

## Introduction

The following instructions apply to standard Type DH horizontal-parallel shaft and Type DB horizontal-right angle shaft enclosed gear drives.

This document provides detailed instructions on the replacement of the housing split studs immediately adjacent to the output shaft bearing bores. Positions A-1 thru A-4, see Figure 1. Contact Rexnord Gear Group Warranty at 414-937-4194 if you have any questions on this procedure.

**WARNING:** Consult applicable local and national safety codes for proper guarding of rotating members. Lock out power source and remove external loads from drive before servicing drive or removing accessories.

## Required Equipment

In addition to standard and metric mechanics tools, the following equipment is required: hydraulic torque wrench (capable of producing 5000 lb-ft of torque), 55mm (M1220/M1230) or 65mm (M1240/M1250) six-point socket and a marking pencil/pen.

## Supplied Parts

Table 1 lists parts supplied to replace the stud bolts immediately adjacent to the output shaft bearing bores.

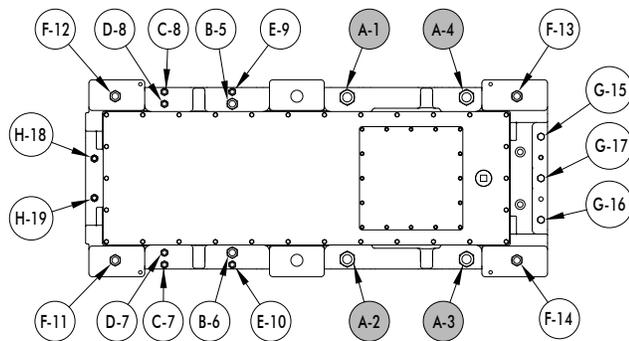
**Table 1 — Replacement Parts Supplied**

Description	Falk Part Number		Qty.
	M1220/M1230	M1240/M1250	
Stud Bolt	D010514 or 2713306	D010515 or 2173307	4
Hex Nut	D010516	D010517	8
Serrated Washer	D010533	D010534	4
Plain Washer	D010527	D010528	4

## Stud Replacement Instructions

Ensure that power to geardrive is locked out and equipment is unloaded. Remove and replace studs one at a time. Replace any failed stud(s) prior to removing any intact studs, see Step 4.

**FIGURE 1**



1. Remove accessories and guarding to improve access to studs requiring replacement. Record mounting dimensions and orientations if necessary.
2. Clean drive of all debris in area around studs to be replaced. Inspect drive for failed studs in positions A-1 thru A-4. Replace any failed studs per Step 4.
3. Loosen nut on stud with a hydraulic torque wrench. Verify a plain washer is under the nut being loosened. Typically the lower nut is secured with a serrated washer that cannot be loosened. After the upper nut is loose, remove lower nut completely and pull stud up and out of the housing.

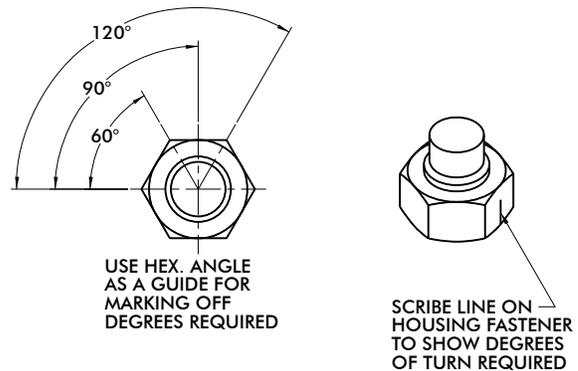
**WARNING:** Impact or slugging wrenches are not approved for use. Impact loads can cause stud bolt failure and the release of stored energy.

4. Coat threads on one end of stud and faces of plain washer with SAE 20 or heavier mineral oil. Assemble nut and plain hardened washer to oiled end of stud. Insert stud with washer and nut through hole in housing. Assemble serrated washer and nut to stud on the bottom. Adjust top and bottom nuts such that approximately equal threads are exposed top and bottom. Pre-tighten nut on top (nut with plain washer) to the torque specified in Table 2. Scribe or mark a line on nut and housing to indicate additional degrees of rotation of the nut required to achieve final tightening, see Figure 2. Complete tightening nut with hydraulic wrench to indicated marking.

**Table 2 — Split Stud Tightening Torques**

Fastener Pre-Torque & Turn of the Nut (Nm [lb-ft]/Degrees)		
Location Letter	M1220-M1230	M1240/M1250
A	760 [560] 120°	760 [560] 120°

**FIGURE 2**



5. Remove next stud on the opposite side of the housing directly across from the first stud replaced per Step 3. Install replacement stud and hardware per Step 4.
6. Replace remaining studs on alternating sides of the housing until all four studs have been replaced.
7. Reassemble all guarding and accessories on drive as previously removed and return drive to service.
8. Return old studs, nuts, washers and completed Return Authorization Form to Factory for credit.