



# Worm Gear Reducer Horizontal Base Kit Installation & Maintenance Manual

## Power Transmission Solutions

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## FORM

9979E  
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### ⚠ WARNING

- Read and follow all instructions carefully.
- Disconnect and lock-out power before installation and maintenance. Working on or near energized equipment can result in severe injury or death.
- Do not operate equipment without guards in place. Exposed equipment can result in severe injury or death.

### ⚠ CAUTION

- Periodic inspections should be performed. Failure to perform proper maintenance can result in premature product failure and personal injury.

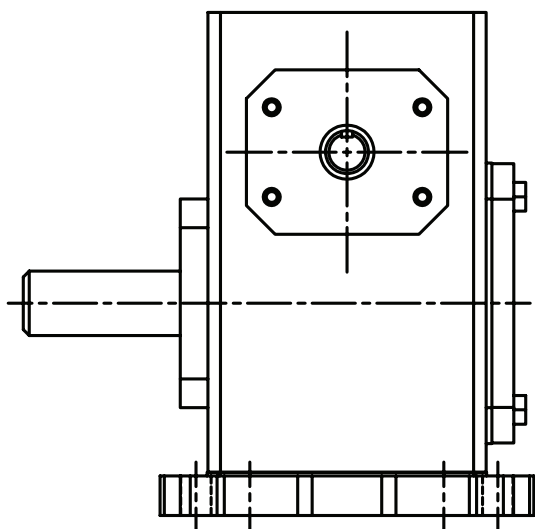
### Unit Sizes 133-325 (one piece base kit)

1. Place reducer on a smooth level surface with the side the base kit will be mounted on up.
2. Align the inner clearance holes in the base kit with the tapped holes in the reducer housing.
3. Insert the four (4) supplied capscrews thru the clearance holes in the base into the threaded holes in the housing.
4. Tighten to the appropriate torque as shown in Table 1.
5. Follow instructions supplied with the reducer for mounting assembled unit.

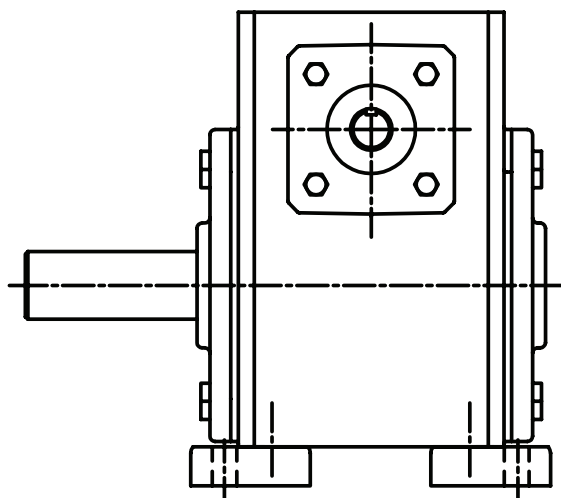
### Unit Sizes 375-600 (two piece base kit)

1. Place reducer on a smooth level surface with the side the base kit will be mounted on up.
2. Align the inner clearance holes in the base kit with the tapped holes in the reducer housing.
3. Insert the two (2) of the four (4) supplied capscrews thru the clearance holes in the base into the threaded holes in the housing.
4. Tighten to the appropriate torque as shown in Table 1.
5. Repeat steps 2, 3 and 4 for the other base.
6. Follow instructions supplied with the reducer for mounting assembled unit.

| Capscrew Tightening Torques |                 |               |                 |
|-----------------------------|-----------------|---------------|-----------------|
| Capscrew Size               | Torque (FT/LBS) | Capscrew Size | Torque (FT/LBS) |
| 1/4 - 20                    | 6.25            | 7/16 - 14     | 35.0            |
| 5/16 - 18                   | 13.0            | 1/2 - 13      | 50.0            |
| 3/8 - 16                    | 20.0            | 5/8 - 11      | 90.0            |



Horizontal Base 133-325  
Center Below Base



Horizontal Base 375 - 600  
Center Below Base