1-2	SHAFT SEAL	27	30146	1	BRACKET
11				28	30546	1	SPACER BLOCK (XP HOUSING)
12	30405	1	SEAL SPACER		30547	1	MTG. PLATE (XP HOUSING)
13	57429-002	1	SPIR-O-LOX EXT. RET. RING	30	30147	1	MTG. PLATE (STD. HOUSING)
14	57429-006	1	TRU-ARC RET. RING #N5001-137	* 31	25855-002	1-3	GASKET (XP HOUSING)
* 15	57320-010	1-2	MAIN BEARING				
* 16	57320-023	1-2	PILOT BEARING				
17	25891	6-12	SPACER WASHERS				

*SUGGESTED SPARES



industrial controls division