

**BALDOR 900 SERIES**  
**WORM GEAR SPEED REDUCERS**  
**Double Reduction Adapter Kits**  
**INSTALLATION INSTRUCTIONS**

1. REMOVING PRIMARY UNIT OUTPUT BEARING CARRIER

The unit is filled with oil. Follow these instructions to avoid spilling the oil.

Place the primary unit on its side with the output shaft pointing vertically upward.

Remove the bearing carrier screws and retain for re-assembly.

Remove and discard the bearing carrier and shims taking care not to damage the bearing cone, which is located on the output shaft. The adapter contains a new seal and bearing cup.

2. INSTALLING THE DOUBLE REDUCTION ADAPTER

Care must be taken not to damage the seal in the adapter during installation. Cover the output shaft keyway of the primary unit with electrical tape to prevent the seal from being cut.

Lubricate the lip of the seal in the adapter and the output shaft of the primary unit.

The installation of the adapter requires adjustment for proper endplay of the tapered roller bearings. The output bearings must be adjusted for .001" to .003" endplay. Place the adapter on the primary unit in place of the bearing carrier. Apply pressure to the adapter and rotate the input shaft to seat the bearings. Measure the gap between the primary housing and adapter with a feeler gage. New shims are supplied with the unit. Select a combination of shims totaling .001" to .003" more than the measured gap. Shim thicknesses are .003"(green), .005" (blue), and .010" (brown).

Remove the adapter, apply sealant to the mating surfaces of the adapter and the primary unit. Place the shims over the adapter rabbet and install the adapter on the primary unit.

Install and tighten the original screws securely. Remove the tape.

3. CONNECTING THE PRIMARY UNIT TO THE SECONDARY

Remove and discard the motor adapter mounting screws and motor adapter from the secondary unit.

Install the key provided with the primary unit into the primary unit output shaft.

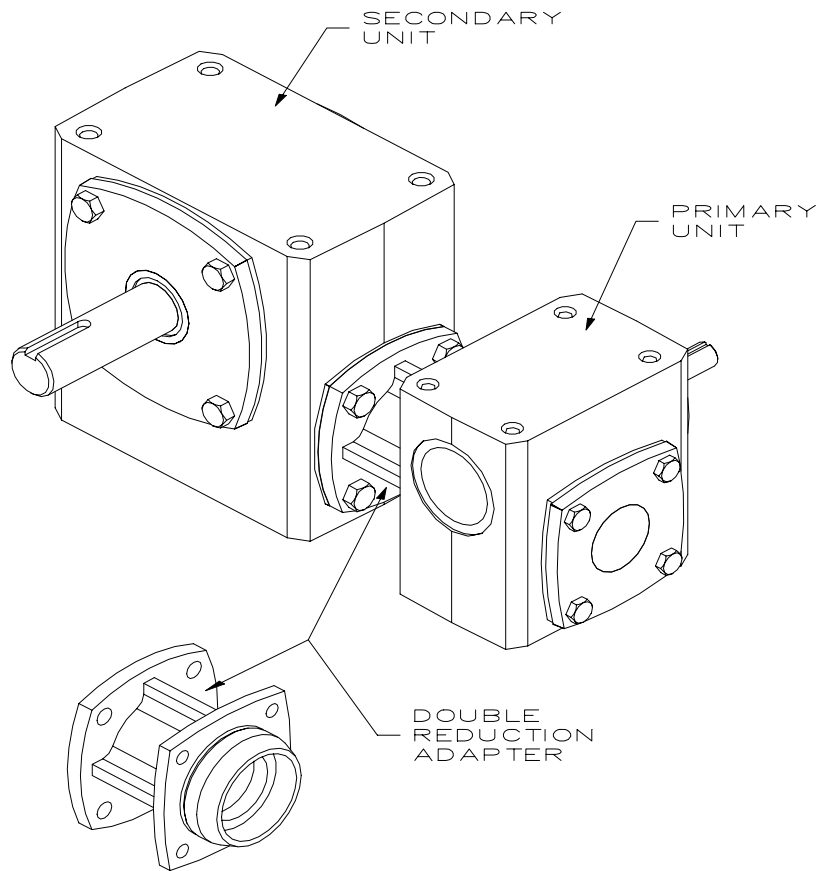
Coat the primary unit output shaft with anti-seize compound provided with the secondary unit.

Install the primary unit output shaft into the quill of the secondary unit.

Rotate the primary unit to the desired position.

Using the four screws provided with the adapter kit, join the primary unit to the secondary.

LT0066A02



Double Reduction Adapter Kit Part Number	Primary Unit (any style except shaft mount)	Secondary Unit (F and HF styles only)
DR913X913B5	913	913-B5
DR913X918B5	913	918-B5
DR913X921B5	913	921-B5
DR913X924B5	913	924-B5
DR913X926B5	913	926-B5
DR918X924B7	918	924-B7
DR918X926B7	918	926-B7
DR918X932B7	918	932-B7

Each Adapter Kit Consists of:

- 1 Adapter
- 1 Bearing cup (installed)
- 1 Seal (installed)
- 1 Shim set
- 4 Screws
- 4 Lock Washers
- 1 Sealant Package