50N PLANETARY GEAR DRIVE
SERVICE AND REPAIR MANUAL

Example Part Number

50N A D1 A 4 - 16 Z
Model Gear Drive Mounting Output Shaft Input Mounting Input Spline Ratio Options

THIS SERVICE MANUAL IS EFFECTIVE
FROM: .... S/N 16401, JULY 1993
TO: .......... CURRENT
REF: ....... SM50ND2-AG
50N MODEL SERVICE MANUAL

SINGLE/DOUBLE STAGE PLANETARY GEAR DRIVE

This manual will assist in disassembly and assembly of the above model 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.

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<tr>
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<th>Oil Capacity</th>
<th>Oil Level</th>
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<td>Horizontal Shaft</td>
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<td>To horizontal centerline of gear drive</td>
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<tr>
<td></td>
<td>Vertical Shaft</td>
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<td>To midway on upper/primary gear set</td>
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<td>Vertical Shaft</td>
<td>2.50 pints</td>
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</table>

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

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Disassembly Procedure

All parts should be inspected as they are removed from unit. Scribe across mounting case (1), ring gear (2), and cover (3) joints on outside of gearbox to assure proper orientation of oil fill and drain plugs, motor mounting, etc., as the unit is reassembled.

1) Remove hydraulic motor and Eskridge Brake from gearbox. Drain oil.

2) Remove the twelve 7/16 x 3” hex cap screws (27) and 7/16 lockwashers (31), which retain cover (3) and ring gear (2) to mounting case (1).

3) Lift cover (3) off of unit and remove input gear (12) and input thrust washer (26).

4) Remove primary planetary assembly (includes items 6,8,14,17,25 and 30).

5) Remove secondary planetary assembly (includes items 5,7,13,15,16,24, and 29).

6) Place unit on a press table with the output shaft (4) protruding downward through a hole in the table. Unit should be supported only by mounting case (1). The only thing retaining output shaft (4) at this point is the locknut (22) and lockwasher (23). Bend lockwasher tab out of locknut slot. Use a spanner wrench to loosen locknut. Take locknut and lockwasher completely off of output shaft.

CAUTION: Locknut is no longer retaining output shaft. Take precautions if the unit is moved because the 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 (threaded end) until it passes through inner shaft bearing (19). Outer shaft bearing (18) will come out of unit attached to shaft. Set aside the spacer (9) and shims (10) until needed in UNIT ASSEMBLY.

CAUTION: Care should be taken not to injure feet or damage output shaft during this procedure.

Output Shaft Subassembly
(ITEMS 4,18,34) (See exploded drawing for larger view)

1) If outer bearing cone (18) needs to be replaced, it will need to be pressed off of output shaft. Also inspect inner bearing cone (19). Shaft was pressed through inner bearing cone during shaft removal procedure; it is located in mounting case seated inside the inner bearing cup (21). In some instances, outer bearing cone (18) may need to be removed if shaft seal (34) is to be replaced. If outside diameter of output shaft (external end opposite bearing) is smaller than the inside diameter of seal, then shaft seal may be replaced without removing bearing cone.

2) Lubricate inner lip of new shaft seal (34) and turn until open side of seal is up. Slide seal onto output shaft until it fits snug over shaft seal diameter.

3) Press outer bearing cone (18) onto output shaft (4). With small end of bearing cone pointing upward, start over threaded end of shaft and 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 6,8,14,17,25, and 30)

Rotate primary planet gears (8) to check for any abnormal noises or roughness in the primary planet bearings (25). At the same time, inspect planet gears for any damage or worn teeth. If replacement or further inspection is required, proceed as follows.

1) Remove primary planet shafts (14) by pressing them out, thus sheering off roll pins.

NOTE: Support primary carrier (6) only while pressing planet shafts.

2) Slide planet gears (8) and primary planet washers (17) from carrier (6).

3) If any of the primary planet bearings (25) need replacing, press them out of planet gears.

4) Check primary planet shafts (14) for any abnormal wear, especially ones in which bearings needed to be replaced. If any abnormal wear is found, replace planet shaft.

5) Punch remainder of sheared-off roll pins from carrier and planet shafts. New roll pins are always required if they are sheared off.

6) Press new primary planet bearings (25) into planet gears, if required.

7) With a primary planet washer (17) on both sides of planet gear and bearing installed, slide gear into carrier (6) and insert primary planet shaft (14) through carrier, planet gear, and washers. During planet shaft installation, align roll pin

Steps marked with an asterisk (*) apply only to double stage (planetary) models.
hole in planet shaft with the roll pin hole in outside diameter of carrier.

NOTE: Inserting a 1/8" diameter punch in 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 (30) 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 same process for remaining gears.

Secondary Planetary Subassembly
(ITEMS 5,7,13,15,16,24, and 29)

Follow same procedures as that for the Primary Planetary Subassembly, only substitute item numbers as indicated. Secondary carrier (5), secondary planet gear (7), secondary planet shaft (13), carrier cup washer (15), secondary planet washer (16), secondary planet bearing (24), secondary roll pin (29).

Case Subassembly
(ITEMS 1,20,21, and 32)

1) Inspect inner and outer bearing cups (20,21). If cups are damaged, cups and case (1) may need replacement. Contact Eskridge, inc. if you have questions.

2) Clean all foreign material from magnetic oil plug (32) located on side of mounting case (1). Add a small amount of pipe thread compound to pipe plug before installing it back into case.

All subassembly service or repairs should be complete at this time. Continue on through Unit Assembly to complete unit buildup.

Unit Reassembly
1) Start with case assembly (1). Turn case upside down and position on press table. Case pilot diameter should be pointing upward with outer bearing cup (20) exposed. Apply a layer of lithium bearing grease to bearing cup surface.

2) Invert output shaft assembly (4), threaded side down, and carefully lower into case (1) until the shaft's outer bearing cone (18) is seated against outer bearing cup (20).

3) Press shaft seal (34) into case until it is flush with bottom of pilot diameter. Use a press fixture, if possible, to avoid 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.

CAUTION: The only thing holding 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 (4) 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) Install bearing spacer (9) over threaded end of output shaft (4). Spacer should slide all the way down to outer bearing cone (18), where it will rest. Follow spacer with bearing shims (10). The same number (quantity) of shims removed from unit during disassembly should be returned. Shims will sit directly on top of bearing spacer.

NOTE: Quantity of shims (10) may vary from unit to unit. Bearing preload, set at the factory, determines quantity of shims.

7) Apply a layer of lithium bearing grease to inner bearing cup (21) surface.

8) Install inner bearing cone (19) (small end down) over threaded end of output shaft. Press bearing on slowly until it is just seated against bearing cup (21). With a slight press load still applied, rotate case (1) by hand to ensure roller bearings are rotating evenly and smoothly. Inner bearing cone (19) may require additional press load to reach proper bearing preload. If roller bearings are seated properly, continue on to set and check bearing preload.

SHAFT BEARING PRELOAD: Proper shaft bearing preload is achieved when torque required to rotate case is 50 to 80 in-lbs. This rolling torque is equal to a force of approximately 11 to 18 lbs if pulling on mounting case flange to rotate case (1). This may be determined by feel or by using a fish scale or similar measuring device to check rolling torque. Once preload is set, relieve press load and continue to step #9.

9) Install a new retaining ring (22) onto output shaft.

10) Lightly grease a new o-ring (33) and install it into o-ring groove in case (1). Assemble ring gear (2) to case (1). Refer back to scribe marks made across external joints of gearbox prior to Disassembly Procedure. Line up scribe marks between ring gear and case to give correct hole alignment.

NOTE: Be certain that o-ring (33) stays seated in groove during step #10.

11) Install secondary carrier assembly into unit. Carrier assembly should be installed with hub side down (24 tooth spline). Rotate carrier assembly back and forth to mesh secondary planet gear teeth (7) with ring gear (2) teeth. Once teeth mesh, let secondary carrier slide down until it contacts with output shaft spline. The carrier splined hub (5) should slide onto output shaft (4). Carrier hub will rest on top of retaining ring (22) when splines are fully engaged. Check to be certain carrier cup washer (15) is installed.


*13) Install primary carrier assembly into unit, splined hub down.

14) Insert input gear into unit so that teeth mesh with primary planet gears (8). Put input thrust washer (26) over top of input gear.

15) Fill unit with GL-5 grade EP 80/90 gear oil, referring to the Oil Capacity Chart shown on Page 2 of this manual.

Steps marked with an asterisk (*) apply only to double stage (planetary) models.
16) Grease a new o-ring (33) and install it into bottom of cover (3). Refer back to scribe marks made across external joints prior to Disassembly Procedure. Line up scribe marks between cover and ring gear (2) so that orientation of motor mount holes and oil plug are back to their original positions.

**NOTE:** Be certain o-ring (33) stays seated in cover during step 16.

17) Install all twelve of the 7/16 lockwashers (31) and the 7/16 hex capscrews (27) and torque to 70 ft-lbs.

THE GEARBOX IS NOW READY FOR USE.
### SINGLE PLANETARY

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**DESCRIPTION**

- A: ROUND HANG (NO ZERK)
- B: RECTANGULAR FLANGE (NO ZERK)
- C: FLANGELESS (NO ZERK)
- D: CUSTOM
- RING GEAR
- A: COVER-SA-A'
- B: COVER-SA-B* 3-BOLT
- C: COVER-SA-C 4-BOLT
- D: COVER-SA-C 2-BOLT
- D1: 20BA SHAFT 1/8" KEYWAY
- D2: 23T 12/32 D.P. SPLINE
- D3: 2-15/32 SHA 1/2" KEYWAY
- D4: 20BA SHAFT 1/2" KEYWAY
- D5: 1/2"X20SHAFT 3/16" DIA. HOLE
- C1: SHAFT-CUSTOM
- CARRIER-SECONDARY
- CarrIer-PRIMARY
- PLANET GEAR-SEC.
- PLANET GEAR-PRI.
- SHIM(S)
- SUN GEAR-SECONDARY
- 1: INPUT GEAR 21T 2040 D.P SPLINE
- 2: INPUT GEAR 13T 1632 D.P SPLINE
- 3: INPUT GEAR SA-E 1360 SPLINE
- 4: INPUT GEAR14T 12/34 D.P SPLINE
- 5: INPUT GEAR 15T 1632 D.P SPLINE
- B: INPUT GEAR 1" 19X 2.26 KEY
- C: PLANET SHAFT-SECONDARY
- D: PLANET SHAFT-PRIMARY
- E: THRUST WASHER-SEC CUP
- F: THRUST WASHER-SEC PLANET (GEAR)
- G: THRUST WASHER-SEC PLANET (GEAR)
- H: BEARING CONE (INNER)
- I: BEARING CUP (OUTER)
- J: BEARING CUP (INNER)
- K: BEARING CUP (INNER)
- L: BEARING CUP (INNER)
- M: LOCK WASHER- OUTER
- N: LOCK WASHER- OUTER
- O: LOCK WASHER- OUTER
- P: BEARING-PLANET
- Q: BEARING-PLANET
- R: BEARING-PLANET
- S: BEARING-PLANET
- T: THRUST WASHER-INPUT
- U: HEX CAPSCREW 7/16X2 3 1/4 ORS
- V: ROLLPIN-SECONDARY 5/16 X 7/8
- W: ROLLPIN-PRIMARY 1/8 X 1
- X: LOCK WASHER 7/16 MED
- Y: PPS PLUG-MAGNETIC 3/8 NPT-3/32 PD
- Z: O-RINGS 16/16X 3 MM
- AA: Seal- Shaft
- BB: THRUST WASHER
- CC: RETAINING RING
- DD: GREASE FITTING (OPTIONAL) STR. 1/8 NPT
- EE: AIR VENT 3/8 NPT (OPTIONAL)

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**NOTES:**

- Bearing preload determines quantity of shims.
- For grease Zerk option, add 'Z' suffix to base PN.
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 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.
### Planetary Gear Drives

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### Planetary Auger Drives, Anchor Drives & Diggers

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