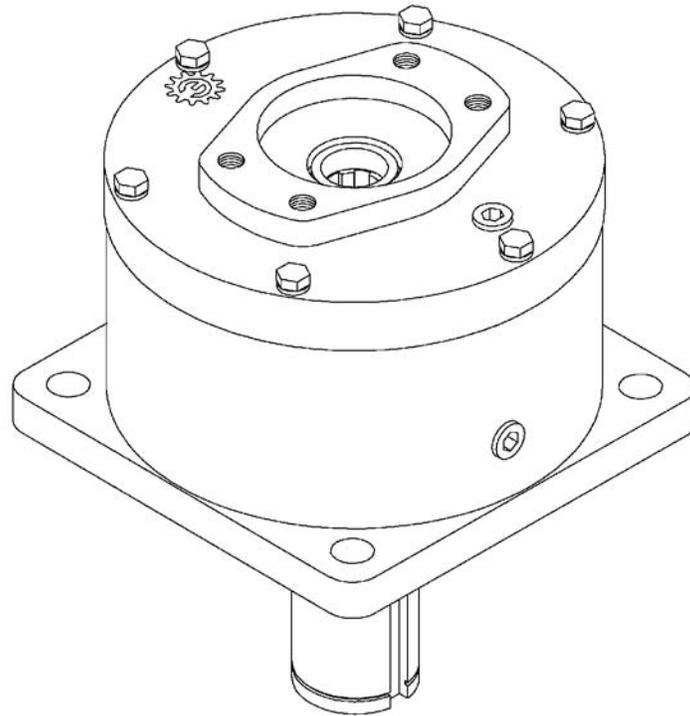
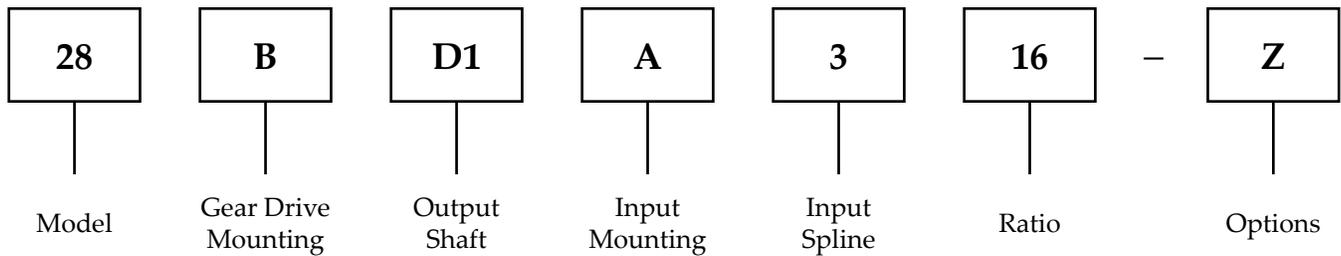




ESKRIDGE



Example Part Number



THIS SERVICE MANUAL IS EFFECTIVE
FROM: S/N 16401, JULY 1993
TO: CURRENT
REF: SM28BPD2-B

28B & 28P MODEL SERVICE MANUAL

SINGLE & DOUBLE STAGE PLANETARY GEAR DRIVE

This manual will assist in disassembly and assembly of the 28B and 28P Model 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 89/90 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>Ratio</u> | <u>Oil Capacity</u> | <u>Oil Level</u> |
|---------------------------|--------------|-------------------------|--|
| Horizontal Shaft | Single | 1.0 pint / 0.5 liters | To horizontal centerline of gear drive |
| Vertical Shaft | Single | 1.75 pints / 0.9 liters | To midway on upper/primary gear set |
| Horizontal Shaft | Double | 1.25 pints/ 0.6 liters | To horizontal centerline of gear drive |
| Vertical Shaft | Double | 2.25 pints/ 1.1 liters | To midway on upper/primary gear set |



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

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Unit Disassembly Procedure

(Refer to exploded view drawings on Pages 6–9)

There are two unit types in the B28/P28 series: single planetaries without a primary carrier and double planetaries with a primary carrier. Steps marked with an asterisk (*) apply only to the double planetary model.

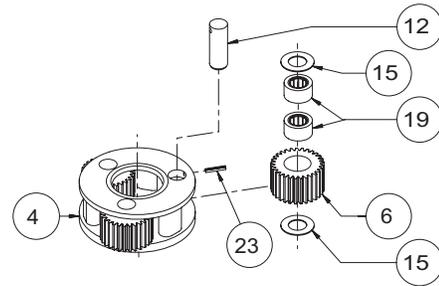
All parts should be carefully inspected as they are removed from unit. Scribe across mounting case (1) and cover (2) joint on outside of gear drive to assure proper orientation of oil fill and drain plugs, motor mounting, etc., as unit is reassembled.

- 1) Remove hydraulic motor and Eskridge brake from gear drive; 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 unit and remove input gear (11), input thrust-washer (21) and *thrust bearing (33).
- *4) Primary ring gear (31) and 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 the output shaft spline.

The unit is now disassembled into groups of parts and/or sub-assemblies. The area(s) 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.

Secondary Planet Carrier Subassembly

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



Disassembly

Rotate planet gears (6) to check for any abnormal noises or roughness in the planet bearings (19). 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 roll pins (23) completely into the planet shafts (12) using a 3/16" diameter punch. Press planet shafts out of carrier (4).

NOTE: Support only the carrier (4) while pressing out planet shafts.

- 2) Remove planet gears (6) and planet washers (15) from carrier (4).
- 3) If any of the planet bearings (19) need replacing, press them out of the planet gears.
- 4) Check planet shafts (12) 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 3/16" diameter punch, drive roll pins out of planet shafts.
- 6) If required, press new planet bearings (19) into planet gears.
- 7) With a planet washer (15) on both sides of planet gear (6) and bearing (19) installed, slide gear into carrier (4). Insert planet shaft (12) through the carrier, planet gear and washers. During planet shaft installation, align roll pin hole in planet shaft with chamfered edge facing out, to the roll pin hole in outside diameter of carrier.

NOTE: Inserting a 3/16" diameter punch in the planet shaft roll pin hole will help in the alignment of holes between planet shaft and carrier during Step 7.

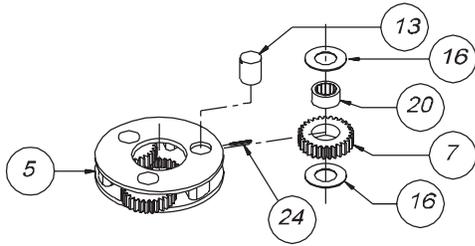
- 8) Once holes are properly aligned, drive a roll pin (23) through primary carrier and into planet shaft to retain parts. Use a drift to drive roll pin flush to carrier and to prevent striking planet gear teeth.

Repeat the same procedure for remaining gears.

*Step applies only to double planetary models.

*Primary Planet Carrier Subassembly

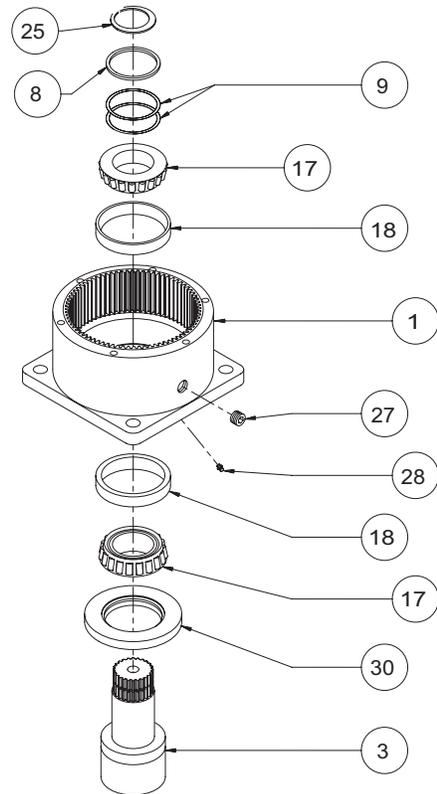
(Items 5, 7, 13, 16, 20 & 24)



Follow the same procedure as that for the Secondary Planet Carrier Subassembly, except substitute item numbers as indicated: primary carrier (5), primary planet gear (7), primary planet shaft (13), primary planet washer (16), primary planet bearing (20) and primary roll pin (24). Note that roll pins are 1/8" in diameter.

Case Subassembly

(Items 1, 3, 17, 18, 27, 28 & 30)



Disassembly

- 1) 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 (25). Remove retaining ring 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.

- 2) With output shaft down through center hole 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.

- 3) If outer bearing cone (17) needs replacing, it will need to be pressed off of output shaft (3). Also inspect inner bearing cone (17), which can be found 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 (1) 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.
- 4) Lubricate inner lip of new shaft seal (3) and turn so that open side of seal (30) is up. Slide seal onto output shaft until it fits snug over shaft seal diameter.
- 5) With small end of bearing cone pointing upward, place outer bearing cone (17) onto the internal end of the output shaft

*Step applies only to double planetary models.

(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. Do not press on outer roller cage, or it will damage bearing.

- 6) Inspect inner and outer bearing cups (18). If cups are damaged, the cups and case (1) may need replacement. Contact Eskridge for further details.
- 7) Clean all foreign material from magnetic oil plug (27) located in side of mounting case (1). Add a small amount of pipe thread compound to pipe plug before installing back into case.

Reassembly

- 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 pointing 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.

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.

- 4) Stand unit assembly upright on output shaft (3).
- 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 of shims that were removed from unit during disassembly should be returned. Follow shims with support washer (8). Install 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.

***Step applies only to double planetary models.**

Unit Reassembly

(Refer to exploded drawings on Pages 6–9)

- 1) Start with case assembly positioned shaft down.
 - 2) Place thrust bearing (32) on internal end of the shaft. Install secondary carrier (4) assembly into unit; carrier assembly should be installed with hub side down (24 tooth spline). Rotate carrier assembly back and 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).
 - *3) Install sun gear (10) in secondary carrier. Install primary carrier assembly in unit so that its splined hub meshes with sun gear.
 - 4) Install input gear (11) in unit. Refer to the exploded view drawing for proper orientation.
 - *5) Place thrust bearing (33) over input gear (11).
 - 6) Place input thrust washer (21) over input gear (11).
 - *7) Grease a new o-ring (29) and install in bottom (internal stepped) end of ring gear (31). 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. Place ring gear over primary carrier onto top of case (1) so that it meshes with planet gears (7).
 - 8) Fill unit with proper level of a GL-5 grade EP 80-90 gear oil; see Page 2 for details. Proper oil level will measure to middle of primary planet gears.
 - 9) Grease 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 9.**
- 10) Install all six of the 5/16 lockwashers (26) and the 5-/16 hex capscrews (22) and torque them to 20 ft-lbs.

THE GEARBOX IS NOW READY TO USE.

Exploded View Drawing – 28B, Single Stage

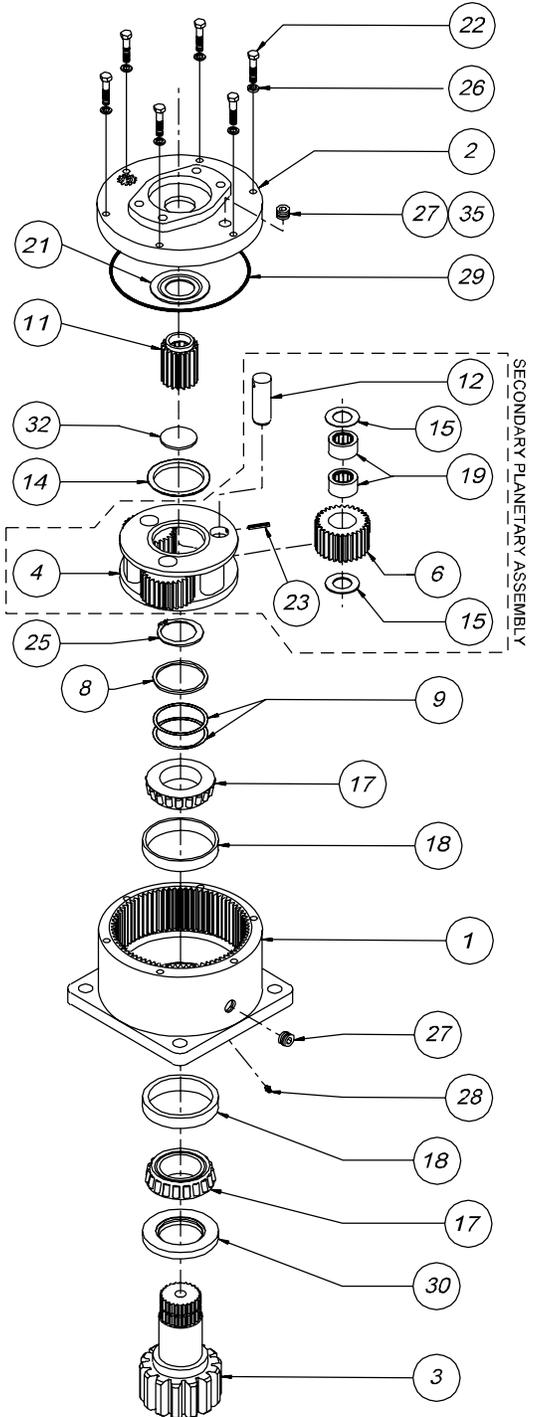
| RATIO'S | |
|-------------|-------------|
| 4:1 4.08 | 5:1 5.05 |

MODEL B28
SINGLE PLANETARY



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

| PART NUMBER | PART NUMBER | QTY. | ITEM | CODE | DESCRIPTION |
|-------------|--------------|-------------|------|------|---------------------------------------|
| ← | 28-004-3504 | 1 | 1 | | B28 CASE-SQUARE- (NO ZERK) |
| ← | 28-004-3504Z | | | | B28 CASE-SQUARE- W/ZERK |
| ← | - | | | | C28 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 |
| ← | 20-004-4022 | 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. |
| ← | 50-004-1062 | 1 | 4 | | CARRIER-SECONDARY |
| ← | 85-004-1051 | 3 | 6 | | PLANET GEAR-SEC. |
| ← | - | - | - | 7 | PLANET GEAR-PRI. |
| ← | 20-004-1031 | 1 | 8 | | SUPPORT WASHER |
| ← | 20-004-1091 | * | 9 | | SHIM |
| ← | 85-004-1552 | N/A | | 1 | INPUT GEAR 21T,20/40 D.P.SPLINE |
| ← | 85-004-1382 | 85-004-1392 | | 2 | INPUT GEAR 13T,16/32 D.P.SPLINE |
| ← | 85-004-1272 | 85-004-1262 | 1 | 11 | INPUT GEAR SAE 1"-6B SPLINE |
| ← | 85-004-1292 | N/A | | 4 | INPUT GEAR 14T,12/24 D.P.SPLINE |
| ← | 85-004-1562 | 85-004-1572 | | 5 | INPUT GEAR 15T,16/32 D.P.SPLINE |
| ← | 85-004-1592 | N/A | | 6 | INPUT GEAR 1"DIA X .25" KEY |
| ← | 71-004-0121 | 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 | 6 | 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-SOG 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 |
| ← | 28-004-1021 | 1 | 32 | | THRUST BEARING |
| ← | 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.

E.C.N. 2197
X28BD1-BD DATE: 04-15-04

Exploded View Drawing – 28B, Double Stage

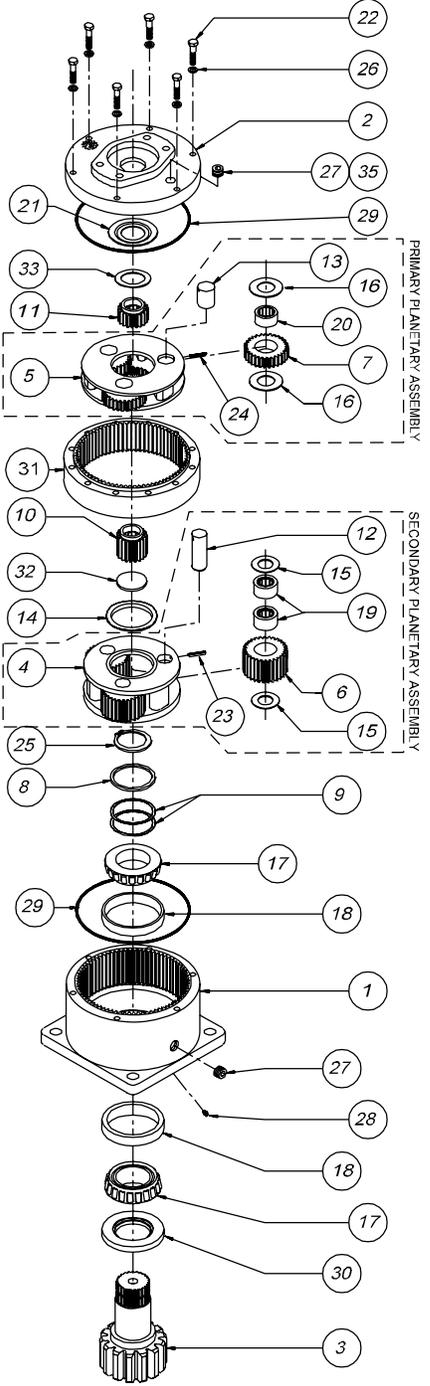
MODEL B28
DOUBLE PLANETARY



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 INVERTED | 25.53:1 5.05 5.05 |

| CODE | DESCRIPTION | ITEM | QTY. | PART NUMBER | PART NUMBER | PART NUMBER | PART NUMBER |
|------|---------------------------------------|------|------|--------------|-------------|-------------|-------------|
| | B28 CASE-SQUARE- (NO ZERK) | 1 | 1 | 28-004-3504 | | | |
| | B28 CASE-SQUARE- W/ZERK | | | 28-004-3504Z | | | |
| | C28 CASE-CUST.MTG PER CUSTOMER SPECS. | | | - | - | - | - |
| A | COVER-SAE 'A' | | | 85-004-1513 | | | |
| B | COVER-SAE 'B' 2-BOLT | 2 | 1 | 85-004-1593 | | | |
| 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 | 50-004-1062 | 50-004-1062 | 50-004-1052 | 50-004-1052 |
| | CARRIER-PRIMARY | 5 | 1 | 50-004-1082 | 50-004-1072 | 50-004-1082 | 50-004-1072 |
| | PLANET GEAR-SEC. | 6 | 3 | 85-004-1051 | 85-004-1051 | 85-004-1041 | 85-004-1041 |
| | 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 | 85-004-1412 | 85-004-1092 | 85-004-1072 | 85-004-1072 |
| 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"-8B SPLINE | | | 85-004-1122 | 85-004-1112 | | 85-004-1112 |
| 4 | INPUT GEAR 14T, 12/24 D.P.SPLINE | 11 | 1 | 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 | 71-004-0121 | | | |
| | 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 | 6 | 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 2.75 GR8 | 22 | 6 | 01-150-1490 | | | |
| | 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 | 2 | 01-402-0560 | | | |
| | SEAL-SHAFT | 30 | 1 | 01-405-0550 | | | |
| | RING GEAR | 31 | 1 | 85-004-1313 | | | |
| | THRUST BEARING | 32 | 1 | 28-004-1021 | | | |
| | THRUST BEARING | 33 | 1 | 01-112-0230 | | | |
| | AIR VENT 3/8 NPT (OPTIONAL) | 35 | (1) | 01-216-0070 | | | |



NOTE ★ BEARING PRELOAD DETERMINES QUANTITY OF SHIMS.
SEAL KIT; P/N 20-016-0521; INCLUDES(2) ITEM 29 AND (1) ITEM 30.
▷ FOR 20:1 RATIO, INPUT CODES 1, 4 AND 6 REQUIRE "INVERTED" RATIO CARRIER ASSEMBLIES.

ECN 2197
X28B02-BF DATE: 04-15-04

Exploded View Drawing – 28P, Single Stage

MODEL P28
SINGLE PLANETARY

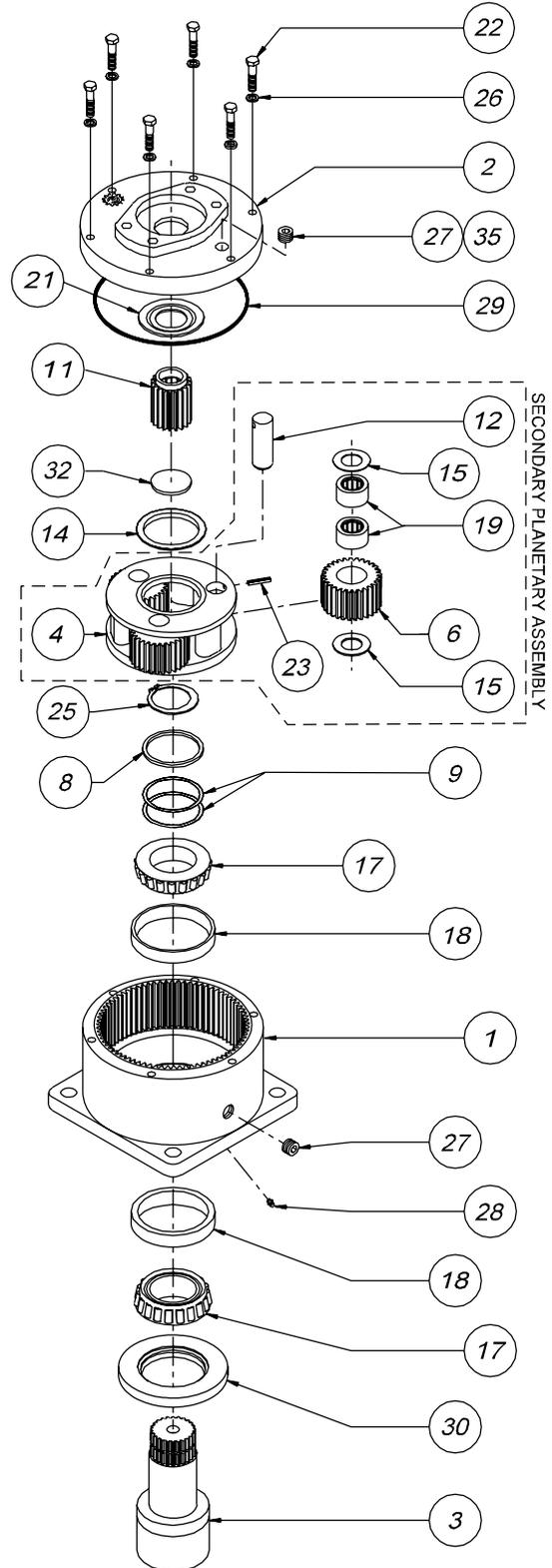


EFFECTIVE
FROM: S/N 16401 07-01-93
TO: (CURRENT)

| RATIO'S | |
|-------------|-------------|
| 4:1 4.08 | 5:1 5.05 |

| PART NUMBER | PART NUMBER | QTY. | ITEM | CODE | DESCRIPTION |
|-------------|--------------|------|------|------|---------------------------------------|
| ← | 28-004-3524 | 1 | 1 | | P28 CASE-SQUARE-SINGLE PLT.(NO ZERK) |
| ← | 28-004-3524Z | | | | P28 CASE-SQUARE-SINGLE PLT. W/ZERK |
| - | - | | | | C28 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. |
| 50-004-1062 | 50-004-1052 | 1 | 4 | | CARRIER-SECONDARY |
| 85-004-1051 | 85-004-1041 | 3 | 6 | | PLANET GEAR-SEC. |
| ← | 20-004-1031 | 1 | 8 | | SUPPORT WASHER |
| ← | 20-004-1091 | * | 9 | | SHIM |
| 85-004-1552 | N/A | 1 | 11 | 1 | INPUT GEAR 21T,20/40 D.P.SPLINE |
| 85-004-1382 | 85-004-1392 | | | 2 | INPUT GEAR 13T,16/32 D.P.SPLINE |
| 85-004-1272 | 85-004-1262 | | | 3 | INPUT GEAR SAE 1"-6B SPLINE |
| 85-004-1292 | N/A | | | 4 | INPUT GEAR 14T,12/24 D.P.SPLINE |
| 85-004-1562 | 85-004-1572 | | | 5 | INPUT GEAR 15T,16/32 D.P.SPLINE |
| 85-004-1592 | N/A | | | 6 | INPUT GEAR 1"DIA X .25" KEY |
| ← | 71-004-0121 | 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 2.75 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 |
| ← | 28-004-1021 | 1 | 32 | | THRUST BEARING |
| ← | 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.



E.C.N. NO. 2197
X28PD1-BE DATE: 04-15-04

Exploded View Drawing – 28P, Double Stage

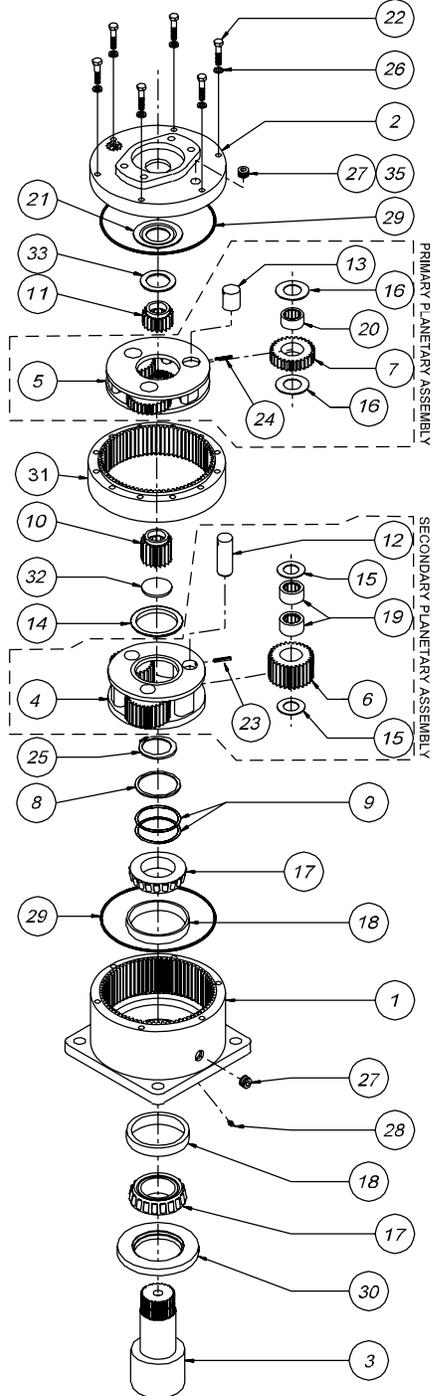
MODEL P28
DOUBLE PLANETARY



EFFECTIVE
FROM: S/N 16549 07-29-93
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 INVERTED | 25.53:1 5.05 5.05 |

| CODE | DESCRIPTION | ITEM | QTY. | PART NUMBER | PART NUMBER | PART NUMBER | PART NUMBER |
|------|---------------------------------------|------|------|--------------|-------------|-------------|-------------|
| | P28 CASE-SQUARE- (NO ZERK) | | | 28-004-3524 | | | |
| | P28 CASE-SQUARE- W/ZERK | 1 | 1 | 28-004-3524Z | | | |
| | C28 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 | | | 20-004-4112 | | | |
| C1 | SHAFT-CUSTOM PER CUSTOMER SPECS. | | | - | - | - | - |
| | CARRIER-SECONDARY | 4 | 1 | 50-004-1062 | 50-004-1062 | 50-004-1052 | 50-004-1052 |
| | CARRIER-PRIMARY | 5 | 1 | 50-004-1082 | 50-004-1072 | 50-004-1082 | 50-004-1072 |
| | PLANET GEAR-SEC. | 6 | 3 | 85-004-1051 | 85-004-1051 | 85-004-1041 | 85-004-1041 |
| | 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 | 85-004-1412 | 85-004-1092 | 85-004-1072 | 85-004-1072 |
| 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 | 71-004-0121 | | | |
| | 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 | 6 | 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 2.75 GR8 | 22 | 6 | 01-150-1490 | | | |
| | 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 | 2 | 01-402-0560 | | | |
| | SEAL-SHAFT | 30 | 1 | 01-405-0610 | | | |
| | RING GEAR | 31 | 1 | 85-004-1313 | | | |
| | THRUST BEARING | 32 | 1 | 28-004-1021 | | | |
| | THRUST BEARING | 33 | 1 | 01-112-0230 | | | |
| | 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 (1 EA.) O-RINGS AND (1 EA.) SEAL. PLUS ADD (ONE EXTRA) O-RING.
▷ FOR 20:1 RATIO, INPUT CODES 1, 4 AND 6 REQUIRE "INVERTED" RATIO CARRIER ASSEMBLIES.

ECN 2197
X28P02-BF DATE: 04-15-04

Eskridge Product Warranty

ESKRIDGE, INC. ("Eskridge") warrants to its original purchaser ("Customer") that new component parts/units ("Units") sold by Eskridge will be free of defects in material and workmanship and will conform to standard specifications set forth in Eskridge sales literature current at the time of sale or to any custom specifications acknowledged by written Customer approval of drawings, SUBJECT TO THE FOLLOWING QUALIFICATIONS AND LIMITATIONS:

1. Prior to placing Units in service, the Customer shall provide proper storage such that foreign objects (e.g., rain or debris) cannot enter any Units via entry ports which are normally closed during operation.
2. The Customer must notify Eskridge in writing of any claim for breach of this warranty promptly after discovery of a defect. The warranty period shall commence when a unit is placed in service and shall expire upon the earlier of
 - a. the expiration of twelve (12) months from the date of Commencement of Service (as defined in Paragraph 4)
 - b. the completion of one thousand (1000) hours of service of the Units
 - c. the expiration of six (6) months after the expiration of any express warranty relating to the first item of machinery or equipment in which the Units are installed or on which it is mounted, or
 - d. the installation or mounting of the Units in or on an item of machinery or equipment other than the first such item in which the Units are installed or on which the Units are mounted.
3. Units shall be deemed to have been placed in service (the "Commencement of Service") at the time the machinery or equipment manufactured or assembled by the Customer and in which the Units are installed or on which the Units are mounted is delivered to the Customer's dealer or the original end-user, which ever receives such machinery or equipment first.
4. This warranty shall not apply with respect to Units which, upon inspection by Eskridge, show signs of disassembly, rework, modifications, lack of lubrication or improper installation, mounting, use or maintenance.
5. Eskridge makes no warranty in respect to hydraulic motors mounted on any Units. Failure of any such motor will be referred to the motor manufacturer.
6. Claims under this warranty will be satisfied only by repair of any defect(s) or, if repair is determined by Eskridge in its sole, absolute and uncontrolled discretion to be impossible or impractical, by replacement of the Units or any defective component thereof. No cash payment or credit will be made for defective materials, workmanship, labor or travel. IN NO EVENT SHALL ESKRIDGE BE LIABLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES OF ANY KIND OR NATURE, FOR WHICH DAMAGES ARE HEREBY EXPRESSLY DISCLAIMED.
7. From time to time, Eskridge may make design changes in the component Units manufactured by it without incorporating such changes in the component Units previously shipped. Such design changes shall not constitute an admission by Eskridge of any defects or problems in the design of previously manufactured component Units.
8. All freight charges on Units returned for warranty service are the responsibility of the Customer.

Warranty Return Policy

1. Any part/Unit(s) returned to Eskridge must be authorized by Eskridge with an assigned return (CSR) number.
2. All Units shall be returned freight prepaid.
3. Any Units qualifying for warranty will be repaired with new parts free of charge (except for freight charges to Eskridge as provided above).
4. If Units are found to be operable, you have two options:
 - a. The Units can be returned to you with a service charge for inspection, cleaning, and routine replacement of all rubber components and any other Units that show wear;
 - b. We can dispose of the Unit(s) at the factory if you do not wish it to be returned.

NOTE: Any order of Units by customer shall only be accepted by Eskridge subject to the terms stated herein. Any purchase order forms used by Customer (to accept this offer to sell) which contain terms contrary to, different from, or in addition to the terms herein shall be without effect, and such terms shall constitute material alteration of the offer contained herein under K.S.A 84-2-207 (2)(b), and shall not become part of the contract regarding the sale of the Units.

The foregoing warranty is the sole warranty made by Eskridge with respect to any Units and is in lieu of any and all other warranties, expressed or implied. There are no warranties which extend beyond the description on the face hereof without limiting the generality of the foregoing, Eskridge expressly disclaims any implied warranty of merchantability or fitness for any particular purpose, regardless of any knowledge Eskridge may have of any particular use or application intended by the purchaser. The suitability or fitness of the Units for the customer's intended use, application or purpose and the proper method of installation or mounting must be determined by the customer.

OTHER ESKRIDGE PRODUCTS

PLANETARY GEAR DRIVES

| SERIES | TORQUE RATING (IN-LB) MAX. INTERMITTENT |
|--|--|
| 20 - SHAFT OUTPUT | 20,000 |
| 28 - SHAFT OUTPUT | 50,000 |
| 50 - SHAFT OUTPUT OR SPINDLE OUTPUT | 50,000 |
| 65 - SHAFT OUTPUT | 65,000 |
| 105 - SHAFT OUTPUT | 105,000 |
| 130/133 - SHAFT OUTPUT OR SPINDLE OUTPUT | 130,000 |
| 150 - SHAFT OUTPUT | 150,000 |
| 250/252 - SHAFT OUTPUT OR SPINDLE OUTPUT | 250,000 |
| 440 - SHAFT OUTPUT, SPINDLE OUTPUT OR WHEEL DRIVE | 440,000 |
| 600 - SHAFT OUTPUT, SPINDLE OUTPUT OR WHEEL DRIVE | 600,000 |
| 1000 - SHAFT OUTPUT, SPINDLE OUTPUT OR WHEEL DRIVE | 1,000,000 |

MULTIPLE DISC BRAKES

| SERIES | FEATURES | TORQUE RATING (IN-LB) |
|---------------------|--------------------------|------------------------------|
| 10 - INTEGRAL BRAKE | SAE B | TO 4,800 |
| 90B | SAE B | TO 4,800 |
| 90BA | SAE B, ADJUSTABLE TORQUE | TO 4,800 |
| 92B | SAE B, LOW PROFILE | TO 2,800 |
| 93 (931 OR 932) | FOR NICHOLS MOTORS | TO 6,100 |
| 95C | SAE C | TO 12,000 |
| 98D | SAE D | TO 25,000 |

PLANETARY AUGER DRIVES, ANCHOR DRIVES & DIGGERS

| SERIES | MODELS | TORQUE RATING (FT-LB) |
|---------------|-------------------|------------------------------|
| D50 | 1500, 2500 & 5000 | 1,500 - 5,000 |
| 76 | BA & BC, 2-SPEED | 8,000 - 12,500 |
| 77 | BA, BC & BD | 6,000 - 12,500 |
| 78 | 35 & 48, 2-SPEED | 9,000 - 12,500 |
| 75 | 38 & 51, 2-SPEED | 16,500 - 20,000 |
| D600 | D600 | 50,000 |
| D1000 | D1000 | 83,000 |

