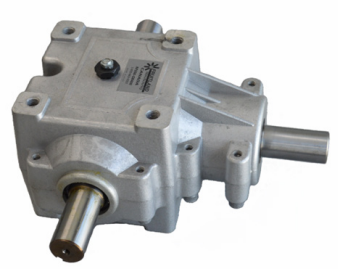
FRUITLAND

324 Leaside Avenue
Stoney Creek, ON Canada L8E 2N7
Tel: 905-662-6552 / TF: 1-800-663-9003
Fax: 905-662-5412

www.fruitlandmanufacturing.com

RIGHT ANGLE GEAR BOX

RF500-GB400
1 TO 1 GEAR BOX



Specifications:

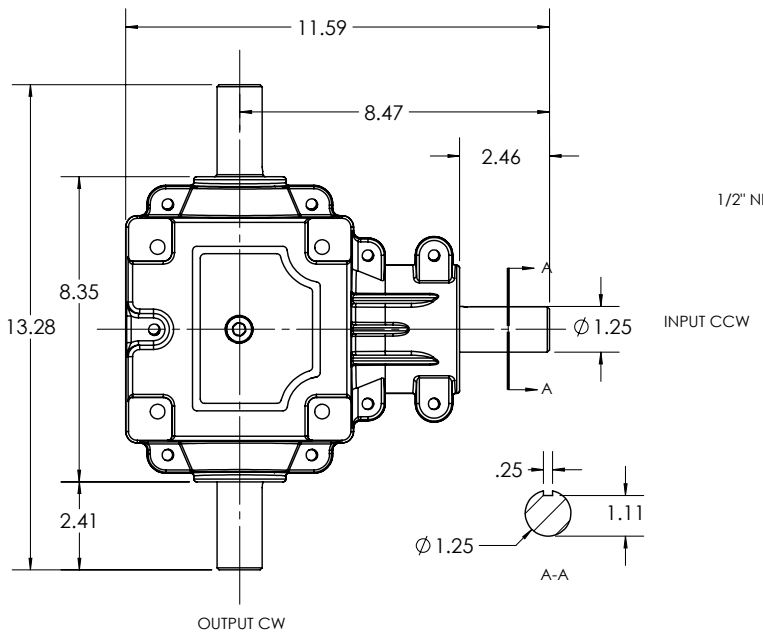
- Ratio 1:1
- Input 1400 RPM Max, 75 HP Max
- Oil capacity : .775 L, (26.2 oz)
- Two-piece aluminum housing for high strength, corrosion resistance and thermal capacity
- Weight: 30 Lbs.

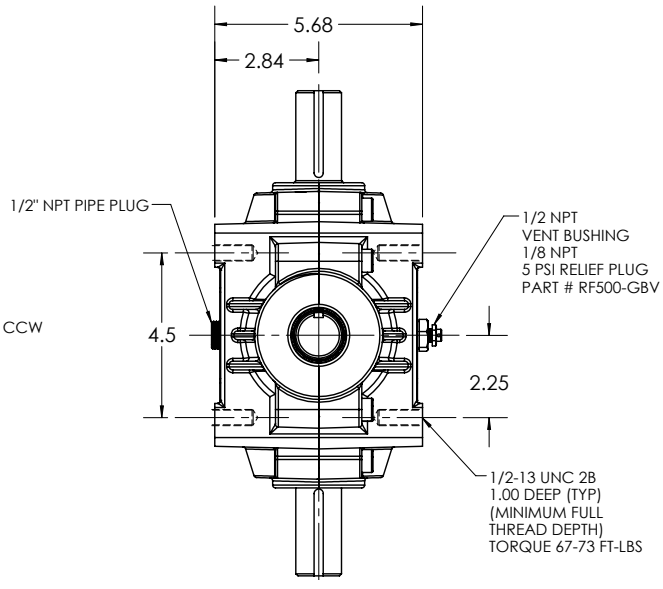
Lubrication:

All gear drives are factory filled to the correct amount of oil. Shaft bearings are splash lubricated and partially submerged in oil when the gear drive is mounted horizontally. In general, the oil level should be approximately half the depth of the gear drive (to parting line) for horizontal mounting, or to the shaft centerlines, if mounted other than horizontally.

Lubricants:

- Mobilube HD 80W-90 or equivalent in an ambient temp. 15° to 125° F and oil temp. 200°F
- Mobilube synthetic SHC 75W-90 or equivalent in an ambient temp. below 15°F or operating continuously above 200°F. Do not combine synthetic and non -synthetic oil





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WARNING

Disconnect power prior to any maintenance and do not bypass or inactivate any safety or protective device. Lock out and tag the power supply to prevent unexpected application of power.

Maintenance:

Routinely inspect mounting bolts, couplers, or other power transmitting devices to ensure all parts are firmly anchored. Keep shafts and vent plugs (when included) clean to prevent foreign particles from entering seals or housing. Inspect daily for any oil leaks and any unusual noises. Inspect weekly for end play in shafts. Inspect belt drive tension after the first ten hours of operation and periodically thereafter.

Oil Change:

Check the oil level every 24 hours of operation. Change the oil when the gear drive has been in service for 50 hours. Routine oil change intervals will vary for each particular installation depending on the severity of the environment. **Normal changes should occur between 250 and 1000 hours of operation.** The longest life at continuous service will be realized when the oil temperature does not exceed 200°F. For oil substitutions, or for high input seeds, contact Fruitland Manufacturing.

Do not change or add oil while the gear drive is running. Damage to the gear drive or injury to personnel may result. The gear drive housing, oil, plugs, and associated components may reach high temperatures and cause severe burns. Use extreme care when servicing the gear drive.

Long term storage or inactivity:

When a gear drive is stored, prior to initial installation, or following removal from sevice, the following steps are recommended:

- Fill completely with oil. Attach a prominent notice that the gear drive must be drained and
- refilled to the proper level prior to start-up.
- Apply a rust preventative to the externally exposed shafts.
- Store the gear drive in a temperature and humidity controlled area.
- Periodically, rotate the shafts by hand.

If the gear drive is in service but inactive for 60 days or more, periodically rotate the shafts by hand and check the oil level prior to start-up.

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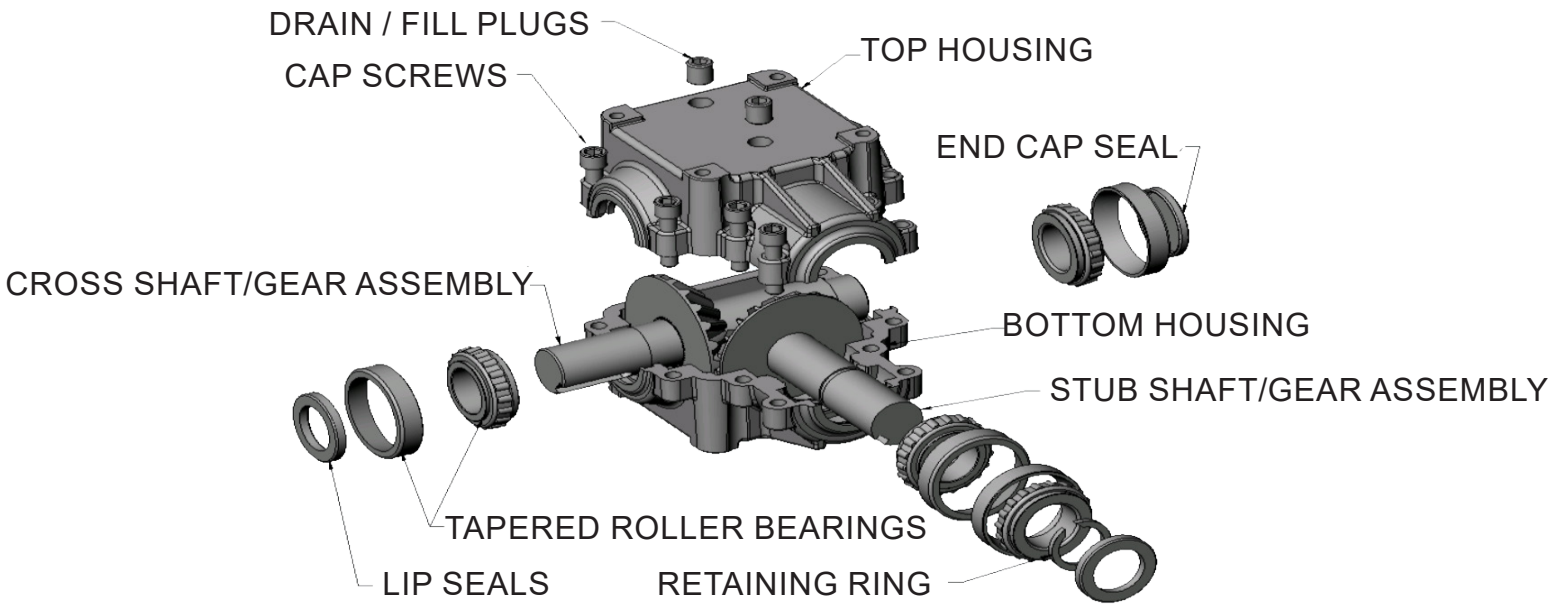
TROUBLESHOOTING



Symptom	Probable Cause	Remedy
Breather leaking	Incorrect oil level	Check oil level
	RPM too high	Reduce RPM
	Unit running hot	Provide addtional cooling
Unit running hot	Incorrect oil level	Check oil level
	Inadequate air flow	Provide additional cooling
	Excessive RPM or load	Change to synthetic oil
	Contaminated oil	Replace oil
	Failing bearings	Replace bearings
Unusual noise	Gear mesh changed	Inspect driveline
	Excessive external load	Inspect belt tension
	Failing bearings or gears	Replace bearings or gears
Oil leaking	Failing seals	Replace seals
	Mating surfaces	Rebuild gear drive
Vibration	Loose mounting bolts	Inspect / tighten
	Loose couplers, pulleys	Inspect / tighten
	Failing bearings or gears	Replace bearings or gears
	Driveline misalignment	Correct misalignment