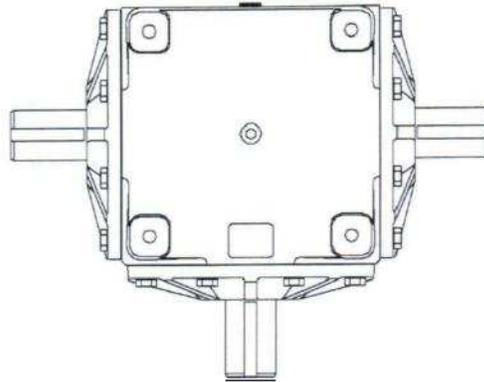
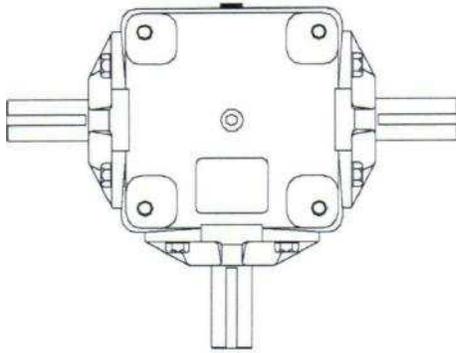


**INSTALLATION - OPERATION AND  
MAINTENANCE INSTRUCTIONS  
FOR STRAIGHT BEVEL GEAR  
RC-18, RC-38, RC-99 & RC-204  
MITRE GEAR BOXES**



**WARNING**

The gearbox must be filled to proper level with recommended lubricant before operation.

**INSTALLATION**

- 1.) Check relative rotation of shafts to suit application before installing.
- 2.) Remove plastic protective plugs from threaded mounting holes. Mount gearbox securely on a flat, rigid surface.
- 3.) Shafts should be accurately aligned with connecting devices.
- 4.) Components assembled to the projecting shafts should be installed as close to housing as possible and not so tightly fitted that assembly forces required could damage the drive.
- 5.) Standard drives should be mounted with all shafts horizontal.
- 6.) Install vented filler plug (with sintered bronze insert) into pipe-tapped hole at top surface of housing and solid plug in remaining pipe tapped holes.

**OPERATION**

- 1.) For all 1:1 ratio gearboxes, do not exceed max. Rpm's listed in the chart below

Model Number	Maximum RPM
RC-18	1800
RC-38	1400
RC-99	1000
RC-204	800

- 2.) The thermal capacity of the gearbox is the maximum capacity at which the gearbox will operate without exceeding an operating temperature of 220 °F. Under certain conditions of high load and high rpm, the thermal capacity can be less than the mechanical capacity. If 220 °F is exceeded, please contact the factory.

## LUBRICATION

- 1.) Remove vented filler plug and level plug (where provided) at horizontal shaft centerline.
- 2.) Fill gearbox with **AGMA 5EP** oil until lubricant flows out of the level plughole.
- 3.) Gearboxes that are not supplied with an oil level plug should be filled with the specified quantity of recommended lubricant as listed in the chart below.

RC-18. . .16 oz.	RC-38. . .24 oz	RC-99. . .72oz	RC-204. . .128oz
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## RELUBRICATION

Service life and efficiency of gears and bearings will be affected by oxidation or contamination of the lubricating oil. Improved performance will be obtained by periodic relubrication in accordance with the following recommendations:

- 1.) After an initial operating period of approximately 500 hours or 6 months, the housing should be completely drained, preferably while warm. Refill housing to proper level with fresh oil.
- 2.) Under normal conditions, the drive should be relubricated at intervals of approximately 2500 hours of operation or every six months (whichever occurs first).

Note: If the unit has a grease zerk, it should be regreased at these times.

## CAUTION

Relubricate more frequently if unit is operated in abnormally high ambient temperatures or unusually contaminating atmosphere.

## MAINTENANCE

Gear lash and endplay should be checked every time the drive is relubricated. If excess lash or endplay is observed, the gearbox should be inspected. Adjustment or factory replacement parts may be the answer. The lash and endplay can be adjusted as described in the Assembly Instructions for the unit.



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