

MOTOR SEAL & OIL REPLACEMENT – Leeson Inline Gearbox

1. Release belt tension per design; Release latch clamp on double reduction systems. Remove the 3/8"-16 nut on adjustment rod at bottom of motor bracket.
2. Remove belt by rotating motor bracket. **Note:** May need to remove top of cabinet to allow enough rotation to remove belt.
3. Remove "hair" pin cotter from pivot rod.
4. Slide motor bracket back to disengage one end of pivot rod from mounting brackets.
5. Tip motor bracket and motor down to remove from other mounting bracket.
6. Loosen two (2) Allen head set screws on motor sheave.
7. Use adjustable pulley puller to remove sheave from motor shaft.
8. Remove ¼"-20 mounting bolts to remove bracket from motor.
9. Measure the Gearbox Lubricant level. **(See Page 28).**
10. Stand the motor on end with the output shaft pointed up.
11. Using a small hook tool or small flat blade screw driver, slide tool into seal next to shaft being careful not to gouge into shaft.
12. Pry seal upward until one side comes out of housing.
13. Pull seal upward off of output shaft.
14. Wipe shaft and seal well with clean rag. Try to get shaft clean and dry as possible.
15. Using either masking tape or electrical tape, cover the entire length of the keyway slot.
16. Wipe the lip of the new seal with a little oil.
17. Push seal onto shaft, lip edge down, and slide down shaft until positioned over seal well.
18. Gently tap seal housing with a small hammer until seal is started evenly into well.
19. Using a ¾" open end wrench or similar tool as press, tap seal until completely seated into well.
20. Remove tape from shaft.
21. Reassemble gear motor on mounting bracket following "new" bracket instructions *(If required)* **(See Pages #29-30)**
22. Adjust belt tension to ½" deflection with 10 lbs. of force applied between pulleys.

MEASURING GEAR BOX LUBRICANT

Stand motor upright on end housing. Allow motor to stand on end for a few minutes so fluid level will stabilize. Remove 3/16" Allen socket head plug from output housing. Using the supplied "pre-marked check" stick, gently push dip stick down to bottom of gearbox. Make sure to get the lowest point. Slowly remove stick from motor and measure depth of fluid. A reddish color fluid is Dexron III ATF. If the color is a clear (slightly opaque), it is Mobil XP-300 gear oil.



Measure the fluid level from the bottom of the stick. It should measure approximately 1 3/8" (*line indicator on the stick is 1 3/8"*). Any measurement from 1 1/4" to 1 3/8" is good. If less than 1 1/4", then fluid needs to be added. Matching the fluid type, add about 1 fluid ounce to gearbox. Re-measure depth. Add until depth is between 1 1/4" and 1 3/8". Replace plug and reinstall gearmotor.

