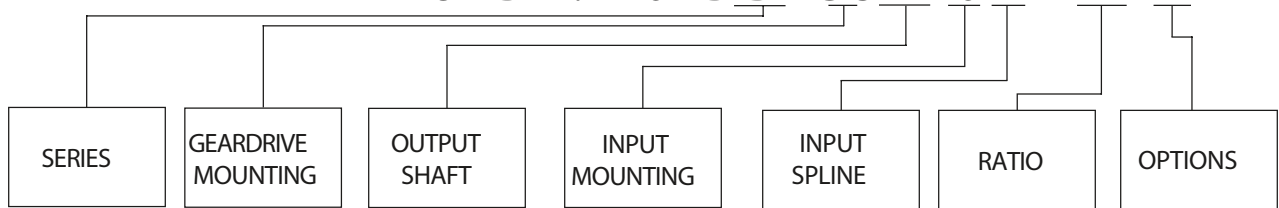


EXAMPLE PART NUMBER: 20 B D1 C 3 - 20 Z



## 20B/20P PLANETARY GEAR DRIVE SERVICE & REPAIR MANUAL

THIS SERVICE MANUAL IS EFFECTIVE  
FROM: ..... S/N 16401, JULY 1993  
TO: ..... CURRENT  
REF: ..... SM20B20PD2-AC

A Ramsey Industries Brand

# 20B/20P SERVICE MANUAL

## SINGLE AND DOUBLE STAGE PLANETARY GEAR DRIVE

This manual will assist in disassembly and assembly of the above series 20 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.

<u>OPERATING POSITION</u>	<u>STAGE</u>	<u>OIL CAPACITY</u>	<u>OIL LEVEL</u>
Horizontal Shaft	SINGLE	0.75 pints (0.35 liters)	To horizontal centerline of gear drive
Vertical Shaft	SINGLE	1 pints (0.47 liters)	To midway on upper/primary gearset
Horizontal Shaft	DOUBLE	1 pints (0.47 liters)	To horizontal centerline of gear drive
Vertical Shaft	DOUBLE	1.25 pints (0.59 liters)	To midway on upper/primary gearset



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

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## Before Disassembly

In the 20B/20P series, there are two types of units: single planetaries without a primary carrier, and double planetaries which have a primary planet carrier. Steps with an asterisk (\*) apply only to the double planetary model.

## Unit Disassembly

Refer to exploded view drawings on pages 6-9.

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

- 1) Remove hydraulic motor and Eskridge Brake from gearbox. Drain oil.
- 2) Remove the six 5/16 x 1 1/2" hex cap screws (22) and 5/16 lockwashers (26), which retain cover (2) to mounting case (1).
- 3) Lift cover (2) off of unit and remove input gear (11) and input thrust washer (21).
- \*4) Primary planetary assembly is now ready for removal (includes items 5,7,13,16,20 & 24). Secondary sun gear (10) is splined to primary carrier (5) and may come out when removing planetary assembly. If not, remove sun gear.
- 5) The secondary planetary assembly (includes items 4,6,12,14,15,19, & 23) is splined to the output shaft (3). It may now be lifted, by hand, from output shaft spline.
- 6) Place unit on a press table with the output shaft (3) protruding downward through a hole in the table. Unit should be supported only by mounting case (1). The only thing retaining output shaft (3) is the retaining ring. Remove retaining ring (25) from output shaft, followed by support washer (8) and bearing shims (9).

**CAUTION:** Retaining ring is no longer retaining output shaft. Take precautions if moving unit. Shaft may fall out.

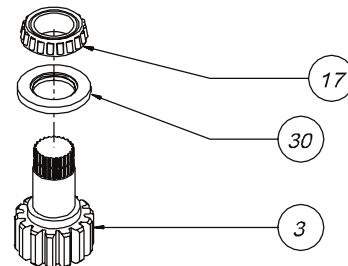
- 7) With output shaft down through centerhole in press table and unit supported by case, press shaft out by applying press load to top end of shaft (internal end) until it passes through inner bearing cone (17). Outer bearing cone (17) will come out of unit attached to shaft.

**CAUTION:** Care should be taken not to injure feet or damage output shaft during this procedure. Once shaft has been pressed through inner shaft bearing, it will drop from unit.

The unit is now disassembled into groups of parts and/or subassemblies. The area requiring repair or service should be identified by thorough inspection of the parts after they have been washed in solvent. If repair is necessary, refer to the individual repair section to follow.

## Output Shaft Subassembly

(Items 3,17,30)

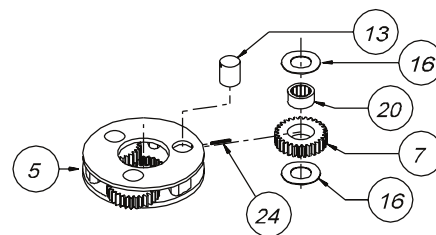


- 1) If outer bearing cone (17) needs replacing, it will need to be pressed off of output shaft (3). Also inspect inner bearing cone (17). Shaft was pressed through inner bearing cone during shaft removal procedure, so find bearing in mounting case seated inside the inner bearing cup (18). In some instances, outer bearing cone (17) may need to be removed if shaft seal (30) is to be replaced. If outside diameter of output shaft (external end opposite bearing) is smaller than inside diameter of seal, then shaft seal may be replaced without removing bearing cone.
- 2) Lubricate inner lip of new shaft seal (30) and turn so that open side of seal is up. Slide seal onto output shaft until it fits snug over shaft seal diameter.
- 3) With small end of outer bearing cone (17) pointed upward, place it onto the internal end of the output shaft (3). 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. **DONOT** press on outer roller cage of bearing or it will damage bearing.

## \*Primary Planetary Subassembly

(Items 5, 7, 13, 16, 20 & 24)



Rotate primary planet gears (7) to check for any abnormal noises or roughness in the primary planet bearings (20).

At the same time, inspect planet gears for any damage or worn teeth. If replacement or further inspection is required, proceed as follows.

- 1) Drive the spring pins (or roll pins) (24) completely into the planet shafts (13) using a pin punch. Press planet shafts out of carrier (5).

**NOTE:** Only support primary carrier (5) while pressing planet shafts out.

- 2) Remove planet gears (7) and primary planet washers (16) from carrier (5).

(\* Applies only to the double planetary model.

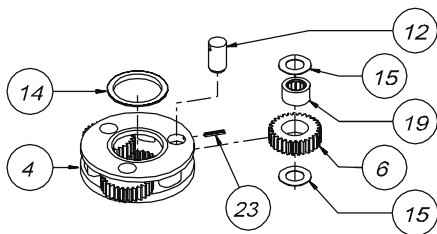
- 3) If any of the primary planet bearings (20) need replacing, press them out of planet gears.
- 4) Check primary planet shafts (13) for any abnormal wear, especially ones in which bearings needed to be replaced. If any abnormal wear is found, replace planet shaft.
- 5) Using a punch, drive roll pins out of planet shafts.
- 6) If required, press new primary planet bearings (20) into planet gears.
- 7) With a primary planet washer (16) on both sides of planet gear, with bearing installed, slide gear into carrier (5). Insert primary planet shaft (13) through the carrier, planet gear, and washers. During planet shaft installation, align roll pin hole in planet shaft, to the roll pin hole in outside diameter of carrier.

NOTE: Inserting a 1/8" diameter punch in the 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 (24) 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 the same process for remaining gears.

### Secondary Planetary Subassembly

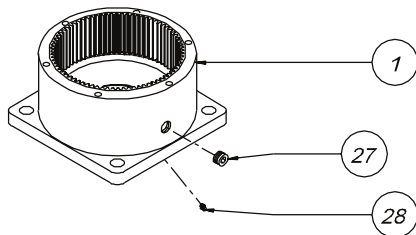
(Items 4, 6, 12, 14, 15, 19 & 23)



Follow same procedures as that for the Primary Planetary Subassembly, only substitute item numbers as indicated; Secondary carrier (4), secondary planet gear (6), secondary planet shaft (12), carrier thrust washer (14), secondary planet washer (15), secondary planet bearing (19), secondary roll pin (23).

### Case Subassembly

(Items 1, 18, 27 & 28)



- 1) Inspect inner and outer bearing cups (18). If cups are damaged, the cups and case (1) may need replacement. Contact Eskridge, inc. if you have questions.

- 2) Clean all foreign material from magnetic oil plug (27) located inside of mounting case (1). Add a small amount of pipe thread compound to pipe plug before installing back into case.

## Unit Assembly

Refer to exploded view drawings on pages 6-9.

- 1) Start with case assembly (1). Turn case upside down and position it so that the side with the threaded holes is resting on the press table. Case pilot diameter should be pointed upward with outer bearing cup (18) exposed. Apply a layer of lithium bearing grease to outer bearing cup surface.
- 2) Invert the output shaft assembly (3) (retaining ring groove down) and carefully lower into the case (1) until the shaft's outer bearing cone (17) is seated against the outer bearing cup (18).
- 3) Press shaft seal (30) into case until it is flush with bottom of pilot diameter. Use a press fixture, if possible, to eliminate 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 (3).

CAUTION: The only thing retaining 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 (3) 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) Apply a layer of lithium grease to inner bearing cup (18) and surface.
- 7) Install inner bearing cone (17) (small end down) over internal end of output shaft. Press bearing down slowly until it is just seated against inner bearing cup (18). With a slight press load still applied, rotate case (1) by hand to ensure that the roller bearings are rotating evenly and smoothly. Slide bearing shims (9) over output shaft and down onto inner bearing cone (17). The same number (quantity) of shims which were removed from unit during Disassembly Procedure should be returned.
- 8) Install support washer (8) over shims and a new retaining ring (25) above support washer into groove provided in output shaft. Inner bearing cone (17) may require additional press load to expose retaining ring groove. Apply only enough press load to allow retaining ring to engage into groove.

NOTE: Quantity of shims (9) may vary from unit to unit. Always use the same quantity of shims when reassembling.

- 9) Install secondary carrier (4) assembly into unit. Carrier assembly should be installed with hub side down (24 tooth spline). Rotate carrier assembly back and

(\* Applies only to the double planetary model.

forth to mesh secondary planet gear teeth (6) with case (1) teeth. Once teeth mesh, let secondary carrier slide down until it makes contact with the output shaft spline. The carrier splined hub (4) should spline onto output shaft (3). Carrier hub will rest on top of retaining ring (25) when splines are fully engaged. Install carrier thrust washer (14).

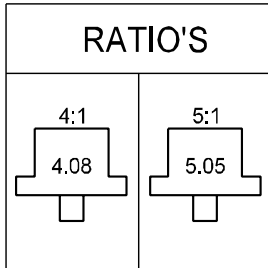
- \*10) Turn primary carrier assembly upside down so that splined end of carrier (5) is up. Insert splined end of secondary sun gear (10) into carrier spline until fully engaged. Install carrier assembly into unit, sun gear down. Sun gear teeth will mesh with the secondary planet gears, and the primary planet gear teeth (7) will mesh with the mounting case (1).
- 11) Put input thrust washer (21) over step of input gear (11). Insert input gear into unit so that teeth mesh with planet gears.
- 12) Fill unit with proper level (see page 2) of a GL-5 grade EP 80/90 gear oil. Proper oil level will measure to middle of primary planet gears (7).
- 13) Grease a new o-ring (29) and install into bottom of cover (2). Refer back to scribe marks made across external joint prior to Disassembly Procedure. Line up scribe marks between cover and case (1) so that orientation of motor mount holes and oil plugs are back to their original positions.

NOTE: Be certain o-ring (29) stays seated in cover during step #12.

- 14) Install all six of the 5/16 lockwashers (26) and the 5/16 hex capscrews (22) and torque them to 20 ft-lbs.

THE GEAR DRIVE IS NOW READY FOR USE.

# 20B Single Stage Exploded View Drawing



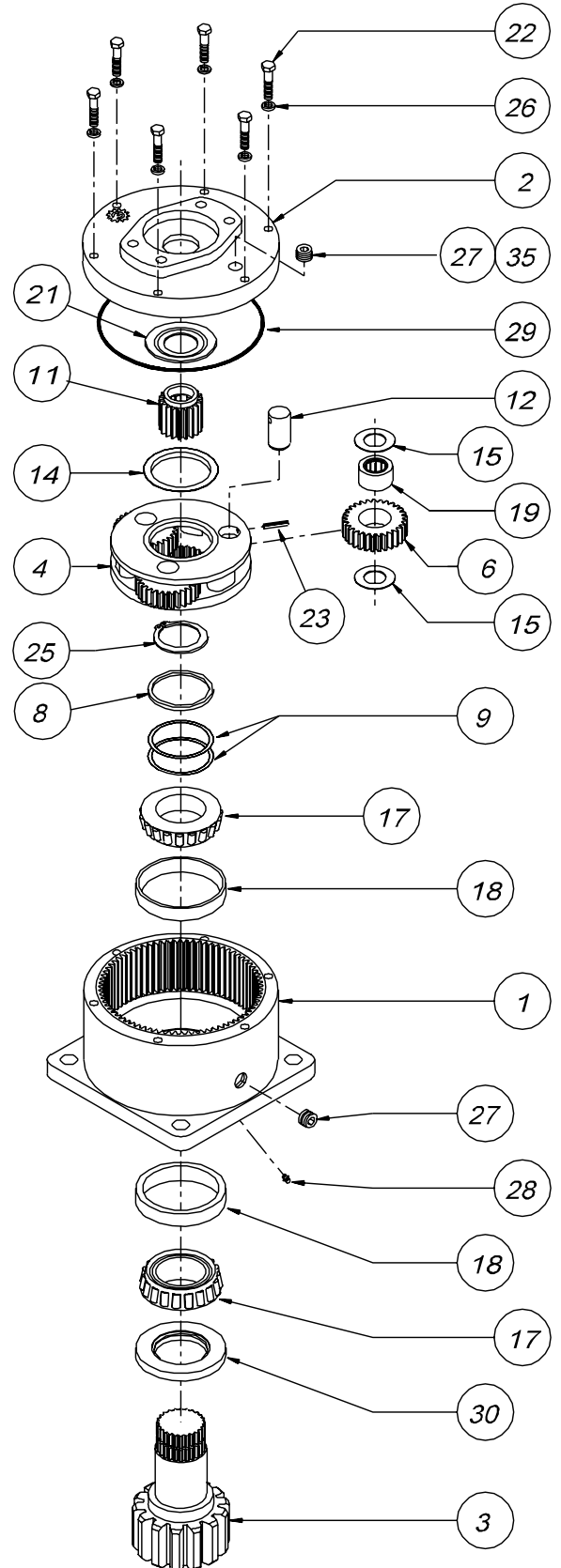
## MODEL B20 SINGLE PLANETARY



EFFECTIVE  
FROM: S/N 16401 07-01-93  
TO: (CURRENT)

PART NUMBER	PART NUMBER	QTY.	ITEM	C O D E	DESCRIPTION
←	20-004-3024	1	1		B20 CASE-SQUARE- (NO ZERK)
←	20-004-3024Z			B20 CASE-SQUARE- W/ZERK	
-	-			CB20 CASE-CUSTOM PER CUSTOMER SPECS.	
←	85-004-1513	1	2	A	COVER-SAE 'A'
←	85-004-1503			B	COVER-SAE 'B' 2-BOLT
←	28-004-1013			C	COVER-SAE 'C' 4-BOLT
←	20-004-4022	1	3	D1	2" DIA SHAFT-3/8" KEYWAY
←	20-004-4032			D2	SHAFT 23T, 12/24 D.P. SPLINE
←	20-004-4042			D3	2" DIA.SHAFT-1/2"KEYWAY
←	28-004-4202			D4	2.25"D.SHAFT-1/2"KEYWAY
-	-			C1	SHAFT-CUSTOM PER CUSTOMER SPECS.
←	20-004-1282	1	4		CARRIER-SECONDARY
←	20-004-1041	3	6		PLANET GEAR-SEC.
←	20-004-1031	1	8		SUPPORT WASHER
←	20-004-1091	*	9		SHIM
←	20-004-1302	1	11	1	INPUT GEAR 21T,20/40 D.P.SPLINE
←	20-004-1122			2	INPUT GEAR 13T,16/32 D.P.SPLINE
←	20-004-1102			3	INPUT GEAR SAE 1"-6B SPLINE
←	20-004-1192			4	INPUT GEAR 14T,12/24 D.P.SPLINE
←	20-004-1322			5	INPUT GEAR 15T,16/32 D.P.SPLINE
←	20-004-1142			6	INPUT GEAR 1"DIA X .25" KEY
←	20-004-1081	3	12		PLANET SHAFT-SECONDARY
←	50-004-1011	1	14		THRUST WASHER-SEC.CUP
←	85-004-1181	6	15		THRUST WASHER - (SEC. PLANET GEAR)
←	01-102-0160	2	17		BEARING CONE
←	01-103-0160	2	18		BEARING CUP
←	01-105-0010	3	19		BEARING-SEC.PLANET
←	50-004-1091	1	21		THRUST WASHER-INPUT
←	01-150-1400	6	22		HEX CAPSCREW 5/16-18 X 1.5, GR8
←	01-153-0210	3	23		ROLLPIN-SECONDARY 3/16 X 7/8
←	01-160-0250	1	25		RETAINING RING (NO.N5100-206)
←	01-166-0110	6	26		LOCKWASHER 5/16 MED
←	01-207-0070	2	27		PIPE PLUG-MAG. 3/8 NPT-SOC HD
←	01-215-0050	(1)	28		GREASE FITTING (OPTIONAL)
←	01-402-0560	1	29		O-RING 167 MM X 3 MM
←	01-405-0550	1	30		SEAL-SHAFT
←	01-216-0070	(1)	35		AIR VENT 3/8 NPT (OPTIONAL)
-	-	-	-	-	-

NOTE \* BEARING PRELOAD DETERMINES QUANTITY OF SHIMS.  
SEAL KIT; P/N 20-016-0501; INCLUDES ITEMS 29 AND 30.

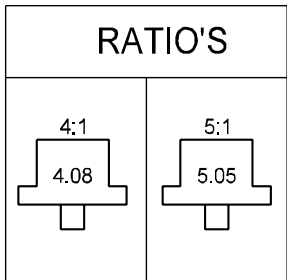


# 20P Single Stage Exploded View Drawing

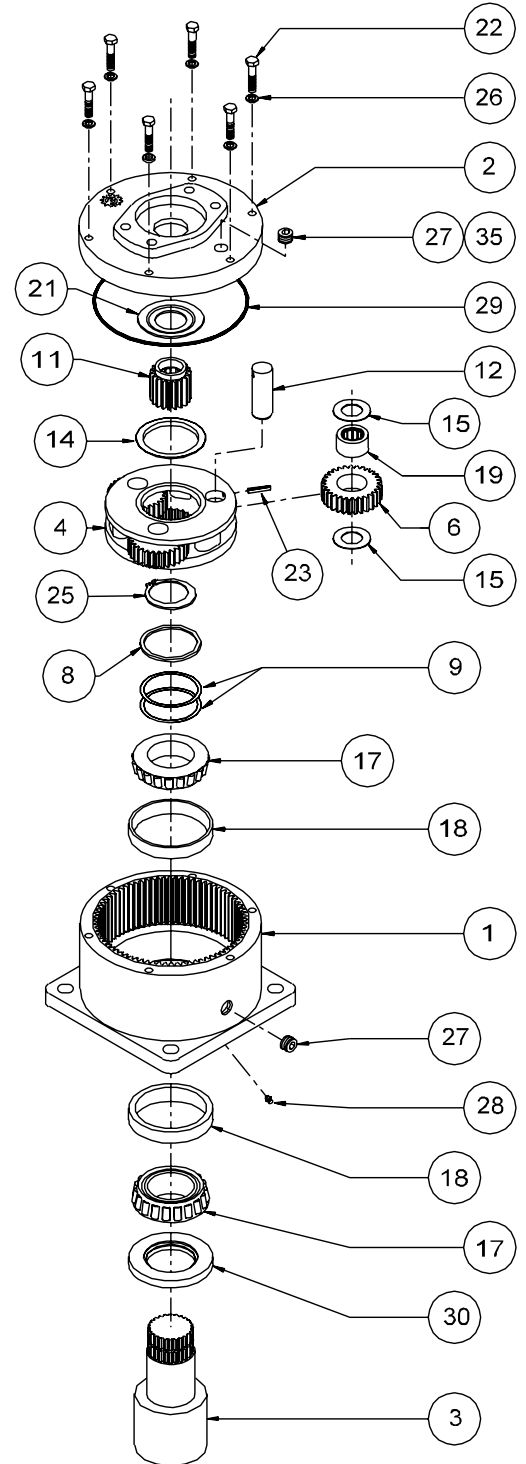
## MODEL P20 SINGLE PLANETARY



EFFECTIVE  
FROM: S/N 16401 07-01-93  
TO: (CURRENT)



PART NUMBER	PART NUMBER	QTY.	ITEM	CODE	DESCRIPTION
←	20-004-3074	1	1		P20 CASE-SQUARE-SINGLE PLT.(NO ZERK)
←	20-004-3074Z				P20 CASE-SQUARE-SINGLE PLT. W/ZERK
-	-				CP20 CASE-CUST.MTG PER CUSTOMER SPECS.
←	85-004-1513	1	2	A	COVER-SAE 'A'
←	85-004-1503			B	COVER-SAE 'B' 2-BOLT
←	28-004-1013			C	COVER-SAE 'C' 4-BOLT
←	20-004-4122	1	3	F1	SHAFT-1.5" KEYED
←	20-004-4112			F2	SHAFT-2" KEYED
-	-			C1	SHAFT-CUSTOM PER CUSTOMER SPECS.
20-004-1282	20-004-1292	1	4		CARRIER-SECONDARY
20-004-1041	20-004-1051	3	6		PLANET GEAR-SEC.
←	20-004-1031	1	8		SUPPORT WASHER
←	20-004-1091	*	9		SHIM
20-004-1302	N/A	1	11	1	INPUT GEAR 21T,20/40 D.P.SPLINE
20-004-1122	20-004-1132			2	INPUT GEAR 13T,16/32 D.P.SPLINE
20-004-1102	20-004-1112			3	INPUT GEAR SAE 1"-6B SPLINE
20-004-1192	N/A			4	INPUT GEAR 14T,12/24 D.P.SPLINE
20-004-1322	20-004-1312			5	INPUT GEAR 15T,16/32 D.P.SPLINE
20-004-1142	N/A			6	INPUT GEAR 1"DIA X .25" KEY
←	20-004-1081	3	12		PLANET SHAFT-SECONDARY
←	50-004-1011	1	14		THRUST WASHER-SEC.CUP
←	85-004-1181	6	15		THRUST WASHER- (SEC. PLANET GEAR)
←	01-102-0160	2	17		BEARING CONE
←	01-103-0160	2	18		BEARING CUP
←	01-105-0010	3	19		BEARING-SEC.PLANET
←	50-004-1091	1	21		THRUST WASHER-INPUT
←	01-150-1400	6	22		HEX CAPSCREW 5/16-18 X 1.5, GR8
←	01-153-0210	3	23		ROLLPIN-SECONDARY 3/16 X 7/8
←	01-160-0250	1	25		RETAINING RING
←	01-166-0110	6	26		LOCKWASHER 5/16 MED
←	01-207-0070	2	27		PIPE PLUG-MAG. 3/8 NPT-SOC HD
←	01-215-0050	(1)	28		GREASE FITTING (OPTIONAL)
←	01-402-0560	1	29		O-RING 167 MM X 3 MM
←	01-405-0610	1	30		SEAL-SHAFT
←	01-216-0070	(1)	35		AIR VENT 3/8 NPT (OPTIONAL)
-	-	-	-	-	-



NOTE \* BEARING PRELOAD DETERMINES QUANTITY OF SHIMS.  
SEAL KIT; P/N 20-016-0511; INCLUDES ITEMS 29 AND 30.

ECN 1083  
X20PD1-BD DATE 05-08-00

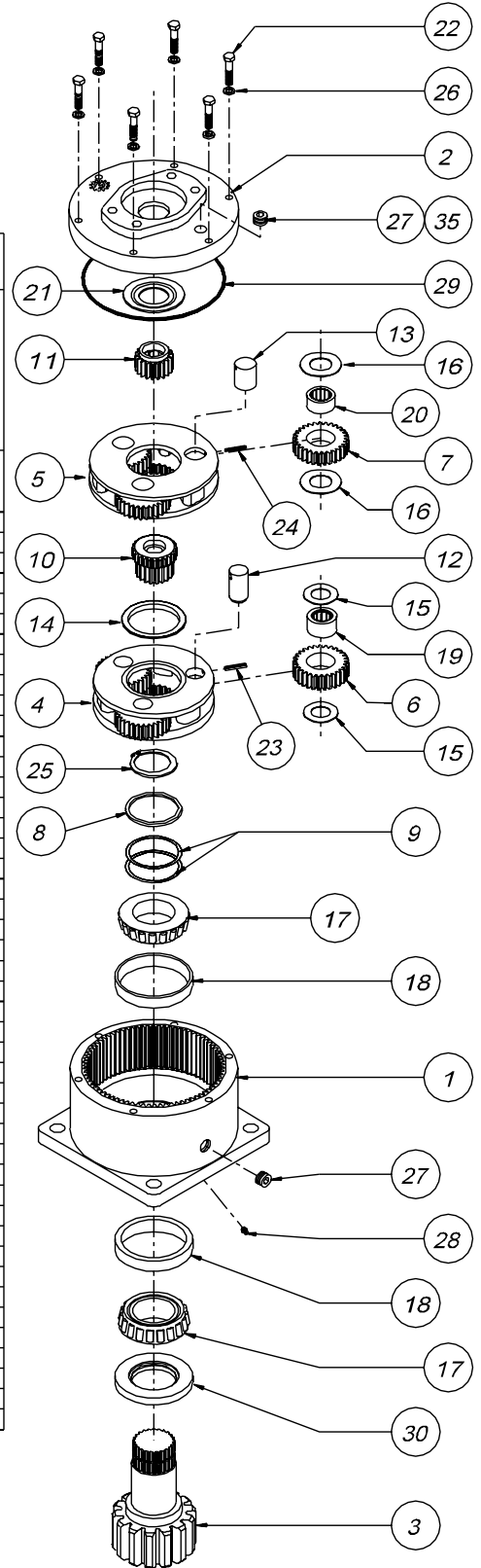
# 20B Double Stage Exploded View Drawing



**MODEL B20**  
DOUBLE PLANETARY  
EFFECTIVE  
FROM: S/N 16401 07-01-93  
TO: (CURRENT)

RATIO'S			
16.65:1 4.08 4.08	20.62:1 5.05 4.08	20.62:1 4.08 5.05	25.53:1 5.05 5.05
		INVERTED	

CODE	DESCRIPTION	ITEM	QTY.	PART NUMBER	PART NUMBER	PART NUMBER	PART NUMBER
	B20 CASE-SQUARE-DOUBLE PLT.(NO ZERK)	1	1	20-004-3014			
	B20 CASE-SQUARE-DOUBLE PLT. W/ZERK			20-004-3014Z			
	C20 CASE-CUSTOM PER CUSTOMER SPECS.			-	-	-	-
A	COVER-SAE 'A'			85-004-1513			
B	COVER-SAE 'B' 2-BOLT	2	1	85-004-1503			
C	COVER-SAE 'C' 4-BOLT			28-004-1013			
D1	2"DIA SHAFT-3/8" KEYWAY			20-004-4022			
D2	SHAFT 23T, 12/24 D.P. SPLINE			20-004-4032			
D3	2" DIA.SHAFT-1/2"KEYWAY	3	1	20-004-4042			
D4	2.25"D.SHAFT-1/2"KEYWAY			28-004-4202			
C1	SHAFT-CUSTOM PER CUSTOMER SPECS.			-	-	-	-
	CARRIER-SECONDARY	4	1	20-004-1282	20-004-1282	20-004-1292	20-004-1292
	CARRIER-PRIMARY	5	1	50-004-1082	50-004-1072	50-004-1082	50-004-1072
	PLANET GEAR-SEC.	6	3	20-004-1041	20-004-1041	20-004-1051	20-004-1051
	PLANET GEAR-PRI.	7	3	85-004-1031	85-004-1021	85-004-1031	85-004-1021
	SUPPORT WASHER	8	1	20-004-1031			
	SHIM	9	*	20-004-1091			
	SUN GEAR-SECONDARY	10	1	20-004-1332	20-004-1062	20-004-1072	20-004-1072
1	INPUT GEAR 21T, 20/40 D.P. SPLINE			85-004-1402		85-004-1402	N/A
2	INPUT GEAR 13T, 16/32 D.P. SPLINE			85-004-1102	85-004-1062		85-004-1062
3	INPUT GEAR SAE 1"-6B SPLINE			85-004-1122	85-004-1112		85-004-1112
4	INPUT GEAR 14T, 12/24 D.P. SPLINE			85-004-1533		85-004-1533	N/A
5	INPUT GEAR 15T, 16/32 D.P. SPLINE			85-004-1542	85-004-1422		85-004-1422
6	INPUT GEAR 1"DIA X .25" KEY			85-004-1582		85-004-1582	N/A
	PLANET SHAFT-SECONDARY	12	3	20-004-1081			
	PLANET SHAFT-PRIMARY	13	3	81-004-0071			
	THRUST WASHER-SEC.CUP	14	1	50-004-1011			
	THRUST WASHER-(SEC. PLANET GEAR)	15	6	85-004-1181			
	THRUST WASHER-(PRI. PLANET GEAR)	16	6	81-004-1561			
	BEARING CONE	17	2	01-102-0160			
	BEARING CUP	18	2	01-103-0160			
	BEARING-SEC.PLANET	19	3	01-105-0010			
	BEARING-PRI.PLANET	20	3	01-105-0410			
	THRUST WASHER-INPUT	21	1	50-004-1091			
	HEX CAPSCREW 5/16-18 X 1.5, GR8	22	6	01-150-1400			
	ROLLPIN-SECONDARY 3/16 X 7/8	23	3	01-153-0210			
	ROLLPIN-PRIMARY 1/8 X 1	24	3	01-153-0080			
	RETAINING RING (NO.N5100-206)	25	1	01-160-0250			
	LOCKWASHER 5/16 MED	26	6	01-166-0110			
	PIPE PLUG-MAG. 3/8 NPT-SOC HD	27	2	01-207-0070			
	GREASE FITTING (OPTIONAL)	28	(1)	01-215-0050			
	O-RING 167 MM X 3 MM	29	1	01-402-0560			
	SEAL-SHAFT	30	1	01-405-0550			
	AIR VENT 3/8 NPT (OPTIONAL)	35	(1)	01-216-0070			
	-	-	-	-	-	-	-



NOTE \* BEARING PRELOAD DETERMINES QUANTITY OF SHIMS.

SEAL KIT; P/N 20-016-0501; INCLUDES ITEMS 29 AND 30.

▷ FOR 20:1 RATIO, INPUT CODES 1, 4 AND 6 REQUIRE "INVERTED" RATIO CARRIER ASSEMBLIES.

ECN 1803  
X20B02-BE DATE 04-04-02

# 20P Double Stage Exploded View Drawing

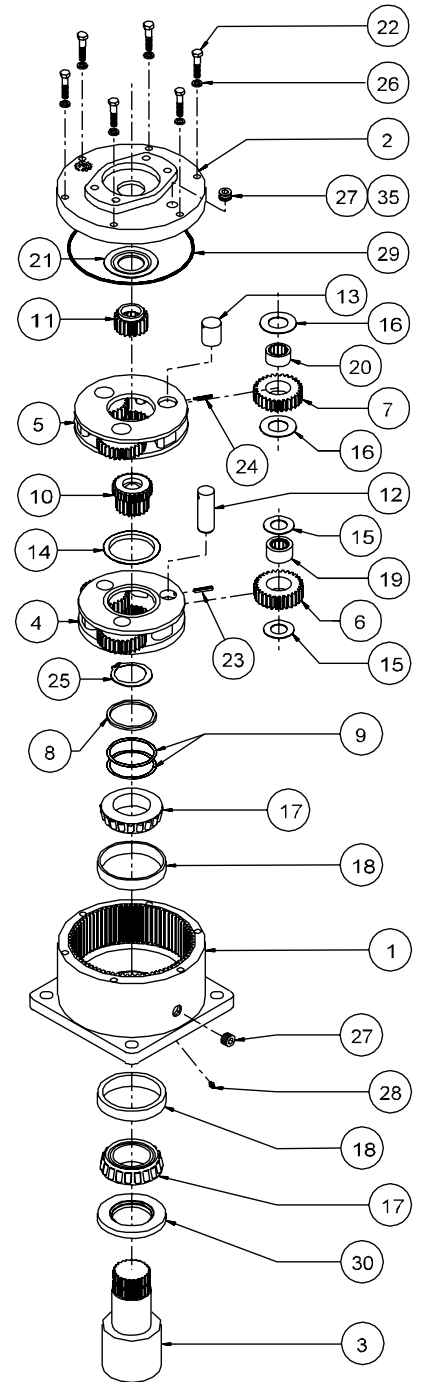
**MODEL P20**  
DOUBLE PLANETARY



EFFECTIVE  
FROM: S/N 16401 07-01-93  
TO: (CURRENT)

RATIO'S			
16.65:1 4.08 4.08	20.62:1 5.05 4.08	20.62:1 4.08 5.05	25.53:1 5.05 5.05
		INVERTED	

CODE	DESCRIPTION	ITEM	QTY.	PART NUMBER	PART NUMBER	PART NUMBER	PART NUMBER
	P20 CASE-SQUARE-DOUBLE PLT.(NO ZERK)	1	1	20-004-3064			
	P20 CASE-SQUARE-DOUBLE PLT. W/ZERK			20-004-3064Z			
	CP20 CASE-CUST.MTG PER CUSTOMER SPECS.			-	-	-	-
A	COVER-SAE 'A'			85-004-1513			
B	COVER-SAE 'B' 2-BOLT	2	1	85-004-1503			
C	COVER-SAE 'C' 4-BOLT			28-004-1013			
F1	SHAFT-1.5" KEYED			20-004-4122			
F2	SHAFT-2" KEYED	3	1	20-004-4112			
C1	SHAFT-CUSTOM PER CUSTOMER SPECS.			-	-	-	-
	CARRIER-SECONDARY	4	1	20-004-1282	20-004-1282	20-004-1292	20-004-1292
	CARRIER-PRIMARY	5	1	50-004-1082	50-004-1072	50-004-1082	50-004-1072
	PLANET GEAR-SEC.	6	3	20-004-1041	20-004-1041	20-004-1051	20-004-1051
	PLANET GEAR-PRI.	7	3	85-004-1031	85-004-1021	85-004-1031	85-004-1021
	SUPPORT WASHER	8	1	20-004-1031			
	SHIM	9	*	20-004-1091			
	SUN GEAR-SECONDARY	10	1	20-004-1332	20-004-1062	20-004-1072	20-004-1072
1	INPUT GEAR 21T,20/40 D.P.SPLINE			85-004-1402		85-004-1402	N/A
2	INPUT GEAR 13T,16/32 D.P.SPLINE			85-004-1102	85-004-1062		85-004-1062
3	INPUT GEAR SAE 1"-6B SPLINE			85-004-1122	85-004-1112		85-004-1112
4	INPUT GEAR 14T,12/24 D.P.SPLINE			85-004-1533		85-004-1533	N/A
5	INPUT GEAR 15T,16/32 D.P.SPLINE			85-004-1542	85-004-1422		85-004-1422
6	INPUT GEAR 1"DIA X .25" KEY			85-004-1582		85-004-1582	N/A
	PLANET SHAFT-SECONDARY	12	3	20-004-1081			
	PLANET SHAFT-PRIMARY	13	3	81-004-0071			
	THRUST WASHER-SEC.CUP	14	1	50-004-1011			
	THRUST WASHER-(SEC. PLANET GEAR)	15	6	85-004-1181			
	THRUST WASHER-(PRI. PLANET GEAR)	16	6	81-004-1561			
	BEARING CONE	17	2	01-102-0160			
	BEARING CUP	18	2	01-103-0160			
	BEARING-SEC.PLANET	19	3	01-105-0010			
	BEARING-PRI.PLANET	20	3	01-105-0410			
	THRUST WASHER-INPUT	21	1	50-004-1091			
	HEX CAPSCREW 5/16-18 X 1.5, GR8	22	6	01-150-1400			
	ROLLPIN-SECONDARY 3/16 X 7/8	23	3	01-153-0210			
	ROLLPIN-PRIMARY 1/8 X 1	24	3	01-153-0080			
	RETAINING RING	25	1	01-160-0250			
	LOCKWASHER 5/16 MED	26	6	01-166-0110			
	PIPE PLUG-MAG. 3/8 NPT-SOC HD	27	2	01-207-0070			
	GREASE FITTING (OPTIONAL)	28	(1)	01-215-0050			
	O-RING 167 MM X 3 MM	29	1	01-402-0560			
	SEAL-SHAFT	30	1	01-405-0610			
	AIR VENT 3/8 NPT (OPTIONAL)	35	(1)	01-216-0070			
-		-	-	-	-	-	-



NOTE \* BEARING PRELOAD DETERMINES QUANTITY OF SHIMS.  
SEAL KIT; P/N 20-016-0511; INCLUDES ITEMS 29 AND 30.

▷ FOR 20:1 RATIO, INPUT CODES 1, 4 AND 6 REQUIRE "INVERTED" RATIO CARRIER ASSEMBLIES.

ECN 1803  
X20PD2-BE DATE 05-8-00

**ESKRIDGE FINISHED PRODUCT  
LIMITED WARRANTY**

**1.1 Scope of Warranty Coverage.** Upon the terms and subject to the conditions set forth in this limited warranty:

(a) ESKRIDGE (referred to herein as “**ESKRIDGE**” or the “**Manufacturer**”) warrants to each initial end user customer (a “**Purchaser**”) of a new finished product together with any accessories manufactured and sold directly from ESKRIDGE (the “**Product**”) that the Product shall be free from defects in material and workmanship, under normal working and service conditions, for a period of eighteen (18) months from the date the Product is shipped from ESKRIDGE. (the “**Warranty Term**”). A Purchaser shall be eligible for an additional eighteen (18) months of coverage in addition to the Warranty Term (also referred to as the “**Standard (+) PLUS benefit**”) only if the Purchaser (i) complies with Section 1.2(a) and (ii) registers the Product during the Warranty Term at [myproduct.eskridgeinc.com](http://myproduct.eskridgeinc.com).

(b) Notwithstanding the foregoing, this warranty does not cover components damaged by accident, abuse, misuse, neglect, untrained operators, collision, overloading, modification, disassembly, rework, misapplication, improper installation, lack of lubrication or maintenance, or improper service. This warranty does not cover the paint or material finish, removal or reinstallation of the Product, or normal wear and tear and loss of functionality due to aging of the Product (which may include but is not limited to bearings, bushings, seals, O-rings, gaskets, brake material, motor brushes, electrical cables and more).

**1.2 Eligibility of Warranty Coverage.**

(a) A Purchaser shall be eligible for warranty coverage under this Limited Warranty during the Warranty Term only if:

(i) Prior to placing a Product in service, and throughout use of the Product during the Warranty Term, the Purchaser provides (or causes to be provided) proper storage such that foreign objects (e.g. rain or debris) cannot enter any Product through entry ports which are normally closed during operation.; and

(ii) The Purchaser maintains, or causes to be maintained, the Product according to commercially reasonable standards and utilizes the Product for the purposes for which it was created; and

(iii) No repairs or alterations have been made by any party other than ESKRIDGE, including Purchaser, unless otherwise authorized in writing by ESKRIDGE.

**1.3 Transferability of Warranty.**

(a) This warranty is transferable only from the Purchaser to the first subsequent transferee (the “**Transferee**”) of the Product from Purchaser upon (i) written notification to ESKRIDGE and (ii) registration of the transfer, both within 30 days of such Product transfer.

(b) Upon satisfaction of transfer requirements set forth in Section 1.3(a), the Transferee shall succeed to all the rights and obligations of the Purchaser set forth in this Limited Warranty.

**1.4 Certain Limitations on Scope of Warranty Service.**

(a) Any obligation of ESKRIDGE under this warranty, statutory or otherwise, is limited to the repair of the Product, at its factory or Authorized Service Centers. Notwithstanding the foregoing, if field service or repair is performed by ESKRIDGE at the request of the Purchaser and no defect is found with material or workmanship of the Product, the Purchaser shall compensate ESKRIDGE for its time and expenses within thirty (30) days of delivery of an invoice relating to the same. If repair is determined by ESKRIDGE in its sole, absolute and uncontrolled discretion to be impossible or impractical, then ESKRIDGE may satisfy this warranty by replacing the Product. ESKRIDGE will not provide any cash payment or credits for defective materials or workmanship.

(b) Purchaser shall be responsible for any and all freight charges for any Product receiving warranty service under this limited warranty. Any travel time, transportation charges, freight charges, or similar costs incurred by ESKRIDGE in connection with the replacement or repair of defective parts, shall, be the responsibility of the Purchaser. If applicable, ESKRIDGE shall invoice Purchaser for the total amount of such charges within sixty (60) days of fulfilling its duties under this warranty, payable within thirty (30) days of delivery of such invoice. In no event shall ESKRIDGE be liable for bills for service, labor or other expenses that have been incurred by the Purchaser without approval or prior authorization by ESKRIDGE for inspection, maintenance, or repair of the Product.

(c) If a Product is found to be operable upon inspection, the Product, at Purchaser's election, may be either (1) returned to the Purchaser with a service charge from ESKRIDGE for inspection, cleaning, and routine replacement of all rubber components and any other parts that show wear; or (2) ESKRIDGE can dispose of the product safely.

**1.5 Limitations of Liability.** ESKRIDGE shall in no event be liable for punitive, special or consequential damages relating to the Product or this Warranty. ESKRIDGE makes no warranty in respect to third-party accessories, upgrades, or additions to the Product.

**1.6 Improving Product.** ESKRIDGE reserves the right to improve the Product through changes in design or materials as it may deem desirable or necessary without being obligated to incorporate, upgrade, or otherwise modify previously manufactured products.

**1.7 Limitations of Warranty.**

(a) THE WARRANTY SET FORTH ABOVE IS THE ONLY EXPRESS WARRANTY. ESKRIDGE HEREBY DISCLAIMS AND EXCLUDES ANY OTHER EXPRESS, IMPLIED, OR STATUTORY WARRANTIES, ARISING BY OPERATION OF LAW, COURSE OF DEALING, COURSE OF PERFORMANCE, USAGE, OF TRADE, OR OTHERWISE, INCLUDING, WITHOUT LIMITATION, ANY WARRANTIES OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, AND INTELLECTUAL PROPERTY RIGHTS OF A THIRD PARTY.

(b) ANY IMPLIED WARRANTY WHICH BY LAW MAY NOT BE EXCLUDED IS LIMITED IN DURATION TO ONE (1) YEAR FROM THE DATE OF ORIGINAL RETAIL PURCHASE OF THE PRODUCT.

(c) This warranty gives you specific legal rights, and you may also have other rights which vary from jurisdiction to jurisdiction.

(d) This warranty is valid only in the U.S.A. and Canada. For warranty outside the U.S.A. and Canada contact your nearest Eskridge Distributor.

**1.8 No Modifications to Warranty.** No ESKRIDGE dealer, distributor, agent or employee is authorized to make any modification, extension or addition to this warranty.

**1.9 How to Apply for Warranty Coverage.**

All claims are handled by contacting your nearest Eskridge Distributor. For questions, please contact customer support: [eskcustomersupport@ramseyindustries.com](mailto:eskcustomersupport@ramseyindustries.com).

Visit [Dealer Locator - Eskridge](#) for Eskridge Distributor locations and contact information.

Additional warranty, service support, product information, and parts information can be found on [www.eskridgeinc.com](http://www.eskridgeinc.com).