Dodge TXT Torque-Arm Reducers with Tapered Bushings

These instructions must be read thoroughly before installation or operation. This instruction manual was accurate at the time of printing. Please see **baldor.com** for updated instruction manuals.

See the instruction manual packaged with the reducer for proper positioning, lubrication, maintenance, etc. Read this manual before attempting to install the reducer.

Note! The manufacturer of these products, Baldor Electric Company, became ABB Motors and Mechanical Inc. on March 1, 2018. Nameplates, Declaration of Conformity and other collateral material may contain the company name of Baldor Electric Company and the brand names of Baldor-Dodge and Baldor-Reliance until such time as all materials have been updated to reflect our new corporate identity.

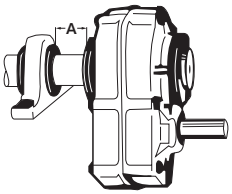
WARNING: To ensure the drive is not unexpectedly started, turn off and lock-out or tag power source before proceeding. Failure to observe these precautions could result in bodily injury.

WARNING: All products over 25 kg (55 lbs) are noted on the shipping package. Proper lifting practices are required for these products.

Installation:

1. One bushing assembly is required to mount the reducer on the driven shaft. An assembly consists of two tapered bushings, bushing screws and necessary shaft key or keys.
2. The driven shaft must extend through the full length of the reducer. The reducer should be mounted the recommended minimum distance from the shaft bearing (shown as dimension “A” in the drawing and table on the next page).
3. Place one bushing on the shaft and position per dimension “A” (as shown in the drawing and table on the next page).
4. If the reducer must be positioned closer to the bearing than dimension “A”, place the screws in the unthreaded holes in the bushing before positioning. Allow 1/8 between the screw heads and the bearing.
5. Insert the output key in the shaft and bushing. For ease of installation shaft keyseat should be at the top position.
6. Place the reducer in position on the shaft aligning hub keyway with the shaft key.
7. Insert screws in the unthreaded holes in bushing flange and align with threaded holes in bushing backup plate. If necessary, rotate bushing backup plate to align with bushing screws. Tighten the screws lightly.
8. Place the second taper bushing in position on the shaft and align the bushing keyway with the shaft key. Align the unthreaded holes in the bushing with the threaded holes in the backup plate. If necessary, rotate the backup plate to align with bushing holes. Insert bushing screws and tighten slightly.
9. Alternately and evenly tighten the screws in bushing nearest to equipment to the recommended wrench torque given in the table on other side. Repeat on outer bushing.

WARNING: Because of the possible danger to person(s) or property from accidents which may result from the improper use of products, it is important that correct procedures be followed. Products must be used in accordance with the engineering information specified in the catalog. Proper installation, maintenance and operation procedures must be observed. The instructions in the instruction manuals must be followed. Inspections should be made as necessary to assure safe operation under prevailing conditions. Proper guards and other suitable safety devices or procedures as may be desirable or as may be specified in safety codes should be provided, and are neither provided by ABB nor are the responsibility of ABB. This unit and its associated equipment must be installed, adjusted and maintained by qualified personnel who are familiar with the construction and operation of all equipment in the system and the potential hazards involved. When risk to persons or property may be involved, a holding device must be an integral part of the driven equipment beyond the speed reducer output shaft.



Reducer Size	Wrench Torque (in-lb)	A①	Reducer Size	Wrench Torque (in-lb)	A①	Reducer Size	Wrench Torque (in-lb)	A①
TXT115, TXT125 HXT115, HXT125 TXT105, HXT105 TXT109	200	1-1/4	TXT515B, TXT525B HXT515B, HXT525B TXT505A, HXT505A TXT509B	360	1-13/16	TXT915, TXT926 TXT905	900	2-7/16
TXT215, TXT225 HXT215, HXT225 TXT205, HXT205 TXT209	200	1-1/4	TXT615, TXT625 HXT615, HXT625 TXT605, TXT609	360	1-13/16	TXT1015 TXT1024	900	2-7/16
TXT315A, TXT325A HXT315A, HXT325A TXT305A, HXT305A TXT309A	200	1-1/2	TXT715, TXT725 HXT715, HXT725 TXT705, TXT709	800	2-1/16	TXT1215 TXT1225	900	2-11/16
TXT415A, TXT425A HXT415A, HXT425A TXT405A, HXT405A TXT409A	360	1-3/4	TXT815, TXT825 TXT805	800	2-1/16	TDT1325	900	2-11/16
						TDT1425	1600	3
						TDT1530	1600	3-1/2

① Recommended minimum distance to loosen bushing using screws as jack-screws.

Removing the Reducer from the Shaft:

1. Remove all external loads on the equipment.
2. Remove TA rod assembly as required.
3. Remove bushing screws.
4. Place the screws in the threaded holes provided in the bushing flanges. Tighten the screws alternately and evenly until the bushings are free on the shaft. For ease of tightening screws make sure screw threads and threaded holes in bushing flanges are clean.

   If the reducer was positioned closer than the recommended minimum distance, loosen the inboard bushing screws until clear of bushing flange (approximately 1/8“).

   Use (2) two wedges at 180° between the bushing flange and bushing backup plate.

   Drive wedges alternately and evenly until the bushing is free on the shaft.
5. Remove the outside bushing, the reducer and then the inboard bushing.

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