

# Dodge® Motorized Torque-Arm II™ Position D Breather Kit (Part Number 472300) Instruction Manual

MTA2-MTA3    MTA4-MTA8

These instructions must be read thoroughly before installation or operation. This instruction manual was accurate at the time of printing. Please see [dodgeindustrial.com](http://dodgeindustrial.com) for updated instruction manuals.

**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

**NOTE:** This kit should only be used when mounting a Motorized Torque-Arm vertically in position D.

1. Assemble position D breather kit as shown in Figure 1 (MTA2-MTA3) or Figure 2 (MTA4-MTA8).

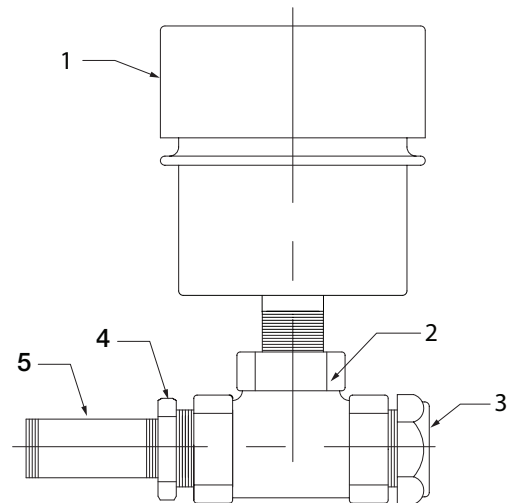


Figure 1 - Position D Breather Kit (MTA2-MTA3)

**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 Dodge nor are the responsibility of Dodge. 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.

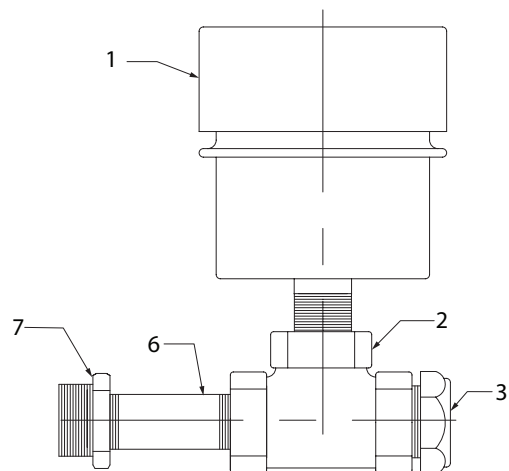
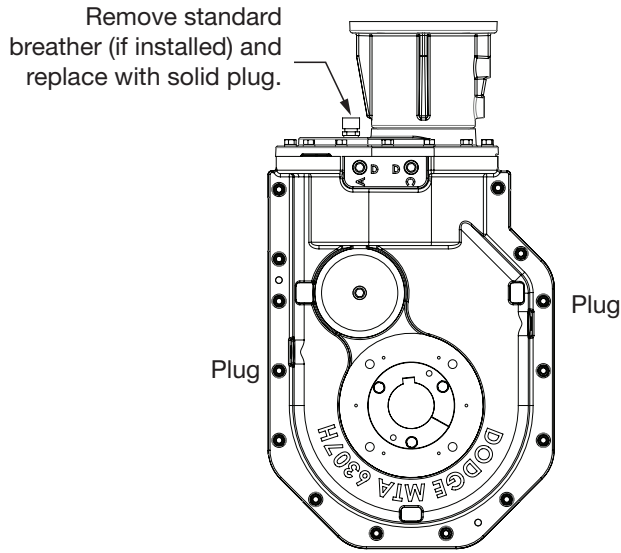
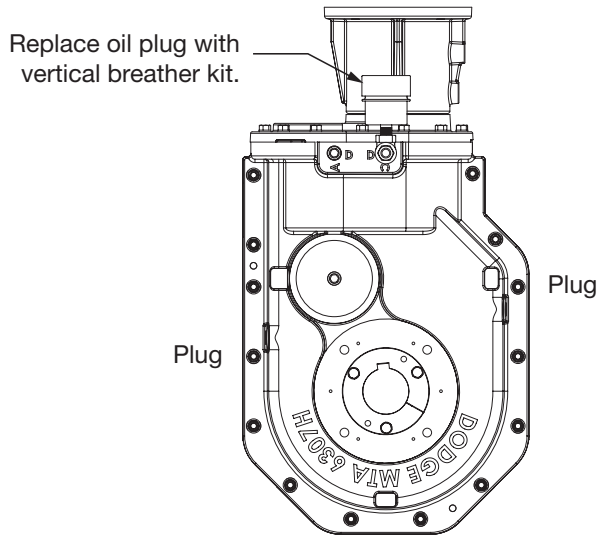


Figure 2 - Position D Breather Kit (MTA4-MTA8)

2. Replace top oil plug on reducer with assembled vertical breather kit (see Figure 3).
3. Remove standard breather from reducer (if installed) and replace with solid oil plug (see Figure 4).



**Figure 3 - Installing Position D Breather Kit  
Top Oil Plug Replacement**



**Figure 4 - Installed Position D Breather Kit  
Replaces Standard Breather**

**Table 1 - Parts for Position D Breather Kit**

Ref. Number ①	Part Descriptions	Part Number	Quantity	
			MTA2-3	MTA4-8
	Vertical (Position D) Breather Kit	472300	-	-
② 1	Expansion Chamber	240053	1	1
② 2	1/2 Pipe Tee	034720004AB	1	1
② 3	Oil Sight Gauge	430121		
② 4 ③	1/2 x 3/8 Hex Bushing	034600006AB	1	-
② 5 ③	Pipe Nipple 3/8 x 3	034530024CB	1	1
② 6 ④	Pipe Nipple 1/2 x 3	034530024DB	1	1
② 7 ④	3/4 x 1/2 Hex Bushing	034600010AB	-	1

- ① Refer to Figure 1 or Figure 2
- ② Makes up assembly under which it is listed
- ③ This part is used only on MTA 2 - MTA 3
- ④ This part is used only on MTA 4 - MTA 8

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