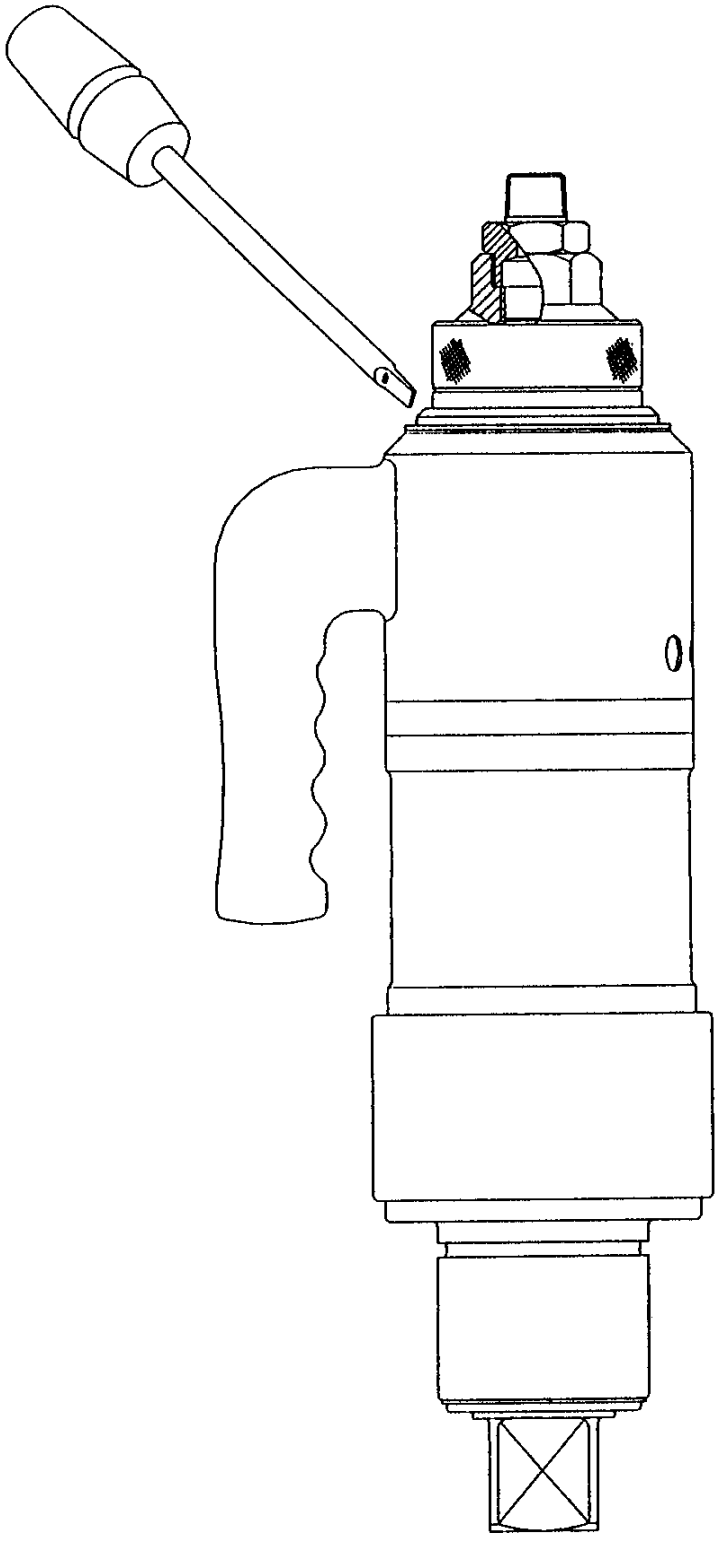
FITTING ANNULAR TRANSDUCER
MODEL NO. 50260.ETS
TO PT5500 GEARBOXES

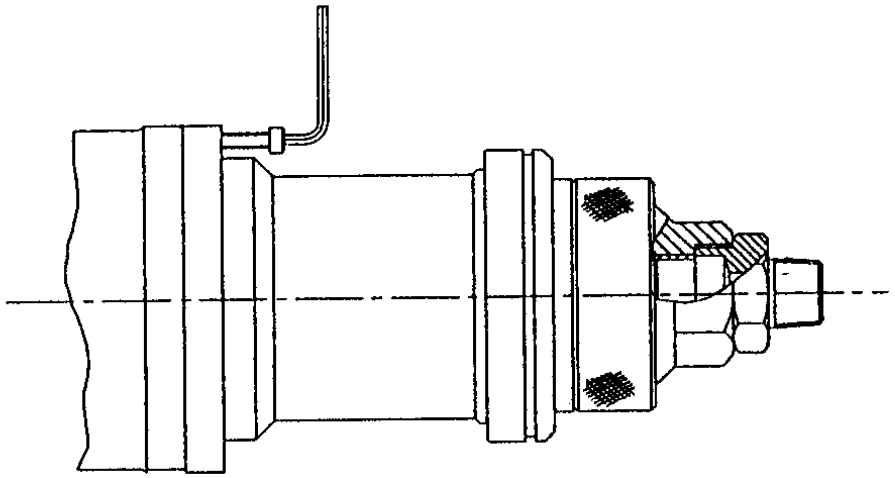
FITTING INSTRUCTIONS (PART NO. 34176)

ISSUE 1

NORBAR TORQUE TOOLS LTD, Beaumont Road, Banbury, Oxfordshire, OX16 1XJ, UNITED KINGDOM
Tel : + 44 (0) 1295 270333, Fax : + 44 (0) 1295 753643
www.norbar.com enquiry@norbar.com

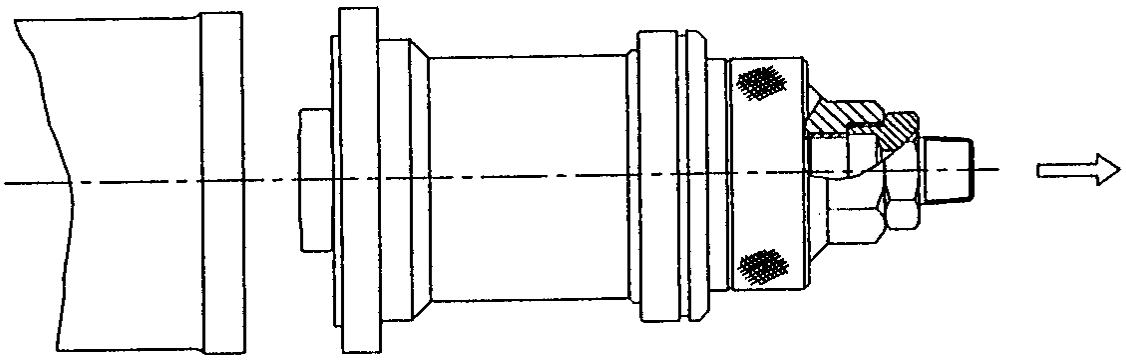


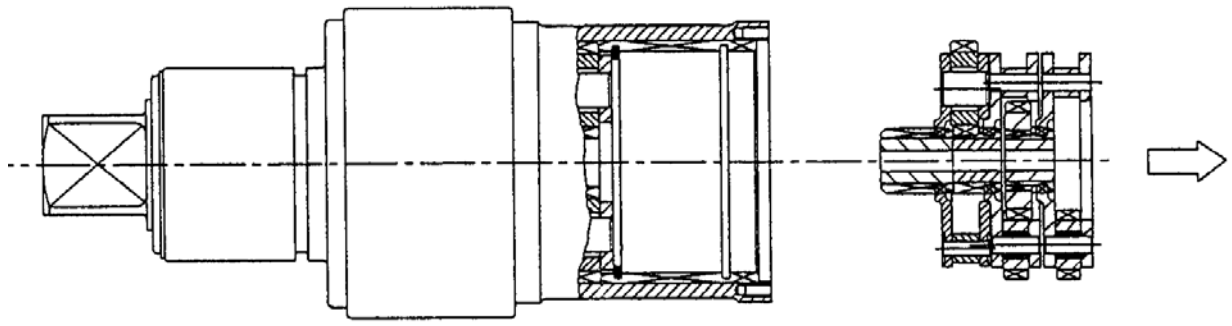
1. Ensuring gearbox assembly is held sercurely. Take a suitable screwdriver and prize off retaining ring located at rear of air motor - remove motor sleeve.



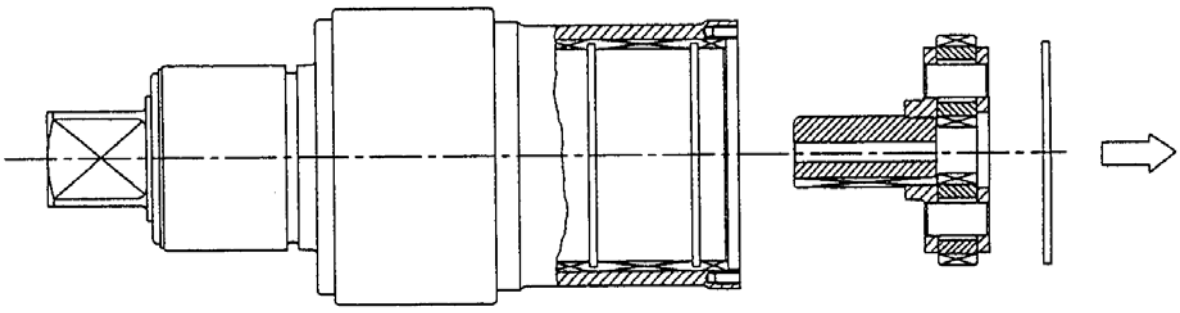
2. Taking a 5/32” Allen key unscrew 4 off cap screws from around motor flange. Remove motor .

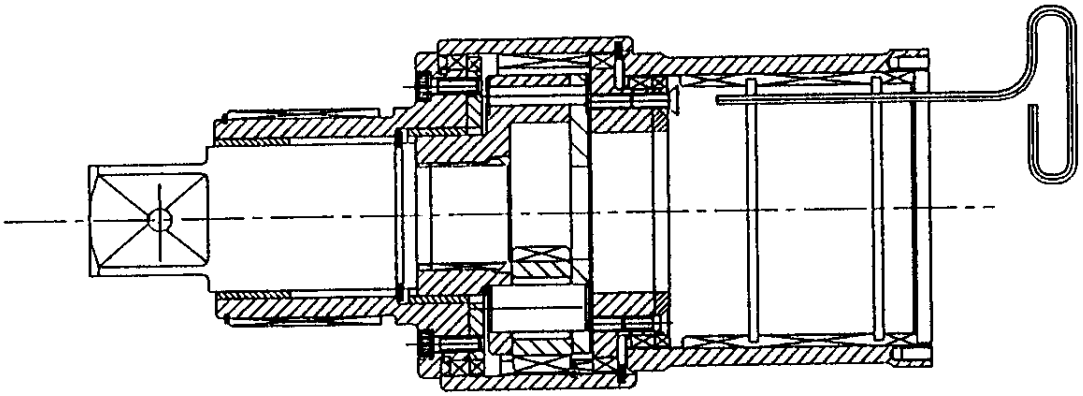
Note: Motor drive pinion may remain in gearbox, if so, remove separately.



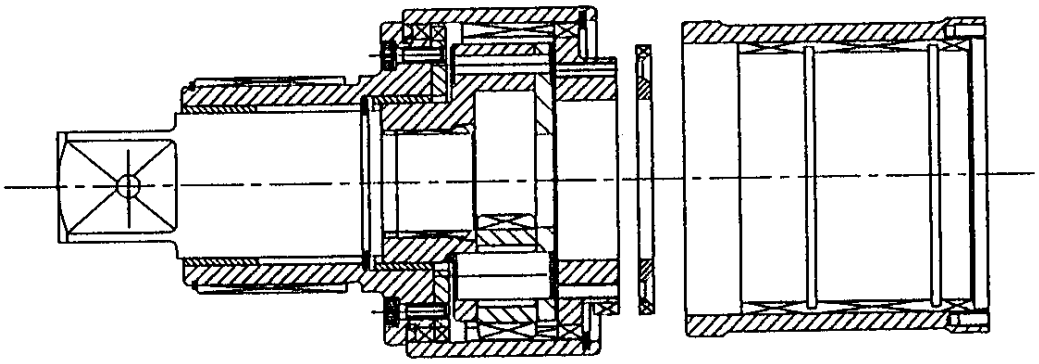


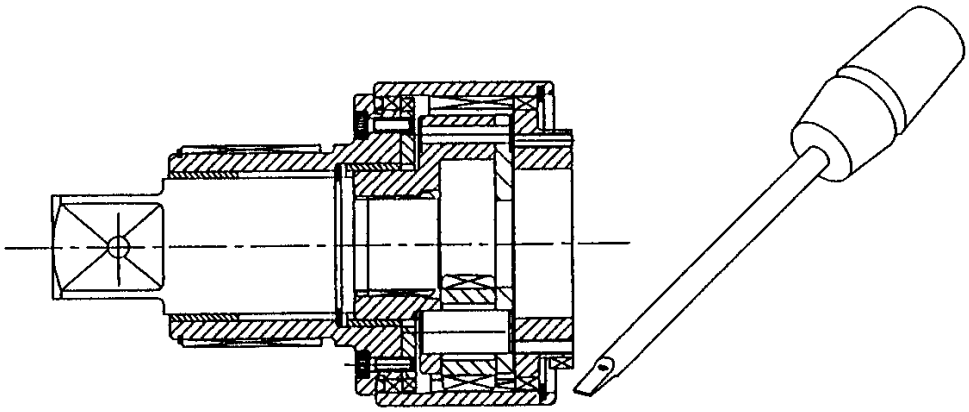
3. Remove multistage gear carriers from gearbox annulus until retaining ring is visible. Using technique previously employed in step 1. Remove retaining ring associated gear carrier.



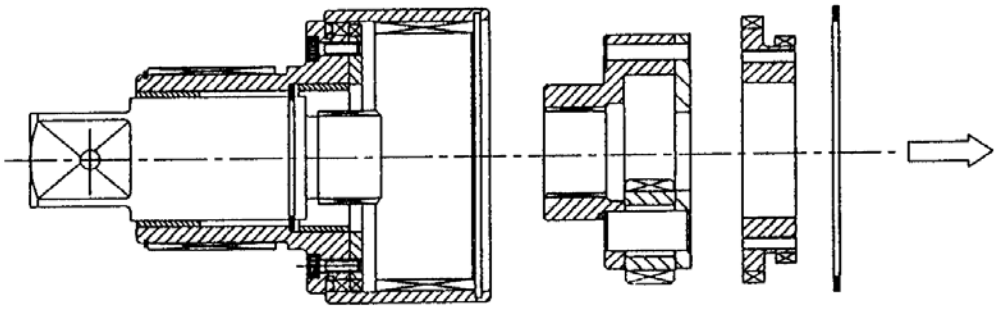


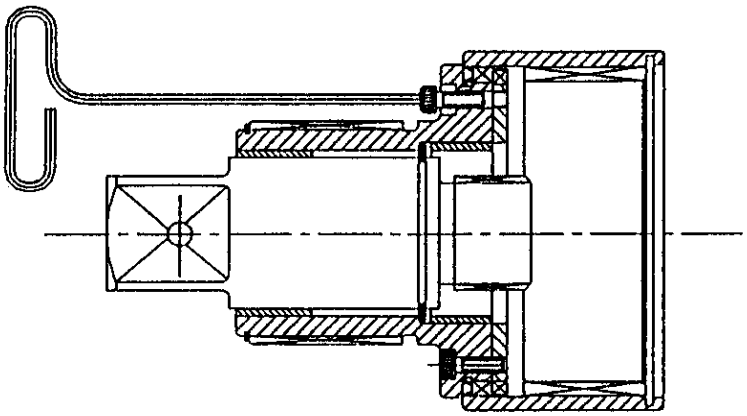
4. Using extended 4mm allen key remove 7 off M5 countersunk head screws. It is now possible to separate small diameter annulus from large.



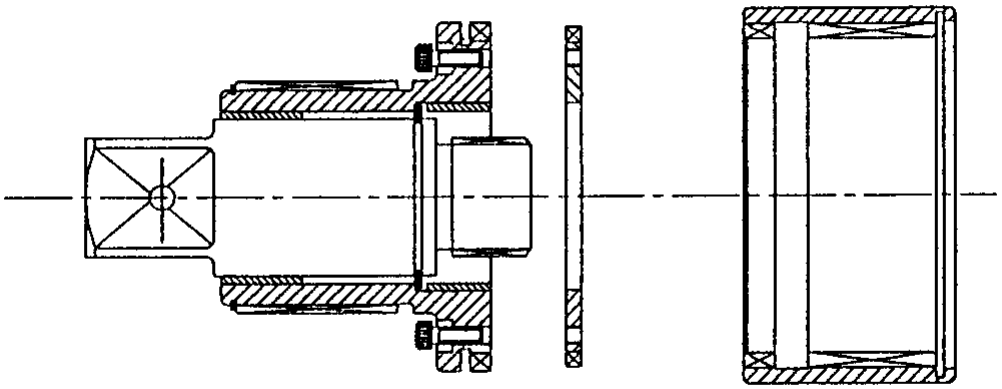


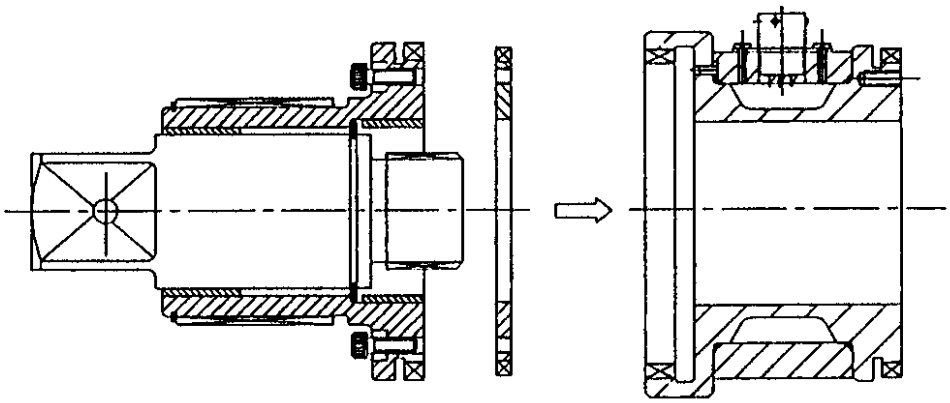
5. Using screwdriver remove retaining ring from large diameter annulus remove connecting ring and final stage carrier.



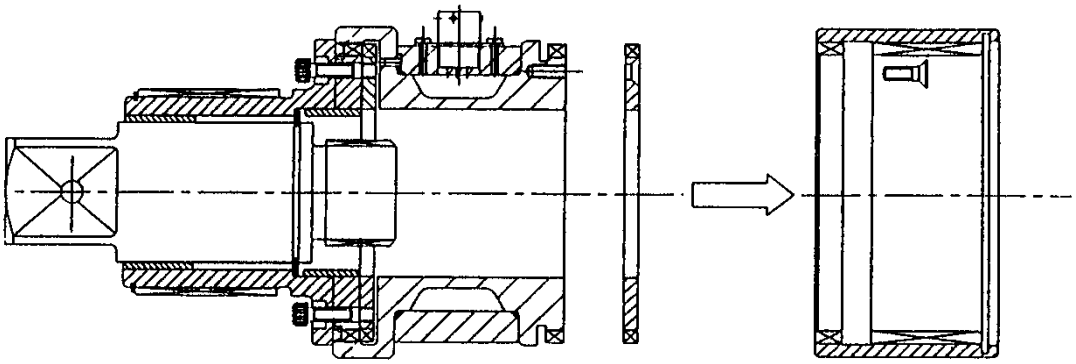


6. Using plain or as shown here an extended 4mm allen key remove 7 off M5 cap screws from around periphery of bearing nose. Remove nose and retainer plate from annulus. The annulus is now ready for re-assembly with annular transducer.





7. Taking bearing nose (screws and retainer plate previously removed in step 6) offer retainer plate to annular transducer. Align teeth and insert plate into annulus. Carefully rotate plate 1/2 pitch. Align teeth of bearing nose with annulus teeth and insert. Screw in 7 off M5 cap screws and torque tighten to 7 N.m (60 lbs.in).



8. Taking large diameter annulus retainer plate and screws supplied with transducer align teeth of retainer plate with teeth of annulus. Insert plate. Carefully rotate plate 1/2 pitch. Take transducer and nose sub-assy align teeth of transducer with teeth of annulus and insert. Locate 7 off M5 countersunk screws supplied and using a 3mm extended allen key tighten. Take new transducer shaft supplied and insert female end into transducer ensure splines mesh and push shaft fully home.

From this point onward. Assembly is a reversal of steps 6-1.