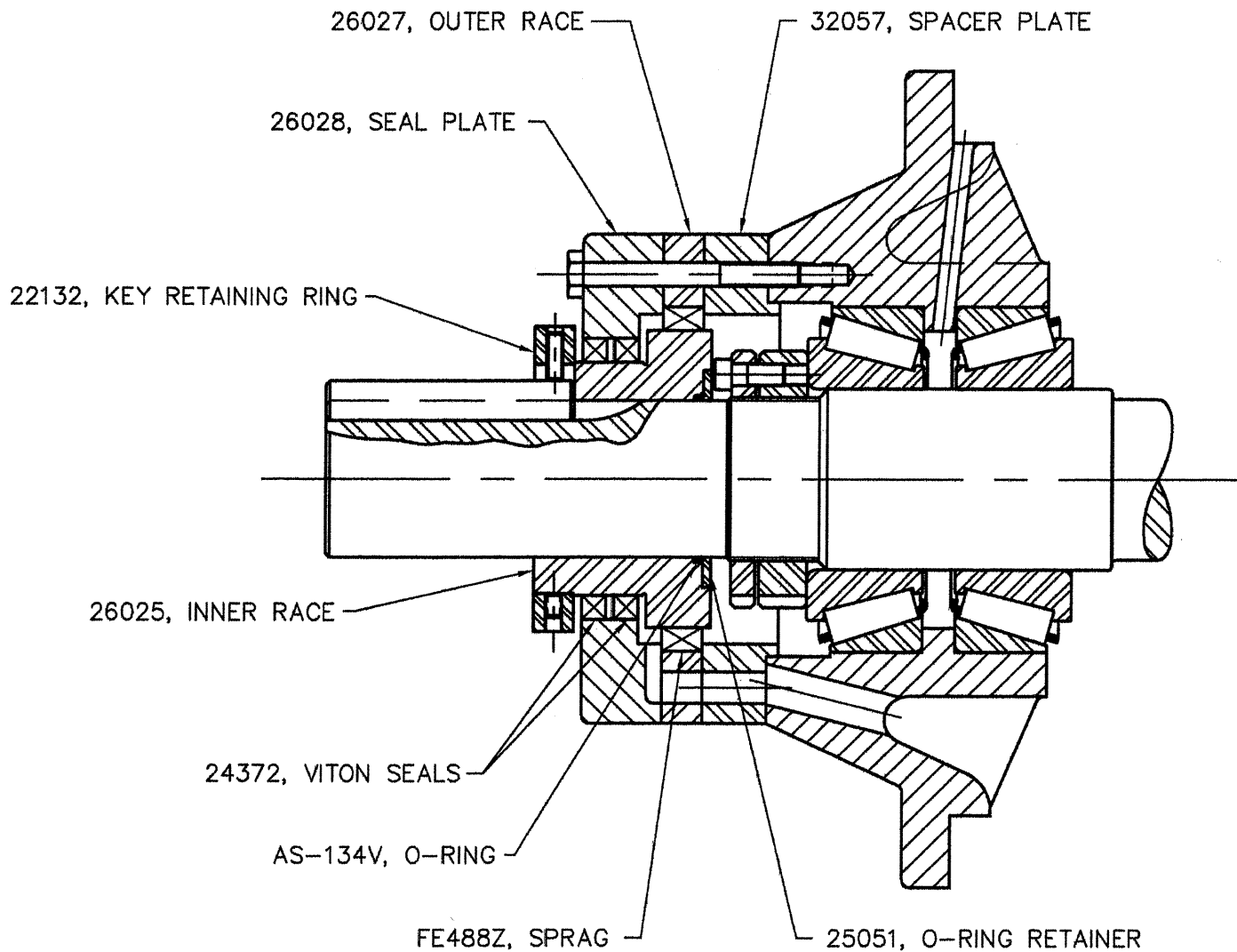


**Assembly Instructions**  
**Models: 85, 110, 135, 155, 175, 1008, & 1110**

- 1.) Place the Non-Reverse spacer plate on the horizontal carrier. The oil drain back hole should be located at the bottom.
- 2.) Slide the o-ring retainer plate onto the horizontal shaft to a point past the inner end of the keyway. Next slide the o-ring onto the shaft, taking care not to cut it with the keyway, and position it next to the retainer plate. Slide the sprag inner race onto the shaft and push it, with the o-ring and retainer plate, until it is against the cap screws located in the Timken Locknut set. The slot in the sprag inner race has to be aligned with the keyway.
- 3.) Install the sprag into the sprag outer race. Slide the outer race with the sprag over the inner race. The inner race can be rotated in the clockwise direction to start the sprag onto the inner race. The oil drain back hole must be located at the bottom.
- 4.) Install the seals in the oil seal plate; grease must be packed between the seals. Slide the oil seal plate onto the inner race and insert the bolts. Do not tighten the bolts at this time. Insert a key into the keyway of the shaft and the slot in the inner race.
- 5.) Alternately tighten the bolts while holding a light torque load on the horizontal shaft in the CCW direction. This procedure will center the sprag in the races. Install key retaining ring, tighten set screws.
- 6.) Fill the sprag with approximately one pint of oil before testing the gear drive.



DR.BY: R. ADAMS

CK.BY: *See M.K. 6-1303*

APP.BY:

**AMARILLO  
GEAR  
COMPANY**

NON-REVERSE  
ASSEMBLY  
MODEL 135, 1008, 1110

MODEL: 135, 1008, 1110

DATE: 6/13/03

PART NO.

DWG NO. 24169