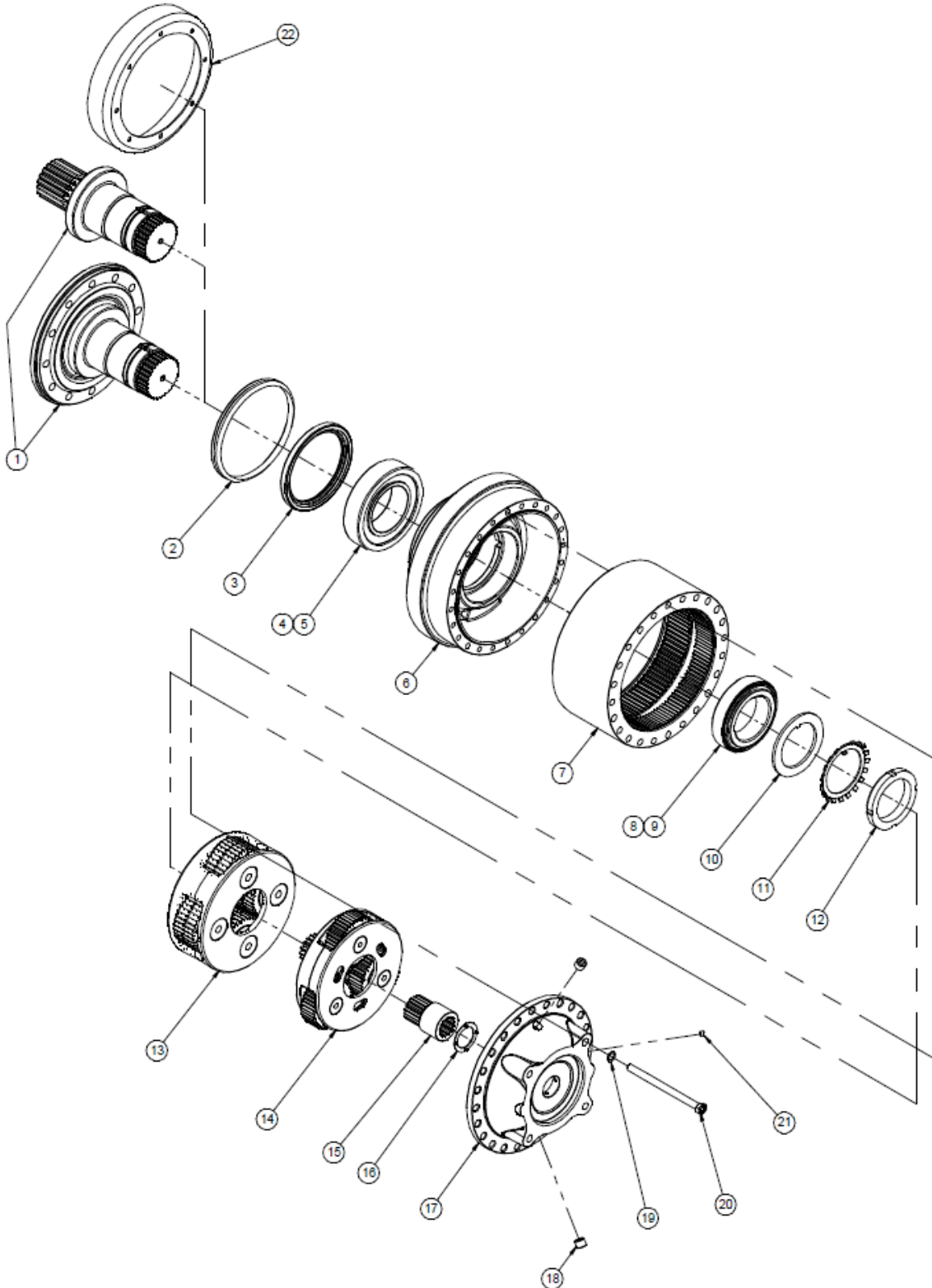


Power Wheel® Service Manual
Model 350 Double Reduction
Shaft and Spindle Output Drives



400 E. Auburn Drive
Auburn, Indiana 46706-3499
Phone: (260) 925-3200



IDENTIFICATION

IMPORTANT: All Power Wheel units and kits are shipped with a label that includes the Auburn Gear part number, order code and work order.



In addition to the label, Power Wheel drives are stamped with an identification number and date code, which appears on the cover or hub flange as shown.

Example: **60003508 17 243**

When ordering parts, the information included on the label or the stamped identification number is necessary to accurately identify the drive and obtain the correct replacement parts. Once this information has been obtained, contact Auburn Gear for the appropriate parts list.

DISASSEMBLY OF POWER WHEEL

STEP 1

Remove twenty-four hex head bolts (20) and washers (19) from cover (17). Thrust washer (16) usually remains with cover.

STEP 2

Lift sun gear (15) from primary carrier assembly (14).

STEP 3

Remove primary carrier assembly (14) from ring gear (7).

STEP 4

Remove ring gear (7) from hub (6). It may be necessary to strike ring gear (7) with a rubber mallet to loosen from hub (6).

STEP 5

Remove the secondary carrier assembly (13).

STEP 6

One tab of lock washer (11) will be engaged in slot of bearing nut (12); bend tab back to release. Remove the bearing nut (12), lock washer (11) and thrust washer (10). NOTE: A special locknut wrench, AG21308, is required for the removal of the bearing locknut. Contact Auburn Gear to purchase wrench and other service tools. Drawings are also attached.

STEP 7

Place assembly in press with output shaft or spindle (1) down on hub flange (6). Place material under output shaft or spindle so not to damage when it's pressed out of hub. Care should be taken to avoid damaging splines and threads on output shaft or spindle while pressing it out. NOTE: Bearing cone (8) has been designed with a press fit with respect to output shaft or spindle (1). Considerable force will be required to remove cone from output shaft or spindle. If a press is not available you will need the AGXXXXX(Contact Auburn Gear) Spindle/Shaft removal tool. Place the small disk on the end of the spindle/shaft. Mount the cross tube to the hub. Turn the screw against the small disk, DO NOT use an impact gun. Turning the screw will force the spindle/shaft out of the bearing cone.

STEP 8

Remove the oil seal (3) & boot seal (2), if included and bearing cones (4 & 8) from hub (6). Inspect bearing cups (5 & 9) in position and remove only if replacement is required.

ASSEMBLY OF POWER WHEEL

STEP 1

Press new bearing cups (5 & 9) in each side of the hub (6). It is recommended that bearing cups (5 & 9) and cones (4 & 8) be replaced in sets.

STEP 2

Assemble bearing cone (4) into cup (5) at seal end of hub (6) and press a new seal (3) into hub (6). Install boot seal (2) on hub (6) if unit is so equipped.

STEP 3

Position output shaft or spindle (1) upright on bench. Lubricate lips of seals (2) and (3), seal surface of output shaft or spindle, and lower hub (6) onto output shaft or spindle (1). Hub (6) should be centered as it is lowered over output shaft or spindle (1) to prevent seal damage. NOTE: On heavy duty seals (order code T) there is to be no lubricant on seal (3), output shaft or spindle (1), or hub (6).

STEP 4

Press inner bearing cone (8) onto shaft (1) until rollers just contact inner bearing cup (9) using a cylinder that is in full contact with the

ID of the bearing cone (see photo below).



STEP 5

Install tab of thrust washer (10) into slot of output shaft or spindle (1). Place lock washer (11) onto output shaft or spindle (1).

STEP 6

Torque bearing nut (12) to 50 lb ft using tool AG21308.

STEP 7

Rotate hub several revolutions in each direction to allow bearings to seat.

STEP 8

Using an appropriate pick, check each roller of the inner bearing cone (8) for looseness.

STEP 9

If all rollers are tight, proceed to step 12.

STEP 10

With bearing nut tool AG21308 placed on bearing nut (12), tap end of bearing nut tool with an appropriate hammer to advance the inner bearing cone (8) further onto shaft (1).

STEP 11

Repeat steps 7 thru 10 until all inner bearing cone rollers are tight.

STEP 12

Identify and mark the target tab/slot combination required to achieve the recommended preload of 3/4 tab to 1 full tab. Refer to figures below.



STEP 13

Set the bearing preload by advancing the bearing nut (12) onto the shaft (1) between 3/4 tab to 1 full tab. To advance the bearing nut to the preload position, tighten bearing nut using tool AG21308 until the slot and tab combination identified in Step 12 are aligned. Do not exceed 150 lb ft. If the appropriate slot and tab are not aligned prior to reaching 150 lb ft, tap end of bearing nut tool as described in Step 10 and continue to tighten bearing nut. Repeat as required until the appropriate tab and slot are aligned.

STEP 14

Secure bearing nut (12) by bending the lock washer tab into the aligned bearing nut slot.

STEP 15

Assemble the secondary carrier assembly (13) on the output shaft or spindle (1).

STEP 16

Clean mating surfaces and apply a bead of silicone sealant to face of hub (6) that mates with ring gear (7). See instructions on sealant package. Assemble ring gear (7) to hub (6) being careful to align bolt holes.

STEP 17

Assemble the primary carrier assembly (14) into the ring gear (7). It will be necessary to rotate carrier to align secondary sun gear {part of primary carrier assembly (14)} with planet gear teeth in secondary carrier assembly (13). Install primary sun gear (15) into primary carrier assembly. Sun gear (15) should turn freely by hand when assembled.

STEP 18

Apply a bead of silicone sealant to cover face of ring gear (7). Secure thrust washer (16) with tangs engaged in cover (17).

NOTE: Washer (16) can be secured to cover (17) with a small amount of grease or silicone sealant. Assemble cover (17) to ring gear (7). Align cover (17) with hub (6) such that pipe plug holes on cover align with mounting holes in hub.

STEP 19

Assemble the twenty-four 9/16-12 x 8 inch grade 8 bolts (20) and flat washers (19). Torque bolts to 120 - 130 lb.-ft. (163.2 – 176.8 Nm).

STEP 20

After motor is assembled to drive or drive is sealed at output shaft or spindle, position filler opening horizontally and fill unit to oil level hole in cover (17). Install pipe plugs (18). Torque pipe plug (21) 4-8 lb.-ft. and pipe plugs (18) 6-10 lb.-ft.

NOTE: When installing a hydraulic motor to the Power Wheel drive it is necessary to place an "O" ring or gasket (not supplied by Auburn Gear) between the motor and the planetary drive. "O" ring sizes: SAE A 2-042, SAE B 2-155, SAE C 2-159, SAE D 2-163.

CARRIER ASSEMBLIES

It is recommended that the primary and secondary carrier assemblies (13 & 14) be serviced in their entirety to protect the integrity of the Power Wheel drive.

LUBRICATION RECOMMENDATIONS

IMPORTANT: POWER WHEEL PLANETARY DRIVES ARE SHIPPED WITHOUT LUBRICANT AND MUST BE FILLED TO THE PROPER LEVEL PRIOR TO START UP.

Observe lubrication recommendations given by the original equipment manufacturer. When specific recommendations are not available, use mild extreme pressure lubricant API-GL-5, No. 80 or 90 when filling the Power Wheel under normal temperature ranges between 0 - 120°F (-18 to 49°C). Power Wheel is to be half full of oil when unit is mounted level and horizontal. Use drain and fill plugs located in cover. Oil is to be changed after first 50 hours of operation with subsequent changes every 1000 hours or yearly, whichever ever comes first. If unit is to be operated vertically, if ambient conditions are outside the specified range, or if the oil temperature exceeds 200°F (93°C) contact Auburn Gear for oil and level recommendations.

STORAGE

A protective film is applied to the Power Wheel at the factory to prevent rust during shipment. Additional protection may be required if the Power Wheel is to be stored for an extended period of time.

SEALING COMPOUND

Silastic RTV732 sealer and General Electric Silimate RTV No. 1473 or RTV No. 1503 are currently recommended for sealing gasket surfaces. Sealant should be applied in a continuous bead, which should be centered on the surface to be sealed but should move to the inside of the hole at each bolthole location. For service requirements order Auburn Gear part number 604101.

SPECIFICATIONS

Maximum intermittent output torque 250,000 lb. in. (28,200 Nm)
 Maximum input speed 4,000 RPM
 Oil capacity 140 oz (4,100 cc)

ITEM NO.	DESCRIPTION*	NO. USED IN ASS'Y.	ITEM NO.	DESCRIPTION*	NO. USED IN ASS'Y.
1	Shaft or Spindle Output	1	13	Secondary Carrier Assembly	1
2 **	Boot Seal 604466	1	14	Primary Carrier Assembly	1
3	Oil Seal 604465	1	15	Primary Sun Gear	1
4 & 5	Bearing Set 613376	1	16	Thrust Washer	1
6	Hub	1	17	Cover	1
7	Ring Gear	1	18	Pipe Plug	2
8	Bearing Cone 613305	1	19	Washer-Flat 604703	24
9	Bearing Cup 613306	1	20	Hex Head Bolt 6183130	24
10	Thrust Washer 619379	1	21	Pipe Plug	1
11	Lock Washer 605013	1	22**	Metal Seal Guard	1
12	Bearing Nut 614933	1			

* Contact Auburn Gear with part number and order code of drive to obtain the appropriate parts list. Refer to parts list for the specific part numbers and quantities.

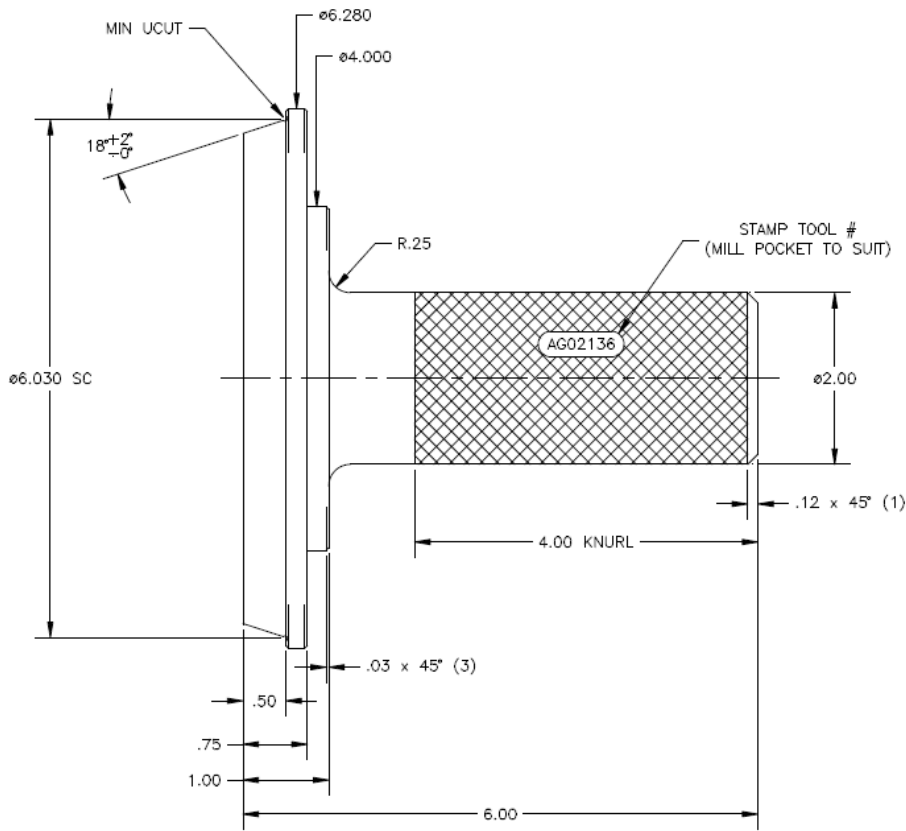
** Not required in all assemblies
 Refer to parts list for the specific part numbers and quantities

Model 250 Power Wheel® Service Kits

Part No.	Description	Included Items
AG02136	Bearing Cup Driver	See Below
AG20992	Bearing Cup Driver	See Below
AG21308	Bearing Locknut Tool	See Below
AG21336	Seal Driver Tool	See Below
6410130**	Seal Kit	3 & 11
6410131**	Bearing & Seal Kit	3,4,5,8,9 & 11
604466	Boot Seal	Sold Separately

** Indicates kit also includes a tube of sealant, part number 604101

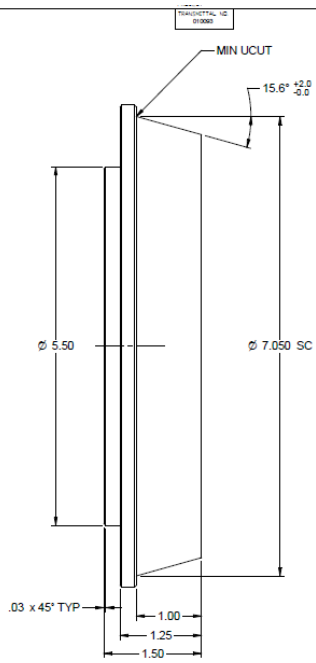
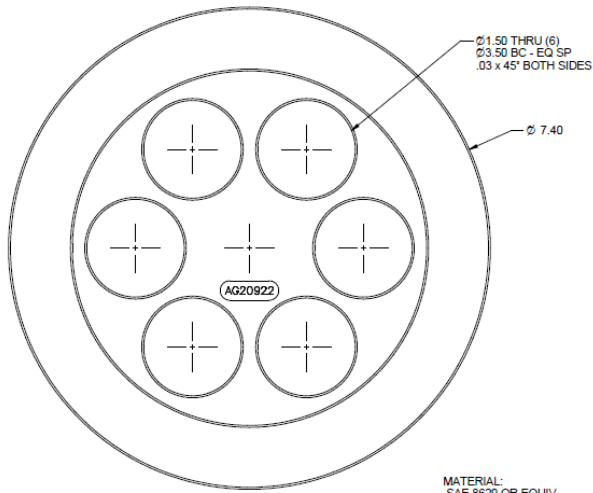
MH750-0518 Power Wheel® is a registered trademark of Auburn Gear



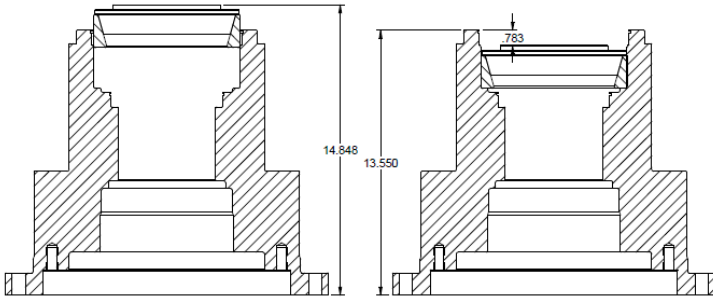
MATERIAL:
SAE 8620 OR EQUIV
CARB HARDEN Rc 58-62

		NAME DRIVER-BEARING CUP	
		USED FOR	
		PART DIM.	GAGE DIM.
		PART NO.	600041
A JPS 016602 REVISED & REDRAWN VPM 08-28-11		MACH. ASSET NO.	
LET TRAN	DESCRIPTION	DATE	DRN Bard DATE 01-10-96
TOLERANCES UNLESS OTHERWISE SPECIFIED		SCALE Full	GRD DNE
2 PLC-.010 3 PLC-.005 4 PLC-.0005 ANGLES-#		SHEET NO. 1 of 1	
NOTE: MARK ALL DETS WITH TL NO'S, PT. NOS., DET. NO'S & VENDOR'S SYMBOL REMOVE SHARP CORNERS.		SHEETS	T.OOL NO. AG02136
		A B C D	
		1	

02136001

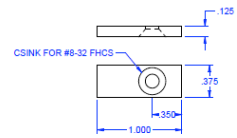
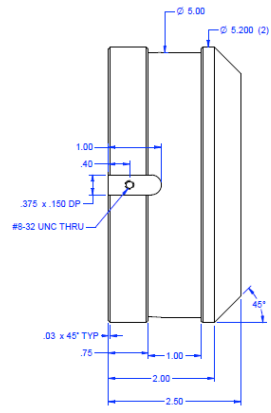
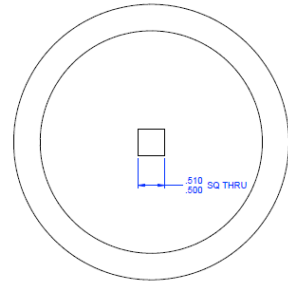
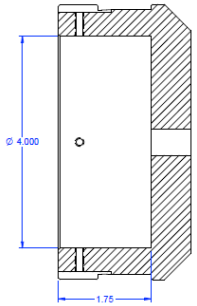
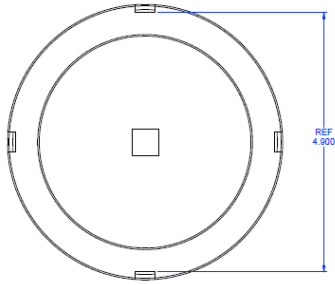


MATERIAL:
 SAE 8620 OR EQUIV
 CARB HARDEN Rc 58-62
 STAMP TOOL #
 (MILL POCKET TO SUIT)



NAME		DRIVER-BEARING CUP	
USED FOR			
PART CN		SIDE CN	
PART NO		E2832-000	
MACH ASSET NO		Auburn Gear	
SCALE		1:3.33	
SHEET NO		1 OF 1	
TOOL NO		AG20992	
DATE		REV	
BY		CHK	
APP		APP	

NOTE: MARK ALL DET'S WITH TL, HD'S, RT, HD'S, DET, HD'S, & VECTOR'S SYMBOL. REMOVE SHARP CORNERS.



SURFACES LABELED 'IG'		NAME	DRIVER-NUT
CONCENTRICITY IS REQUIRED FOR SURFACES TO BE SQUARE, PLAT, FINISHED & CONCENTRIC TO EACH OTHER WITHIN .0005 TIR		PROP NO.	
TOLERANCES UNLESS OTHERWISE SPECIFIED FOLLOW THE DIMENSIONAL PRACTICES MANUAL		PROJ NO.	M330 PW
REWORK QUALITY CONTROL		DESIGNER	AG
		DATE	21
		SHEET NO.	3 OF 3
		REV. NO.	AG21308

