GEARBOX RETRO FIT KIT, PART NO. 1039008
for use with the
10” HEAVY DUTY POWER SWEEP
(using 1034570 gearbox to replace 1025102 gearbox)

Before beginning assembly it is suggested to read through these instructions and lay out all items from the kit to ensure all parts are accounted for. This not only helps you become familiar with the parts and the assembly procedures, but also makes you aware of what tools, equipment or materials you may need to complete the installation process.

WARNING! Do Not enter the bin unless all power driven equipment has been shutdown and locked out.

Install Gearbox
This gearbox will lengthen the power sweep by 2 1/2” (64 mm) and decreases the center distance between the original upper and lower gearbox by 2” (51 mm).

Generally there is plenty of room at the end of the sweep for the additional length and there is about 2” (51 mm) of clearance from the sweep to the bin floor. However, if there should not be enough room for the additional length, modifications to the sweep will need to be made at the time of reassembly.

1. Before disassembly of the old gearbox, verify the distance from the outside of the sweep wheel to the closest section of the bin wall (See Fig. 1).
   Measure the distance from the bottom of the shield and flight to the bin floor and write this dimension down for later reference.
2. Remove and retain the 5/8" x 1 1/2" bolt and locknut that is used to attach the shield bracket to the gearbox bracket (See Fig. 2).

3. Disconnect the u-joint from the gearbox by removing the 3/8" x 2 1/2" bolt and locknut (be careful not to lose the 1/4" x 1 1/2" key on the gearbox shaft). Retain the key and hardware for reassembly.

4. Remove the cover door on the center well to gain access to the chain. Disconnect the spring from the tensioner to relieve tension on the chain and remove chain (See Fig. 2). Retain chain and half link for reassembly.

5. Measure the distance from the outside of the sprocket from which the chain was previously removed, to where the bottom side of the cover door would be located [this distance is generally around 1" (25 mm)]. See Fig. 3.

6. Next, determine how much to cut out of the center panel to relocate the lower box of the new 1034570 gearbox.

   This is determined by taking the measurement from the bottom of the sweep to the bin floor (this measurement was taken in Step 1 and recorded for later reference). Subtract 2" (51 mm) from this measurement, then add the desired distance from bottom of sweep to bin floor (be sure to allow for bolt heads and other obstructions that may be present in the bin floor).

   Example: If the sweep flight was 2 1/2" (64 mm) off the bin floor and 1 1/2" (38 mm) was desired distance after installation of the new gearbox, the formula would be: 2 1/2" - 2" + X = 1 1/2" (X = 1"), (64 mm - 51 mm + X = 38 mm) (X = 25 mm).

   This means you would need to raise the lower gearbox 1" (25 mm) from its current position to achieve the desired distance of 1 1/2" (38 mm) from the sweep to bin floor.

   If the value for X is larger than the measurement taken in Step 5 (top of sprocket to bottom of cover door), there will need to be some additional modification to the cover door.
7. Check the distance from the bottom of the cover door to the center of the shaft on the lower gearbox (See Fig. 4). Verify if there is enough room to simply slide the lower box up the desired amount that was determined in Step 6 (this may be possible with some wells and gearboxes).

If there is enough room, continue with Step 8 then go to Step 10. If there is not enough room, continue with Step 8 and then go to Step 9.

8. Remove the old gearbox, both gearbox brackets and the driven sprocket and two-bolt flange bearing (See Fig. 5). Retain all hardware for use when reassembling.

9. If the gearbox cannot be moved up without interference from the shaft hole, the hole will need to be cut higher.

Cut the larger hole in the panel to allow the lower gearbox shaft to be raised the needed distance that was determined in Step 7 (See Fig. 6).

Be sure to protect the clutch assembly and nylon rollers from sparks and other debris. Clean all metal filings and debris from area after cutting has been completed.

10. Using the hardware previously retained, install the new lateral bracket, gearbox support bracket and the new gearbox. Install the new sweep shield bracket onto the gearbox (See Fig. 7).
11. After the new gearbox has been installed and secured into place, measure the distance from the center of the shaft on the upper gearbox to the bin floor (See Fig. 8, this dimension should equal the radius of the flight, plus the desired distance between the sweep and bin floor). If not, adjust accordingly.

For example: If 7” (17.8 cm) is the diameter of the sweep flight, you would have a 3 1/2” (89 mm) radius. Add the desired distance of 1 1/2” (38 mm), the distance from the center of the shaft to the bin floor should be 5” (12.7 cm).

![Fig. 8](image)

**Fig. 8**

12. Place the two-bolt flange bearing onto the shaft of the lower gearbox. Check to make sure the bearing does not extend past the top portion of the well. **If it does, the bearing will need to be rotated 90° from its original position, and its mounting holes redrilled.**

If necessary, rotate the bearing 90°, mark the mounting holes and drill two 17/32” (13.5 mm) dia. holes (See Fig. 9). Install the bearing using the hardware previously retained and secure bearing to shaft with the lock collar.

**If the bearing does not extend past the top of the well, you may still need to redrill the mounting holes depending on how high the lower gearbox was raised.**

If necessary, drill two 17/32” (13.5 mm) dia. holes or lengthen the existing slotted holes to reinstall the bearing.

![Fig. 9](image)

**Fig. 9**

13. Replace the sprocket and chain using the hardware previously retained. Place the cover door into position and secure into place. Rotate the shaft on the gear box to verify the cover door does not interfere with the sprocket.

If the cover door does contact the sprocket, use flat washers or similar means to space the cover accordingly. Make sure to seal the gap between the cover door and top of well.

14. Reinstall the u-joint, flight and shield. Check all hardware to ensure it is tight and verify all parts are properly installed.
PARTS LIST
Gearbox Retro Fit Kit
Part No. 1039008

For use with the
10" Heavy Duty Power Sweep

<table>
<thead>
<tr>
<th>Ref. No.</th>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1034570</td>
<td>Gearbox DBL Series 1.5:1 ratio</td>
</tr>
<tr>
<td>2</td>
<td>1039034</td>
<td>Support Bracket, Gearbox</td>
</tr>
<tr>
<td>3</td>
<td>1037894</td>
<td>Bracket, Gearbox Sweep</td>
</tr>
<tr>
<td>4</td>
<td>1039032</td>
<td>Lateral Support Bracket</td>
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</tbody>
</table>

Refer to the Lubrication & Maintenance Section in the Owner’s & Operator’s Manual supplied with the Power Sweep Unit for proper care and maintenance of the gearbox.