

Polyglycol Retro-Fill Instructions

Important Note: Polyglycol oil is not compatible with the bladder material, and may cause degradation and failure of the expansion bladder. The bladder must be removed and the housing port plugged using the included hardware.

DISASSEMBLY AND BLADDER REMOVAL

1. Drain the oil from the reducer.
2. Wrap output shaft with electrical tape to prevent damage to the seal lip.
3. Remove the bolts holding the side covers.
4. Remove the gear shaft assembly and side covers, taking care not to damage the shim gaskets. Be sure to keep the shims with the cover on which they are installed. Failure to do so will result in improper positioning of the gear.
5. Remove the nut and sealing washer holding the bladder in place.
6. Remove and discard the nylon bladder support arch (if present) and bladder.

Note: It is not necessary to remove the worm shaft.

7. Thoroughly clean and flush all parts.
8. Remove the red bladder warning sticker.

PLUG INSTALLATION AND RE-ASSEMBLY

1. Insert 1/4-20 screw through the housing port from the inside.
2. Install sealing washer & nut, and tighten firmly.
3. Re-assemble the reducer making sure to keep the shims with their proper side cover. Failure to do so will result in improper positioning of the gear.
4. Tighten the bolts in an alternating pattern.
5. Refill with the appropriate quantity of polyglycol oil, refer to Table 1.

Note: In most cases, the kit contains more oil than is required. Discard any remaining oil.

6. Place the yellow Klubersynth UH-1 6-460 sticker on the reducer in a conspicuous location.

Table 1

Frame	Qty.	Frame	Qty.
913	7 oz	926	32 oz
915	11 oz	930	53 oz
918	16 oz	932	68 oz
921	20 oz	938	93 oz
924	28 oz		



Baldor Electric Company

P.O. Box 2400, Fort Smith, AR 72902-2400 U.S.A., Ph: (1) 479.646.4711, Fax (1) 479.648.5792, International Fax (1) 479.648.5895

www.baldor.com