Gear Reducer Replacement Instructions:

It is very important that the gear reducer is installed correctly onto the motor. The gear reducer must be installed so that it is square to the motor's base. This will allow the line shaft to install into the gear reducer properly.

It would be best to assemble the gear reducer onto the motor on a level surface. When attaching the new gear reducer, use a level to ensure the gear reducer is level also. This should ensure that the bore of the gear reducer is square to the motor.

After the gear reducer is attached to the motor it is also very important to make sure the line shaft will align properly with the motor assembly.

Please make sure each unit is square and level before replacing any parts.

Level and Alignment Instructions

To ensure proper alignment of the motor and shaft, it is also important to ensure that each unit of the machine is square and level.

Level the bottom unit by adjusting the leveling feet. After the machine is level, make sure the base unit side panels are square to the shelf. If they are not square, loosen the back panel screws on the base unit and realign the side panels to make sure they are square to the bottom shelf.

After the base unit is level, loosen the screws in the back flange of the shelf that is attached to the side panels on the upper units, and adjust the side panels until all the units are square. Then retighten the bolts. Do this with each unit starting from the base.

Note: It is best to make sure the machine is square and level before replacing the motor or gear reducer to make sure the motor will align properly with the shaft.

Removing the Motor

1. Disconnect power from motor
2. Remove motor shaft guard and shaft guard from the unit above
3. Disconnect shaft assembly from unit above by pulling down on the top coupler against the spring and disengaging
4. Remove the shelf from the unit above the base
5. Loosen the idlers in the powerhead to reduce tension on the powerhead belt
6. Remove belt from around the line shaft
7. Remove the base shelf
8. Disconnect the timer from the motor
9. Remove the two front mounting bolts
10. Slide the motor/gear reducer assembly away from the left hand side panel
11. Remove the motor/gear reducer assembly

Installing the New Motor

1. Slide new motor and gear reducer assembly under the back tabs and install bolts, and nuts and reconnect the timer (Do not tighten bolts at this time)
2. Lift shaft and rotate the motor until the shaft aligns and fits into the square bore in the gear reducer
3. Tighten the front motor bolts
4. Reinstall the powerhead belt and tighten the idlers
5. Reattach the unit shelf and tighten the bolts
6. Reinstall the unit shaft assembly and the top and bottom shaft guards
7. Reinstall the base shelf
8. Reconnect power

Important:

This whole process requires the end user to take the time to follow the proper steps to ensure the GR and motor are assembled correctly or they will likely cause damage to the shaft, gear reducer or the machine bushings.

If incorrectly assembled, most issues will not be immediately apparent or cause any problems with the operation of the machine in the beginning, but will cause failure over time. It may take weeks or months before a future failure will occur.
### Description

<table>
<thead>
<tr>
<th></th>
<th>Description</th>
<th>Part #</th>
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<tbody>
<tr>
<td>1</td>
<td>Motor 1/2 HP 60 Hz for RJ65</td>
<td>5190</td>
</tr>
<tr>
<td></td>
<td>Motor 3/4 HP 60 Hz for RJ88</td>
<td>5074</td>
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<tr>
<td></td>
<td>Motor 1/2 HP 50/60 Hz 110V/220V</td>
<td>5191</td>
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<tr>
<td></td>
<td>Motor 3/4 HP 50/60 Hz 110V/220V</td>
<td>5075</td>
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<td>2</td>
<td>Short Coupler With Set Screw</td>
<td>5897T</td>
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<td>3</td>
<td>Stabilizer for RJ GR Motor</td>
<td>4155X</td>
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<td>4</td>
<td>SQ bore Shaft Assy. (SR# 193808-Current)</td>
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<td>SQ bore Shaft Assy. (SR# 192024-193807)</td>
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<td>5</td>
<td>Gear Reducer 7.5 to 1.0 for RJ88/65</td>
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<tr>
<td>6</td>
<td>Shaft Guard for RJ Base</td>
<td>J1033</td>
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</tbody>
</table>

**Serial Numbers:** 192024 to Current

Items A & B are obsolete and have been replaced with 4 & 5

For technical support on our products or additional accessories, please call us at 248-624-7710 or visit our web site: [www.dedoes.com](http://www.dedoes.com)