



2SNT24 and 2SNT30 Replacement Gearbox

Used with:

- 1994 & Earlier Two-Section No-Tills



When you see this symbol, the subsequent instructions and warnings are serious - follow without exception. Your life and the lives of others depend on it!

General Information

These instructions explain how to install the replacement gearbox. This gearbox replaces factory gearboxes on two-section, no-till drills built in 1994 and earlier.

These instructions apply to:

- 197-150A GEARBOX REPLACEMENT KIT LH**
197-153A GEARBOX REPLACEMENT KIT RH

Manual Update

Refer to the drill operator's manual for detailed information on safely operating, adjusting, troubleshooting and maintaining the gearbox. Refer to the parts manual for part identification.

- 1994 Two-Section NT Operator's Manual. 196-117M-A
- 1993 Two-Section NT Operator's Manual. 196-117M
- 1992 Two-Section No-Till Operator's Manual. . . 196-074M-A
- 1994 and 1993 Two-Section NT Parts Manual. . . 196-117P
- 1992 Two-Section No-Till Parts Manual. 196-074P

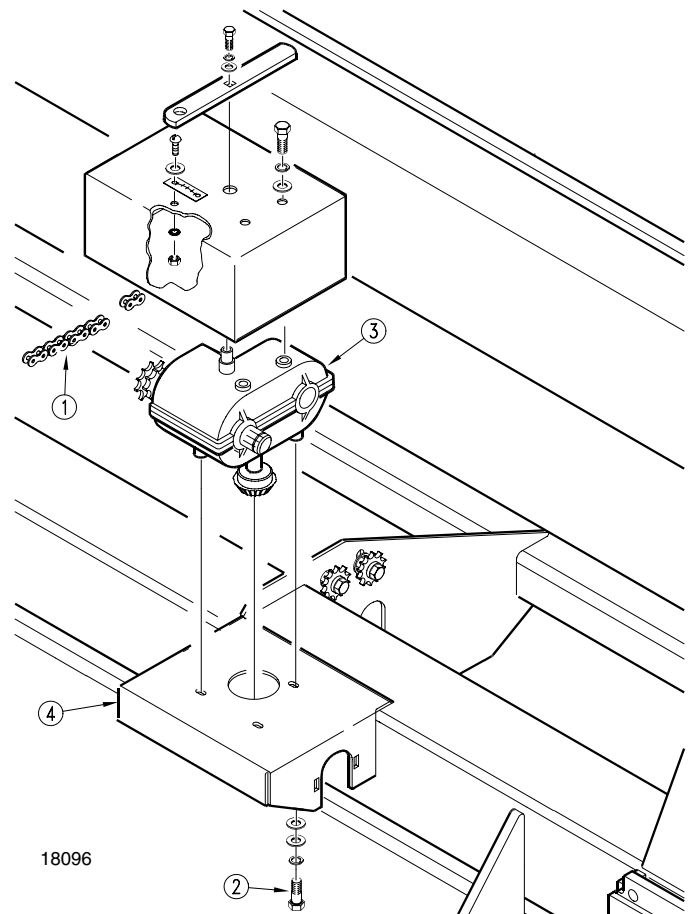
Before You Start

On page 3 are detailed listings of parts included in the gearbox packages. Use these lists to inventory parts received.

Assembly Instructions

The following instructions and illustrations are for the left-hand drive. If installing gearbox on right-hand drive, follow these instructions, remembering that your parts will mirror the illustrations.

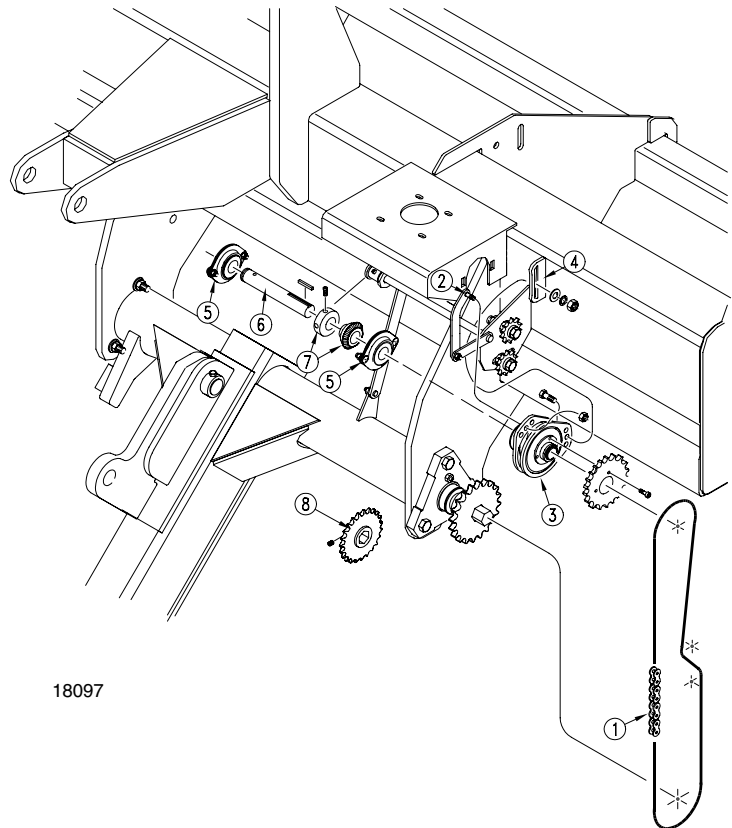
1. Remove chain (1) from gearbox to seed-cup sprocket. Save chain for later reinstallation.
2. Remove and discard bolts (2) holding gearbox (3) on gearbox shelf (4). Remove and discard gearbox and gearbox cover.



Assembly

3. Remove chain (1) from gauge-wheel sprocket and clutch sprocket.
4. Disconnect clutch arm (2) from clutch (3). Disconnect clutch from frame (4).
5. Remove bolts from bearing flanges (5) on gearbox jackshaft (6). Remove jackshaft and disassemble set collar and bevel gear (7) from jackshaft. Discard set collar and bevel gear.
6. Replace bevel gear with 16-tooth sprocket from kit (8) using key from preexisting bevel gear. Do not tighten set screws on sprocket at this time.
7. Reinstall jackshaft and reconnect clutch. Reinstall chain over gauge-wheel sprocket and clutch sprocket.

NOTE: On 24-foot drills, you may need to torch-cut the gauge-wheel plate for the new sprocket to fit.

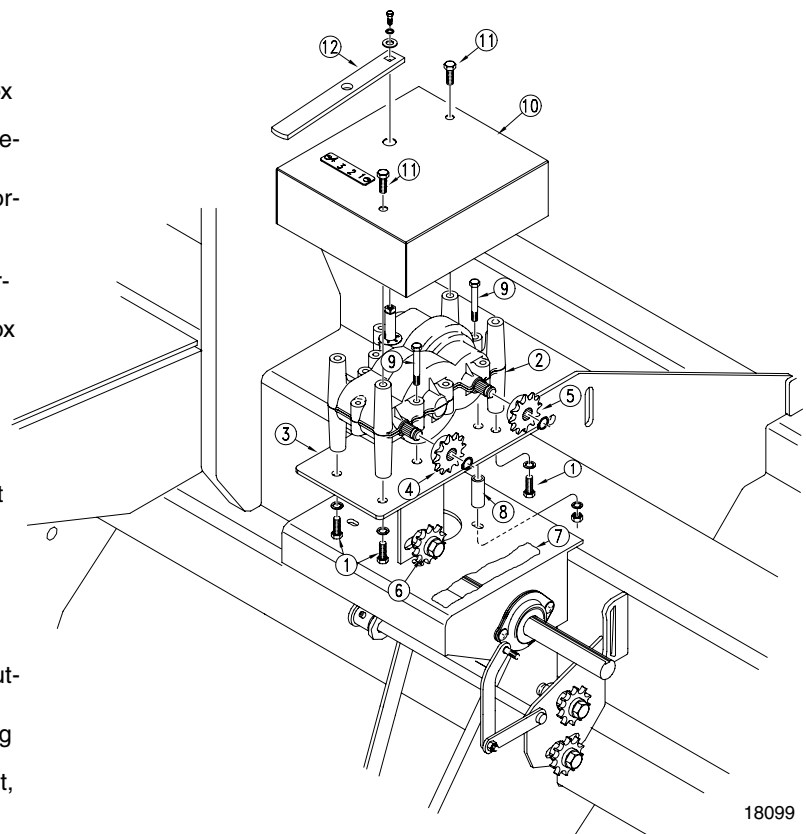


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8. Using four 3/8-inch, self-tapping screws and lock washers (1), bolt new gearbox (2) onto mounting plate (3).
9. Mount 16-tooth, spline-bore sprocket (4) on gearbox input shaft above idler bracket. Mount 12-tooth, spline-bore sprocket (5) on gearbox output shaft. Secure sprockets with snap rings.
10. Mount 12-tooth sprocket (6) on idler bracket in this order: 1/2-inch bolt, sprocket, jam nut, flat washer, bracket, lock washer, and nut.
11. Torch a rectangular access hole (7) in existing gearbox shelf. To locate access hole, hold new gearbox and mounting plate over gearbox shelf. Align gearbox output sprocket (5) with seed-cup sprocket. Mark idler-bracket location.
12. Use mounting spacers (8) and 3/8-by-2 1/2-inch bolts (9) to bolt mounting plate and gearbox on gearbox shelf.
13. Align drive sprocket on jackshaft with gearbox input sprocket (4). Tighten set screws on drive sprocket.
14. Route chain provided in kit over jackshaft drive sprocket and gearbox input sprocket (4). Use new idler (6) to remove chain slack.

NOTE: You may need to remove links from the chain.

15. Reroute chain removed in step one over gearbox output sprocket (5) and seed-cup sprocket.
16. Assemble new gearbox cover (10) on gearbox using two 3/8-inch, self-tapping screws (11). Assemble gearbox handle (12) onto gearbox with 1/4-inch bolt, lock washer and flat washer.



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Listing of Parts**197-150A Gearbox Replacement Kit LH***Your Kit Includes:*

Qty.	Part No.	Part Description
1	120-237D	GEARBOX SHIFT HANDLE
1	136-071D	CHAIN RL #40 48 PITCHES
1	197-149H	GEARBOX MOUNT WELDMENT LH
1	197-151M	MANUAL 2SNT GEARBOX RPLACEM
1	197-239D	GEAR BOX COVER LH
3	197-273D	GEARBOX SPACER
2	800-141C	SNAP RING EXT F/PEERLESS G.
2	801-001C	SCREW RD HD 8-32 X 3/8 BRA
6	801-076C	SCR SELF TAPPING 3/8X1
3	802-114C	HHCS 3/8-16X2 1/2 GR5
1	802-226C	HHCS 1/2-13X2 3/4 GR5
1	802-300C	HHCS 1/4-28X3/8 GR5
3	803-014C	NUT HEX 3/8-16 PLT
1	803-020C	NUT HEX 1/2-13 PLT
2	803-035C	NUT HEX 8-32 BRASS
1	803-036C	NUT HEX JAM 1/2-13 PLT
2	804-002C	WASHER INTERNAL STAR #8 BRA
1	804-006C	WASHER LOCK SPRING 1/4 PLT
1	804-007C	WASHER FLAT 1/4 SAE PLT
7	804-013C	WASHER LOCK SPRING 3/8 PLT
2	804-016C	WASHER FLAT 1/2 SAE PLT
1	808-160C	SPKT 40B12 X 36T SPLINE BOR
1	808-271C	SPKT 40B16 X 36T SPLINE BOR
1	808-272C	SPKT 40B16 X 1 W/KW & SS
1	817-025C	NO. 40 12T IDLER SPKT.
1	819-059C	DRIVE TYPE PLATE, 4 3 2 1
1	890-282C	GEAR BOX

197-153A Gearbox Replacement Kit RH*Your Kit Includes:*

Qty.	Part No.	Part Description
1	120-237D	GEARBOX SHIFT HANDLE
1	136-071D	CHAIN RL #40 48 PITCHES
1	197-151M	MANUAL 2SNT GEARBOX RPLACEM
1	197-152H	GEARBOX MOUNT WELDMENT RH
1	197-240D	GEAR BOX COVER RH
3	197-273D	GEARBOX SPACER
2	800-141C	SNAP RING EXT F/PEERLESS G.
2	801-001C	SCREW RD HD 8-32 X 3/8 BRA
6	801-076C	SCR SELF TAPPING 3/8X1
3	802-114C	HHCS 3/8-16X2 1/2 GR5
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1	808-271C	SPKT 40B16 X 36T SPLINE BOR
1	808-272C	SPKT 40B16 X 1 W/KW & SS
1	817-025C	NO. 40 12T IDLER SPKT.
1	819-045C	2SNT DRIVE TYPE PLATE
1	890-282C	GEAR BOX