



# Quantis® In-Line Helical Reducer

## Instruction Manual

### Integral Gearmotors

### C-Face Reducers

### Separates

### Sizes 38–168

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:** High voltage and rotating parts can cause serious or fatal injury and property damage. The use of electrical machinery, like all other utilization of concentrated power and rotating equipment, can be hazardous. Installation, operation and maintenance should be performed only by qualified electrical and mechanical maintenance personnel familiar with NEMA safety standards, the National Electrical Code and sound local practices. The manual is to be studied thoroughly by personnel responsible for the installation and maintenance of this equipment before installation is begun. Personnel must be familiar with the potential hazards involved. If this warning is not observed, personal injury and/or property damage may result. Keep this document for future reference.

**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.

**WARNING:** All products over 25 kg (55 lbs) are noted on the shipping package. Proper lifting practices are required for these products.

## GENERAL

Please read these instructions carefully. They contain vital information on proper installation, operation, maintenance and service for the Quantis ILH gear reducer.

Each Dodge gear reducer is thoroughly inspected and tested at the factory prior to shipment. Care is taken in packing of each gear reducer. However, each gear reducer should be thoroughly inspected before it is accepted from the transportation company. If any of the goods called for in the bill of lading are damaged or missing, do not accept the shipment until the freight agent makes appropriate notation on your freight bill. If any loss or damage is discovered later, notify the agent at once and request an inspection. Though Dodge will be happy to assist you with claims for loss or damage in shipment, the transportation company is responsible for reimbursing you for such claims. Claims for loss or damage in shipment must not be deducted from the Dodge invoice, nor should payment of the Dodge invoice be withheld awaiting claims adjustment. The carrier, not Dodge, guarantees safe delivery. If considerable damage or shortage has occurred and the situation is urgent, contact your Dodge representative.

## WARRANTY

**NOTE: Service and repair under warranty should be performed only by a Dodge Industrial, Inc. Authorized Service Shop. Contact Dodge Product Support for Assistance.**

The Quantis ILH is warranted under the Dodge “Standard Terms and Conditions of Sale.” Warranty claims must be submitted to Dodge within one year from the date of installation or within three years from the date of manufacture, whichever comes first. The warranty does not extend to failures induced by misuse, improper storage or handling, abuse, or misapplication.

## LUBRICATION

The Quantis ILH Gear Reducer is factory filled with ISO 220 EP type mineral oil to the correct oil level for the specified mounting position. **Changes in the mounting position will require relocation of the oil level and vent plugs.** Oil may have to be added or drained to get to the correct oil level in the new mounting position. See the Mounting Position Diagrams for the correct plug locations for various mounting positions of the Quantis ILH unit. The oil level should be checked before startup and frequently thereafter, preferably with the unit at operating temperature.

The Quantis ILH gearbox is factory-filled with lubricant. The factory-fill lubricant is suitable for use at all output speeds and in ambient temperatures from +10°F to +105°F (-12°C to +41°C). No initial oil change after break in is needed. The initial factory oil fill is good for up to 10,000 hours or 3 years of service, whichever comes first, in normal industrial environments.

Normal operating conditions are defined as steady loads not exceeding normal ratings and running conditions as defined in the Quantis ILH catalog. Oil quantity and levels should be checked at frequent intervals, depending on usage. Oil changes are required after 10,000 operating hours or 3 years—whichever comes first. The period can be extended to 20,000 operating hours or 6 years, if a synthetic lubricant is used. The lubricant should be changed more frequently if the unit is operating in a hostile environment. For extremely hot, wet, or dirty conditions consult Application Engineering at (864) 284 5700. In those mountings that require grease lubrication for specific bearings, relubricate the affected bearings every year or every 2,000 operating hours—whichever comes first. Use a grease with a lithium complex thickener and ISO 220 viscosity mineral oil base lubricant. Use 15 pumps of grease for the first re-greasing and 5 pumps of grease for subsequent re-greasing.

Quantis ILH Reducers are shipped with filling, oil level and drain plugs in place. A separate breather is included with the unit. Before putting the unit into service the filling plug must be replaced with the breather. HB38 and HF38 (1, 2 and 3 stage gear units) have one oil plug, ventilation is not necessary.

Approximate oil volumes for each Quantis ILH unit are listed in the Mounting Position Diagrams in pints and liters. The oil volumes are approximate and should not be used to determine correct oil level. The correct oil level is defined as the bottom of the appropriate oil level hole.

**NOTE: Do not mix oils from different manufacturers. If a change to another type or brand of oil is made, the existing lubricant should be drained and the gearcase flushed with a small quantity of the new lubricant before refilling with the new lubricant. This is necessary to avoid possible incompatibility problems between the two lubricants. The list below gives approved alternative lubricants. This is not an exclusive list. Equivalent lubricants from other manufacturers may be used.**

All reducers are factory-filled according to the mounting position indicated on the order. **If the mounting position is changed from the ordered mounting the position, the oil level must be changed.** The oil volumes shown in the mounting position charts are approximate. The correct oil level is determined by the oil level hole in the housing except for size 38 reducers. If the reducer is ordered with the standard mineral oil and the oil is later changed to synthetic oil, it is recommended the shaft seals be changed to Viton (FKM) material.

ILH is furnished with oil level, drain, and fill plugs except for the size 38, which only has a fill plug. Before starting operation, the breather must be located in the correct location.

Continued operation in cold ambient conditions requires special modifications. Contact Dodge Industrial Inc. Gearing Application Engineering, Greenville, SC for application assistance at (864) 284 5700.

The density of the standard factory fill oil is 0.93 lbs/pint (1.98 lbs/liter).

Table 1 shows lubricants that are available as factory fill in Quantis reducers. The standard factory fill lubricant is Mobilgear 600 XP 220, which is a high performance mineral oil lubricant with special additives for use in industrial gear products.

Table 1—Lubricant Selection Table

Ambient Temperature ①	Oil Type	ISO Viscosity Grade	Available Oils	Available Food Grade Oils (NSF H1)	Compatible Seals
10°F to 105°F (-12°C to 41°C)	Mineral Oil	220	Mobilgear 600 XP 220 (standard factory fill ②)	-	Nitrile (NBR) Seal and Harsh Duty (XT) Nitrile Seal
-20°F to 50°F (-29°C to 13°C)	Synthetic Oil	68	Mobil SHC 626	-	Viton (FKM) Seal
-30°F to 14°F (-35°C to -10°C)	Synthetic Oil	150	Mobil SHC 629	-	Viton (FKM) Seal
-10°F to 115°F (-23°C to 46°C)	Synthetic Oil	220	Mobil SHC 630	-	Viton (FKM) Seal
30°F to 140°F (-0°C to 60°C)	Synthetic Oil	460	Mobil SHC 634	-	Viton (FKM) Seal
45°F to 105°F (7°C to 41°C)	Mineral Oil	460	-	Chevron FM 460	Harsh Duty (XT) Nitrile Seal and Nitrile (NBR) Seal

① Ambient temperatures listed are for lubricant only and do not indicate a particular gear unit's suitability to run in that ambient.

② Previous factory fill oil was Mobilgear 630 - Mobilgear 600 XP 220 and Mobilgear 630 are compatible with each other and do not require a flush. Recommendations will be made based on specific application details.

## MOUNTING POSITION DIAGRAMS

### IN-LINE HELICAL C-FACE REDUCERS & INTEGRAL GEARMOTORS

These mounting arrangements are for all output configurations and output shaft types.

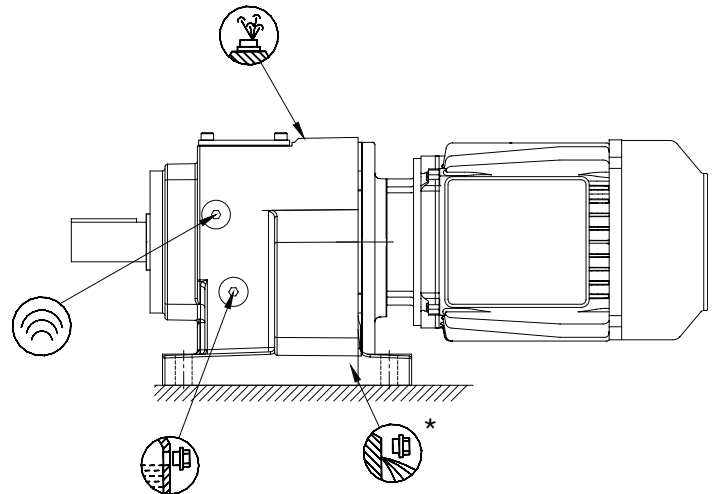
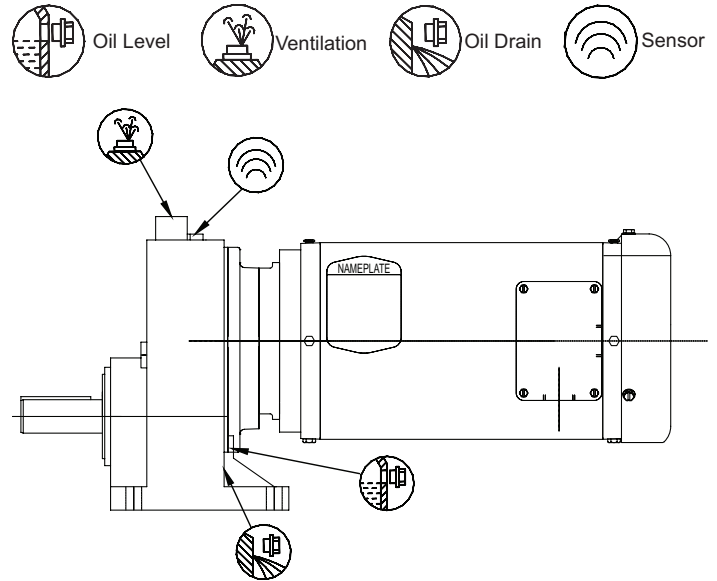
**IMPORTANT!** When ordering, please specify mounting position for correct oil quantity. In cases of mounting position other than shown here with regard to the oil quantity, please reference the Incline Mounting page in the Quantis Engineering Catalog, and contact Dodge Application Engineering.

**NOTE:** The oil volumes shown are approximate values and cannot be used to correctly set the reducer oil level - **ALWAYS** fill the reducer to the correct oil level plug and recheck in 1 week.

A1			
Unit Size	Reduction Stage	Pints	Liters
38	1	0.3	0.2
48	1	0.5	0.3
68	1	1.1	0.5
88	1	1.6	0.8

A1			
Unit Size	Reduction Stage	Pints	Liters
38	2	1.1	0.5
	3	1.1	0.5
48	2	2.3	1.1
	3	2.3	1.1
58	2	3.2	1.5
	3	3.2	1.5
68	2	3.8	1.8
	3	3.6	1.7
88	2	8.7	4.1
	3	8.5	4.0
108	2	14.2	6.7
	3	13.7	6.5
128	2	19.0	9.0
	3	18.4	8.7
148	2	25.8	12.2
	3	24.7	11.7
168	2	39.7	18.8
	3	38.3	18.1

#### A1 - Horizontal - Floor Mount

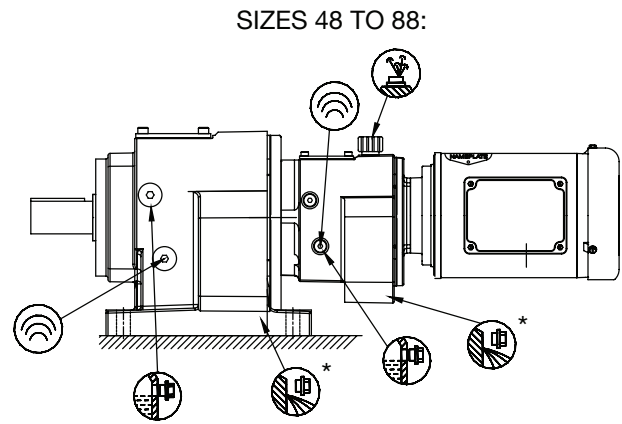


A1					
Unit Size	Reduction Stage	Input Reducer Pints	Input Reducer Liters	Primary Reducer Pints	Primary Reducer Liters
38	4	0.3	0.2	1.6	0.8
	5	1.1	0.5	1.6	0.8
48	4	0.3	0.2	4.5	2.1
	5	1.1	0.5	4.5	2.1
68	4	0.3	0.2	7.9	3.7
	5	1.1	0.5	7.9	3.7
88	4	0.5	0.3	19.2	9.1
	5	2.3	1.1	19.2	9.1
108	4	0.5	0.3	24.4	11.6
	5	2.3	1.1	24.4	11.6
128	4	1.1	0.5	36.9	17.5
	5	2.3	1.1	36.9	17.5
148	4	1.1	0.5	54.9	25.9
	5	2.3	1.1	54.9	25.9
168	4	1.1	0.5	80.3	38.0
	5	3.8	1.8	80.3	38.0

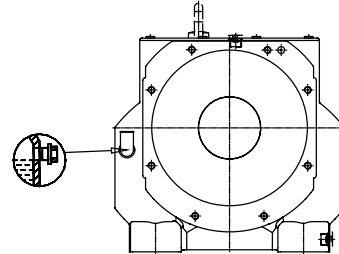
All ILH 38 units are sealed for life and furnished with only one plug for filling and draining.

NOTE: 4 and 5 stage reduction reducer consists of two reducers assembled to each other, the Input Reducer and the Primary Reducer. The reducers are sealed from each other and require different oil levels per the chart.

\* Hole location on opposite side of reducer.



FILL HOLE FOR SIZES 108 TO 168:



## IN LINE HELICAL C-FACE REDUCERS & INTEGRAL GEARMOTORS

These mounting arrangements are for all output configurations and output shaft types.

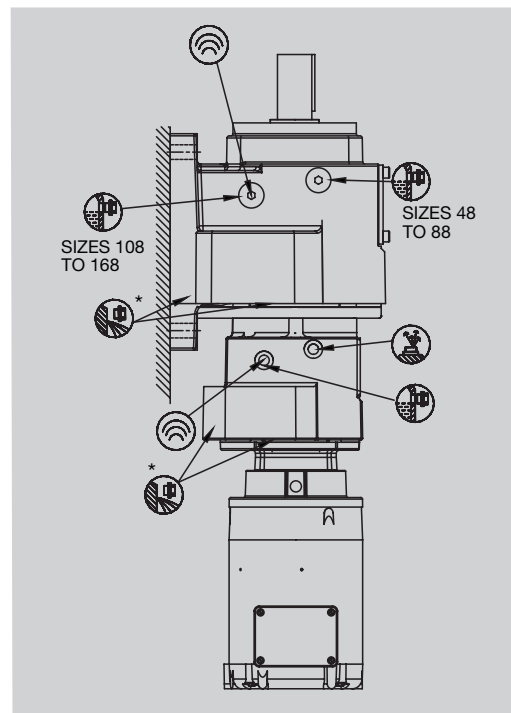
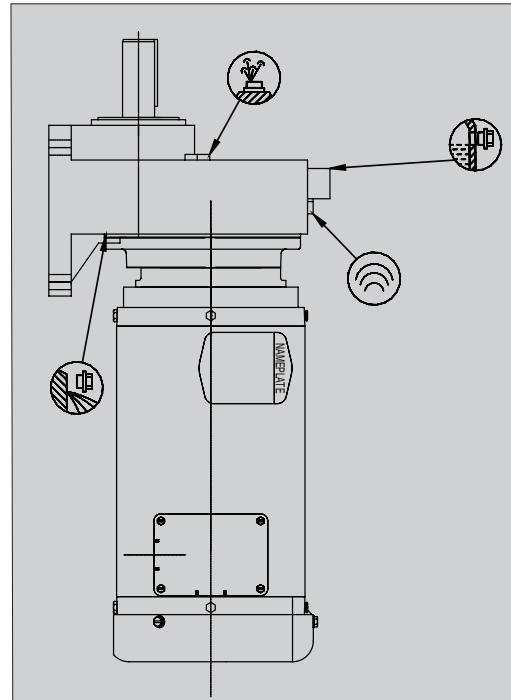
**IMPORTANT!** When ordering, please specify mounting position for correct oil quantity. In cases of mounting position other than shown here with regard to the oil quantity, please reference the Incline Mounting page in the Quantis Engineering Catalog and contact Application Engineering.

**NOTE:** The oil volumes shown are approximate values and cannot be used to correctly set the reducer oil level - **ALWAYS** fill the reducer to the correct oil level plug and recheck in 1 week.

A2			
Unit Size	Reduction Stage	Pints	Liters
38	1	1.2	0.6
48	1	2.2	1.1
68	1	3.9	1.9
88	1	8.0	3.8

A2			
Unit Size	Reduction Stage	Pints	Liters
38	2	2.5	1.2
	3	2.3	1.1
48	2	5.1	2.4
	3	5.1	2.4
58	2	7.2	3.4
	3	7.4	3.5
68	2	8.7	4.1
	3	8.5	4.0
88	2	18.6	8.8
	3	18.8	8.9
108	2	29.6	14.0
	3	30.0	14.2
128	2	44.2	20.9
	3	45.8	21.5
148	2	58.5	27.7
	3	59.6	28.2
168	2	88.1	41.7
	3	92.4	43.7

### A2 - Vertical Floor Mount - Motor Shaft Up

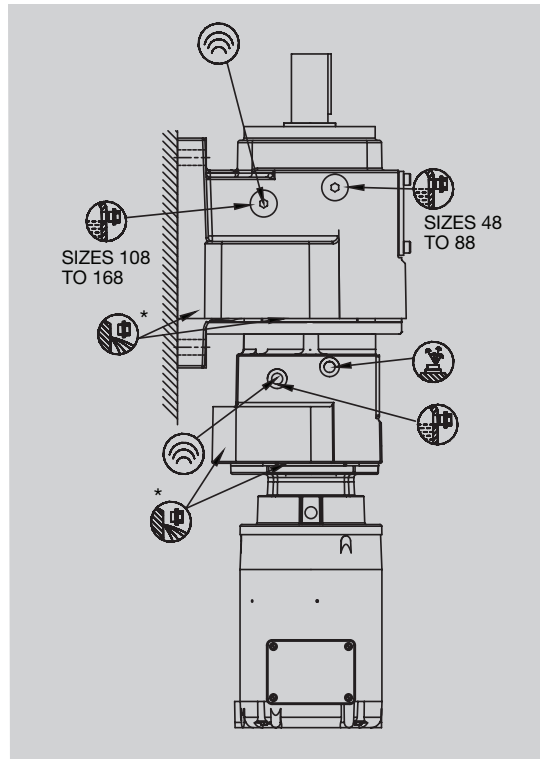


A2					
Unit Size	Reduction Stage	Input Reducer Pints	Input Reducer Liters	Primary Reducer Pints	Primary Reducer Liters
38	4	1.2	0.6	2.2	1.1
	5	2.5	1.2	2.2	1.1
48	4	1.2	0.6	5.7	2.7
	5	2.5	1.2	5.7	2.7
68	4	1.2	0.6	9.8	4.6
	5	2.5	1.2	9.8	4.6
88	4	2.2	1.1	24.8	11.8
	5	5.1	2.4	24.8	11.8
108	4	2.2	1.1	31.2	14.8
	5	5.1	2.4	31.2	14.8
128	4	3.9	1.9	48.1	22.8
	5	5.1	2.4	48.1	22.8
148	4	3.9	1.9	65.3	30.9
	5	5.1	2.4	65.3	30.9
168	4	3.9	1.9	91.7	43.4
	5	8.7	4.0	91.7	43.4

All ILH 38 units are sealed for life and furnished with only one plug for filling and draining.

NOTE: 4 and 5 stage reduction reducer consists of two reducers assembled to each other, the Input Reducer and the Primary Reducer. The reducers are sealed from each other and require different oil levels per the chart.

\* Hole location on opposite side of reducer.



**NOTE: Shaded A2 mounting is not a recommended mounting position for continuous duty applications due to the weight of oil on the high speed input seal. A2 is not recommended for input speeds above 1750 rpm. A2 mounting can be used for intermittent duty applications.**

## IN LINE HELICAL C-FACE REDUCERS & INTEGRAL GEARMOTORS

These mounting arrangements are for all output configurations and output shaft types.

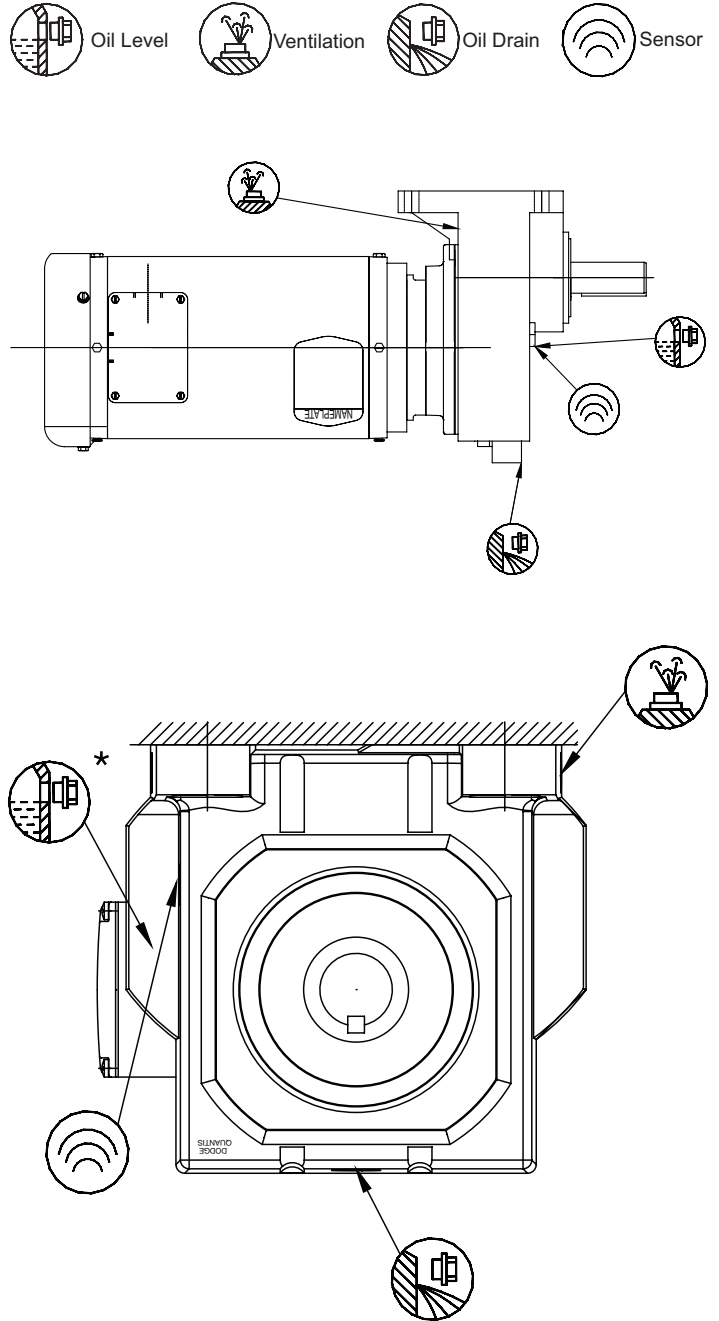
**IMPORTANT!** When ordering, please specify mounting position for correct oil quantity. In cases of mounting position other than shown here with regard to the oil quantity, please reference the Incline Mounting page in the Quantis Engineering Catalog and contact Application Engineering.

**NOTE:** The oil volumes shown are approximate values and cannot be used to correctly set the reducer oil level - **ALWAYS** fill the reducer to the correct oil level plug and recheck in 1 week.

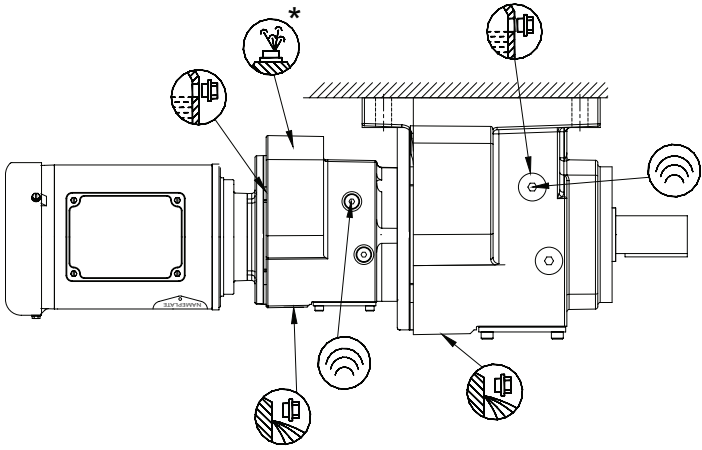
A3			
Unit Size	Reduction Stage	Pints	Liters
38	1	0.8	0.4
48	1	1.5	0.7
68	1	3.1	1.5
88	1	5.3	2.5

A3			
Unit Size	Reduction Stage	Pints	Liters
38	2	1.3	0.6
	3	1.3	0.6
48	2	3.2	1.5
	3	3.2	1.5
58	2	4.4	2.1
	3	4.6	2.2
68	2	5.3	2.5
	3	5.5	2.6
88	2	12.0	5.7
	3	12.5	5.9
108	2	18.2	8.6
	3	19.0	9.0
128	2	27.9	13.2
	3	29.8	14.1
148	2	50.5	23.9
	3	49.5	23.4
168	2	67.8	32.1
	3	71.4	33.8

### A3 - Horizontal - Ceiling Mount



A3					
Unit Size	Reduction Stage	Input Reducer Pints	Input Reducer Liters	Primary Reducer Pints	Primary Reducer Liters
38	4	0.8	0.4	1.8	0.9
	5	1.3	0.6	1.8	0.9
48	4	0.8	0.4	3.7	1.8
	5	1.3	0.6	3.8	1.8
68	4	0.8	0.4	7.2	3.4
	5	1.3	0.6	7.2	3.4
88	4	1.5	0.7	17.0	8.1
	5	3.2	1.5	17.0	8.1
108	4	1.5	0.7	29.8	14.1
	5	3.2	1.5	29.8	14.1
128	4	3.1	1.5	48.8	23.1
	5	3.2	1.5	48.8	23.1
148	4	3.1	1.5	62.0	29.3
	5	3.2	1.5	62.0	29.3
168	4	3.1	1.5	103.2	48.8
	5	5.3	2.5	103.2	48.8



All ILH 38 units are sealed for life and furnished with only one plug for filling and draining.

NOTE: 4 and 5 stage reduction reducer consists of two reducers assembled to each other, the Input Reducer and the Primary Reducer. The reducers are sealed from each other and require different oil levels per the chart.

\* Hole location on opposite side of reducer.



## IN LINE HELICAL C-FACE REDUCERS & INTEGRAL GEARMOTORS

These mounting arrangements are for all output configurations and output shaft types.

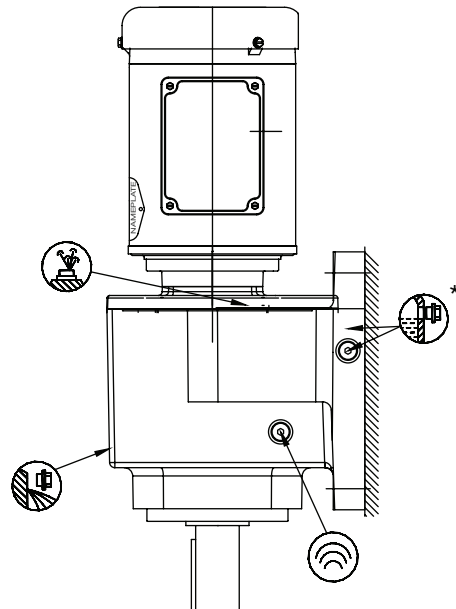
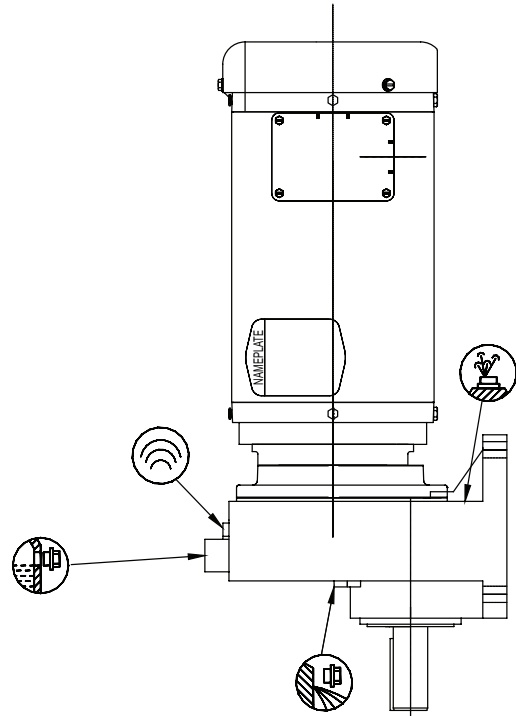
**IMPORTANT!** When ordering, please specify mounting position for correct oil quantity. In cases of mounting position other than shown here with regard to the oil quantity, please reference the Incline Mounting page in the Quantis Engineering Catalog and contact Application Engineering.

**NOTE:** The oil volumes shown are approximate values and cannot be used to correctly set the reducer oil level - **ALWAYS** fill the reducer to the correct oil level plug and recheck in 1 week.

A4			
Unit Size	Reduction Stage	Pints	Liters
38	1	1.0	0.5
48	1	1.5	0.7
68	1	3.7	1.8
88	1	4.9	2.3

A4			
Unit Size	Reduction Stage	Pints	Liters
38	2	1.5	0.7
	3	1.9	0.9
48	2	3.8	1.8
	3	4.9	2.3
58	2	5.7	2.7
	3	7.2	3.4
68	2	6.8	3.2
	3	8.5	4.0
88	2	15.9	7.5
	3	19.7	9.3
108	2	27.9	13.2
	3	33.0	15.6
128	2	42.1	19.9
	3	51.6	24.4
148	2	54.3	25.7
	3	68.1	32.2
168	2	96.6	45.7
	3	115	54.4

### A4 - Vertical Wall Mount - Motor Shaft Down



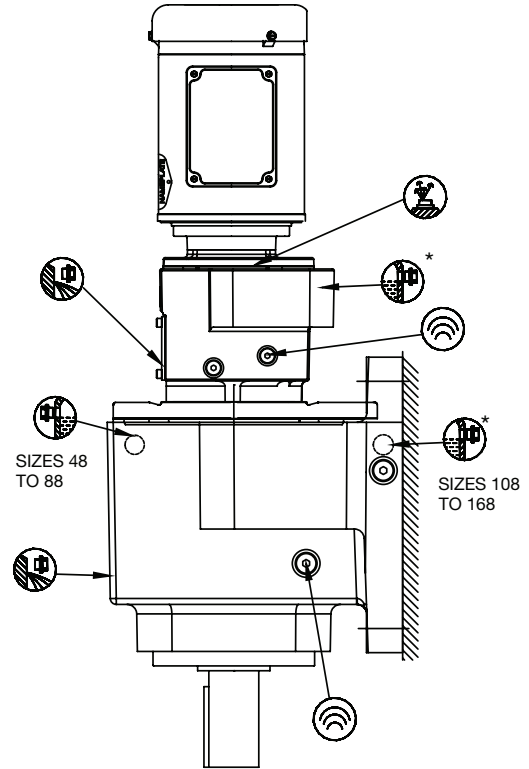
**NOTE:** A4 mounting is not recommended for input speeds above 1750 RPM.

A4					
Unit Size	Reduction Stage	Input Reducer Pints	Input Reducer Liters	Primary Reducer Pints	Primary Reducer Liters
38	4	1.0	0.5	2.2	1.0
	5	1.5	0.7	2.2	1.0
48	4	1.0	0.5	5.1	2.4
	5	1.5	0.7	5.1	2.4
68	4	1.0	0.5	9.0	4.3
	5	1.5	0.7	9.0	4.3
88	4	1.5	0.7	22.1	10.5
	5	3.8	1.8	22.1	10.5
108	4	1.5	0.7	35.7	16.9
	5	3.8	1.8	35.7	16.9
128	4	3.7	1.8	55.9	26.4
	5	3.8	1.8	55.9	26.4
148	4	3.7	1.8	72.9	34.5
	5	3.8	1.8	72.9	34.5
168	4	3.7	1.8	124.0	58.7
	5	6.8	3.2	124.0	58.7

All ILH 38 units are sealed for life and furnished with only one plug for filling and draining.

NOTE: 4 and 5 stage reduction reducer consists of two reducers assembled to each other, the Input Reducer and the Primary Reducer. The reducers are sealed from each other and require different oil levels per the chart.

\* Hole location on opposite side of reducer.



NOTE: A4 mounting is not recommended for input speeds above 1750 RPM.

## IN LINE HELICAL C-FACE REDUCERS & INTEGRAL GEARMOTORS

These mounting arrangements are for all output configurations and output shaft types.

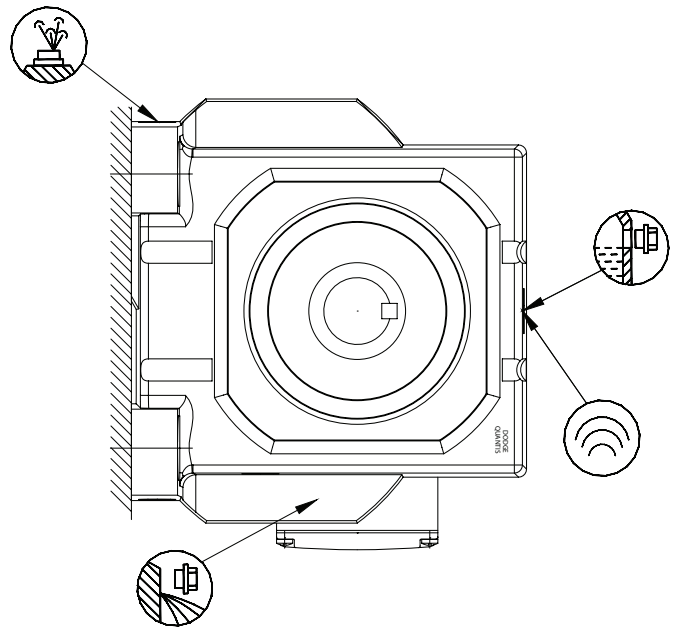
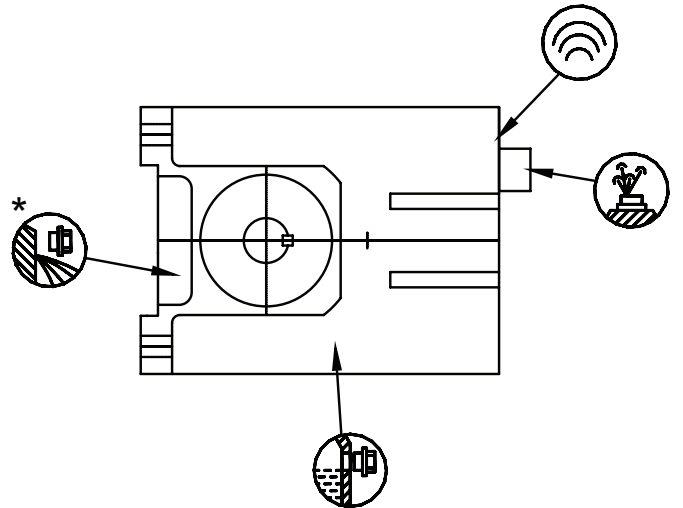
**IMPORTANT!** When ordering, please specify mounting position for correct oil quantity. In cases of mounting position other than shown here with regard to the oil quantity, please reference the Incline Mounting page in the Quantis Engineering Catalog and contact Application Engineering.

**NOTE:** The oil volumes shown are approximate values and cannot be used to correctly set the reducer oil level - **ALWAYS** fill the reducer to the correct oil level plug and recheck in 1 week.

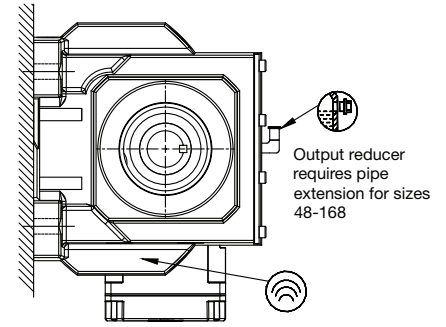
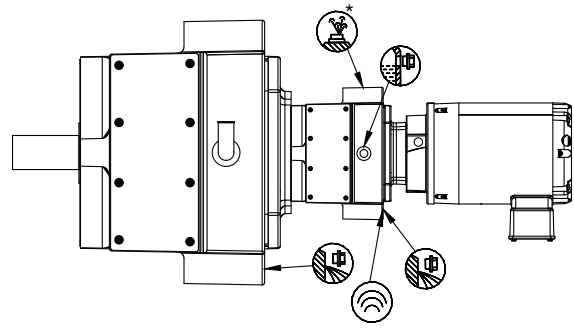
A5			
Unit Size	Reduction Stage	Pints	Liters
38	1	0.5	0.3
48	1	1.2	0.6
68	1	2.1	1.0
88	1	3.3	1.6

A5			
Unit Size	Reduction Stage	Pints	Liters
38	2	1.3	0.6
	3	1.3	0.6
48	2	3.4	1.6
	3	3.2	1.5
58	2	4.6	2.2
	3	4.6	2.2
68	2	5.7	2.7
	3	5.5	2.6
88	2	12.9	6.1
	3	12.5	5.9
108	2	22.2	10.5
	3	21.8	10.3
128	2	33.8	16.0
	3	33.4	15.8
148	2	44.0	20.8
	3	43.1	20.4
168	2	73.5	34.8
	3	72.1	34.1

### A5 - Horizontal - Wall Mount



A5					
Unit Size	Reduction Stage	Input Reducer Pints	Input Reducer Liters	Primary Reducer Pints	Primary Reducer Liters
38	4	0.5	1.3	1.9	0.9
	5	1.3	0.6	1.9	0.9
48	4	0.5	0.3	4.5	2.1
	5	1.3	0.6	4.5	2.1
68	4	0.5	0.3	7.8	3.7
	5	1.3	0.6	7.8	3.7
88	4	1.2	0.6	18.6	8.8
	5	3.4	1.6	18.6	8.8
108	4	1.2	0.6	31.7	15.0
	5	3.4	1.6	31.7	15.0
128	4	2.1	1.0	46.6	22.0
	5	3.4	1.6	46.6	22.0
148	4	2.1	1.0	61.3	29.0
	5	3.4	1.6	61.3	29.0
168	4	2.1	1.0	97.2	46.0
	5	5.7	2.7	97.2	46.0



All ILH 38 units are sealed for life and furnished with only one plug for filling and draining.

NOTE: 4 and 5 stage reduction reducer consists of two reducers assembled to each other, the Input Reducer and the Primary Reducer. The reducers are sealed from each other and require different oil levels per the chart.

\* Hole location on opposite side of reducer.

## IN LINE HELICAL C-FACE REDUCERS & INTEGRAL GEARMOTORS

These mounting arrangements are for all output configurations and output shaft types.

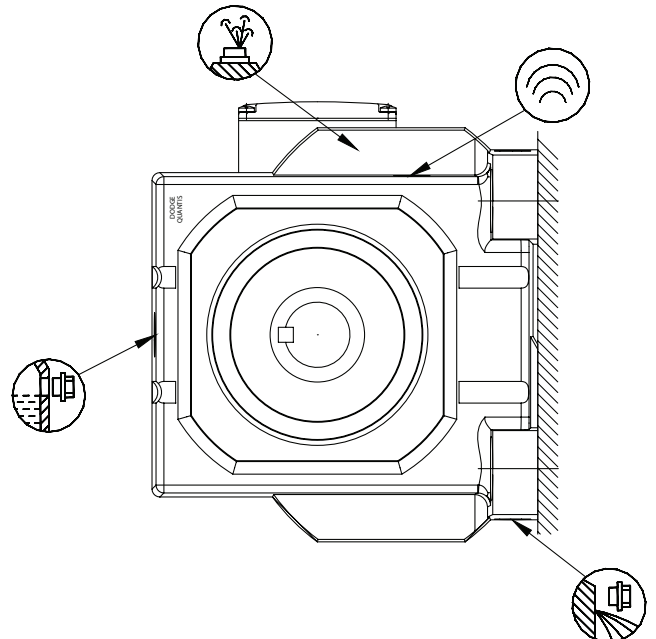
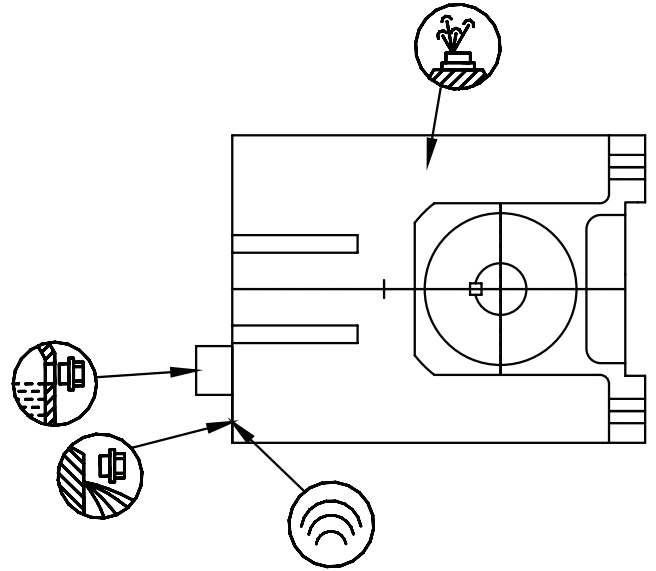
**IMPORTANT!** When ordering, please specify mounting position for correct oil quantity. In cases of mounting position other than shown here with regard to the oil quantity, please reference the Incline Mounting page in the Quantis Engineering Catalog and contact Application Engineering.

**NOTE:** The oil volumes shown are approximate values and cannot be used to correctly set the reducer oil level - **ALWAYS** fill the reducer to the correct oil level plug and recheck in 1 week.

A6			
Unit Size	Reduction Stage	Pints	Liters
38	1	0.5	0.3
48	1	1.0	0.5
68	1	2.2	1.1
88	1	3.4	1.6

A6			
Unit Size	Reduction Stage	Pints	Liters
38	2	1.3	0.6
	3	1.9	0.9
48	2	2.7	1.3
	3	3.0	1.4
58	2	4.0	1.9
	3	4.2	2.0
68	2	4.9	2.3
	3	5.1	2.4
88	2	11.2	5.3
	3	11.4	5.4
108	2	19.7	9.3
	3	20.1	9.5
128	2	29.8	14.1
	3	31.3	14.8
148	2	38.7	18.3
	3	40.4	19.1
168	2	63.6	30.1
	3	65.9	31.2

### A6 - Horizontal - Wall Mount

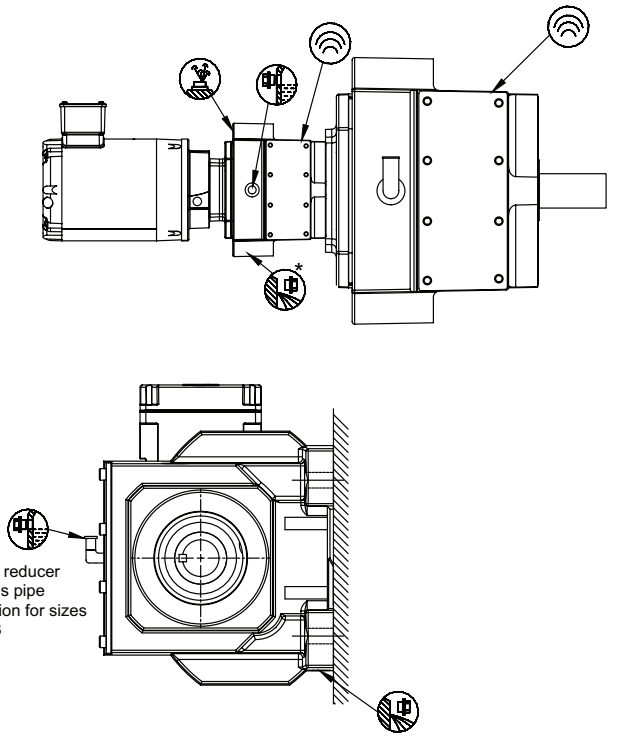


A6					
Unit Size	Reduction Stage	Input Reducer Pints	Input Reducer Liters	Primary Reducer Pints	Primary Reducer Liters
38	4	0.5	0.3	1.6	0.7
	5	1.3	0.6	1.6	0.7
48	4	0.5	0.3	3.3	1.6
	5	1.3	0.6	3.3	1.6
68	4	0.5	0.3	6.5	3.1
	5	1.3	0.6	6.5	3.1
88	4	1.0	0.5	15.6	7.4
	5	2.7	1.3	15.6	7.4
108	4	1.0	0.5	26.4	12.5
	5	2.7	1.3	26.4	12.5
128	4	2.2	1.1	39.4	18.6
	5	2.7	1.3	39.4	18.6
148	4	2.2	1.1	49.8	23.6
	5	2.7	1.3	49.8	23.6
168	4	2.2	1.1	78.2	37.0
	5	4.9	2.3	78.2	37.0

All ILH 38 units are sealed for life and furnished with only one plug for filling and draining.

NOTE: 4 and 5 stage reduction reducer consists of two reducers assembled to each other, the Input Reducer and the Primary Reducer. The reducers are sealed from each other and require different oil levels per the chart.

\* Hole location on opposite side of reducer.



## LONG-TERM STORAGE

**NOTE: Unless an extended warranty has been negotiated prior to sale, time in storage is considered time in service for warranty purposes.**

If the drive is not installed immediately, it should be stored in a clean, dry, protected area. During periods of long term storage (six months or longer) special procedures must be followed. The unit should be filled to the highest oil level hole with an approved lubricant blended with 2%, by volume, of “Daubert Chemical Co. Nox-Rust VCI-105” oil. Apply a thick coating of rust preventative on all unpainted surfaces including threads, bores, keyways, and shafts. Apply a thick coating of chassis-type grease to all exposed shaft seals. If the unit is to be stored outdoors or in a damp, unheated area indoors, cover the entire exterior with a rust preventative. Seal the unit in a moisture proof container or wrapping with a desiccant inside. Shade the enclosure from direct sunlight. Rotate the input shaft at least 60 revolutions once a month to redistribute the lubricant and prevent brinnelling of bearings and drying of seals.

Upon removal from storage, remove all protective coatings applied for protection during storage. Check all hardware for proper tightness. Drain and refill the gear reducer with a recommended lubricant. If the gear reducer has been stored for more than three years or in an area with high ambient temperatures, replace the oil seals. Upon removal from storage, remove all protective coatings applied for protection during storage. Check all hardware for proper tightness. Drain and refill the gear reducer with a recommended lubricant. If the gear reducer has been stored for more than three years or in an area with high ambient temperatures, replace the oil seals.

## INSTALLATION AND OPERATION

Quantis ILH Reducers are shipped with filling, oil level and drain plugs in place. A separate breather is included with the unit. Before putting the unit into service the filling plug must be replaced with the breather. Install the oil level plug and breather plug in the correct location for the appropriate mounting position using the Mounting Position Diagrams. Add or drain oil to get to the correct oil level for the mounting position used.

Review the data plates on the reducer and drive motor to verify that the drive is correct for the intended loads, speeds and power supply. The gear reducer should be installed in a location that meets the following requirements:

- Ambient temperatures below 105°F (41°C).
- Free flow of air around the motor.
- Good access to gear reducer and motor for maintenance.
- A flat, level, rigid steel mounting surface.
- All four feet of the foot-mounted unit must be evenly supported.
- The flange mounted unit must have even support at the flange face.
- Units supported by both flange and feet must be shimmed to avoid housing stress.
- Good alignment to both input and output devices.



## INSTALLATION OF COMPONENTS ON GEAR REDUCER SHAFTS

Use care when installing couplings, sprockets and sheaves (pulleys) on the Quantis ILH input and output shafts. Such components should not be hammered into place. Damage to shafts and bearings may result. If parts do not slip into place easily, check for dirt or burrs that may be binding the assembly. Very tightly fitted parts may need to be heated to get them onto the shafts. Keys should be located for maximum engagement between the shaft and the associated part. Sprockets and sheaves should be mounted as close to the gearcase as possible to minimize overhung loads. Retaining hardware (setscrews, etc.) for couplings, sprockets and sheaves should be tightened as recommended by the component manufacturer. Chain and belt drives must be aligned to run true. Tighten chains and belts according to the chain or belt manufacturer’s instructions. Excessive tension results in rapid chain and belt wear and reduces the bearing life of the Quantis ILH unit.

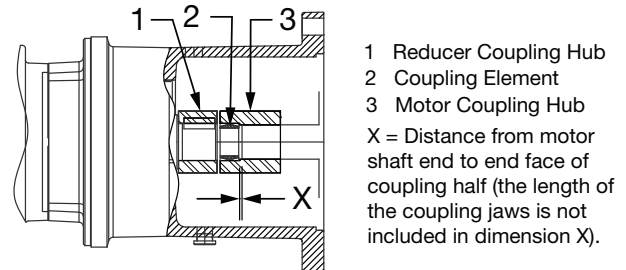


Figure 1 - Three-Piece Coupling Assembly

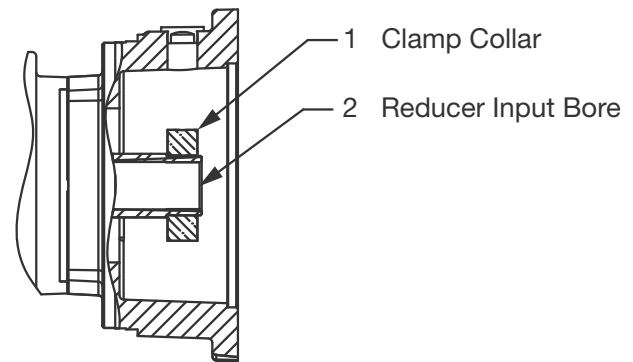


Figure 2 - Clamp Collar Assembly

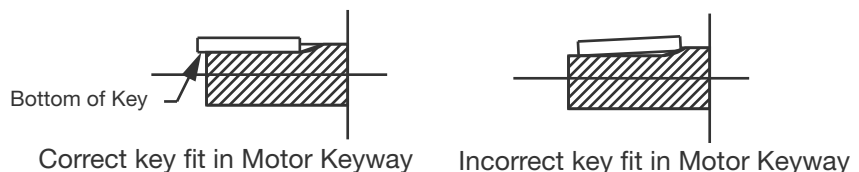


Figure 3 - Clamp Collar Motor Key Fit

**Table 2–Mounting Motors to C-Face Reducers**

For 3-Piece Coupled Input Reducers (Reference Figure 1)	For Clamp Collar Input Reducers (Reference Figure 2)
Prepare the motor by checking the motor shaft extension for dirt or damage. Remove any anti-rust coating that may be on the shaft. Apply a thin even coating of anti-seize compound to the entire motor shaft.	Prepare the motor by checking the motor shaft extension for dirt or damage. Use solvent to remove all traces of anti-rust coating that may be on the shaft.
Insert the coupling key into the motor shaft keyway. Slip the motor coupling half onto the motor shaft and locate it a distance “x” from the motor shaft end. Refer to Figure 1 for definition of distance “x.” Refer to the Table 3 for values of “x” for each motor.	Check the input bore for dirt or damage. Clean the bore with solvent to remove all traces of oil or anti-rust coating.
Tighten the motor coupling half setscrew to the correct torque value listed below.	For NEMA motors ONLY: A special long, tall motor key is provided with the Quantis unit.
Check that the reducer coupling half, with its key in place, is mounted on the reducer input shaft inside the C-face adapter. Make sure this coupling half is mounted on the reducer shaft such that the shaft extends the complete length of the coupling bore. Insert the coupling spider properly into the coupling jaws.	<ol style="list-style-type: none"> <li>1. Discard the motor key and replace it with the special key provided. DO NOT USE THE MOTOR KEY.</li> <li>2. If the special key does not fit snugly in the motor shaft keyway, prepare the key for assembly by nicking its bottom in a couple of spots. A chisel may be used to accomplish this. This must be done on a work surface away from the Quantis unit and the motor. This nicking should widen the key bottom and cause it to fit snugly in the motor keyway. Refer to Figure 3 for definition of key bottom.</li> <li>3. Install the key in the motor shaft keyway by lightly tapping it in place with a rubber mallet.</li> <li>4. Locate the key so that it sits flat in the motor shaft keyway. The key will probably extend beyond the end of the motor shaft. This is OK. The key MUST NOT sit tilted in the keyway. A tilted key can occur when a motor shaft has a sled runner keyway, Refer to Figure 3.</li> <li>5. Mark the clamp collar with a fine tipped marker on both sides of the setscrew to indicate where the center of the set screw is located. Run a line down both sides of the clamp collar that line up with the line previously created.</li> <li>6. Remove the socket head screw and set screw from the clamp collar and apply Loctite 243 thread locker. Reinstall the screws into the clamp collar. Install the clamp collar onto the reducer input shaft and line up the mark previously made on the clamp collar with the center of the keyway in the shaft. If the clamp collar rotates freely, tighten the clamping screw slightly to keep it from rotating during assembly. Make sure the marked line is pointing to the center of the keyway.</li> </ol>
The Quantis ILH C-Face reducer should be firmly anchored to prevent sliding as the motor is mounted. The motor should be rotated on its axis so the motor flange holes line up with the C-Face adapter holes. Check to be sure the motor conduit box, grease fittings and condensations drains (where fitted) will be oriented as needed by the reducer mounting position.	The Quantis ILH C-Face reducer should be firmly anchored to prevent sliding as the motor is mounted. The motor should be rotated on its axis so the motor flange holes line up with the C-Face adapter holes. Check to be sure the motor conduit box, grease fittings and condensate drains (where fitted) will be oriented as needed by the reducer mounting position.
Hoist motor level and in line with reducer input shaft. For EZ Kleen Quantis reducers with 180TC or larger NEMA input, install the o-ring provided onto the motor pilot to seal the input assembly from water ingress.	Hoist motor level and in line with reducer input shaft. For EZ Kleen Quantis reducers with 180TC or larger NEMA input, install the o-ring provided onto the motor pilot to seal the input assembly from water ingress.
Align the motor coupling half such that its jaws are aligned with the gaps between the spider and the reducer coupling half jaws. Push the motor into place. Motor flange to C-face adapter clearances are tight and good alignment is essential.	Align the motor shaft with the gear reducer input bore making sure that the motor shaft keyway is in line with the input bore key. Push the motor into place. Motor shaft to input bore clearances are tight and good alignment is essential.
Insert and tighten the motor retaining bolts Tighten to the correct torque value listed in Table 3.	Insert and tighten the motor retaining bolts. Tighten to the correct torque value listed in Table 3.



Table 3–Mounting Motors to C-Face Reducers

For 3-Piece Coupled Input Reducer (Reference Figure 1)			For Clamp Collar Input Reducers (Reference Figure 2)		
NEMA Motor Frame	Motor Bolt	Bolt Tightening Torque	NEMA Motor Frame	Motor Bolt	Bolt Tightening Torque
56C, 140TC	3/8-16	276 lb-in (31 Nm)	56C, 140TC	3/8-16	276 lb-in (31 Nm)
180TC, 210TC, 250TC, 280TC	1/2-13	660 lb-in (75 Nm)	180TC, 210TC, 250TC, 280TC	1/2-13	660 lb-in (75 Nm)
320TC, 360TC	5/8-11	1320 lb-in (150 Nm)	320TC, 360TC	5/8-11	1320 lb-in (150 Nm)
IEC Motor Frame	Motor Bolt	Bolt Tightening Torque	IEC Motor Frame	Motor Bolt	Bolt Tightening Torque
71	M8	220 lb-in (25 Nm)	71	M8	220 lb-in (25 Nm)
80, 90	M10	440 lb-in (50 Nm)	80, 90	M10	440 lb-in (50 Nm)
100, 112, 132	M12	800 lb-in (90 Nm)	100, 112, 132	M12	800 lb-in (90 Nm)
160, 180, 200, 225, 250	M16	1860 lb-in (210 Nm)	160, 180, 200, 225, 250	M16	1860 lb-in (210 Nm)
EZ Kleen Input Motor Bolt Tightening Torques					
For 3-Piece Coupled Input Reducer (Reference Figure 2)			For Clamo Collar Input Reducers (Reference Figure 2)		
NEMA Motor Frame	Motor Bolt	Bolt Tightening Torque	NEMA Motor Frame	Motor Bolt	Bolt Tightening Torque
56C, 140TC	3/8-16	236 lb-in (27 Nm)	56C, 140TC	3/8-16	236 lb-in (27Nm)
180TC, 210TC, 250TC, 280TC	1/2-13	516 lb-in (58 Nm)	180TC, 210TC, 250TC, 280TC	1/2-13	516 lb-in (58 Nm)
320TC, 360TC	5/8-11	1104 lb-in (125 Nm)	320TC, 360TC	5/8-11	1104 lb-in (125 Nm)
IEC Motor Frame	Motor Bolt	Bolt Tightening Torque	IEC Motor Frame	Motor Bolt	Bolt Tightening Torque
71	M8	186 lb-in (21 Nm)	71	M8	186 lb-in (21 Nm)
80, 90	M10	372 lb-in (42 Nm)	80, 90	M10	372 lb-in (42 Nm)
100, 112, 132	M12	646 lb-in (73 Nm)	100, 112, 132	M12	646 lb-in (73 Nm)
160, 180, 200, 225, 250	M16	1593 lb-in (180 Nm)	160, 180, 200,	M16	1593 lb-in (180 Nm)
For 3-Piece Coupled Input Reducers (Reference Figure 1)			For Clamp Collar Input Reducers (Reference Figure 2)		
View the coupling assembly through the access hole in the C-face adapter. 1. Make sure the couplings jaws fully engage the spider. If they do not, loosen the setscrew in the reducer coupling half and slide it forward until full jaw engagement is achieved. However, make sure the jaws on one coupling half do not contact the hub of the other coupling half. 2. Reaching through the access hole in the C-face adapter with a hex key, tighten the coupling setscrew on the reducer coupling half to the recommended torque given below.			View the clamp collar through the access holes in the C-face adapter. 1. Rotate the clamp collar to locate the setscrew over the key, if necessary. 2. Tighten the setscrew to the torque referenced below. 3. Reach through the access hole in the C-face adapter with a hex socket and tighten the clamp collar clamping bolt to the torque value given below.		
Replace the access hole plugs in the C-face adapter.			Replace the access hole plugs in the C-face adapter.		
<b>NOTE: A TEE handle hex key wrench is not stiff enough to properly tighten the coupling setscrews. A large diameter socket wrench extension with a short hex key insert must be used in conjunction with a torque wrench. Failure to tighten the setscrews to the proper torque may result in movement between shafts and coupling components and cause premature wear on the shafts, coupling and keys.</b>			<b>NOTE: A TEE handle hex key wrench is not stiff enough to properly tighten the clamp collar bolt. A socket wrench extension with a hex insert must be used in conjunction with a torque wrench. Failure to tighten the clamp collar to the proper torque may result in movement between motor and reducer shafts and cause premature wear on the shafts and keys.</b>		

Table 3—Mounting Motors to C-Face Reducers

For 3-Piece Coupled Input Reducers (Reference Figure 1)					For Clamp Collar Input Reducers (Reference Figure 2)				
NEMA Motor Frame	Coupling Size	Setscrew Size	Setscrew Tightening Torque	Motor Coupling Half Position Dimension “X”	NEMA Motor Frame	Clamp Bolt	Clamp Bolt Tightening Torque	Setscrew Size	Set Screw Tightening Torque
56	19	M5	18 lb-in (2 Nm)	0	56	M6	132 lb-in (15 Nm)	M4	27 lb-in (3 Nm)
140	19	M5	18 lb-in (2 Nm)	0	140	M6	132 lb-in (15 Nm)	M4	27 lb-in (3 Nm)
180	24	M5	18 lb-in (2 Nm)	0	180	M8	312 lb-in (35 Nm)	M6	90 lb-in (10 Nm)
210	28	M8	90 lb-in (10 Nm)	0	210	M10	600 lb-in (68 Nm)	M8	220 lb-in (25 Nm)
250	38	M8	90 lb-in (10 Nm)	0	250	M8	312 lb-in (35 Nm)	M6	90 lb-in (10 Nm)
280	42	M8	90 lb-in (10 Nm)	0	280	M8	312 lb-in (35 Nm)	M6	90 lb-in (10 Nm)
320	48	M8	90 lb-in (10 Nm)	0	320	M10	600 lb-in (68 Nm)	M8	220 lb-in (25 Nm)
360	55	M10	150 lb-in (17 Nm)	0	360	M10	600 lb-in (68 Nm)	M8	220 lb-in (25 Nm)
IEC Motor Frame	Coupling Size	Setscrew Size	Setscrew Tightening Torque	Motor Coupling Half Position Dimension “X”	IEC Motor Frame	Clamp Bolt	Clamp Bolt Tightening Torque	Setscrew Size	Set Screw Tightening Torque
80	19	M5	18 lb-in (2 Nm)	0	80	M6	132 lb-in (15 Nm)	M4	27 lb-in (3 Nm)
90	19	M5	18 lb-in (2 Nm)	0	90	M8	312 lb-in (35 Nm)	M6	90 lb-in (10 Nm)
100	24	M5	18 lb-in (2 Nm)	0	100	M8	312 lb-in (35 Nm)	M6	90 lb-in (10 Nm)
112	24	M5	18 lb-in (2 Nm)	0	112	M8	312 lb-in (35 Nm)	M6	90 lb-in (10 Nm)
132	28	M6	42 lb-in (4.8 Nm)	0	132	M10	600 lb-in (68 Nm)	M8	220 lb-in (25 Nm)
160	38	M8	90 lb-in (10 Nm)	0	160	M8	312 lb-in (35 Nm)	M6	90 lb-in (10 Nm)
180	42	M8	90 lb-in (10 Nm)	0	180	M8	312 lb-in (35 Nm)	M6	90 lb-in (10 Nm)
200	42	M8	90 lb-in (10 Nm)	0	200	M10	600 lb-in (68 Nm)	M8	220 lb-in (25 Nm)
225	48	M8	90 lb-in (10 Nm)	0.236 in (6.0 mm)					
250	55	M10	150 lb-in (17 Nm)	0					

**WARNING:** The Quantis ILH and its connected equipment and accessories must be guarded. Rotating parts such as couplings, pulleys, fans and unused shaft extensions must be permanently guarded by the user against accidental contact with personnel and their clothing. The surface temperature of the Quantis ILH enclosure may reach temperatures which can cause discomfort or injury to personnel accidentally coming into contact with hot surfaces. The user should provide guards to prevent accidental contact with hot surfaces. Guards must be sufficiently rigid to maintain adequate guarding in normal service.

**WARNING:** Threaded hardware used to mount the Quantis ILH Unit must be SAE Grade 5 or Metric Class 8.8 or better. **DO NOT USE HARDWARE OF A LOWER GRADE.**

## MAINTENANCE

Check oil levels and oil quality regularly. Change oil at the intervals specified in the Lubricants section of this document. Check alignments of drive components regularly. Check chain and belt tensions and hardware tightness periodically too.

## BOLTS TO BE USED ON MOUNTING FEET AND B5 OUTPUT FLANGES

In addition to the bolts below, it is recommended that a lockwasher or other anti-loosening device be used.

**Table 4–Bolts to be used on Mounting Feet**

Unit Size	Reducer Stage	Grade 5 Inch	Grade 8.8 Metric
38	1	3/8-16 UNC	M10 x 1.5
	2, 3, 4, 5	5/16-18 UNC	M8 x 1.25
48	1	1/2-13 UNC	M12 x 1.75
	2, 3, 4, 5	1/2-13 UNC	M12 x 1.75
58	2, 3	1/2-13 UNC	M12 x 1.75
68	1	5/8-11 UNC	M16 x 2
	2, 3, 4, 5	5/8-11 UNC	M16 x 2
88	1	5/8-11 UNC	M16 x 2
	2, 3, 4, 5	5/8-11 UNC	M16 x 2
108	2, 3, 4, 5	3/4-10 UNC	M20 x 2.5
128	2, 3, 4, 5	7/8-9 UNC	M24 x 3
148	2, 3, 4, 5	1-1/4-7 UNC	M30 x 3.5
168	2, 3, 4, 5	1-1/2-6 UNC	M36 x 4

**Table 5–Bolts and Tightening Torque for B5 and NEMA Output Flanges (Output flange to gearcase)**

Unit Size	Reducer Stage	Grade 8.8 Metric	Tightening Torque (Nm)	Tightening Torque (ft-lb)
38	1	M8	25	18
	2, 3, 4, 5	M8	25	18
48	1	M8	25	18
	2, 3, 4, 5	M10	50	37
58	2, 3	M10	50	37
68	1	M10	50	37
	2, 3, 4, 5	M12	90	66
88	1	M12	90	66
	2, 3, 4, 5	M16	210	155
108	2, 3, 4, 5	M16	210	155
128	2, 3, 4, 5	M16	210	155
148	2, 3, 4, 5	M16	210	155
168	2, 3, 4, 5	M20	400	295

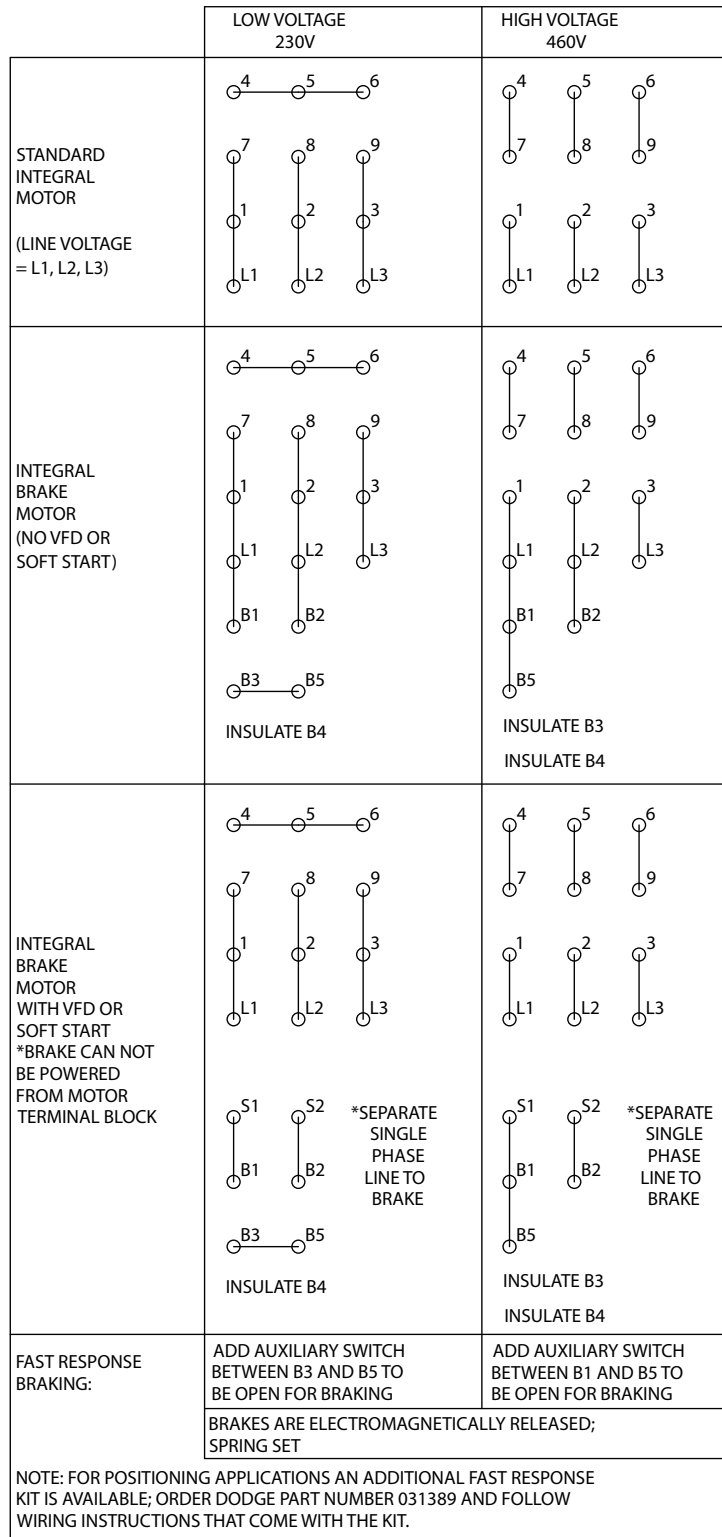


Figure 4 - Wiring Diagram for Dual Voltage/Single Speed Integral Motor

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