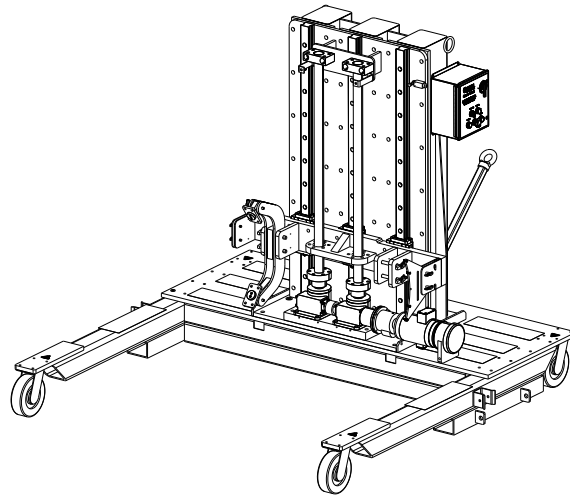




Operation & Service Manual



Model: 08-2037-0000
Lear 85 – PW307B
Engine Installation Tool



03/2013 – Rev. 02

Includes Illustrated Parts Lists

REVISION
01
02

DATE
04/2012
03/2013

TEXT AFFECTED
Original Release
Major Revision

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Additional Documents:
GS2M VFD User Manual

This product can not be modified without the written approval of Tronair, Inc. Any modifications done without written approval voids all warranties and releases Tronair, Inc., its suppliers, distributors, employees, or financial institutions from any liability from consequences that may occur. Only Tronair OEM replacement parts shall be used.

1.0 DESCRIPTION

Tronair Model 08-2037-0000 Engine Installation Tool is designed for use with the Lear 45, 60 and 85 engines. Unit comes equipped with Lear 85 engine adaptor.

Required engine adaptors for use on Lear 45 or 60:

Kit	Aircraft	Engine
K-4662	Lear 45	TFE-731-20
K-4663	Lear 60	PW305

2.0 USAGE

The purpose of this stand is to allow mechanics easy access to the engine system during engine transport, build up and maintenance procedures.

3.0 SPECIFICATIONS

- Length: 102 ½ in (259.4 cm)
- Width: 105 in (266.7 cm)
- Height: 84 9/16 in (214.8 cm)
- Weight: 5,500 lbs (2,495 kg)
- Travel distance from engine centerline to ground: 31 in to 73 in (42 in total travel)

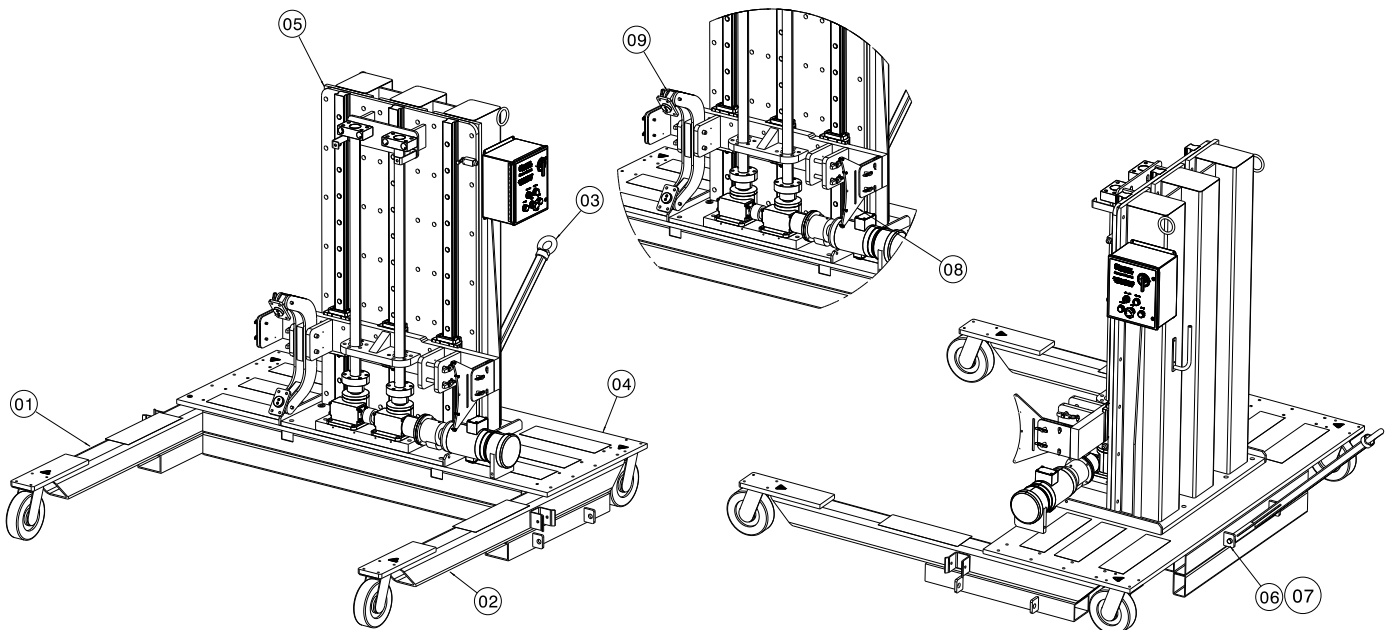
4.0 ASSEMBLY INSTRUCTIONS

4.1 GENERAL INFORMATION

The 08-2037-0000 Engine Installation Tool is assembled in five major pieces. A minimum 3 ton capacity crane and forklift is required for assembly or disassembly.

4.2 ASSEMBLY STEPS

1. Remove and inspect all pieces before beginning assembly



2. Ensure all bolts are tightened to the minimum ft/lbs torque as supplied in attached chart
3. Assemble Items 1 and 2 to Item 4 using ½ - 20 GR 8 hardware provided
 - G-1420-109020.....Bolt, ½ - 20 x 2.5 LG Hex HD Grade 816
 - G-1250-1090NFlatwasher, ½ Narrow.....16
4. Assemble Item 3 to Item 4 using Items 6 and 7

4.2 ASSEMBLY STEPS (continued)

5. Assemble Item 5 to Item 4 using ¾ - 16 GR 8 hardware provided
 - G-1420-111534.....Bolt, ¾ - 16 x 3.5 LG Hex HD Grade 810
 - G-1250-1110NFlatwasher, ¾ Narrow20
 - G-1520-1115.....ESN, ¾ - 16 Grade 810
6. Install Items 8 and 9 to stand based on engine type
7. Plug unit into 120 V power source. Turn knob to “on” position. Extend and retract jack screws. Operate unit with no load and test for binding and/or misalignment in jack screws and carriages
8. Test E-stop

**CAUTION**

Persons should not position themselves under engine at any time.

**CAUTION**

Always transport engine in lowest position

5.0 OPERATING INSTRUCTIONS

1. Plug unit into 120 volt power source with 30 amp circuit breaker
2. Turn power switch to “on”
3. Hold “Retract” or “Extend” button in to move carriage down or up as required
4. Install engine pads and rear stabilizing plate to engine
5. Secure engine to stand by engaging engine pads and rear plate into stand. Pin all connections using ball-lok pins provided
6. Ensure engine is fully supported in the stand before removing engine from engine sling or previous support
7. Hold “Retract” or “Extend” button in to move carriage down or up as required
8. Power switch must be turned to the “off” position before disconnecting power from unit

**CAUTION**

Engine stand must be checked at all four casters while engine stand is immobilized. Ensure floor lock is tightened securely to prevent movement.

6.0 MAINTENANCE

- Engine stand should be inspected for loose or missing hardware before each use
- Check E-stop and limit switches periodically for proper operation
- Helical gear system requires 14 oz oil and should be changed every 1500 hours of operation (see attached IPTS operating instructions)
- Jack screws should be lubricated every three months per APPENDIX IV
- Use a lithium based grease every six months to lubricate the three carriage assemblies
- Stand should be load tested once a year using a 3,000 lb test block or equivalent device

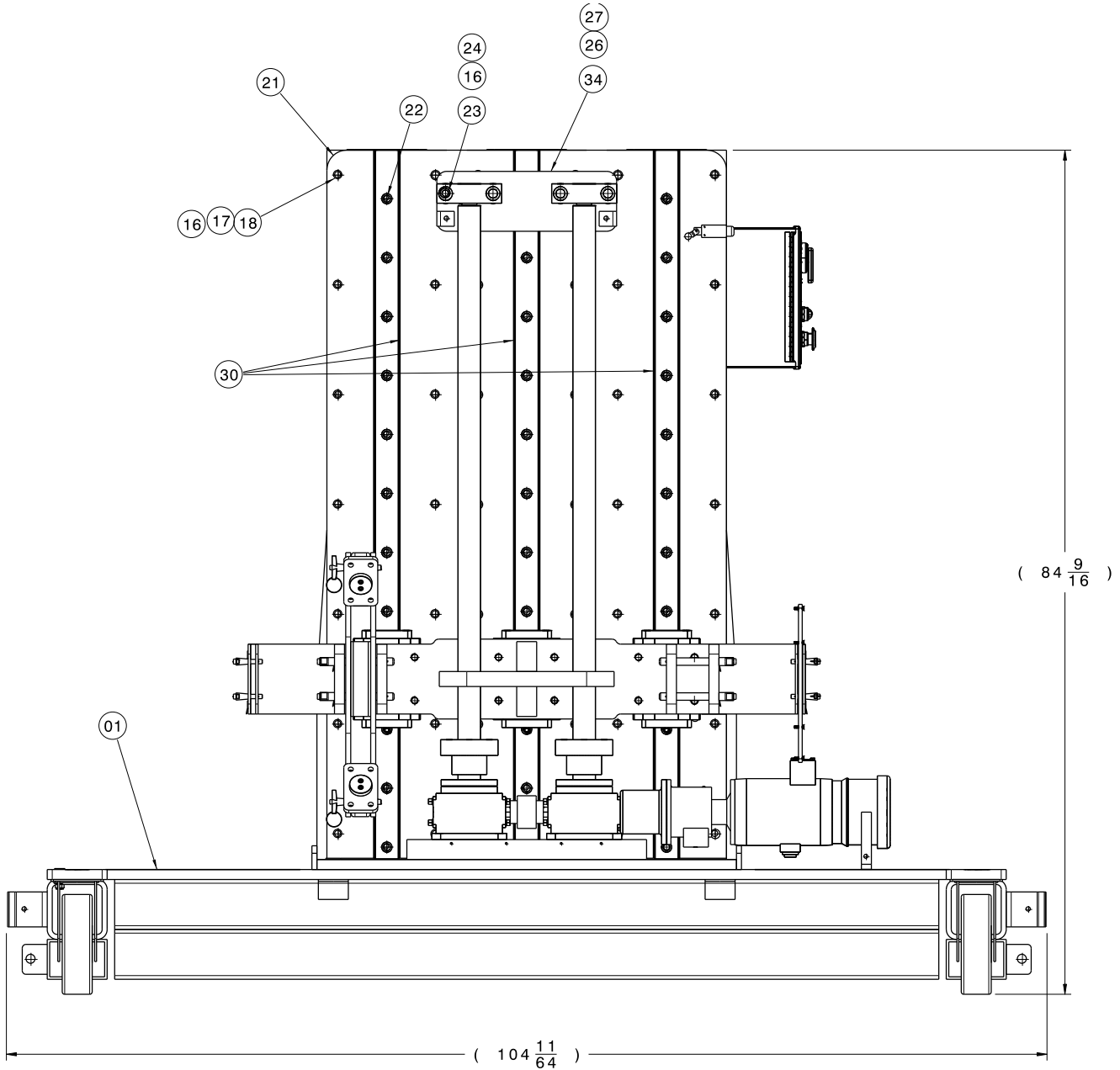
7.0 TROUBLE SHOOTING

If unit does not extend or retract:

- Check that E-stop is pulled out
- Open control panel cover and check for error codes on VFD. Consult VFD user manual
- Check power source and appropriate fuses
- Check wiring per APPENDIX I – INS-2163

Parts List

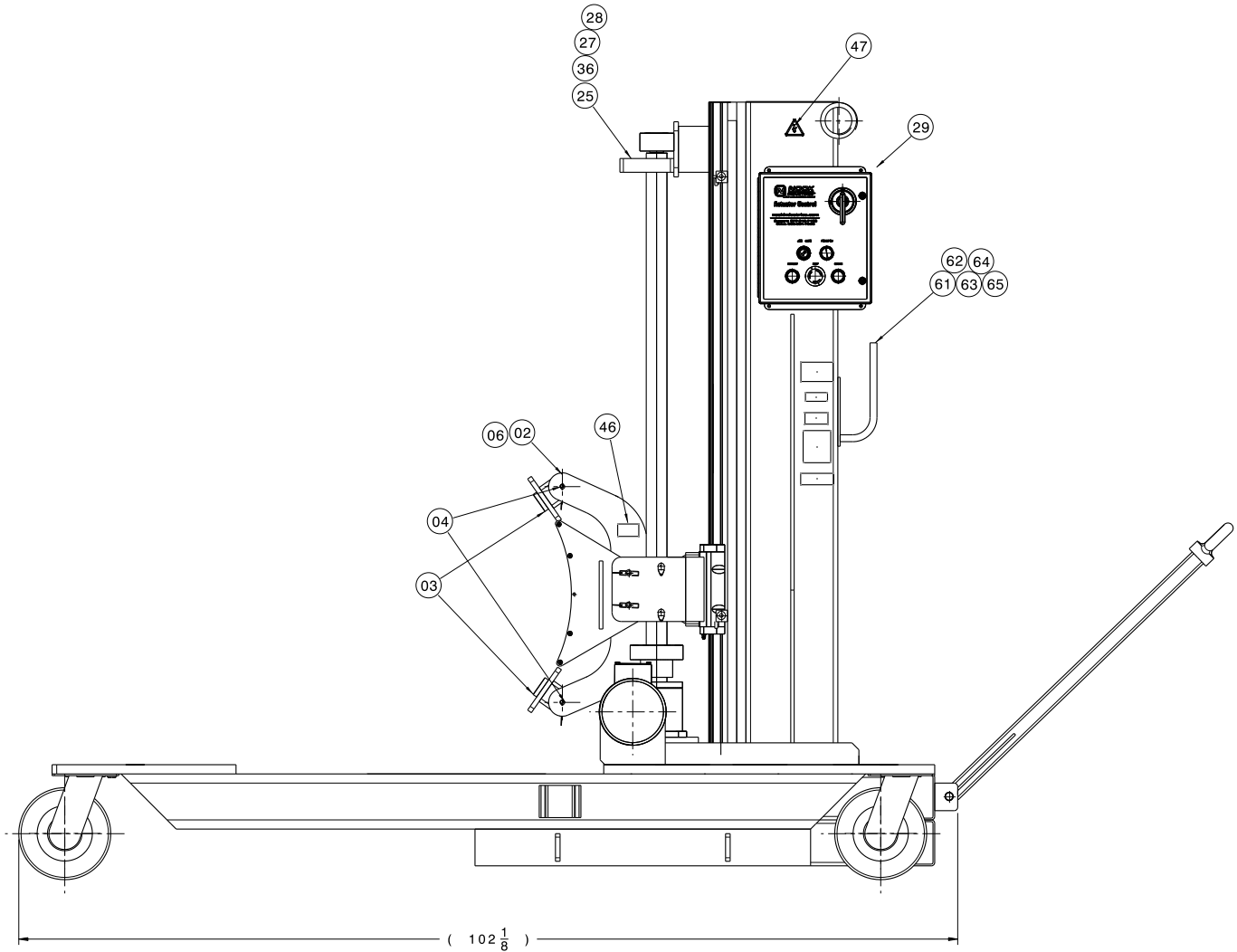
When ordering replacement parts/kits, please specify model, serial number and color of your unit.



ITEM	PART NUMBER	DESCRIPTION	QTY
1	Z-7702	Assembly, Base	1
16	G-1250-1110N	Flatwasher, 3/4 Narrow	74
17	G-1251-1110R	Lockwasher, 3/4 Regular	52
18	G-1420-111524	Bolt, Hex Head, GR 8, 3/4 - 16 x 2 1/2 Long	50
21	J-5085-01	Plate, Front Common Base	1
22	G-1151-110722	Screw, Hex Soc HD Cap, 5/8 - 18 x 2 1/4 Long	36
23	G-1151-111750	Screw, Hex Soc HD Cap, 3/4 - 16 x 5 Long	4
24	G-1520-1115	ESN, GR 8, 3/4 - 16	4
26	G-1420-109524	Bolt, Hex Head, GR 5, 1/2 - 20 x 2 1/2 Long	6
27	G-1250-1090N	Flatwasher, 1/2 Narrow	10
30	H-3495	Profile, Rail	3
34	Z-7818-01	Weldment, Middle Support	1

Parts List

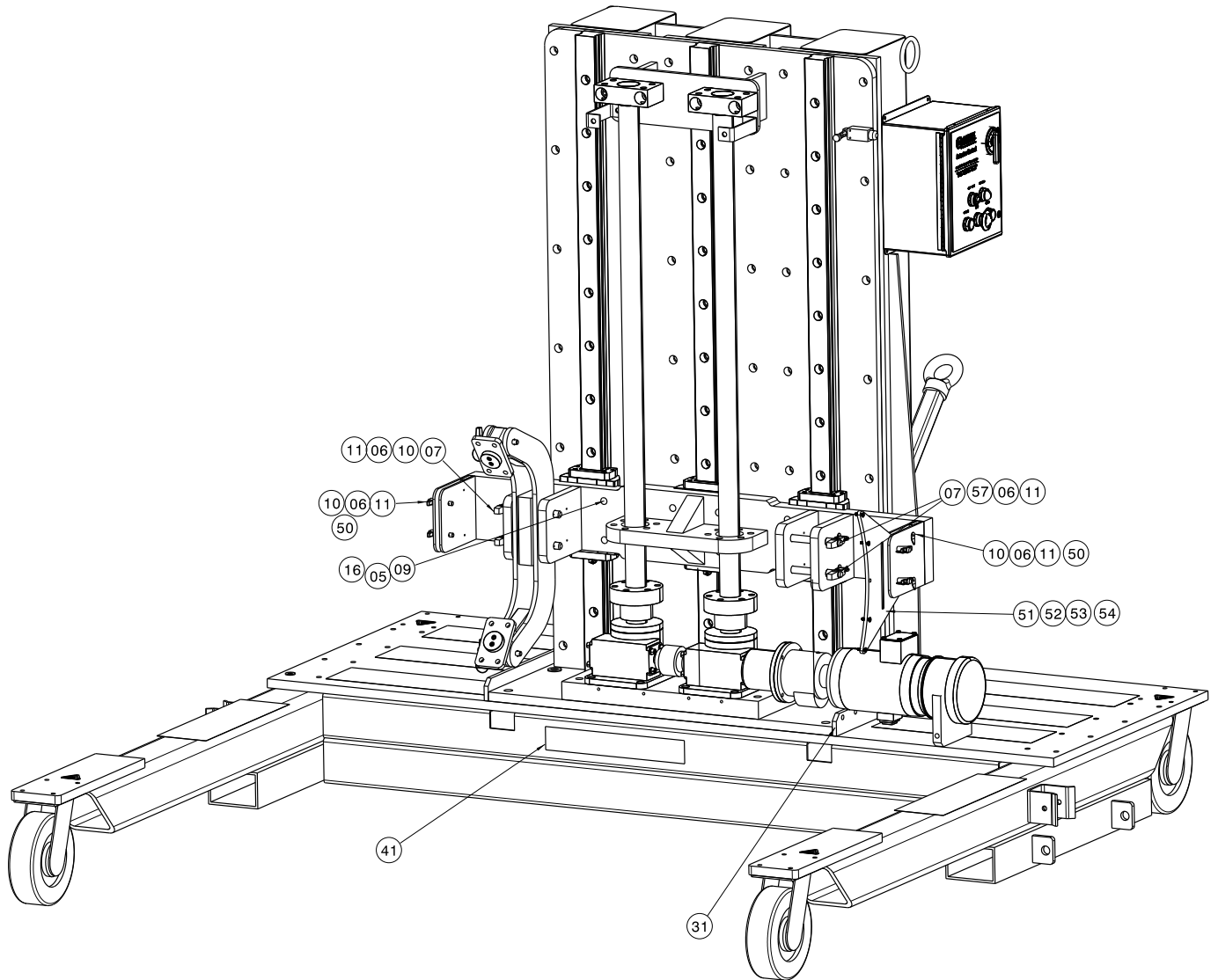
When ordering replacement parts/kits, please specify model, serial number and color of your unit.



ITEM	PART NUMBER	DESCRIPTION	QTY
2	Z-7696-01	Weldment, Assembly Arm	1
3	Z-7697	Assembly, Arm Pad	2
4	G-1310-0831	Pin, 1/2 x 3.1 Ball Lok-T	2
6	H-1026*12	Assembly, Lanyard	10
25	J-5083-01	Bracket, Cover	2
27	G-1250-1090N	Flatwasher, 1/2 Narrow	8
28	G-1202-1095	ESN, 1/2 - 20	4
29	H-3498	Control Box	1
36	G-1100-109512	Bolt, Hex HD GR 5, 1/2 - 20 x 1 1/4 Long	4
46	V-2100	Label, Heavy Object	1
47	V-1050	Label, ISO Electrical	1
61	Z-7013-01	Assembly, Cable Hanger	1
62	H-1206	Cap, End	1
63	G-1503-1050N	Flatwasher, 1/4 Narrow	2
64	G-1502-1050R	Lockwasher, 1/4 Regular	2
65	G-1476-105010	Screw, 1/4 - 20 SOC BUT HD CAP	2

Parts List

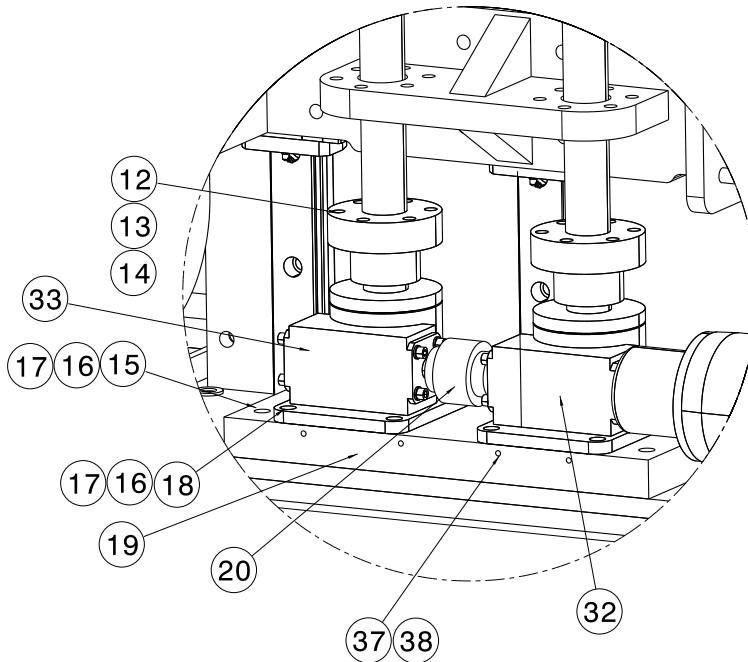
When ordering replacement parts/kits, please specify model, serial number and color of your unit.



ITEM	PART NUMBER	DESCRIPTION	QTY
5	G-1533-160065	Bolt, Metric Class 10.9 M16 x 2 ½ Long	12
6	H-1026*12	Assembly, Lanyard	8
7	G-1307-1255	Pin, ¾ x 5.5	4
9	Z-7760-01	Weldment, Engine Support	1
10	G-1476-103110	Screw, Soc But HD Cap, #10 – 32	8
11	G-1502-1030R	Lockwasher, #10 Regular	8
16	G-1250-1110N	Flatwasher, ¾ Narrow	12
31	J-5329	Motor Mount	1
41	V-1033	Label, Tronair	1
50	G-1310-0710	Pin, 7/16 x 1 Ball Lok-T	4
51	J-5109	Plate, Rear Lear 85	1
52	N-2910	Screw, M6 x 1	4
53	G-1515-M60	Flatwasher, M6	4
54	G-1470-M6-1.0	ESN, M6 x 1.0	4
57	G-1351-15	Rivet, 5/32 Open End Steel	4

Parts List

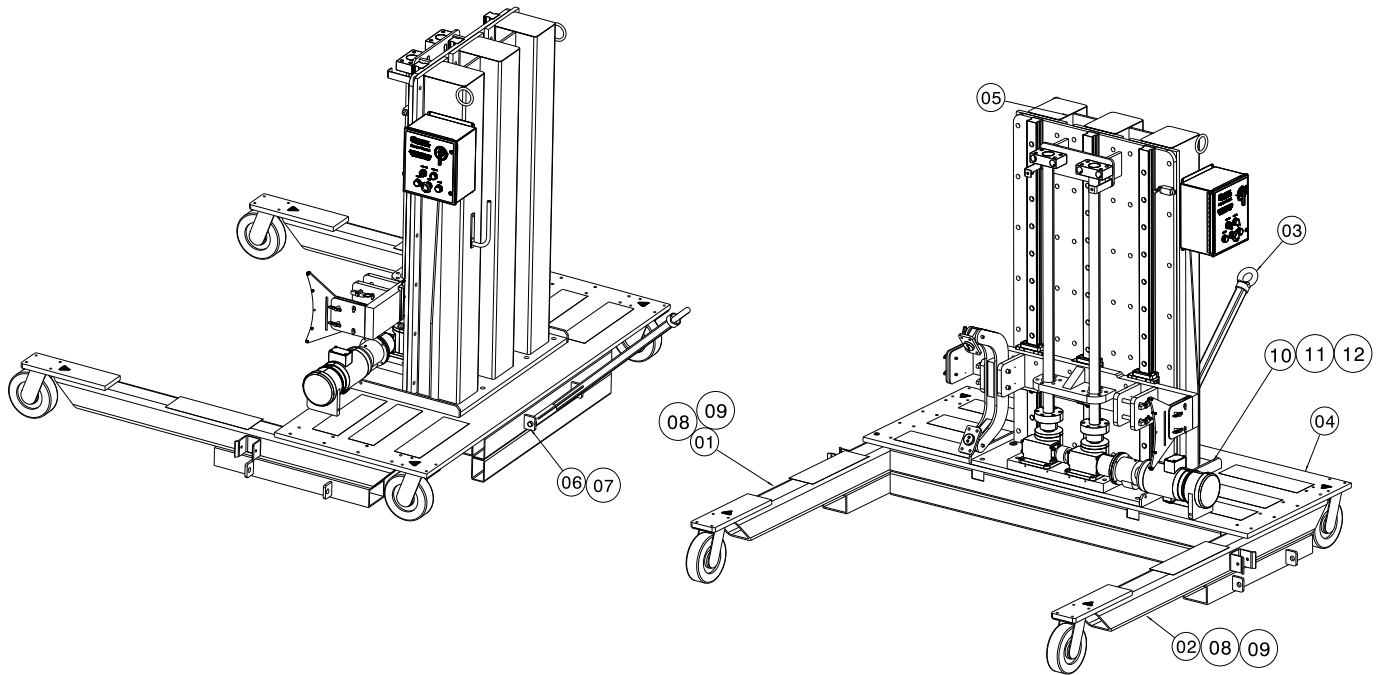
When ordering replacement parts/kits, please specify model, serial number and color of your unit.



ITEM	PART NUMBER	DESCRIPTION	QTY
12.....	G-1420-109544	Bolt, Hex HD GR 8, ½ - 20 x 4.4 Long	12
13.....	G-1250-1090N.....	Flatwasher, ½ Narrow	24
14.....	G-1520-1195	ESN, GR 8, ½ - 20	12
15.....	G-1420-111534	Bolt, Hex HD GR 8, ¾ - 16 3 ½ Long	4
16.....	G-1250-1110N.....	Flatwasher, ¾ Narrow	12
17.....	G-1251-1110R.....	Lockwasher, ¾ Regular.....	12
18.....	G-1420-111524	Bolt, Hex Head, GR 8, ¾ - 16 x 2 ½ Long	8
19.....	J-5084-01	Plate, Pump Mount Base.....	1
20.....	H-3497.....	Coupling, Shaft.....	1
32.....	H-3496.....	Jack, 15 ton with motor	1
33.....	H-3494.....	Jack, 15 ton	1
37.....	G-1420-106012	Bolt, Hex HD GR 8, 5/16 – 18 x 1 ¼ Long.....	4
38.....	G-1250-1060N.....	Flatwasher, 5/16 Narrow	4

Parts List

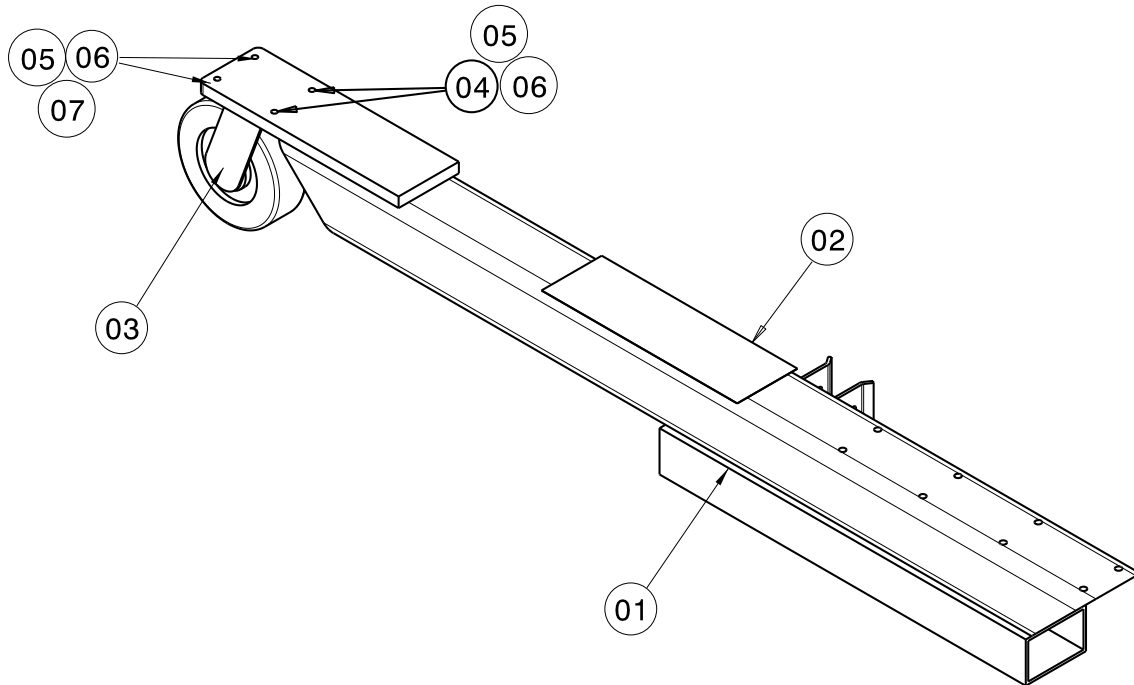
When ordering replacement parts/kits, please specify model, serial number and color of your unit.



ITEM	PART NUMBER	DESCRIPTION	QTY
1	Z-7723	Assembly, Leg	1
2	Z-7668	Assembly, Leg	1
3	Z-7699-01	Weldment, Towbar	1
4	Z-7701	Assembly, Base	1
5	Z-7817-01	Weldment, Upright	1
6	R-1243	Pivot, Rod	1
7	G-1418-08	Pin, Rue, 1.0	2
8	G-1420-109020	Bolt, 1/2 - 13 HH GR 8	16
9	G-1250-1090N	Flatwasher, 1/2 Narrow	16
10	G-1420-111540	Bolt, 3/4 - 16 HH GR 8	10
11	G-1250-1110N	Flatwasher, 3/4 Narrow	20
12	G-1520-1115	ESN, 3/4 - 16 GR 8	10

Parts List

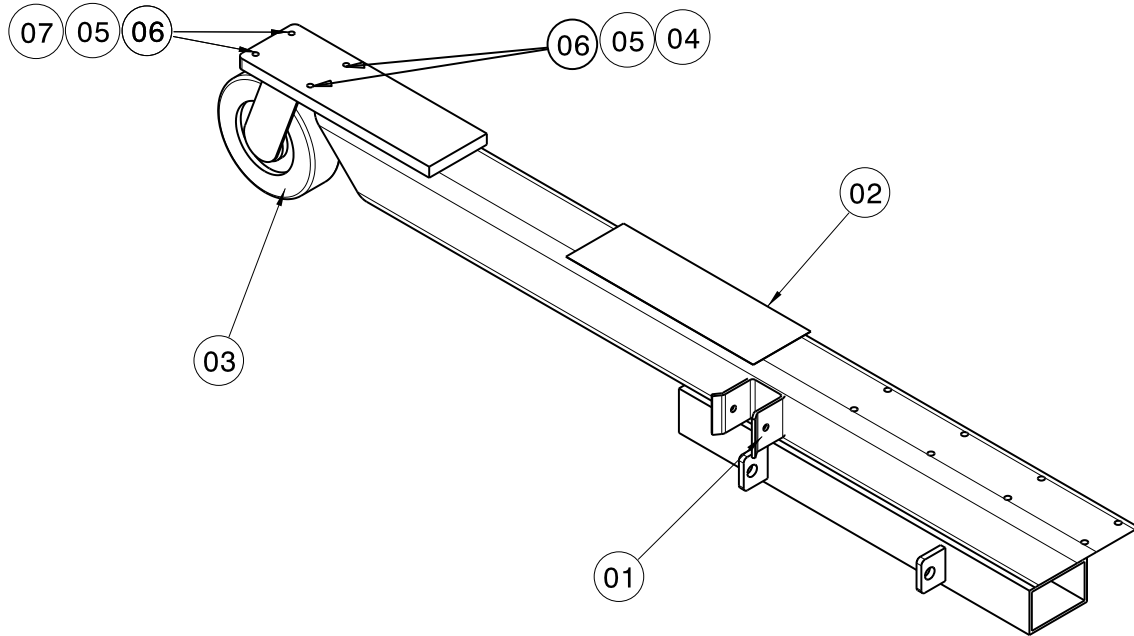
When ordering replacement parts/kits, please specify model, serial number and color of your unit.



ITEM	PART NUMBER	DESCRIPTION	QTY
	Z-7723	Assembly, Leg, <i>consists of:</i>	
1.....	Z-7724-01.....	Weldment, Leg.....	1
2.....	H-1973-04.....	Tread, Anti-Slip, 4" Wide.....	2 ft
3.....	U-1166.....	Caster, 10" Swivel, Brake Lock.....	1
4.....	G-1420-109514.....	Bolt, Hex HD, GR8, ½ - 20.....	2
5.....	G-1503-1090N.....	Flatwasher, SS, ½ ID Narrow.....	4
6.....	G-1502-1090R.....	Lockwasher, SS ½ ID Regular.....	4
7.....	G-1420-109516.....	Bolt, ½ - 20 Hex HD GR 8.....	2

Parts List

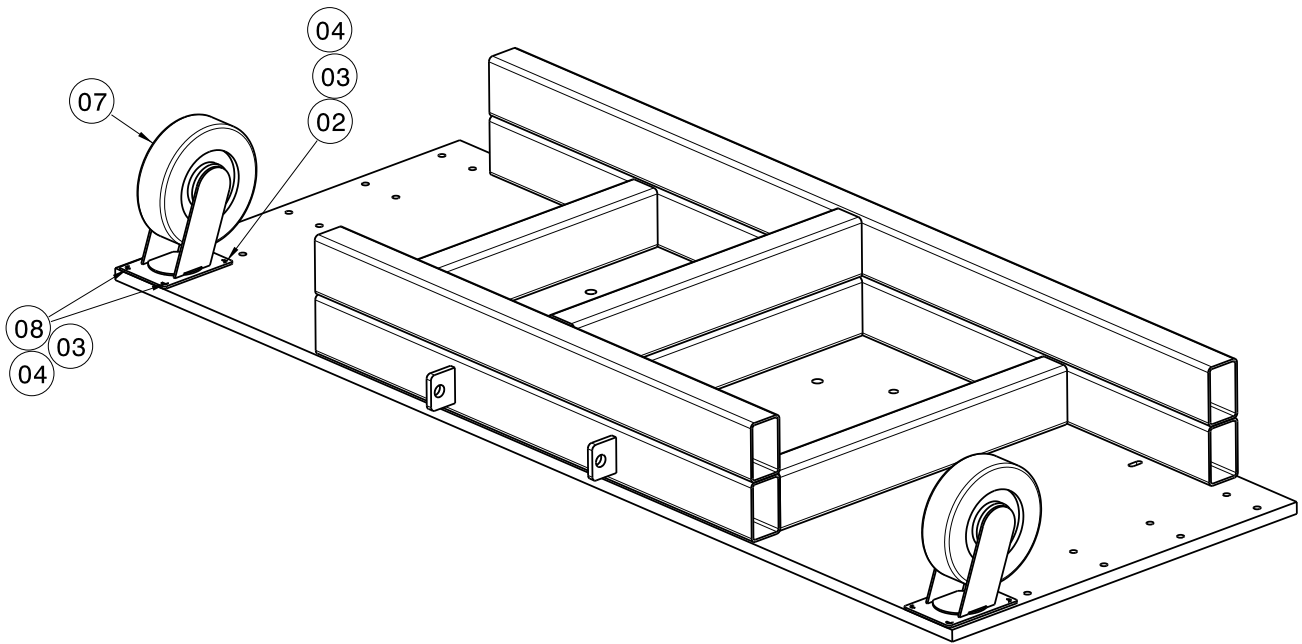
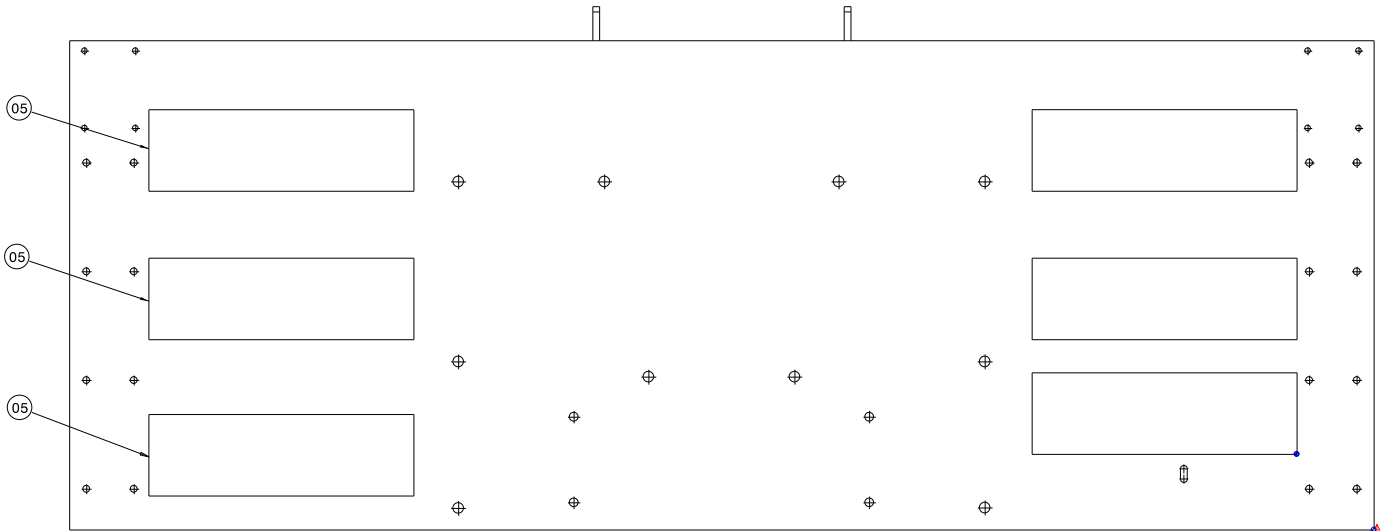
When ordering replacement parts/kits, please specify model, serial number and color of your unit.



ITEM	PART NUMBER	DESCRIPTION	QTY
	Z-7668	Assembly, Leg, <i>consists of:</i>	
1.....	Z-7669-01.....	Weldment, Leg.....	1
2.....	H-1973-04.....	Tread, Anti-Slip, 4" Wide.....	2 ft
3.....	U-1166.....	Caster, 10" Swivel, Brake Lock.....	1
4.....	G-1420-109514.....	Bolt, Hex HD, GR8, ½ - 20.....	2
5.....	G-1503-1090N.....	Flatwasher, SS, ½ ID Narrow.....	4
6.....	G-1502-1090R.....	Lockwasher, SS ½ ID Regular.....	4
7.....	G-1420-109516.....	Bolt, ½ - 20 Hex HD GR 8.....	2

Parts List

When ordering replacement parts/kits, please specify model, serial number and color of your unit.



ITEM	PART NUMBER	DESCRIPTION	QTY
	Z-7701	Assembly, Base, <i>consists of:</i>	
2.....	G-1420-109514	Bolt, Hex HD, GR8, ½ - 20	4
3.....	G-1503-1090N.....	Flatwasher, SS, ½ ID Narrow	8
4.....	G-1502-1090R.....	Lockwasher, SS ½ ID Regular	8
5.....	H-1973-05*19.50	Tread, Anti-Slip, 6" Wide	6
6.....	Z-7700-01.....	Weldment, Base	1
7.....	U-1166.....	Caster, 10" Swivel, Brake Lock	2
8.....	G-1420-109516	Bolt, ½ - 20 Hex HD GR 8	4



APPENDIX I

**INS-2163
Electrical Schematic**



APPENDIX II

**Torque
Specifications**

Standard Steel Bolt Torque Specifications

Standard Dry Torque in Foot-Pounds

Bolt Size (in.)	Coarse Threads/inch	SAE Grade 0-1-2 74,000 psi Low Carbon Steel	SAE Grade 3 100,000 psi Med. Carbon Steel	SAE Grade 5 120,000 psi Med. Carbon Heat T. Steel	SAE Grade 6 133,000 psi Med. Carbon Temp. Steel	SAE Grade 7 133,000 psi Med. Carbon Alloy Steel	SAE Grade 8 150,000 psi Med. Carbon Alloy Steel
1/4	20	6	9	10	12.5	13	14
5/16	18	12	17	19	24	25	29
3/8	16	20	30	33	43	44	47
7/16	14	32	47	54	69	71	78
1/2	13	47	69	78	106	110	119
9/16	12	69	103	114	150	154	169
5/8	11	96	145	154	209	215	230
3/4	10	155	234	257	350	360	380
7/8	9	206	372	382	550	570	600
1	8	310	551	587	825	840	700
1-1/8	7	480	872	794	1304	1325	1430
1-1/4	7	375	1211	1105	1815	1825	1975
1-3/8	6	900	1624	1500	2434	2500	2650
1-1/2	6	1100	1943	1775	2913	3000	3200
1-5/8	5.5	1470	2660	2425	3985	4000	4400
1-3/4	5	1900	3463	3150	5189	5300	5650
1-7/8	5	2360	4695	4200	6980	7000	7600
2	4.5	2750	5427	4550	7491	7500	8200



APPENDIX III

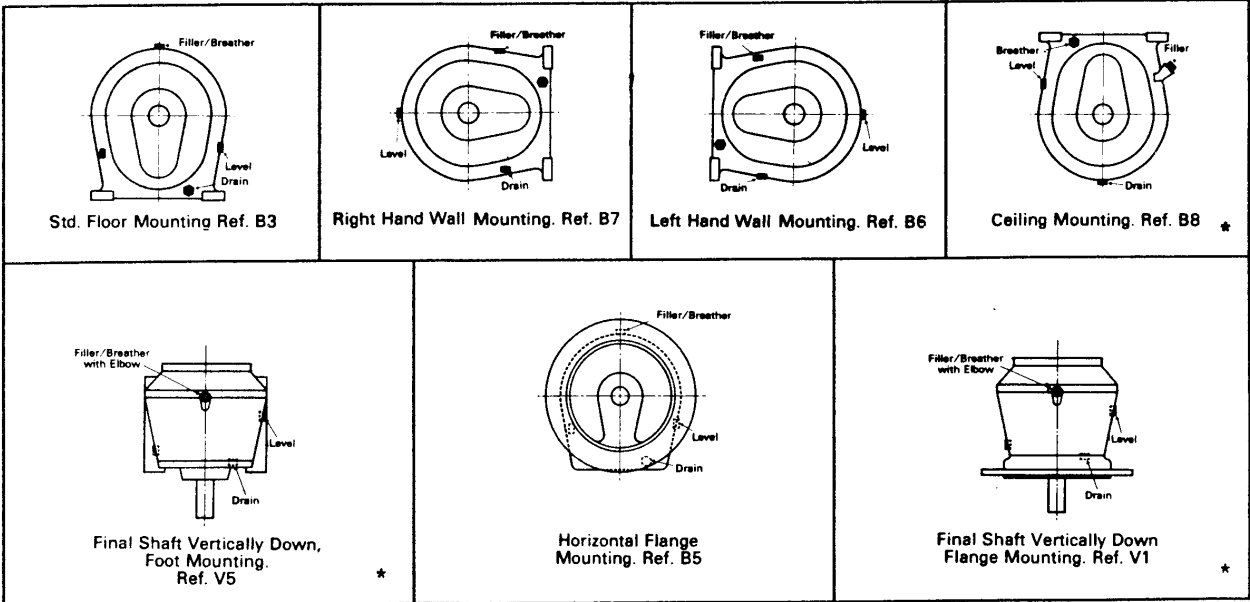
IPTS
Operating Instructions



**Operating Instructions
HELICAL - QUILL INPUT
SIZE AA**

The units are, in general, shipped from the factory with lubricant. At all times keep the breather plug clean. If these become blocked, pressure will build in the box due to the surging of the oil, resulting in leakage through the seals. After the first month in service, drain oil from the gearbox, flush and refill with new oil. This unit is filled with extreme pressure lubricants which protect the teeth in the event of the oil film thinning out due to local temperature rise, or high pressure due to accidental overloads. These oils are liable to form sludge after continuous service. The oil should, therefore, be changed after every 1,500 hours of operation, or more often as conditions may dictate. The grades of oil shown in the schedule are for normal conditions of duty and ambient temperature. High ambient temperatures cause the oil to thin out and reduce its protective qualities. In such cases it will be necessary to utilize heavier grades than shown. Conversely, low temperatures will necessitate a thinner grade, otherwise trouble may be experienced with burning out of motors at starting. In this connection, the pour point of the oil must be less than the lowest ambient temperature to be encountered.

OIL QUANTITY		
MOUNTING POSITIONS	B3, B5, B6, B7 & B8	14 OUNCES
MOUNTING POSITIONS	V1 & V5	20 OUNCES



*INDICATES ELBOW REQUIRED FOR FILL/VENT

Recommended Oil Grades

Castrol	Shell	Exxon	Texaco	Mobil Oil	BP	Gulf Oil
Alpha SP220	Shell Omala 220	Spartan EP220	Meropa 220	Mobilgear 630	BP Energol GR-XP220	Gulf EP Lubricant HD220



APPENDIX IV

**Nook Actionjac
Machine Screw Jacks**

Actionjac™

MACHINE SCREW JACS

Installation, Maintenance and Lubrication Instructions

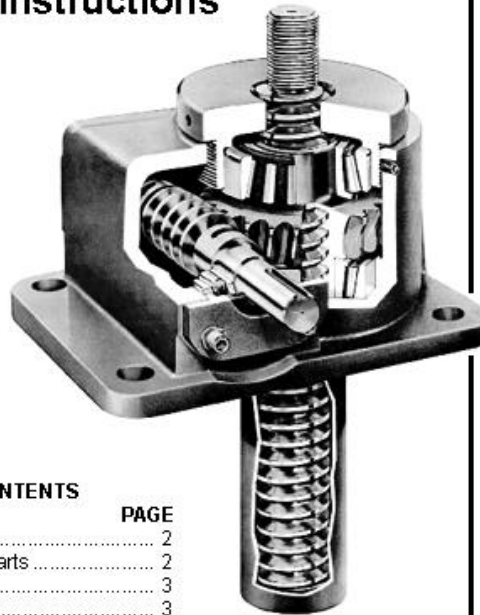


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Reassembly	8-9
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NOOK ...THE LINEAR MOTION PEOPLE

NOOK INDUSTRIES, INC.

CAUTION — The customer is responsible for providing stops at either end of travel. Machine Screw Jacs are usually self-locking. However, self-lowering or creep could result from vibratory conditions. In these cases, a brake should be considered. Overtravel could cause the lifting screw to become disengaged from the drive sleeve.

GENERAL INSTRUCTIONS

Your Machine Screw Jac is a high quality, sturdy unit designed to give many hours of trouble-free service. However, certain precautions and procedures must be observed in handling, installing and servicing the unit in order to obtain optimum performance.

1. Any apparent or suspected damage to equipment manufactured or furnished by Nook Industries during transport from the factory to the user should be immediately reported to both Nook Industries and the carrier.
2. Upon delivery all equipment furnished should be carefully inventoried against shipping papers to determine whether any shortages exist in delivered material. Any such shortages must immediately be reported to Nook Industries and the carrier.
3. The installation of most power transmission equipment does not normally require the services of a factory engineer. These services are not included in the selling price of the equipment unless specifically agreed upon in writing between the seller and purchaser. In applications requiring a more complex arrangement of components, consideration should be given to the use of a factory engineer for construction supervision or check-out of the installation. These services are available from Nook Industries by contacting the Service Department.

4. The Seller's warranty applies insofar as the unit is operated within the rating and service conditions for which it was specifically sold. The purchaser must prevent the existence of any destructive external conditions which might typically include vibratory loads due to critical speeds, severe shock loading, mechanical or thermal overloads, or side loads if the seller was not fully advised of their existence at time of order.
5. Adequate installation, maintenance and safety instructions must be given by the user to personnel directly responsible for the installation and operation of the equipment.
6. In the event of malfunction within the warranty period, the manufacturer must be informed promptly or, in any event, within thirty days if it is intended that the warranty is to cover the incident.

CAUTION — UNITS ARE NOT MEANT FOR PERSONNEL SUPPORT. Refer all applications for potential personnel support to the factory for approval.

ORDERING SPARE/REPAIR PARTS

This booklet contains general instructions, operating, maintenance and troubleshooting instructions for your ActionJac™ Worm Gear Jac. In the event spare or repair parts are required, call your local representative or contact Nook Industries at (216) 271-7900 or 1(800) 321-7800.

Please provide the following information when requesting spare/repair parts:

- Jac Size & Type Designation (i.e., 2 MSJ)
- Serial Number & Year of Manufacture (located on housing nameplate)
- Stroke Length
- Part Description (see pages 6-7)

GENERAL SPECIFICATIONS

The worm gear driven Machine Screw Jac incorporates an alloy steel worm which drives a high tensile bronze worm gear, accurately machined to the high standards of Nook Industries for maximum load carrying capacity and uniformity of motion transmission. All shafts are mounted on heavy duty, anti-friction bearings to increase operating efficiency of the drive mechanism. Thrust bearings are provided to support the rated thrust load of each unit. Housings are made of high strength material, well proportioned to handle the rated thrust and torque loads of each size unit.

CAUTION — In the absence of internal or external stops, it is possible to run the lifting screw out of the unit. Your Machine Screw Jac is NOT equipped with internal stops unless specifically requested in your order.

A lifting screw cover is threaded into the bottom of the unit on the upright model, or in the top of the unit on the inverted model, in order to keep the lifting screw threads free of foreign material.

Depending upon which Jac model is purchased, the lifting screw is made of 4140 heat treated steel, 304 or 316 stainless steel, or a special alloy. The threads of the lifting screw for all models should be well lubricated and kept free of grit, dirt, or other abrasive contaminants.

Fabric type protective boots, or spiral steel protectors, can be provided as an accessory to protect the exposed portion of the lifting screw. In the absence of positive stops, overtravel may crush protective boots.

CAUTION — Standard units should not be operated at input speeds over 1,800 RPM without consulting the factory. Machine Screw Jacs are designed for a maximum of two hours intermittent

operation per day. For values higher than two hours per day, for any continuous operation, or for repeated operation over any segment of total travel, consult factory.

LUBRICATION

Machine Screw Jacs are shipped with grease in the unit. However, before operating any unit remove the housing plug and check on the condition of the lubricant. Lubrication inspection is recommended at regular intervals. Usually one month intervals are satisfactory unless experience indicates that regreasing should occur at shorter or longer intervals.

Each jac unit is furnished with a grease fitting and a pipe plug on opposite sides of the housing. After removing the pipe plug, fill unit with grease until lubricant seeps from the pipe plug opening. Replace pipe plug. Severe operating conditions will shorten the lubrication inspection interval.

The lubricant should not be corrosive to gears, ball or roller bearings and must be neutral in reaction. The lubricant must not contain any grit or dirt, abrasives or fillers. It should not precipitate sediment, nor separate at temperatures up to 300°F. The lubricant must also have resistance to oxidation and must be non-channeling. We recommend the following extreme pressure greases or equivalents. For operating conditions outside these limits consult factory.

TEMPERATURE		
COMPANY	TRADE NAME	RANGE
*Exxon	Nebulla EP#1	0 to 300°F
Mobil	Mobilux EP#1	-20 to 225°F
Arco	Litholine EP#1	-20 to 200°F
Gulf	Gulf Crown EP#1	0 to 250°F
Shell	Aeroshell #22	-85 to 400°F

*Calcium base. All others Lithium base.

The above recommendations are based on intermittent, medium duty service. If the Jacs are to be operated at the relative upper limits of their ratings regarding load or speed, or the application requires continuous operation, consult factory.

Lifting screws should be checked periodically to insure they are adequately lubricated. This is especially necessary in rotating units where no lubrication is deposited on the lifting screw, since it does not pass through the Jac.

All Units are suitable for intermittent operation in ambient temperatures up to 200°F with proper grease. If protective boots are used, the material must be able to withstand the environment.

INSTALLATION INSTRUCTIONS

1. Be certain that the rating of the Jac exceeds the maximum load that may be imposed upon it.
2. The foundation for the unit must be rigid enough to maintain correct alignment with connected machinery and have ample strength to carry the maximum load.
3. The foundation should have a flat mounting surface to uniformly support the Jac unit. The opening for the lifting screw cover (or lifting screw) that passes through base must be as small as possible to provide Jac support over the largest possible area.
4. It is extremely important that the Jac be installed so that the lifting screw is exactly plumb and that all connecting shafting is aligned with the worm shaft.
5. After precise alignment, each member must be securely bolted and if possible, doweled in place. Doweling will assure exact repositioning if ever removed. It is essential that a Jac unit

be securely bolted down to its foundation using bolts of the proper diameter to fit mounting holes. Bolts should be S.A.E. Grade 5 or equivalent.

CAUTION — In the case of rotating units it is essential, for proper alignment and prevention of screw failure, that the load be attached to the traveling nut only when the load is in the position of travel closest to the Jac housing.

Torque values for bolting are as follows:

BOLT SIZE INCHES	APPROX. TORQUE VALUE FOOT POUNDS
1/4	6
3/8	20
1/2	50
5/8	100
3/4	165
7/8	265
1	400
1 1/4	830
1 1/2	1350
1 3/4	2500
2	3650

IMPORTANT — Take up evenly on mounting bolts to avoid damaging the housing.

6. After the Jacs, mitre boxes, couplings, etc. are installed and aligned, there should be no signs of binding or misalignment.
7. Shaft coupling guards are the responsibility of the customer and are not provided unless specifically quoted to and ordered by the customer.
8. Caution must be taken when operating your Jac at either extreme of travel. If possible, hard external stops should be provided.
9. If operating at the upper limits of the unit rating, DO NOT STOP the downward travel of the unit by running the

lifting screw attachments or the load against the housing without checking with Nook Industries, as serious damage to the internal mechanism may result. The customer is responsible for providing mechanical stops and switches for control of the prime mover. None are included unless specifically quoted by and ordered from Nook Industries.

CAUTION — If limit switches are furnished by Nook Industries, they are NOT factory set. Limit switches should be set by carefully moving to the set position by hand or jogging. Care must be taken to avoid running lifting screws out of units or crushing boots.

TIPS FOR DISASSEMBLY AND REASSEMBLY

CAUTION — Never perform any work on the Jac or associated transmission equipment (mitre boxes, couplings, etc.), until absolutely certain that the prime mover cannot be remotely or automatically started. Also make certain that load cannot affect personnel or machinery when the Jac, brake, or other holding devices are removed. Be sure disassembly area is relatively clean to prevent contamination of parts. Store all machined parts on wooden blocks or skids to prevent damage to machined surfaces.

Before starting disassembly, carefully review a typical parts list or certified assembly drawing of the unit.

When removing end caps, be sure to tape shaft extension keyways and other sharp edges to avoid damaging oil seals.

NOTES:

1. Be sure to clean and dry all parts before rebuilding.
2. It is advisable to replace old seals when the unit is rebuilt.

3. Remove any protective coatings on replacement parts before installing.

DISASSEMBLY INSTRUCTIONS

1 MSJ through 100 MSJ Models Only

Refer to typical parts, pages 6-7. All MJ models are not serviceable in the field.

These instructions are necessarily general, and as such, cannot provide for minor details of construction, which may vary from unit to unit.

For specific questions, consult factory giving order number and serial number from unit name plate.

Upright or Inverted Units Disassembly

1. Unscrew lifting screw cover assembly from unit (item 10).
2. Remove protective boot and end attachment from lifting screw, if applicable.
3. Unscrew lifting screw from drive sleeve.
4. Remove socket head set screws in housing.
5. Unscrew housing cover (item 2).
6. Remove end caps on worm shaft assembly.

CAUTION — Handle shims carefully to avoid damage.

7. While tapping one end of the worm shaft with a wooden mallet, turn the worm shaft. This will loosen the bearing cup to facilitate removal. (2 MSJ - 100 MSJ only)
8. Remove the worm shaft bearing cups. (2 MSJ - 100 MSJ only)
9. Drive sleeve and gear assembly should now lift easily from the housing.

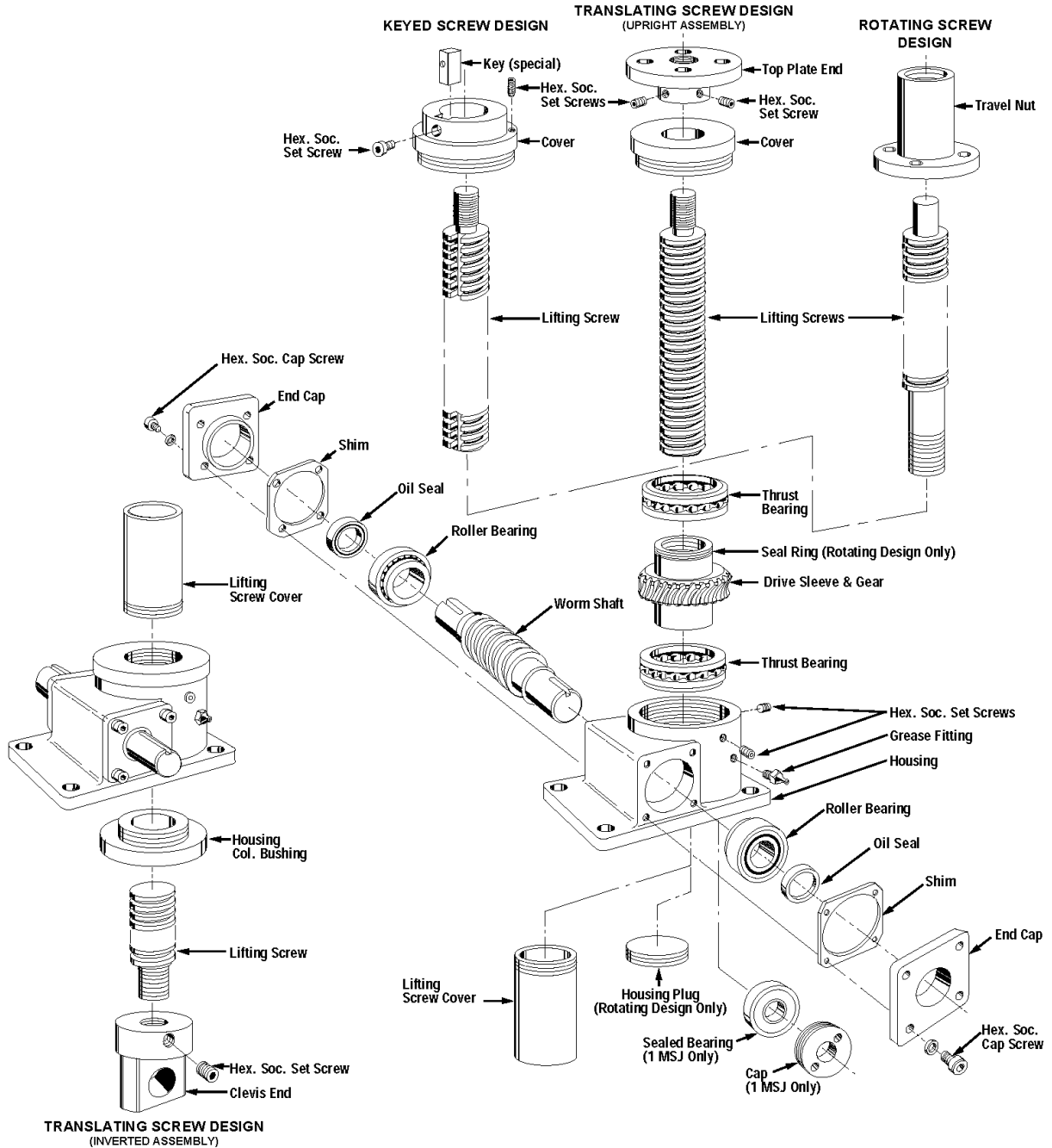
ACTIONJAC™ MACHINE SCREW JAC

ALL MODELS 1 MSJ THROUGH 100 MSJ*

EXPLODED VIEW OF A TYPICAL ASSEMBLY

Views are illustrative **only**. See page 2 for ordering spare/repair parts.

* Models MJ -20 through MJ-200 should not be disassembled. These units are not serviceable in the field.



-
10. Worm shaft assembly can be removed if necessary.

NOTES:

1. Bearing cones are press-fitted to worm shaft. If removal is required use bearing puller.
2. Removal of the bearings from the drive sleeves of Jacs equipped with Taper Roller bearings, may result in their being damaged.

Rotating Units Disassembly

1. Remove set screws from housing.
2. Unscrew housing cover.
3. Remove end caps on worm shaft assembly.

CAUTION—Handle shims carefully to avoid damage.

4. While tapping one end of the worm shaft with a wooden mallet, turn the worm shaft. This will loosen the bearing cup to facilitate removal.
5. Remove the worm shaft bearing cups.
6. Drive sleeve and gear assembly can now be lifted easily from the housing.
7. Thrust bearing assembly can be removed if required. (see note 2)
8. Worm shaft assembly can be removed if necessary.

NOTES:

1. Bearing cones are press-fitted to worm shaft. If removal is required use bearing puller.
2. Removal of the bearings from the drive sleeves of Jacs equipped with Tapered Roller bearings, may result in their being damaged.

Keyed Units Disassembly

1. Remove key retaining bolt.
2. By turning worm shaft, drive lifting screw and key from housing and remove key.
3. Remove set screws from housing and cover.
4. Unscrew housing cover.
5. Remove end caps on worm shaft assembly.

CAUTION—Handle shims carefully to avoid damage.

6. While tapping one end of the worm shaft with a wooden mallet, turn the worm shaft. This will loosen the bearing cup to facilitate removal.
7. Remove the worm shaft bearing cups.
8. Drive sleeve and gear assembly should now lift easily from the housing.
9. Thrust bearing assembly can be removed if required. (see note 2)
10. Worm shaft assembly can be removed if necessary.

NOTES:

1. Bearing cones are press-fitted to worm shaft. If removal is required using bearing puller.
2. Removal of the bearings from the drive sleeves of Jacs equipped with Tapered Roller bearings, may result in their being damaged.

REASSEMBLY

Your Jac can be easily reassembled by reversing the procedure as previously outlined. In reversing disassembly procedures, be sure to pack worm, worm gear, and all

bearings with grease. Also coat all seal areas with grease. After unit is reassembled, fill with grease, see page 3.

1 MSJ reassembly may require that one worm shaft ball bearing be pressed onto worm shaft after drive sleeve and worm are assembled in the housing.

TROUBLE SHOOTING TIPS

Your ActionJac™ Machine Screw Jac will perform satisfactorily if suggestions described in this booklet are carefully followed. It is estimated that approximately 98 percent of Machine Screw Jac failures can be attributed to improper lubrication, misapplication, and misalignment.

TROUBLE SHOOTING CHART

TROUBLE	WHAT TO INSPECT	ACTION
Housing Failure	1. Unit Overload	Reduce load or replace with unit of sufficient capacity.
	2. Improper Support	Unit should be supported over entire base area, not just at bolt hole locations.
	3. Uneven Bolting Torque	Take up evenly on mounting bolts.
Worm Shaft Failure	1. Type of Coupling	Rigid Couplings can cause shaft failure. Replace with coupling which will provide adequate flexibility and lateral float.
	2. Coupling Alignment	Realign as required.
	3. Presence of Excessive Overhung Load	Check Jac for allowable loads.
	4. Unit Overload	See Housing Failure No. 1.
	5. Shock Loading	Apply coupling capable of absorbing shock and, if necessary, replace with unit of sufficient capacity. Shock loads can significantly increase apparent dead weight loads.
	6. "Ganging" Units	If several units are "in-line", the worm shaft of the first unit can assume 300% of the rated input torque. If this value is exceeded, you must replace with a larger unit.

TROUBLE SHOOTING CHART (continued)

TROUBLE	WHAT TO INSPECT	ACTION
Bearing Failure	1. Unit Overload	See Housing Failure No. 1.
	2. Excessive Overhung Load	See Worm Shaft Failure No. 3.
	3. Coupling Alignment	See Worm Shaft Failure No. 2.
	4. Coupling Lateral Alignment	Adjust spacing between connecting shafts to relieve end pressure.
	5. Bearing Adjustment	Bearings must not be pinched. Adjustable tapered bearings must be set at proper lateral clearance. All shafts should turn freely when disconnected from the load.
	6. Bearing Lubrication	Add lubricant if necessary.
	7. Shock Loading	See Worm Shaft Failure No. 5.
Drive Sleeve & Worm Gear Wear	1. Unit Overload	See Housing Failure No. 1.
	2. Bearing Adjustment	See Bearing Failure No. 6.
	3. Lubrication	Proper levels and grade must be maintained. See lubrication page.
Drive Sleeve & Worm Gear Nut Wear	1. Unit Overload	See Housing Failure No. 1.
	2. Alignment	Lifting shafts must be perfectly plumb.
	3. Lubrication	See Gear Wear No. 3.
	4. Side Load	Eliminate Side Load.
Lifting Screw Failure	1. Unit Overload	See Housing Failure No. 1.
	2. Alignment	See Lifting Shaft Failure No. 2.
	3. Side Load	Check with Nook Industries' Engineering Department for allowable side load.

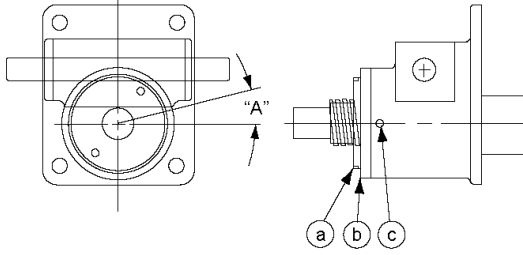
ANTI-BACKLASH ADJUSTMENT

The anti-backlash feature is set at the factory and normally does not require further adjustment. However, as wear develops with extended use, it may become necessary to adjust lash.

ADJUSTMENT PROCEDURE

1. Loosen Locknut (item b)
2. Loosen Set Screw(s) (item c)
3. To reduce backlash, rotate Adjusting Cap (item a) clockwise until resistance is felt. (Do not overtighten)
4. Place a reference mark between thread on Adjusting Cap and Housing.
5. Rotate Adjusting Cap (item a) counter clockwise an amount equal to Dim. "A" on the o.d. of the threads. (See chart)
6. Tighten Set Screws.
7. Holding Adjusting Cap (item a) stationary, tighten Locknut (item b).
8. Operate Jac through entire stroke, checking for tight spots. Note: If Jac has been used only over a portion of its stroke, backlash should be adjusted in the least worn portion of the screw.

CAUTION — Care should be taken not to overtighten the anti-backlash system in order to prevent binding or lockup between the drive nut and lifting screw. Overtightening can cause a destructive heat buildup or failure.



Item	Description	Jac Model	"A" Dim.
a	Adjusting Cap	1 MSJ, 2 MSJ, 2.5 MSJ	$\frac{7}{32}$
b	Locknut	5 MSJ, 10 MSJ	$\frac{5}{16}$
c	Set Screw	15 MSJ, 20 MSJ	$\frac{3}{8}$
		20 MSJ, 30 MSJ	$\frac{3}{8}$
		35 MSJ	$\frac{1}{2}$
		50 MSJ	$\frac{11}{16}$
		75 MSJ	$\frac{13}{16}$
		100 MSJ	1

Actionjac™ MACHINE SCREW JACS

STATEMENT OF ASSURANCE

Thank you for purchasing another quality product from Nook Industries, Inc. Every effort has been taken to assure this product was manufactured to the highest industry standards of quality, precision and performance.

WARRANTY


Unless otherwise stated herein, Seller will repair or replace, without charge, f.o.b. point of shipment, any parts proven to Seller's satisfaction and upon Seller's examination to have been defective in material or workmanship when furnished, provided claim is made within one year after date of shipment. Deterioration or wear occasioned by abuse, severe eccentric loading, overloading, chemical or abrasive action or excessive heat shall not constitute defects. Equipment and accessories not of the Seller's manufacture are warranted only to the extent that they are warranted by the manufacturers, and this warranty is applicable only if the defect was the result of normal use, application and service, and is void if the product or any part hereof was tampered with, repaired or altered by any person other than the factory or authorized repair station. THERE ARE NO OTHER WARRANTIES, EXPRESS, STATUTORY, OR IMPLIED, INCLUDING THAT OF MERCHANTABILITY AND OF FITNESS.

Authorization for return must be received from Nook Industries before returning any equipment for inspection or warranty repair.

WARNING

The equipment shown in this bulletin is intended for industrial use only and should not be used to lift, support, or otherwise transport human cargo, unless you have a written statement from Nook Industries, Inc. that the Jac unit as used in your application is suitable for lifting human cargo.

NOOK

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APPENDIX V

**Declaration
of
Conformity**



DECLARATION of CONFORMITY

The design, development and manufacture is in accordance with European Community guidelines

ENGINE INSTALLATION TOOL

Relevant provisions complied with by the machinery:
EN ISO 12100-1

Relevant standards complied with by the machinery:
EN ISO 12100-1
EN 1915-1:2001 (5.20)

Identification of person empowered to sign on behalf of the manufacturer:


Quality Assurance Representative