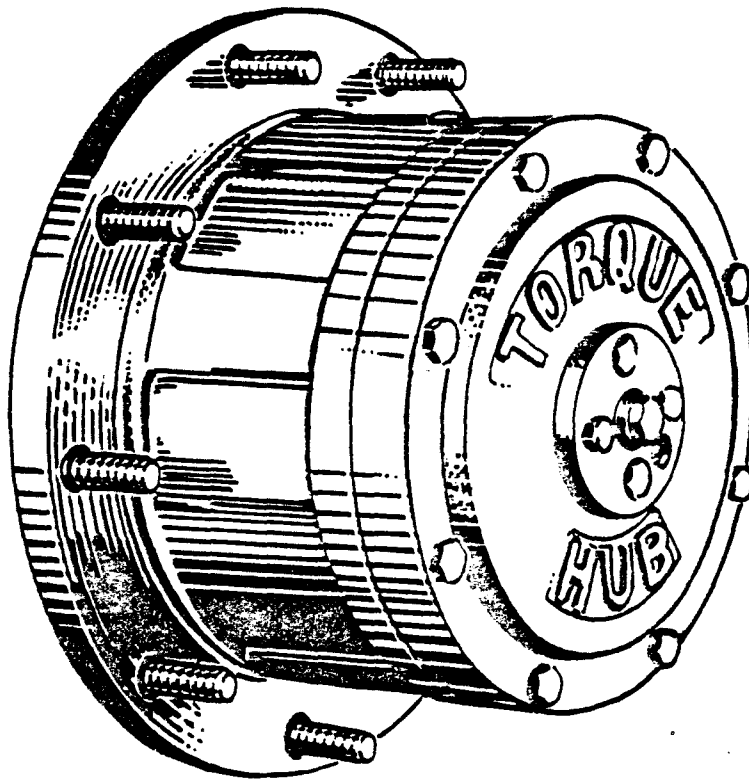


MODEL S10A



FOR MATERIAL HANDLING EQUIPMENT, FARM MACHINERY, ROAD EQUIPMENT, MINING MACHINERY, ETC.

Fairfield Manufacturing Company, Inc.  
South Concord Road, Lafayette, Indiana 47902, U.S.A. 317/474-3474

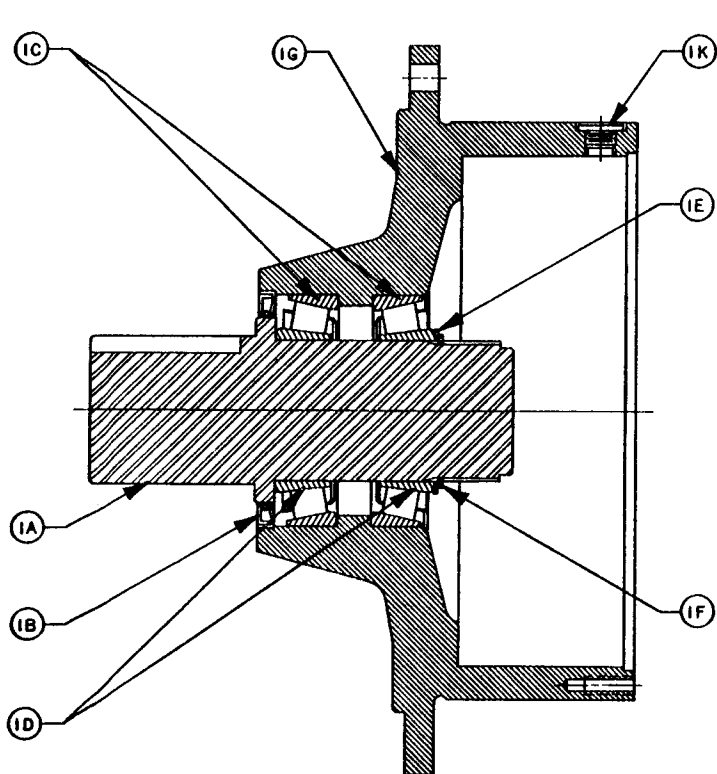
# Fairfield

THE  
DRIVE  
PEOPLE

02-27-81

 ASSEMBLY NO. - S10A64470  
 SHAFT OUTPUT ASSY

ITEM	PART NO.	QTY.	DESCRIPTION	STOCK FACTOR
1	S10A6	1	HUB-SHAFT SUB-ASSY	
	1A	1	OUTPUT SHAFT	1
	1B	1	SEAL	5
	1C	2	BRG. CUP (JHM522610)	6
	1D	2	BRG. CONE (JHM522649)	6
	1E	1	BEARING SHIM	3
	1F	1	RETAINING RING	5
	1G	1	HUB	1
	1K	1	PLUG	2
	1L	1	PIPE PLUG	2
2	1040C0106	1	INTERNAL GEAR	2
3	1020C004	1	CARRIER ASSEMBLY	2
	3A	1	CARRIER	1
	3B	3	ROLL PIN	3
	3C	6	BRG. CUP (JM205110)	18
	3D	6	BRG. CONE (JM205149)	18
	3E	3	PLANET SHAFT	3
	3F	3	CLUSTER GEAR	6
	3G	3	SPACER	3
	3H	3	RETAINING RING	15
4	105000114	1	RING GEAR	2
5	1094C001	2	'O' RING	10
6	10500404	1	COVER	1
6I	950104	2	MAGNETIC PIPE PLUG	4
8	3200304	1	THRUST WASHER	1
13	1010C0218	1	INPUT GEAR	2
15	10200301	4	THRUST WASHER	4
16	10200303	2	THRUST BEARING	2
17	930106	16	BOLT	16
18	10930202	4	SHOULDER BOLT	12
22	96C003	4	LOCK WASHER	4
23	96C001	16	LOCK WASHER	16
24	901202	1	ID PLATE	
25	930301	4	DRIVE SCREW	



1/9/74

TORQUE-HUB  
SERVICE LITERATURE

Rev. A 9-26-75

S10A

70:1, 124:1 Reduction (Last (2) Digits of Model No.)

ASSEMBLY PROCEDURE FOR MAJOR ASSEMBLY

1. Start with Hub-Shaft Sub-Assembly (1) with large open end up.
2. Assemble Internal Gear (2) onto Shaft of Hub-Shaft Sub-Assembly (1).
3. Place Thrust Washer (15), Thrust Bearing (16), and Thrust Washer (15), respectively onto Shaft pilot of Hub-Shaft Sub-Assembly (1).
4. Set Input Gear (13) onto approximate center of Shaft of Hub-Shaft Sub-Assembly (1).
5. Put "O" Ring (5) in Hub counterbore of Hub-Shaft Sub-Assembly (1). Use petroleum jelly or grease to hold "O" Ring in place.
6. Place Carrier Sub-Assembly (3) on a flat surface with Large Gears up. Find marked (punch mark) teeth on the Large Gears. Rotate until the marks are in a 12 o'clock (straight-up) position.
7. Place Ring Gear (4) over Large Gears of Carrier Sub-Assembly (3).
8. Holding Ring Gear (4) into mesh with Large Gears. Pick up Carrier Sub-Assembly (3) and place Small Gears of Carrier Sub-Assembly (3) into mesh with Internal Gear (2) and also working Large Gears into mesh with Input Gear (13). Rotate Ring Gear (4) until marked hole is located over one of the counterbored holes in Hub of Hub-Shaft Sub-Assembly (1).
9. Place Thrust Washer (8) into Cover (6) counterbore. Hold in place with petroleum jelly or grese.
10. Place Thrust Washer (15) and Thrust Bearing (16) into counterbore of Carrier Sub-Assembly (3).
11. Place Thrust Washer (15) onto pilot diameter of Cover (6). Hold in place with petroleum jelly or grease.
12. Put "O" Ring (5) into Cover (6) counterbore. Use petroleum jelly or grease to hold in place.
13. Place Cover (6) onto Ring Gear (4).
14. Secure Cover (6) and Ring Gear (4) into place with Bolts. Use four Shoulder Bolts (18) with Lockwashers (22) for counterbored holes in Hub of Hub-Shaft Sub-Assembly (1). Use Bolts (17) with Lockwashers (23) for remaining holes. Torque all Bolts to 100-110 ft.-lbs.

ASSEMBLY PROCEDURE FOR HUB-SHAFT SUB-ASSEMBLY

1. Press Bearing Cups (races) (1C) into Hub (1G).
2. Press Bearing Cone (1D) onto Output Shaft (1A).

TORQUE-HUB  
SERVICE LITERATURE (CONTINUED)

PAGE 2

S10A  
70:1, 124:1

3. Place Output Shaft (1A) and Bearing Cone (1D) into Hub (1G) and Bearing Cup (race) (1C).
4. Press Bearing Cone (1D) onto Output Shaft (1A), and against Bearing Cup (1C). (Support the Shaft while pressing Bearing Cone (1D) onto Shaft (1A).
5. Place Bearing Shim (1E) onto Output Shaft (1A) and against Bearing Cone (1D).
6. Place Retaining Ring (1F) on Output Shaft (1A) groove. Be sure Ring is completely in groove.
7. Press the Seal (1B) into Hub (1G) and over Output Shaft (1A).
8. Screw "O" Ring Plug (1K) into Hub (1G) outside diameter.
9. This completes the Hub-Shaft Sub-Assembly. The Output Shaft (1A) should now rotate freely with respect to the Hub (1G). The Seal will cause a small amount of drag but if rotation seems excessively tight, tap the outside of the Output Shaft (1A) until it rotates freely.

ASSEMBLY PROCEDURE FOR CARRIER SUB-ASSEMBLY

1. Press Bearing Cups (3C) into Cluster Gear (3F).
2. Set Carrier (3A) on edge so that six small holes and two center holes are in a horizontal plane.
3. Place Bearing Cones (3D) into Bearing Cups (3C).
4. While holding Bearing Cones (3D) in Cluster Gear (3F), pick up Cluster Gear (3F) and place it between two of the off center holes in Carrier (3A) with the small Gear being on the same side as the pin hole in Carrier (3A) wall.
5. While holding Cluster Gear (3F) in place slide Planet Shaft (3E) thru Carrier (3A) holes and thru the Bearing Cones (3D). Larger end of Planet Shaft (3E) should be on pin hole side of Carrier (3A).
6. Slide Spacer (3G) onto small end of Planet Shaft (3E).
7. Place Retaining Ring (3H) into Planet Shaft (3E) groove and against Spacer (3G).
8. Put Roll Pin (3B) thru pin hole in Carrier (3A) wall and into slot in Planet Shaft (3E). This keeps Planet Shaft (3E) from rotating.
9. Repeat these steps with two more Cluster Gears (3F) to complete Carrier Sub-Assembly.