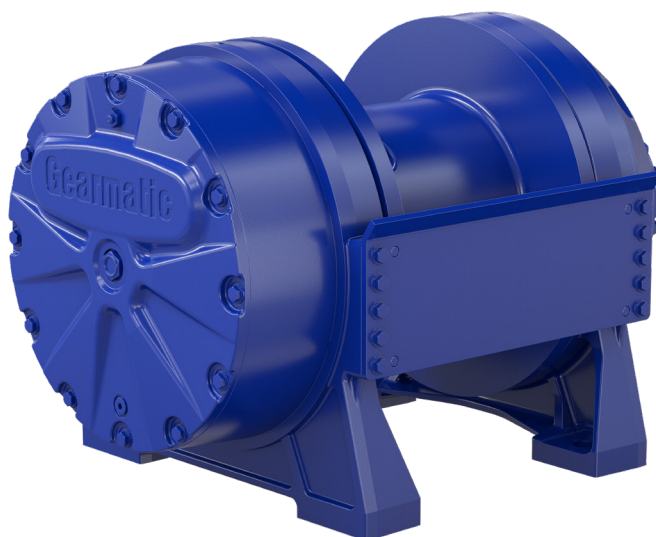


GM50A HYDRAULIC WINCH

EQUAL SPEED AND HIGH SPEED REVERSE



Record serial number below:

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First 2 numbers indicate year of manufacture  
(for serial number location, see page 4).

Visit [www.arrowheadwinch.com](http://www.arrowheadwinch.com) for the most up-to-date product and service information.  
Technical publications for most Arrowhead Winch products are available for download.

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## FOREWORD

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Read this entire publication and retain it for future reference.

For inquiries regarding your Gearmatic Planetary Hoist or this publication, please contact Gearmatic Service Department at 918-251-8511, Monday through Friday, 8:00 a.m. to 4:30 p.m. (CST).

The minimum service intervals specified are for operating hours of the prime mover.

The following service instructions have been prepared to provide assembly, disassembly and maintenance information for the Gearmatic GM50A hoist. Before doing any work on these units, all assembly and disassembly instructions should be read and understood.

Some illustrations in this manual may show details or attachments different from your hoist. Some components have been removed for illustrative purposes. Drawings in this manual represent a typical unit sold through our distribution channels. Some hoists, particularly those sold directly to original equipment manufacturers (OEM), may differ in appearance and options.

## GENERAL SAFETY RECOMMENDATIONS

Safety and informational callouts used in this manual include:

### **WARNING**

**WARNING** – This emblem is used to warn against hazards and unsafe practice which **COULD** result in severe personal injury or death if proper procedures are not followed.

### **CAUTION**

**CAUTION** – This emblem is used to warn against potential or unsafe practices which **COULD** result in personal injury and product or property damage if proper procedures are not followed.

Safety for operators and ground personnel is of prime concern. Always take the necessary precautions to ensure safety to others as well as yourself. The following recommendations are offered as a general safety guide. Local rules and regulations will also apply.

### **CAUTION**

**Winch service must be performed only by personnel trained and qualified in the repair of hydraulic winches. Improper service may result in equipment damage, personal injury, or death.**

1. Be certain equipment (boom, sheave blocks, pendants, etc.) is either lowered to the ground or blocked securely before servicing, adjusting, or repairing hoist.
2. Be sure personnel are clear of work area BEFORE operating hoist.
3. Read all warning and caution tag information provided for safe operation and service of hoist.
4. Inspect rigging and hoist at the beginning of each work shift. Defects should be corrected immediately.
5. Keep equipment in good operating condition. Perform scheduled servicing and adjustments listed in the "Preventive Maintenance" section of this manual.
6. An equipment warm-up procedure is recommended for all start-ups and essential at ambient temperatures below +40°F (4°C). Refer to "Warm-up Procedure" listed in the "Preventive Maintenance" section of this manual.
7. Operate hoist line speeds to match job conditions.
8. Leather gloves should be used when handling wire rope.
9. Never attempt to handle wire rope when the hook end is not free. Keep all parts of body and clothing clear of cable rollers, cable entry area of fairleads and hoist drum.
10. When winding wire rope on the hoist drum, never attempt to maintain tension by allowing wire rope to slip through hands. Always use "Hand-Over-Hand" technique.
11. Never use wire rope with broken strands. Replace wire rope.
12. Do not weld on any part of the hoist.
13. Use recommended hydraulic oil and gear lubricant.
14. Keep hydraulic system clean and free from contamination at all times.
15. Use correct anchor for wire rope and pocket in drum.
16. Do not use knots to secure or attach wire rope.
17. The BRADEN designed wire rope anchors are capable of supporting the rated load when installed properly. For additional safety, ALWAYS maintain a minimum of five (5) wraps of wire rope on the drum.
18. Never attempt to clean, oil or perform any maintenance on a machine with the engine or prime mover running, unless instructed to do so in this manual.
19. Never operate hoist controls unless you are properly positioned at the operators station and you are sure personnel are clear of the work area.
20. Assure personnel who are responsible for hand signals are clearly visible and that the signals to be used are thoroughly understood by everyone.
21. Ground personnel should stay in view of the operator and clear of hoist drum. Do not allow ground personnel near hoist line under tension. A safe distance of at least 1-1/2 times the length of the cable should be maintained.
22. Do not exceed the maximum pressure, PSI (bar), or flow, GPM (LPM), stated in the hoist specifications.
23. Install guarding to prevent personnel from getting any part of body or clothing caught at a point where the cable is wrapped onto the drum or drawn through guide rollers.
24. "Deadman" controls, which automatically shut off power to the hoist whenever the operator leaves his station, should be installed whenever practicable.
25. Never allow anyone to stand under a suspended load.
26. Avoid sudden "shock" loads or attempting to "jerk" load free. This type of operation may cause heavy loads, in excess of rated capacity, which may result in failure of cable and hoist.

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## EXPLANATION OF MODEL NUMBER

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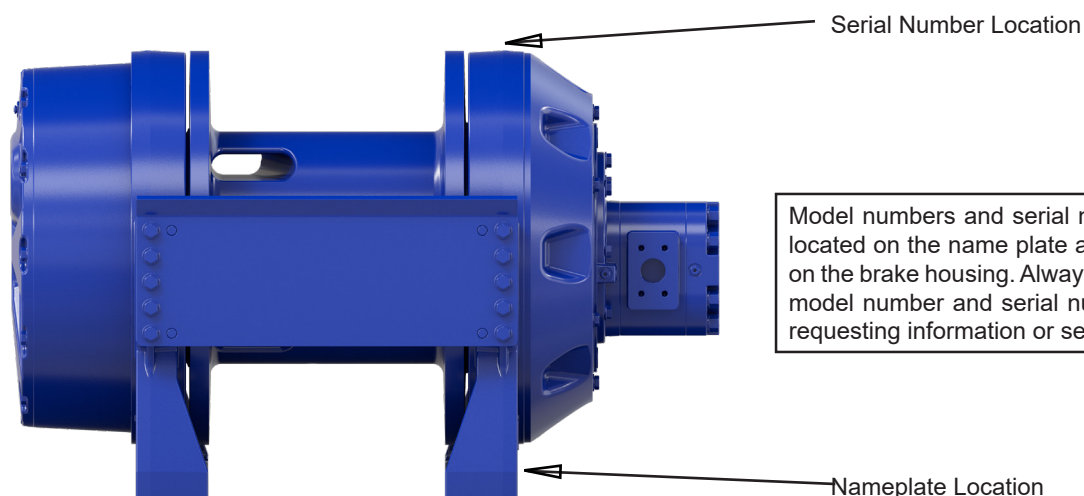
① ② ③ ④ ⑤ ⑥  
GM 50 A - 108 - 120 - 01

1. GM — Gearmatic model
2. 50 — 50,000 lb rated line pull
3. A — Evolutionary designation
4. 108 — Total gear reduction (108:1), Equal Speed
5. 120 — Motor displacement (12.03 CID)
6. 01 — Drum option (other options include 02 and 13)

① ② ③ ④ ⑤ ⑥ ⑦ ⑧  
GM 50 A - HSR - 108 / 23 - 120 - 01

1. GM — Gearmatic model
2. 50 — 50,000 lb rated line pull
3. A — Evolutionary designation
4. HSR — High-Speed Reverse
5. 108 — Total gear reduction (108:1), Equal Speed
6. 23 — High-Speed Reverse: 108:1 hoisting, 23:1 lowering
7. 120 — Motor displacement (12.03 CID)
8. 01 — Drum option (other options include 02 and 13)

**NOTE:** The GM50A High-Speed Reverse Winches lower the load 4.7 times faster than the hoisting speed.



# THEORY OF OPERATION

## DESCRIPTION OF HOIST

The hoist has four basic assemblies

1. Brake housing and motor assembly
2. Output housing assembly
3. Drum
4. Tie plates

The hydraulic motor is bolted to the brake cylinder bolted to the brake housing. The drum assembly is supported by both end bracket assemblies which receives additional support from the tie plates.

## PLANETARY GEAR TRAIN

The hydraulic motor shaft is directly coupled to the inner race of the overrunning brake clutch, which drives the primary sun gear. The primary planet gears walk around the stationary ring gear in the brake housing, driving the primary planet carrier.

The carrier drives the secondary sun gear shaft through the brake housing, which turns the secondary sun gear. The secondary sun gear drives the secondary planet gears around the secondary ring gear splined to the housing. The secondary carrier is splined to the output sun gear shaft, which drives the output sun gear. The output sun gear drives the output planet gears around the output ring gear bolted to the gear housing support. The output planet carrier drives the drum through a splined connection.

## BRAKE SYSTEM

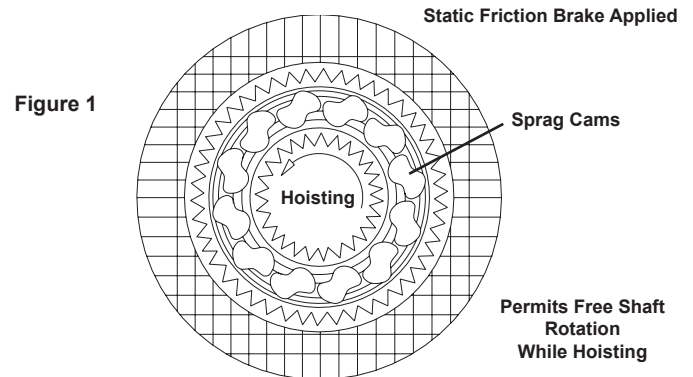
The brake system contains three basic components.

1. Spring applied, disc multi-friction brake
2. Overrunning brake clutch assembly
3. Hydraulic piston and cylinder

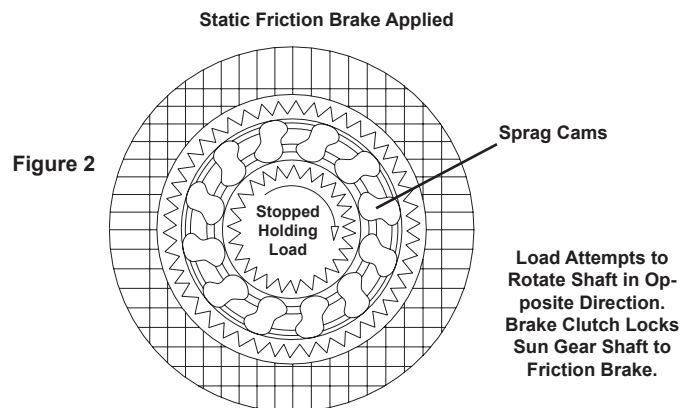
The brake consists of brake discs which are internally splined to the outer hub of the overrunning brake clutch. Spring force applied to the brake piston clamps the brake discs lock the overrunning brake clutch outer hub to the brake housing.

The sprag type overrunning brake clutch is installed between the motor shaft and primary sun gear. The overrunning brake clutch allows the motor shaft to turn freely in the direction to haul-in cable and locks up to force the friction brake discs to turn with the motor shaft to pay out cable. The brake plate remains fully applied when hauling in cable and must be released by lowering pressure to pay out cable.

When hoisting or pulling a load, the brake clutch allows free rotation of the motor shaft and primary sun gear. The sprag cams lay over and permit the primary sun gear to turn free of the outer clutch hub. Figure 1. The friction brake remains fully engaged. The hoist is not affected by any braking action when hoisting.



When the hoisting operation is stopped, the load attempts to turn the primary sun gear in the opposite direction. This reversed input causes the sprag cams to instantly engage and firmly lock the motor shaft and primary sun gear to the outer brake clutch hub. (Figure 2).



When the hoist is powered in reverse, to lower the load, the motor and gear train will not rotate until sufficient lowering pressure is supplied to the brake release piston through the motor port to overcome the brake spring force. With no load on the hoist, approximately 500 PSI is required to compress the brake springs and allow the friction brake discs splined to the outer brake clutch hub to turn free. As lowering pressure increases, the brake is gradually released allowing the motor to drive the gear train in reverse to reel out wire rope.

When the control valve is returned to neutral or "hold", the lowering pressure will decrease and the brake will apply to hold the load.

If the load on the drum barrel tries to drive the motor faster than the supply of oil will permit (i.e. if the motor tries to act as a pump), the hydraulic pressure acting on the brake piston will decrease, causing an increase in the effective spring load, resulting in an increase in braking effort. In this way, a balanced pressure is supplied to the motor and brake release piston according to the load on the hoist drum.

The speed of the hoist in reverse and forward is dependent only on the volume of oil supplied to the motor through the control valve.

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## THEORY OF OPERATION

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### HIGH-SPEED REVERSE LOWERING

During lowering, the reversing side of the hydraulic motor applies hydraulic pressure to the brake piston, releasing the multi-disc brake against spring force. The overrunning clutch connects the motor drive shaft to the internal gear of the primary planetary reduction so that both components rotate at the same speed.

This action bypasses the primary reduction stage and transfers hydraulic motor torque and speed directly to the final planetary reduction gearset. The resulting reduction ratio is 23:1, which causes the cable drum to rotate 4.70 times faster than forward hoisting speed.

If load conditions affect lowering speed, the resulting pressure drop at the brake piston creates friction between the brake discs and steel separator plates. The operator controls lowering speed with the hoist control handle. Returning the handle to neutral stops rotation and automatically applies the disc brake. Heat generated by brake-disc friction is dissipated by cooling flow from the hydraulic motor or from an external source, and the circulation return line routes the flow back to the reservoir.

## HOIST INSTALLATION

1. The hoist must be mounted with the centerline of the drum in a horizontal position. The mounting plane can be rotated to any position around this centerline.
2. When mounting the hoist, use grade 8 capscrews or bolts and nuts using both mounting holes in each end plate. Use narrow, hardened washers under the bolt heads and nuts
3. It is important that the hoist be mounted on a surface that will not flex when the hoist is in use, since this could bind the working parts of the hoist. Also, be sure the hoist is mounted on a flat surface. If necessary, use shim stock to insure proper mounting. The mounting surface must be flat within 0.020 inches (.5 mm).
4. Hydraulic lines and components that operate the hoist should be of sufficient size to assure minimum back pressure at the hoist motor ports. To insure adequate static brake load holding ability, back pressure on the hoist should not exceed 100 psi (690 kPa).

Oil having 150 to 330 SUS viscosity (150 ISO CT) at 100°F (38°C) and viscosity index of 100 or greater will give good results under normal temperature conditions. The use of an oil having a high viscosity index will minimize cold-start trouble and reduce the length of warm-up periods. A high viscosity index will minimize changes in viscosity with corresponding changes in temperature.

Maximum cold weather start-up viscosity should not exceed 5000 SUS with a pour point at least 20°F (11°C) lower than the minimum temperature.

In general terms; for continuous operation at ambient temperatures between 50 and 110°F (10-43°C) use ISO VG 46 – 68 (SAE20); for continuous operation between 10 and 90°F (-12 and 32°C) use ISO VG 32 (SAE10W).

**NOTE:** *Install hydraulic oil circulating oil return line. See the hydraulic circuit drawing and circulating line size requirements on page 11.*

### **WARNING**

**DO NOT weld hoist to mounting surface. Welding may not provide adequate structural support for hoist loads. This may cause loss of load control, which could result in property damage, personal injury or death. Welding may also damage bearings and seals, resulting in premature failure.**

### **WARNING**

**DO NOT use a control valve with any detents or latching mechanism that would hold the control valve in an actuated or running position when the operator releases the control handle. Use of the wrong type of control valve could lead to unintentional operation of the hoist, which could result in property damage, personal injury or death.**

5. Make certain that the hoist drum is centered behind the first sheave and the fleet angle does not exceed 1½ degrees.  
  
The hoist should also be mounted perpendicular to an imaginary line from the center of the drum to the first sheave to ensure even spooling.
6. The hoist directional control valve must be a three-position, four-way valve without detents and with a spring centered motor spool such that the valve returns to the centered position whenever the handle is released, and both work ports are opened to tank (open center, open port). See page 11.
7. The hydraulic oil filter should have a 10 micron nominal rating and be a full-flow type.
8. High quality hydraulic oil is essential for satisfactory performance and long hydraulic system component life.

## RECOMMENDED FASTENER TORQUE

Higher or lower torques for special applications will be specified such as the use of spanner nuts, nuts on shaft ends, jam nuts and where distortion of parts or gaskets is critical.

Lubricated torque values based on use of SAE 30wt engine oil applied to threads and face of bolt or nut.

Avoid using thread lubricants (such as anti-seize compound) as the applied torque may vary by 10-40%, depending upon the product used.

| Bolt<br>Diam.<br>Inches | Thread<br>per<br>inch | Torque LB-FT (N.m) |              |              |              |
|-------------------------|-----------------------|--------------------|--------------|--------------|--------------|
|                         |                       | Grade 5            |              | Grade 8      |              |
|                         |                       | Dry                | Lubed        | Dry          | Lubed        |
| 1/4                     | 20<br>28              | 8<br>(11)          | 6<br>(8)     | 12<br>(16)   | 9<br>(12)    |
| 5/16                    | 18<br>24              | 17<br>(23)         | 13<br>(17)   | 24<br>(33)   | 18<br>(24)   |
| 3/8                     | 16<br>24              | 31<br>(42)         | 23<br>(31)   | 45<br>(61)   | 35<br>(47)   |
| 7/16                    | 14<br>20              | 50<br>(68)         | 35<br>(47)   | 70<br>(95)   | 50<br>(68)   |
| 1/2                     | 13<br>20              | 75<br>(102)        | 55<br>(75)   | 110<br>(149) | 80<br>(108)  |
| 9/16                    | 12<br>18              | 110<br>(149)       | 80<br>(108)  | 150<br>(203) | 110<br>(149) |
| 5/8                     | 11<br>18              | 150<br>(203)       | 115<br>(156) | 210<br>(285) | 160<br>(217) |

| Bolt<br>Diam.<br>Inches | Thread<br>per<br>inch | Torque LB-FT (N.m) |                |                |                |
|-------------------------|-----------------------|--------------------|----------------|----------------|----------------|
|                         |                       | Grade 5            |                | Grade 8        |                |
|                         |                       | Dry                | Lubed          | Dry            | Lubed          |
| 3/4                     | 10<br>16              | 265<br>(359)       | 200<br>(271)   | 380<br>(515)   | 280<br>(380)   |
| 7/8                     | 9<br>14               | 420<br>(569)       | 325<br>(441)   | 600<br>(813)   | 450<br>(610)   |
| 1                       | 8<br>14               | 640<br>(868)       | 485<br>(658)   | 910<br>(1234)  | 680<br>(922)   |
| 1 1/8                   | 7<br>12               | 790<br>(1071)      | 590<br>(800)   | 1290<br>(1749) | 970<br>(1315)  |
| 1 1/4                   | 7<br>12               | 1120<br>(1518)     | 835<br>(1132)  | 1820<br>(2468) | 1360<br>(1817) |
| 1 3/8                   | 6<br>12               | 1460<br>(1979)     | 1095<br>(1485) | 2385<br>(3234) | 1790<br>(2427) |
| 1 1/2                   | 6<br>12               | 1940<br>(2360)     | 1460<br>(1979) | 3160<br>(4284) | 2370<br>(3214) |

To convert LB-FT to Kg-m, multiply LB-FT value by 0.1383

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## WIRE AND SYNTHETIC ROPE INSTALLATION

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Below provides instructions on installing wire and synthetic rope using various anchoring methods.

### **WARNING**

Wire and synthetic rope anchors alone are not designed to hold rated loads. Loads applied directly to the anchor may cause the rope to pull free and result in the sudden loss of load control, property damage, serious injury or death.

### **WARNING**

A minimum number of five wraps of rope must be on the drum to handle full rated load.

### WEDGE ANCHOR — WIRE ROPE

If the drum is designed with an anchor pocket, follow these steps:

1. Make sure the anchor pocket and wedge are clean and dry. The end of the wire rope being anchored to the drum must be clean and dry and not frayed. Anything on the end of the wire rope to keep it from fraying (i.e. tape or wire) must not be in contact with the wedge when the installation is complete.
2. Take the free end of the wire rope and insert it through the small opening of the anchor pocket.
3. Loop the wire rope and push the free end about 3/4 of the way back through the pocket.
4. Install the wedge as shown in Figure 1 then pull the slack from the cable.
5. The “dead” end of the rope should extend slightly beyond the end of the wedge as shown in Figure 2.
6. Using a hammer and brass drift, drive the wedge as deep into the pocket as possible to ensure it is fully seated.
7. Check to ensure the wedge does not protrude from either end of the pocket, which will cause it to interfere with proper spooling of rope onto the drum (see Figures 3 and 4).

### PART NUMBERS — WIRE ROPE WEDGE

113743 for 3/4” to 1-1/4”

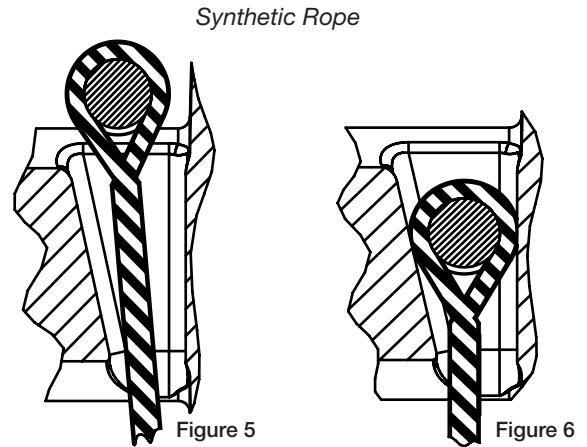
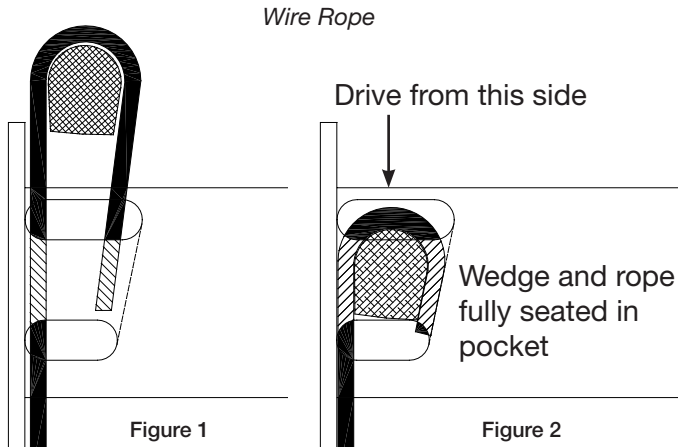
### WEDGE ANCHOR — SYNTHETIC ROPE

If the drum is designed with an anchor pocket approved for use with synthetic rope, follow these steps:

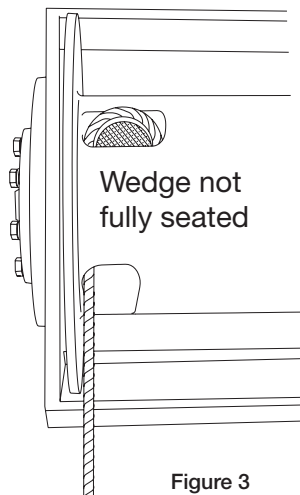
1. Make sure the anchor pocket and wedge are clean and dry. The end of the synthetic rope being anchored to the drum must be clean and dry and not frayed.
2. Make sure you are using the correct wedge anchor for synthetic rope.

# WIRE AND SYNTHETIC ROPE INSTALLATION

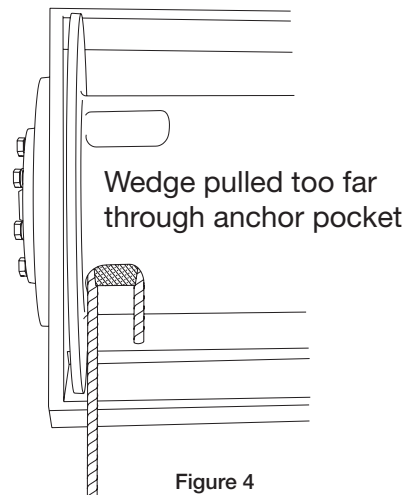
## Correct Installations



## Incorrect Installations

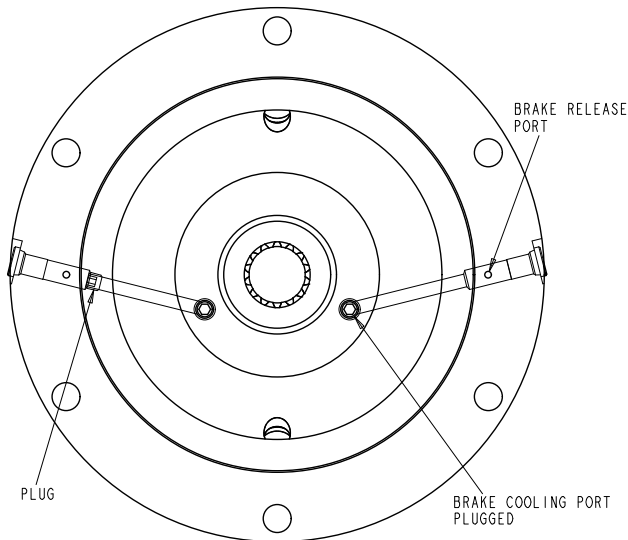


- Rope not tight against wedge
- Wedge may be too large



- "Dead" end of rope and/or wedge may interfere with proper spooling
- Wedge may be too small

# HYDRAULIC CIRCUIT



Standard overwound configuration shown. Drum rotates counterclockwise with viewed from motor end.

Figure 1 illustrates a basic hydraulic circuit. Oil is circulated through the primary housing so that it enters through the brake cooling orifice and leaves at port "Q". Port "Q" should be located as close to top dead center as possible.

Hydraulic oil must circulate through the housing. This provides cooling for the brake and also ensures that the housing is completely filled with oil.

In order to maintain maximum efficiency in the hoist, select the size of hydraulic lines according to the maximum volume of oil to be used in the hoist (see Table). If the hydraulic lines used are too small, they may cause excess back pressure at the reverse motor port sufficient to release the brake (100 psi maximum) (6.9 bar).

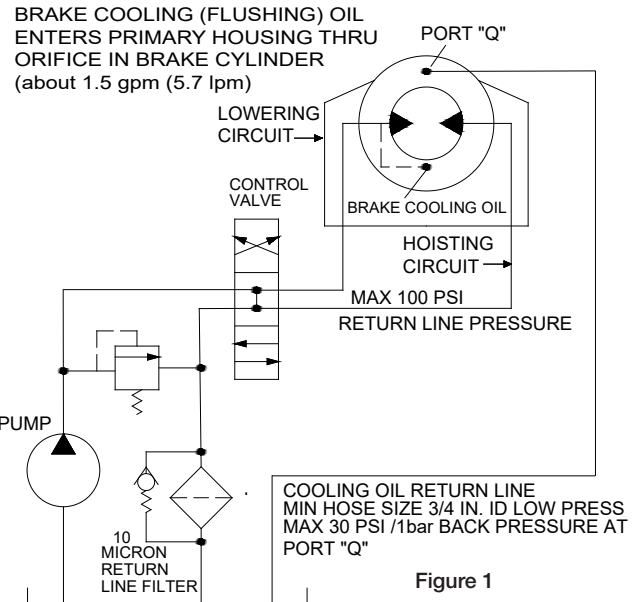


Figure 1

CIRCULATION RETURN PORT IN THE MOTOR END MUST BE CONNECTED TO TANK WITH A TANK LINE.

The sizes shown in the table are to be used as a guide only. If trouble is experienced due to the use of long hoses it will be necessary to use hoses which are one size larger.

Line from Port Q – ¾ inch (19 mm) minimum

| HOSE REQUIREMENTS           |                               |                             |
|-----------------------------|-------------------------------|-----------------------------|
| Oil Flow gpm<br>(l/min)     | Pressure Lines<br>Inside Dia. | Return Lines<br>Inside Dia. |
| 95-140 gpm<br>360-530 l/min | 2 in.<br>(51 mm)              | 2¼ in.<br>(57 mm)           |
| 70-94 gpm<br>265-359 l/min  | 1½ in.<br>(38 mm)             | 1¾ in.<br>(44 mm)           |
| 45-69 gpm<br>170-264 l/min  | 1¼ in.<br>(32 mm)             | 1½ in.<br>(38 mm)           |

Line From Case Drain - ¾ in. (19 mm) Minimum

Once the hydraulic circuit has been completed, bleed all air from the primary housing before running the hoist.

In order to obtain smooth control during low speed lowering, it is recommended that the hydraulic pump is operated at maximum gpm (l/min) and that the control valve is used to control the hoist speed.

---

## PREVENTIVE MAINTENANCE

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A regular program of preventive maintenance for your planetary hoist is required to minimize the need for emergency servicing and promote safe, reliable hoist operation.

The user of Gearmatic hoist products is responsible for hoist inspection, testing, operator training and maintenance noted below with frequency dependent upon the severity of the hoist duty cycle and the thoroughness of the preventive maintenance program. Field experience, supported by engineering tests, indicate the three service procedures listed below are the most critical to safe, reliable hoist operation and **MUST** be observed.

- Regular Gear Oil Changes
- Use of Proper Gear Oil – recommended type for prevailing ambient temperatures and additives
- Periodic Disassembly and Inspection of All Wear Components – in compliance with ANSI specification B30.5c, 1987 and API RP 2D

Inspection records as well as records of preventive maintenance, repairs and modifications must be retained for a minimum of four (4) years. These records should include but are not limited to, hoist model and serial number, date, description of the problem, repairs performed, parts used and description of the final test.

**Pre-Use Inspection** (each shift the hoist is used): This inspection must be performed prior to placing the crane into service and then as necessary during the day for extended operation.

1. Check for external oil leaks and repair as necessary. **This is extremely important due to the accelerated wear that can be caused by insufficient lubricating oil in the hoist.** Lubricant level must be visible in the lower half of the sight glass. Use only recommended lubricants. See Recommended Lubricants chart in this manual.
2. Check hydraulic plumbing for damage, such as chafed or deteriorating hoses and repair as necessary.
3. Visually inspect for loose or missing bolts, pins, keepers or cotter pins and replace or tighten as necessary.
4. The gear oil should be changed after the first 100 hours of operation or 30 days. The regular gear oil change intervals may be adopted after the first oil change.
5. Inspect the full length of wire rope, rigging and all sheaves according to the wire rope and crane manufacturer's recommendations.
6. A warm-up procedure is recommended at each start-up and is mandatory at ambient

temperatures below +40°F (4°C). The engine should be run at its lowest RPM with the hydraulic hoist control in neutral allowing sufficient time to warm up the system. The hoist should then be operated at low speeds, hoisting and lowering with no load, several times to prime all hydraulic lines with warm oil and to circulate lubricant through the planetary gear sets.

### **WARNING**

**Failure to properly warm up the hoist, particularly under low ambient temperature conditions, may result in temporary brake slippage due to high back pressures attempting to release the brake, which could result in property damage, severe personal injury or death.**

**Quarterly Inspection** (every 3 months) or monthly in Severe Duty Applications or prior to placing the machine in service if it has not been used for three months or more.

1. Perform the Pre-Use Inspection.
2. Inspect all hoist fasteners for tightness and corrosion. Replace all corroded fasteners and tighten per the torque specifications on page 8.
3. The hydraulic system filters should be changed after the first 50 hours of operation then every 500 hours or quarterly or in accordance with the crane manufacturer's recommendations.
4. Take a sample of the gear oil from the hoist drum following the oil sampling procedure on page 16. The oil sample must be taken prior to changing the gear oil. Analyze the sample for wear metals, viscosity, signs of overheating, oxidation, water and other contaminants. If the oil sample contains an unusual amount of metallic particles, the hoist should be removed from service and undergo a tear-down inspection.

**Annual Inspection, Testing & Preventive Maintenance** or semi-annually in Severe Duty Applications.

1. Perform the Pre-Use and Quarterly Inspections.
2. Change the hoist gear oil after a sample is taken.

The gear oil should be changed whenever the ambient temperature changes significantly and an oil from a different viscosity range would be more appropriate. Oil viscosity is critical to reliable brake clutch operation. Testing indicates excessively heavy or thick gear oil may contribute to intermittent brake clutch slippage. Make certain the gear oil viscosity used in your hoist is correct for your prevailing ambient temperature.

---

## PREVENTIVE MAINTENANCE

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### **WARNING**

The gear oil must be changed to remove wear particles that impede reliable and safe operation of the brake clutch and erode bearings and seals. Failure to change gear oil at recommended intervals may contribute to intermittent brake slippage, loss of load control, injury or death.

### **WARNING**

Failure to use the proper type and viscosity gear oil may result in loss of load control, property damage, injury or death.

**NOTE:** If the oil sampling and analysis has not been performed as required, tear-down inspections are needed. Refer to the hoist disassembly section of this manual.

Drain the *hydraulic* oil from the brake housing by removing the plug on the hoist motor end flange. Drain the *gear* oil from the drum and output housing by removing the drain plug on the hoist output end cover and the drain plug in the drum. Ensure both end housings are vented for faster draining. After all the oil is drained, reinstall the drain plugs and re-fill the output housing with one of the recommended oils listed on page 16 to the oil level plug or sight gage. The brake housing will fill hydraulic oil via the orifice in the brake cylinder.

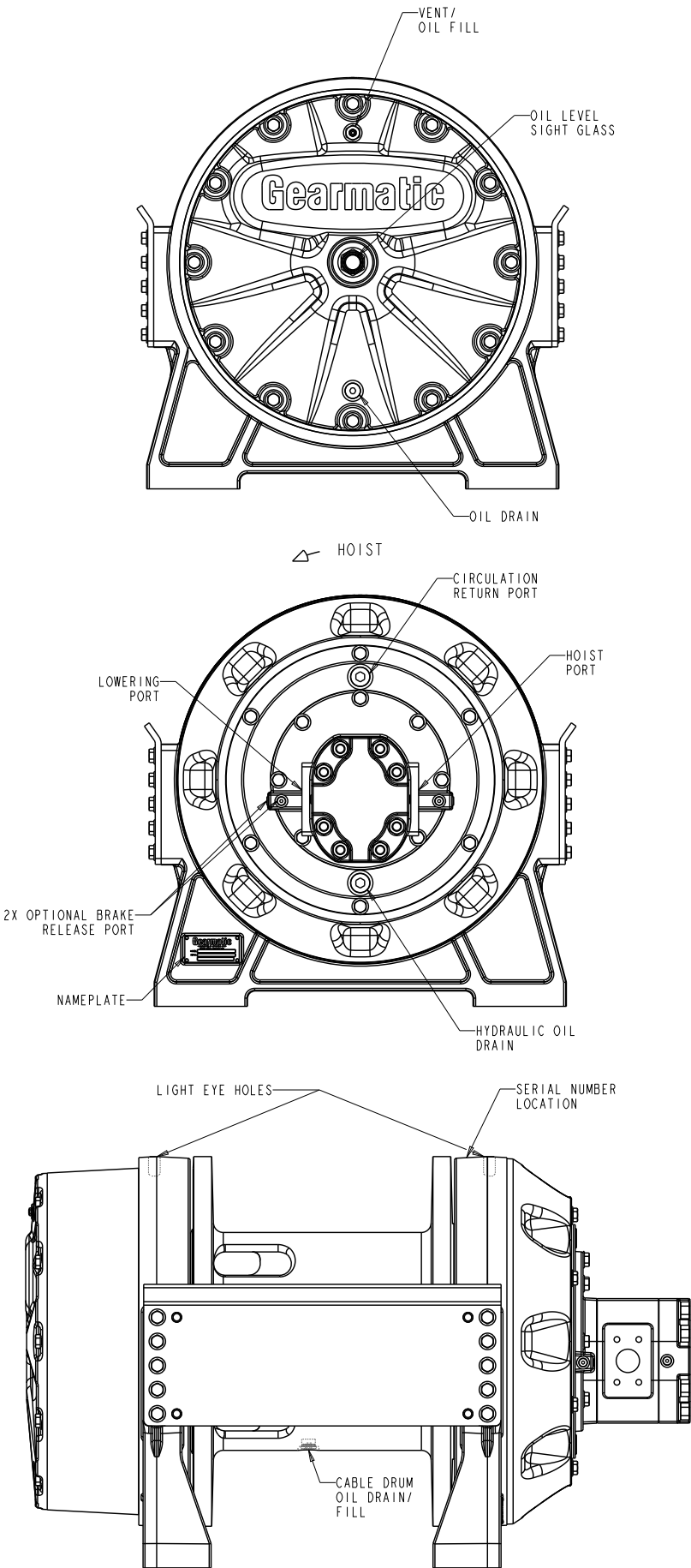
### **WARNING**

**DO NOT** insert fingers through oil drain hole to determine drain hole alignment. Movement of the drum could result in severe injury should appendages be present in the drain hole.

The vent plug is located in the output end cover. It is important to keep the vent plug clean and unobstructed. Whenever the gear oil is changed, the vent plug should be removed, cleaned in solvent and reinstalled. Do not paint over the vent plug or replace with a solid plug or grease fitting.

The vent plug should always be installed above the level of the hydraulic oil.

PREVENTIVE MAINTENANCE



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## LONG TERM STORAGE

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### STORAGE PRECAUTIONS

If your GM50A hoist is not used for extended periods of time should be kept indoors in a climate controlled structure when possible.

The drum should be rotated at least every 6 months using the procedure outlined below to coat the seals, seal surfaces, internal gearing and static brake system with oil. It should not be exposed to moisture, which causes rust and corrosion.

### MAINTENANCE INSTRUCTIONS

1. Check the gear oil level as described in the service manual. Add gear oil if required to fill to the correct level.
2. Using paint or marker, mark the drum flange and side plate at the top of the drum when the winch or hoist is in the storage position (Figure 3).
3. Place splash pan under the hydraulic motor.
4. Remove plugs in the hydraulic motor work ports.
5. Connect the reel in and reel out hose ports to vehicle or HPU\*.
6. If the winch or hoist is equipped with separate case drain, connect it to the hydraulic tank.
7. Rotate the winch or hoist in both directions 5 complete turns.
8. Rotate the winch or hoist an additional 1/2 turn to ensure that the drum is 180° from the procedure starting point.
9. Remove hydraulic hoses.
10. Replace plugs in the hydraulic motor work ports to prevent corrosion.
11. If the winch or hoist must be stored outside, apply corrosion inhibitor between the outside drum flange and side plates.
12. Wipe any oil from winch or hoist.

\*In order to keep the hydraulic motor lubricated, the winch or hoist must be connected to an adequate source of hydraulic flow when turning the unit. A vehicle hydraulic system or Hydraulic Power Unit (HPU) and associated hydraulic plumbing can be used to generate the flow needed to rotate the hoist and release the spring applied hydraulically released static brake.

Figure 1



Figure 2



Figure 3



## PLANETARY GEAR OIL

### ⚠ WARNING ⚠

Failure to use the proper type and viscosity of planetary gear oil may contribute to intermittent brake clutch slippage, which could result in the sudden loss of load control, property damage, serious injury or death.

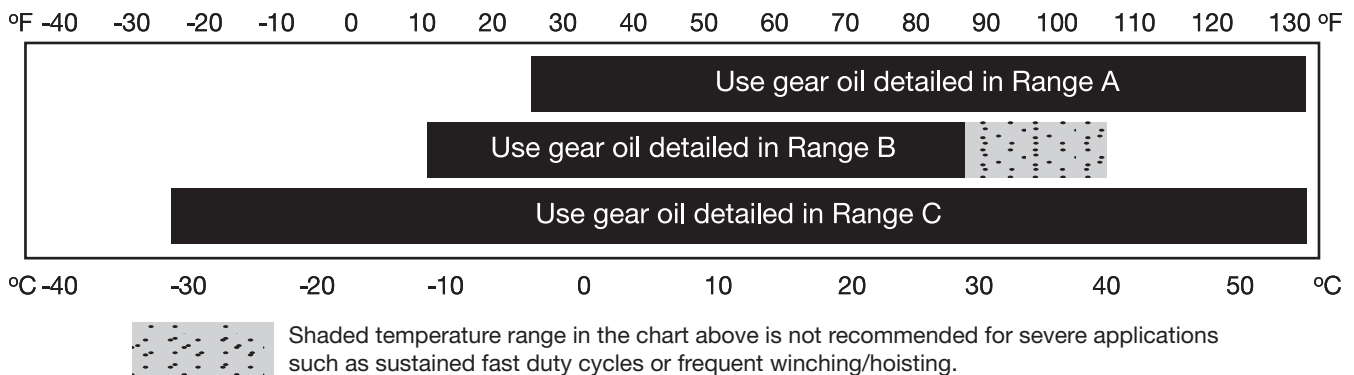
### ⚠ WARNING ⚠

Some gear lubricants contain large amounts of EP (Extreme Pressure) and anti-friction additives, which may contribute to brake clutch slippage or damage to brake brake discs or seals. **DO NOT** use oil labeled as meeting “API Service GL-5.”

### ⚠ WARNING ⚠

Oil viscosity is affected by ambient temperature and is critical to reliable brake clutch operation. Tests indicate that excessively heavy or thick gear oil may contribute to intermittent brake clutch slippage. Ensure the gear oil viscosity used in your hoist is appropriate for the prevailing ambient temperature.

## PREVAILING AMBIENT TEMPERATURE



**NOTE: A warm-up procedure is recommended at each start-up and is essential at ambient temperatures below 40°F (4°C).**

|                | Mobil                | Shell           | Chevron                             |
|----------------|----------------------|-----------------|-------------------------------------|
| <b>Range A</b> | Mobilgear 600 XP 200 | Omala S2 GX 220 | Gear Compounds EP 220 or Meropa 220 |
| <b>Range B</b> | Mobilgear 600 XP 150 | Omala S2 GX 150 | Gear Compounds EP 150 or Meropa 150 |
| <b>Range C</b> | Mobilgear SHC 150    | Omala S4 GX 150 |                                     |

*Gearmatic winches/hoists are factory filled with Mobilgear 600 XP 150 or equivalent. Consult with your oil supplier for equivalent oil options as required.*

The hydraulic oil should be changed whenever the ambient temperature changes significantly and an oil from a different viscosity range would be more appropriate. Oil viscosity is critical to reliable brake operation. Our tests indicate that excessively heavy or thick oil may contribute to intermittent brake slippage. Make certain the oil viscosity used in your hoist is correct for your prevailing ambient temperature.

**NOTE:** *If the oil sampling/analysis has not been performed as required, tear-down inspections will be required. Refer to Hoist Disassembly section of this manual.*

## HOIST OPERATION

The following warnings and instructions are basic to safe hoist operation. Please read them carefully and follow them each time your hoist is operated. These instructions are provided in addition to any information furnished by the Original Equipment Manufacturer. Equipment operators should be completely familiar with the overall operation of the piece of equipment on which the hoist is mounted (i.e. crane, dredge, drill rig, etc.). If you have

any questions concerning the safe operation of this hoist or the equipment it is mounted on, contact the equipment manufacturer that installed the hoist, or the Gearmatic Technical Support Department at 1-918-251-8511, Monday through Friday, 0800 to 1630 hours CST, by fax at 1-918-259-1575, or via the internet at [www.arrowhead-winch.com](http://www.arrowhead-winch.com).

### **WARNING**

**Ground personnel must stay in view of the operator and clear of the load and hoist drum at all times. Do not allow personnel near the hoist line under tension. Do not allow personnel near the hoist drum while the hoist is in operation. Do not allow personnel to be in line with the load. Do not allow personnel to stand under a suspended load. A safe distance of at least 1½ times the working length of the cable should be maintained by ground personnel. A broken cable and/or lost load may cause property damage, personal injury or death.**

### **Warm-Up Procedures**

A warm-up procedure is recommended at each start-up and is essential at ambient temperatures below +40°F (4°C).

The engine should be run at its lowest recommended RPM with the hydraulic hoist control valve in neutral allowing sufficient time to warm up the system. The hoist should then be operated at low speeds, raise and lower with no load on the hook, several times to prime all lines with warm hydraulic oil, and to circulate gear lubricant through the planetary gear sets.

After the hoist/boom is properly positioned, we recommend the operator slowly pay-out, then haul-in a short length of cable. The hoist should perform these operations in a smooth and controlled manner. If the hoist does not operate smoothly or makes any unusual sounds, the source of the problem should be identified and corrected before any attempt is made to lift a load.

### **CAUTION**

**If the hoist is mounted on a crane that has an extendable boom, care must be taken to pay-out cable as the boom is extended. Failure to pay-out sufficient cable could result in a “two-blocking” condition that could result in damage to and/or failure of the hoist, cable, sheaves and/or boom.**

Slowly pay-out wire rope from the hoist drum until it reaches the load. Securely fasten the hoist cable to the load and be sure all ground personnel are a safe distance from the load. Slowly lift the load a short distance and stop. A small amount of “bounce” may be observed, depending on the weight of the load, size and type of wire rope, reeving and the amount of boom extension. Allow the load to stabilize and then watch for any sign of downward movement or cable drum rotation. The hoist static brake should hold the load in place without allowing any downward movement at all. If the load creeps down, it should be lowered to the ground immediately and the source of the problem identified and corrected.

If the hoist is holding the load securely, proceed with normal operations in accordance with the equipment manufacturer’s operating procedures and load charts.

### **WARNING**

**Failure to properly warm up the hoist, particularly under low ambient temperature conditions, may result in temporary brake slippage due to high back pressures attempting to release the brake, which could result in property damage, severe personal injury or death.**

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## TEAR-DOWN INSPECTION

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### **Tear-Down Inspection**

If a hoist has an unknown history of repair and/or maintenance, the hoist should undergo a tear-down inspection prior to being placed into service.

A tear-down inspection of the hoist should include the complete disassembly, cleaning, inspection and replacement of all worn, cracked, corroded or distorted parts such as pins, bearings, shafts and brake components. All seals and o-rings should be replaced during a tear-down inspection. Always use new Spirol pins in the planet gear shafts.

**Any deficiency must be corrected immediately.**

Before placing the hoist back in service, the rebuilt hoist must be pull tested to the rated load of the hoist with a dynamometer or equivalent measuring device. The hoist should be dynamically tested by rotating the drum several times, in both raising and lowering directions, while under load of at least 30 % of the hoist rated lifting capacity

Check for smooth, quiet operation during this procedure.

## TROUBLESHOOTING

| TROUBLE                                                                              | PROBABLE CAUSE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | REMEDY                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |
|--------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <p style="text-align: center;"><b>A</b></p> <p>Hoist will not pull maximum load.</p> | <ol style="list-style-type: none"> <li>1. System relief valve may be set too low.</li> <li>2. If this trouble occurs suddenly after working at a maximum pull, a particle of dirt may be lodged under the system relief valve, holding it partially open. If this is the cause, a considerable loss in line speed may be noticed as the load on the cable is increased.</li> <li>3. If the pump is belt driven, the belts may be slipping.</li> <li>4. The oil level in the reservoir may be too low. The suction line may be restricted or have an air leak causing cavitation at the inlet port. This will cause the pump to make a whining noise.</li> <li>5. The hoist may be mounted on an uneven or flexible surface which causes distortion of the hoist base and binding of the gear train. Binding in the gear train will absorb horsepower needed to generate the rated line pull and cause heat.</li> <li>6. Be certain hydraulic system temperature is not more than 180°F. Excessive hydraulic oil temperatures increase motor internal leakage and reduce motor performance.</li> <li>7. Hoist line pull rating is based on 1st layer of wire rope. Expected line pull may be in excess of hoist rating.</li> <li>8. After all the causes listed above have been investigated and it is found that the hoist will stall at maximum pressure without developing the maximum pull on the bare drum, the trouble may be in the hoist.</li> </ol> | <p>Install a pressure gauge in the hoisting port and apply a stall pull on the hoist. If pressure is low, increase relief valve setting until recommended pressure is obtained.</p> <p><b>NOTE:</b> If pressure does not increase in proportion to adjustment, relief valve may be contaminated or worn out. In either case, the relief valve may require disassembly or replacement.</p> <p>Remove relief valve, disassemble and clean parts thoroughly in a suitable solvent. Reassemble and install relief valve. Reset pressure according to specifications.</p> <p>Check belts when pump is at full PSI (kg/cm<sup>2</sup>) (stall pull on hoist). Tighten belts if they are found to be slipping.</p> <p>Check oil level in the reservoir. Check the suction line for damage, externally and internally. Replace suction line if necessary.</p> <p>Reinforce mounting surface.</p> <p>If necessary, use steel shim stock to level hoist.</p> <p>First loosen, then evenly retighten all hoist mounting bolts to recommended torque.</p> <p>Same as remedy for A-5.</p> <p>Same as remedy for B-4.</p> <p>Refer to hoist performance charts for additional information.</p> <p>Install a pressure gauge in the motor hoist port and apply a stall pull on the hoist. If the pressure is up to maximum and the bare drum line pull is less than the specified line pull, the trouble may be in the hoist or hydraulic motor.</p> <p>Disassemble hoist according to disassembly instructions and check that gear train turns freely. If gear train is found to be satisfactory, inspect the hydraulic motor, according to the service instructions for the hydraulic motor.</p> |

## TROUBLESHOOTING

| TROUBLE                                                                                         | PROBABLE CAUSE                                                                                                                                                                                                                | REMEDY                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |
|-------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>B</b><br>Considerable reduction in line speed.                                               | 1. Same as A-2.<br>2. Same as A-4.<br>3. Same as A-6.<br>4. If this trouble has increased gradually, the hydraulic pump or hoist motor may be worn.<br>5. Prime mover(engine or electric motor) may be operating at low speed | Same as remedy for A-2.<br>Same as remedy for A-4.<br>Same as remedy for A-5 and B-4.<br>Remove and inspect pump. If satisfactory, consult the disassembly instructions for the hoist and remove and inspect the motor according to the service instructions for the hydraulic motor.<br>Check/Adjust throttle speed, tune engine.                                                                                                                                                                                                                                                                                        |
| <b>C</b><br>Lowering speed is significantly slower than hoisting speed.                         | 1. Control valve may be restricted in its travel.<br>2. Same as A-1.<br>3. Oil may be too thick causing a high resistance to rotation at the brake discs and causing the relief valve to by-pass.<br>4. Same as F-1.          | Check the travel of the control valve spool. The spool travel should be the same in both directions.<br>Same as remedy for A-1.<br>Follow warm-up procedure in "Preventive Maintenance" section.<br><br>Same as remedy for F-1.                                                                                                                                                                                                                                                                                                                                                                                           |
| <b>D</b><br>Brake will not hold when control valve is returned to neutral after lifting a load. | 1. Excessive system back pressure acting on the brake release port.<br><br>2. Friction brake will not hold due to worn or damaged brake discs.<br>3. Brake clutch is slipping.                                                | Install a pressure gauge at the lowering port of the hydraulic motor. Operate the pump at full throttle and monitor pressure in "neutral" and haul-in positions. If the pressure is greater than 100 PSI (6.9 bar), check for restrictions in the return line from the hoist to the control valve and the control valve to the reservoir.<br>Disassemble hoist to inspect/replace worn parts.<br><br>Improper hydraulic oil may cause the brake clutch to slip. Replace brake parts and refill reservoir with recommended hydraulic oil.<br>Brake clutch may be damaged or worn.<br>Disassemble and inspect brake clutch. |
| <b>E</b><br>Brake will not control or stop the load when lowering.                              | 1. Same as D-1, 2, or 3.<br>2. Hoist is being overloaded.<br><br>3. After the causes listed above have been investigated and found to be satisfactory, the trouble may be in the hoist.                                       | Same as remedies for D-1, 2, or 3.<br>Install a pressure gauge at the hoist port and apply a stall pull on the hoist. If the pressure is higher than the maximum specified PSI, reduce the pressure.<br>Disassemble the primary drive assembly according to the disassembly instructions. Inspect the brake springs, brake discs and brake clutch assembly. Check that the brake clutch assembly will "lock up" in the required direction of rotation.                                                                                                                                                                    |

## TROUBLESHOOTING

| TROUBLE                                                                                                                                                                                                                                                                                                                      | PROBABLE CAUSE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | REMEDY                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <p><b>F</b></p> <p>The hoist will not lower the load or not lower the load smoothly.</p> <p><b>NOTE:</b> If circulation return hose was not installed, drum seals will quickly fail.</p> <p>Also If the brake piston seal is defective, you will usually notice excessive oil flow from the hoist circulation vent port.</p> | <ol style="list-style-type: none"> <li>1. The friction brake may not be releasing as a result of a defective brake piston seal.</li> <li>2. Friction brake will not release as a result of damaged brake disc.</li> <li>3. Hydraulic system flow too low for smooth operation of hoist motor and brake release.</li> <li>4. Same as B-4.</li> <li>5. Same as A-3.</li> <li>6. Same as A-5.</li> <li>7. Control valve handle being operated too quickly.</li> <li>8. No oil circulating through the hoist.</li> <li>9. Control valve does not have good metering characteristics.</li> </ol> | <p>Check brake piston seals.</p> <p>Disassemble brake to inspect brake discs.</p> <p>Operate pump at maximum RPM.</p> <p>Same as remedy for B-4.</p> <p>Same as remedy for A-3.</p> <p>Same as remedy for A-5.</p> <p>Operate control valve smoothly when starting and stopping a load. Conduct operator training as required.</p> <p>Install oil circulation return line. See section on hydraulic circuit.</p> <p>See "Hoist Installation" sections for control valve specifications.</p> |
| <p><b>G</b></p> <p>The hoist runs hot.</p>                                                                                                                                                                                                                                                                                   | <ol style="list-style-type: none"> <li>1. Same as A-5.</li> <li>2. Be certain that the hydraulic system temperature is not more than 180°F. Excessive hydraulic oil temperatures may be caused by: <ol style="list-style-type: none"> <li>A. Plugged heat exchanger.</li> <li>B. Too low or high oil level in hydraulic reservoir.</li> <li>C. Same as A-1.</li> <li>D. Hydraulic pump not operating efficiently.</li> </ol> </li> <li>3. Excessively worn or damaged internal hoist parts.</li> <li>4. Circulation oil drain line may be restricted.</li> </ol>                            | <p>Same as remedy for A-5.</p> <p>Thoroughly clean exterior and flush interior.</p> <p>Fill/drain to proper level.</p> <p>Same as remedy or A-1.</p> <p>Remove and inspect pump.</p> <p>Check suction line for damage. If pump is belt driven, belts may be slipping. Replace/tighten belts.</p> <p>Disassemble hoist to inspect/replace worn parts.</p> <p>Inspect the vent drain line for damage or restrictions.</p>                                                                     |
| <p><b>H</b></p> <p>Hoist "chatters" while raising rated load.</p>                                                                                                                                                                                                                                                            | <ol style="list-style-type: none"> <li>1. Same as A-1.</li> <li>2. Same as B-4.</li> <li>3. Same as F-3.</li> <li>4. Same as F-7.</li> </ol>                                                                                                                                                                                                                                                                                                                                                                                                                                                | <p>Same as remedy for A-1.</p> <p>Same as remedy for B-4.</p> <p>Same as remedy for F-3.</p> <p>Same as remedy for F-7.</p>                                                                                                                                                                                                                                                                                                                                                                 |

## GM50A SERVICE KITS - EQUAL SPEED & HSR

### 66170 - SEAL KIT - EQUAL SPEED & HSR

| PART NO. | DESCRIPTION                  | QTY |
|----------|------------------------------|-----|
| 25016    | O-RING                       | 2   |
| 72109    | O-RING                       | 2   |
| 111515   | U-CUP SEAL                   | 1   |
| 111506   | U-CUP SEAL                   | 1   |
| 24193    | O-RING                       | 2   |
| 113717   | SEAL                         | 1   |
| 113725   | O-RING                       | 1   |
| 26373    | O-RING                       | 1   |
| 108033   | OIL SEAL                     | 1   |
| 113718   | OIL SEAL                     | 1   |
| 113722   | V-RING SEAL                  | 2   |
| 18062    | RELIEF VALVE                 | 1   |
| 106718   | O-RING (-01 & -13 DRUM ONLY) | 1   |

### 66172 - BRAKE KIT - EQUAL SPEED

| PART NO. | DESCRIPTION   | QTY |
|----------|---------------|-----|
| 72204    | DIVIDER PLATE | 6   |
| 113552   | BRAKE DISC    | 3   |
| 25016    | O-RING        | 1   |
| 104385   | DIE SPRING    | 12  |
| 72109    | O-RING        | 1   |
| 111515   | U-CUP SEAL    | 1   |
| 111506   | U-CUP SEAL    | 1   |
| 24193    | O-RING        | 2   |

### 66171 - BEARING KIT - EQUAL SPEED & HSR

| PART NO. | DESCRIPTION             | QTY |
|----------|-------------------------|-----|
| 113745   | PLANET PIN              | 3   |
| 24306    | THRUST WASHER           | 6   |
| 25292    | ROLLER BEARING          | 3   |
| 113748   | SECONDARY PLANET PIN    | 3   |
| 28729    | THRUST WASHER           | 6   |
| 28859    | NEEDLE ROLLER           | 120 |
| 113750   | SECONDARY ROLLER SPACER | 3   |
| 102139   | NEEDLE ROLLER           | 150 |
| 113752   | BEARING SPACER          | 3   |
| 113753   | OUTPUT PLANET PIN       | 3   |
| 113754   | THRUST WASHER HARD      | 6   |
| 103104   | BALL BEARING            | 2   |
| 113716   | BALL BEARING            | 1   |
| 113715   | BALL BEARING            | 1   |
| 113866   | BALL BEARING            | 1   |
| 105637   | BALL BEARING            | 1   |
| 23584    | SPIROL                  | 3   |
| 70862    | ROLLPIN                 | 3   |

### 66173 - BRAKE KIT - HSR

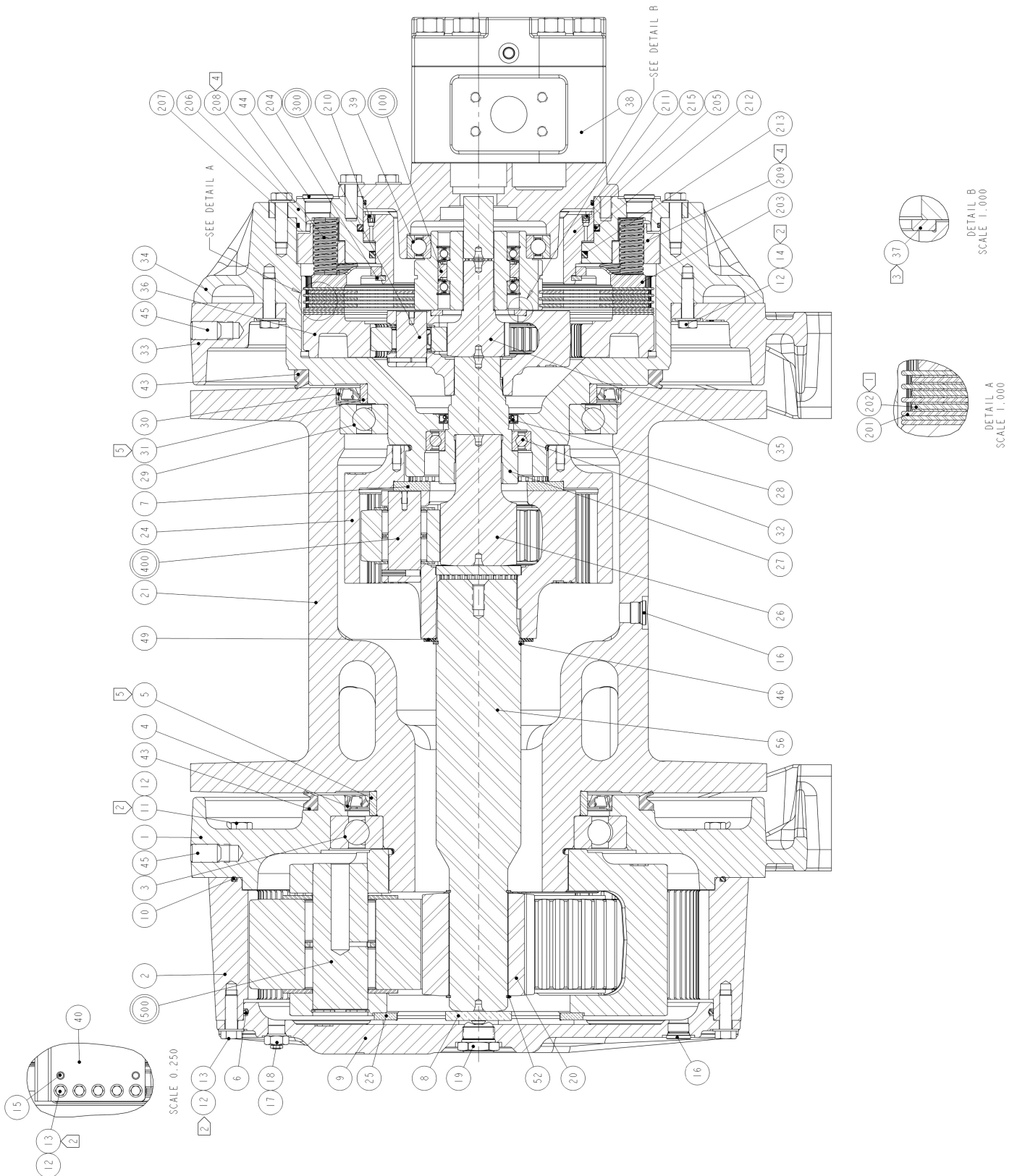
| PART NO. | DESCRIPTION   | QTY |
|----------|---------------|-----|
| 72204    | DIVIDER PLATE | 8   |
| 113555   | BRAKE DISC    | 7   |
| 25016    | O-RING        | 1   |
| 104385   | DIE SPRING    | 18  |
| 72109    | O-RING        | 1   |
| 111515   | U-CUP SEAL    | 1   |
| 111506   | U-CUP SEAL    | 1   |
| 24193    | O-RING        | 2   |

## GM50A SERVICE KITS - EQUAL SPEED & HSR

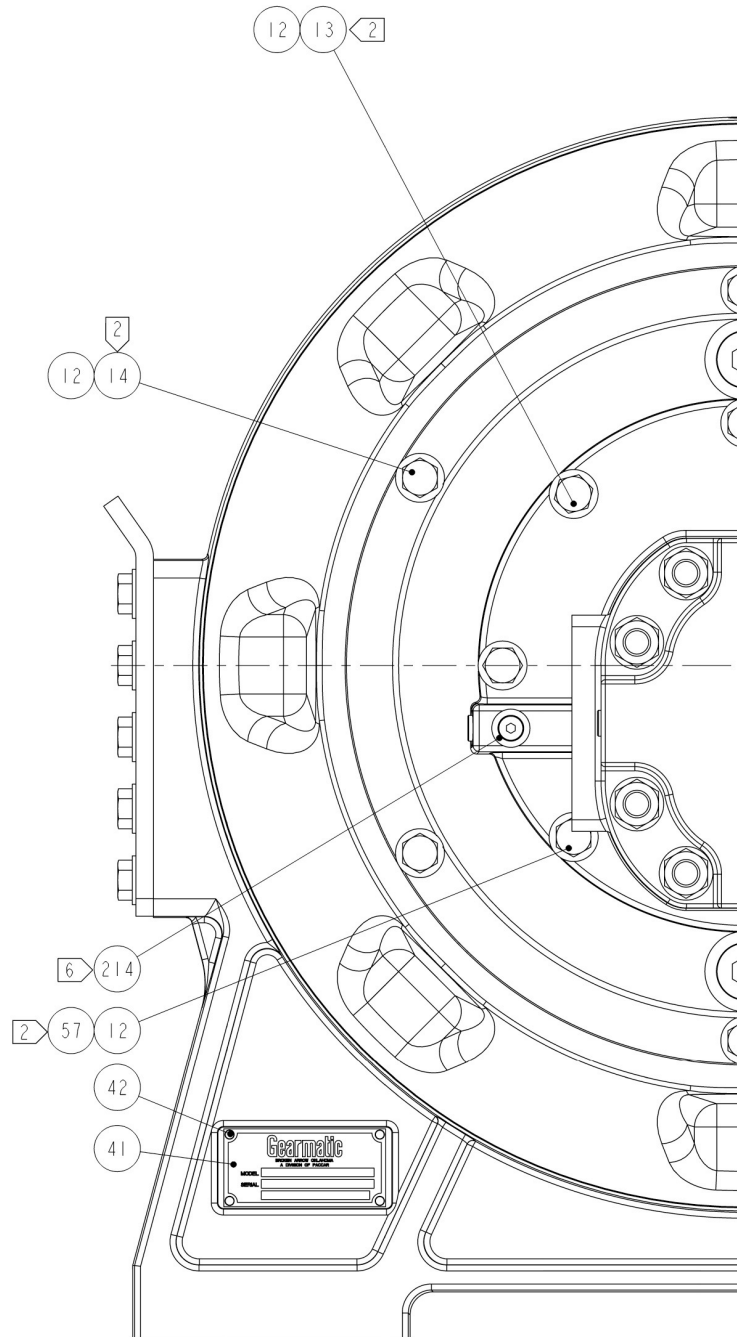
| 66174 - REBUILD KIT EQUAL SPEED |                         |     |
|---------------------------------|-------------------------|-----|
| PART NO.                        | DESCRIPTION             | QTY |
| 25016                           | O-RING                  | 2   |
| 72109                           | O-RING                  | 2   |
| 111515                          | U-CUP SEAL              | 1   |
| 111506                          | U-CUP SEAL              | 1   |
| 24193                           | O-RING                  | 2   |
| 113717                          | SEAL                    | 1   |
| 113725                          | O-RING                  | 1   |
| 26373                           | O-RING                  | 1   |
| 108033                          | OIL SEAL                | 1   |
| 113718                          | OIL SEAL                | 1   |
| 113722                          | V-RING SEAL             | 2   |
| 18062                           | RELIEF VALVE            | 1   |
| 106718                          | O-RING                  | 1   |
| 83509                           | OVERRUNNING CLUTCH ASSY | 1   |
| 113745                          | PLANET PIN              | 3   |
| 24306                           | THRUST WASHER           | 6   |
| 25292                           | ROLLER BEARING          | 3   |
| 113748                          | SECONDARY PLANET PIN    | 3   |
| 28729                           | THRUST WASHER           | 6   |
| 28859                           | NEEDLE ROLLER           | 120 |
| 113750                          | SECONDARY ROLLER SPACER | 3   |
| 102139                          | NEEDLE ROLLER           | 150 |
| 113752                          | BEARING SPACER          | 3   |
| 113753                          | OUTPUT PLANET PIN       | 3   |
| 113754                          | THRUST WASHER HARD      | 6   |
| 103104                          | BALL BEARING            | 2   |
| 113716                          | BALL BEARING            | 1   |
| 113715                          | BALL BEARING            | 1   |
| 113866                          | BALL BEARING            | 1   |
| 105637                          | BALL BEARING            | 1   |
| 23584                           | SPIROL                  | 3   |
| 70862                           | ROLLPIN                 | 3   |
| 72204                           | DIVIDER PLATE           | 6   |
| 113552                          | BRAKE DISC              | 3   |
| 104385                          | DIE SPRING              | 12  |

| 66175 - REBUILD KIT HSR |                         |     |
|-------------------------|-------------------------|-----|
| PART NO.                | DESCRIPTION             | QTY |
| 25016                   | O-RING                  | 2   |
| 72109                   | O-RING                  | 2   |
| 111515                  | U-CUP SEAL              | 2   |
| 111506                  | U-CUP SEAL              | 2   |
| 24193                   | O-RING                  | 2   |
| 113717                  | SEAL                    | 1   |
| 113725                  | O-RING                  | 1   |
| 26373                   | O-RING                  | 1   |
| 108033                  | OIL SEAL                | 1   |
| 113718                  | OIL SEAL                | 1   |
| 113722                  | V-RING SEAL             | 2   |
| 18062                   | RELIEF VALVE            | 1   |
| 106718                  | O-RING                  | 1   |
| 83509                   | OVERRUNNING CLUTCH ASSY | 1   |
| 113745                  | PLANET PIN              | 3   |
| 24306                   | THRUST WASHER           | 6   |
| 25292                   | ROLLER BEARING          | 3   |
| 113748                  | SECONDARY PLANET PIN    | 3   |
| 28729                   | THRUST WASHER           | 6   |
| 28859                   | NEEDLE ROLLER           | 120 |
| 113750                  | SECONDARY ROLLER SPACER | 3   |
| 102139                  | NEEDLE ROLLER           | 150 |
| 113752                  | BEARING SPACER          | 3   |
| 113753                  | OUTPUT PLANET PIN       | 3   |
| 113754                  | THRUST WASHER           | 6   |
| 103104                  | BALL BEARING            | 2   |
| 113716                  | BALL BEARING            | 1   |
| 113715                  | BALL BEARING            | 1   |
| 113866                  | BALL BEARING            | 1   |
| 105637                  | BALL BEARING            | 1   |
| 23584                   | SPIROL                  | 3   |
| 70862                   | ROLLPIN                 | 3   |
| 72204                   | DIVIDER PLATE           | 8   |
| 113555                  | BRAKE DISC              | 7   |
| 104385                  | DIE SPRING              | 18  |

# MAIN ASSEMBLY COMPONENTS - EQUAL SPEED



## MAIN ASSEMBLY COMPONENTS - EQUAL SPEED



### NOTES:

1. LUBRICATE FRICTION PLATES (202) WITH HYDRAULIC OIL BEFORE ASSEMBLY.
2. APPLY LOCTITE 242 TO CAPSCREWS (11, 13, 14, & 57) AND TORQUE TO  $75 \pm 10$  FT LBS.
3. INSTALL THRUST WASHER (37) WITH CHAMFER TOWARD CARRIER (300).
4. SPRINGS (208) TO BE INSTALLED EQUALLY SPACED.
5. APPLY LOCTITE 609 TO SEAL SLEEVES (5 & 31) PRIOR TO ASSEMBLY.
6. O-RING (214) IS LOCATED BETWEEN MOTOR (38) AND HOUSING (206).
7. NOT SHOWN: CABLE WEDGE (ITEM 22)

## MAIN ASSEMBLY COMPONENTS - EQUAL SPEED

| ITEM NO. | PART NO. | DESCRIPTION              | QTY. |
|----------|----------|--------------------------|------|
| 1        | 113814   | GEAR HOUSING SUPPORT     | 1    |
| 2        | 113815   | OUTPUT RING GEAR         | 1    |
| 3        | 113716   | BALL BEARING             | 1    |
| 4        | 113717   | OIL SEAL                 | 1    |
| 5        | 113755   | STAINLESS STEEL SLEEVE   | 1    |
| 6        | 113725   | O-RING                   | 1    |
| 7        | 113756   | THRUST WASHER            | 1    |
| 8        | 106841   | BUTTON, THRUST           | 1    |
| 9        | 113733   | HOUSING COVER            | 1    |
| 10       | 26373    | O-RING                   | 1    |
| 11       | 102347   | CAPSCREW                 | 8    |
| 12       | 27248    | WASHER, HARDENED         | 61   |
| 13       | 104322   | CAPSCREW                 | 37   |
| 14       | 104323   | CAPSCREW                 | 14   |
| 15       | 21112    | PIN-DOWEL                | 8    |
| 16       | 101385   | PLUG, ORB -10 FLUSH      | 2    |
| 17       | 18062    | RELIEF VALVE 7.5-15 PSI  | 1    |
| 18       | 26868    | REDUCER STR THD ADAPTER  | 1    |
| 19       | 25958    | SIGHT GAUGE              | 1    |
| 20       | 113932   | OUTPUT SUN GEAR          | 1    |
| 21       | 113726   | CABLE DRUM               | 1    |
| 22       | 113743   | CABLE WEDGE - GM50A      | 1    |
| 24       | 113734   | SECONDARY RING GEAR      | 1    |
| 25       | 112903   | THRUST BEARING, BRONZE   | 1    |
| 26       | 113759   | SECONDARY SUN GEAR       | 1    |
| 27       | 113801   | SECONDARY SUN GEAR SHAFT | 1    |
| 28       | 108033   | OIL SEAL                 | 1    |
| 29       | 113715   | BALL BEARING             | 1    |
| 30       | 113718   | OIL SEAL                 | 1    |
| 31       | 113760   | STAINLESS STEEL SLEEVE   | 1    |
| 32       | 113866   | BALL BEARING             | 1    |
| 33       | 113816   | BRAKE HOUSING SUPPORT    | 1    |
| 34       | 113808   | BRAKE HOUSING            | 1    |
| 35       | 113761   | PRIMARY SUN GEAR         | 1    |
| 36       | 114089   | PRIMARY RING GEAR        | 1    |

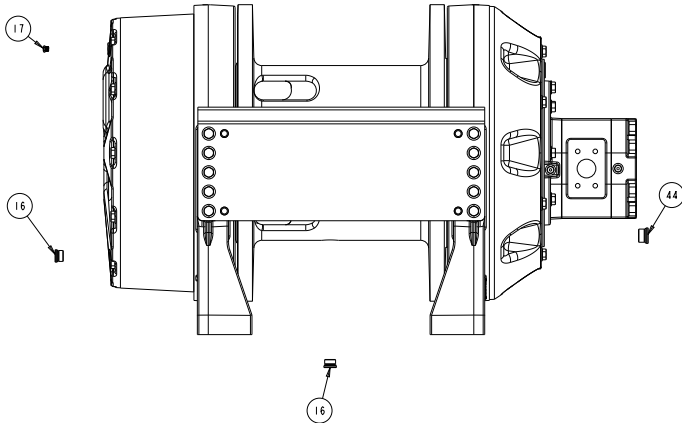
| ITEM NO. | PART NO. | DESCRIPTION                   | QTY. |
|----------|----------|-------------------------------|------|
| 37       | 103975   | THRUST WASHER *               | 1    |
| 38       | 114111   | HYD GEAR MOTOR, OVERWOUND     | 1    |
| 39       | 105637   | BEARING, BALL *               | 1    |
| 40       | 113817   | TIE PLATE                     | 2    |
| 41       | 76323    | NAMEPLATE                     | 1    |
| 42       | 11842    | DRIVE SCREW                   | 4    |
| 43       | 113722   | V-RING SEAL                   | 2    |
| 44       | 22450    | PLUG                          | 2    |
| 45       | 25170    | S075-12SAK SETSCREW           | 2    |
| 46       | 107034   | RETAINING RING, EXT *         | 1    |
| 49       | 103239   | THRUST WASHER                 | 1    |
| 52       | 25528    | SNAP RING                     | 2    |
| 56       | 113976   | OUTPUT SHAFT                  | 1    |
| 57       | 104320   | CAPSCREW *                    | 2    |
| 100      | 83509    | OVERRUNNING CLUTCH ASSY       | 1    |
| 201      | 72204    | DIVIDER PLATE                 | 6    |
| 202      | 113552   | Brake disc                    | 3    |
| 203      | 113762   | PRESSURE PLATE                | 1    |
| 204      | 106852   | RETAINING RING, EXT           | 1    |
| 205      | 114100   | PISTON, BRAKE                 | 1    |
| 206      | 113547   | COVER, PRIMARY HOUSING        | 1    |
| 207      | 25016    | O-RING                        | 1    |
| 208      | 104385   | SPRING, DIE *                 | 12   |
| 209      | 110099   | SPRING SEPARATOR *            | 1    |
| 210      | 76314    | ORIFICE PLUG #46              | 1    |
| 211      | 72109    | O-RING                        | 1    |
| 212      | 111515   | U-CUP SEAL                    | 1    |
| 213      | 111506   | U-CUP SEAL                    | 1    |
| 214      | 24193    | O-RING                        | 2    |
| 215      | 100119   | PIPE PLUG                     | 3    |
| 300      | 85063    | PRIMARY PLANET CARRIER ASSY   | 1    |
| 400      | 85064    | SECONDARY PLANET CARRIER ASSY | 1    |
| 500      | 85065    | OUTPUT PLANET CARRIER ASSY    | 1    |
| -        | 109880   | SHIPPING PLATE                | 2    |

## STAINLESS STEEL LAND

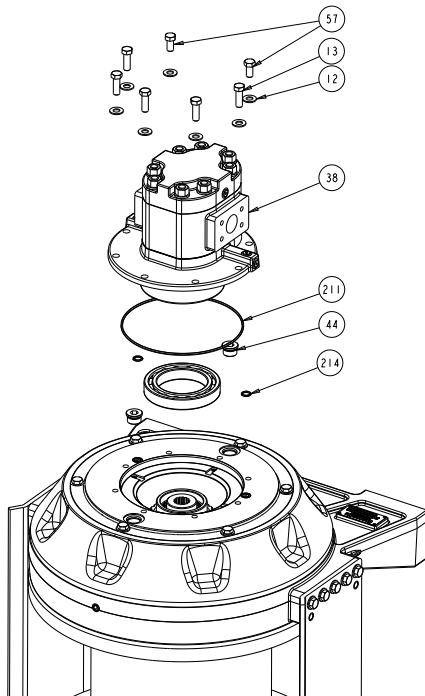
The stainless-steel seal sleeves are press fitted onto the cable drum and brake housing at the factory and are used to reduce wear and contamination that might occur during operation in the marine environment.

# EQUAL SPEED HOIST DISASSEMBLY

1. Remove the wire rope from the hoist. Drain the gear oil from the output gear side by removing drain plug (16). Remove the relief valve (17) to improve oil flow while draining. Drain the hydraulic oil from the motor side using drain plug (44) at the bottom of the motor. Dispose of all used oil in an environmentally responsible manner.



2. Remove the hydraulic hoses and mounting bolts. Clean the outside surface of the hoist in preparation for disassembly. To ease alignment of parts on reassembly, mark the hoist bolted connections with a paint pen or scribe line.
3. Stand the hoist with the motor end up and secure it to prevent falling. Remove the capscrews (13 and 57) and washers (12) that secure the motor (38) to the primary housing cover (206). Lift the motor off the hoist using a slight rotary motion while removing it from the housing. Ball bearing (39) should follow. Remove and discard the motor flange O-ring (211) and brake release O-rings (214).

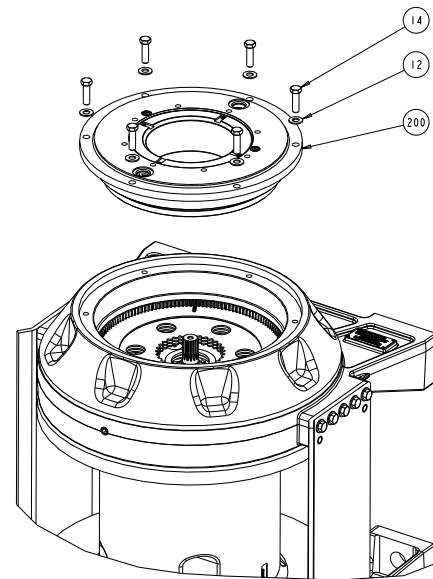


4. Remove the overrunning clutch assembly (100).



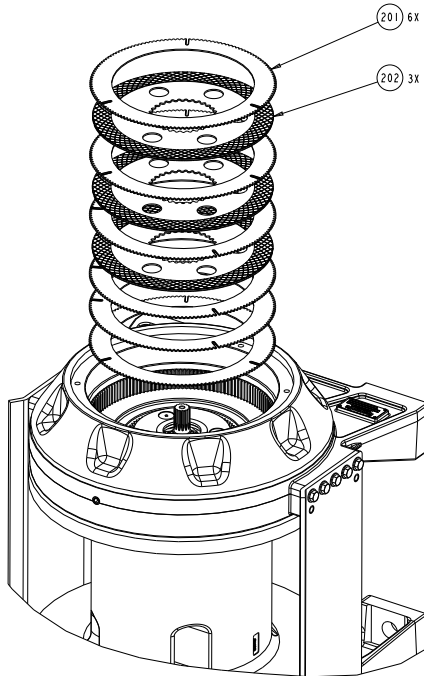
5. Remove the spring tension from the primary housing cover (206) by loosening the six capscrews (14) one turn each, alternating across the housing. Remove the primary housing cover, turning it with a slight rotary motion when lifting it out of the housing.

NOTE: Refer to brake parts group section for disassembly and assembly

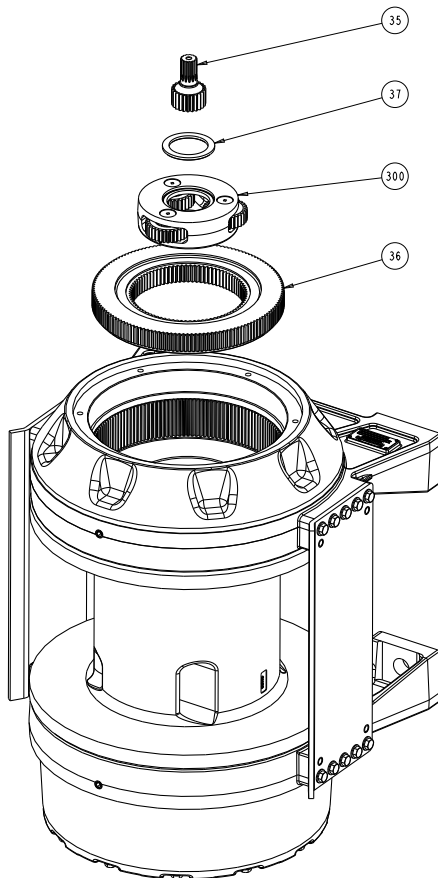


6. Remove the divider plates (201) and brake discs (202).

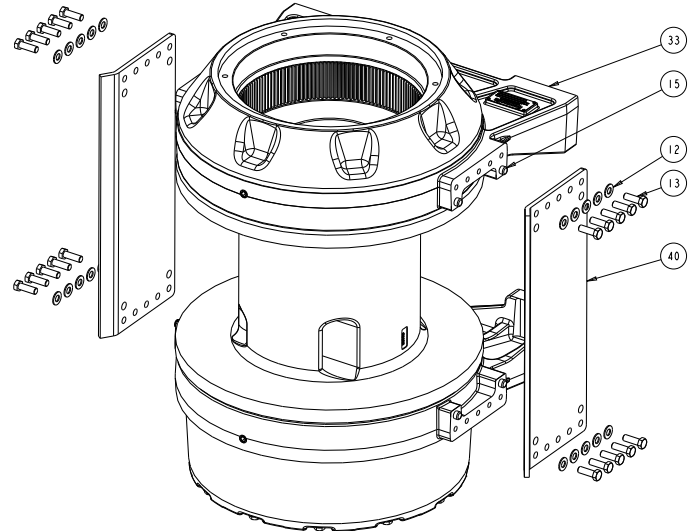
## EQUAL SPEED HOIST DISASSEMBLY



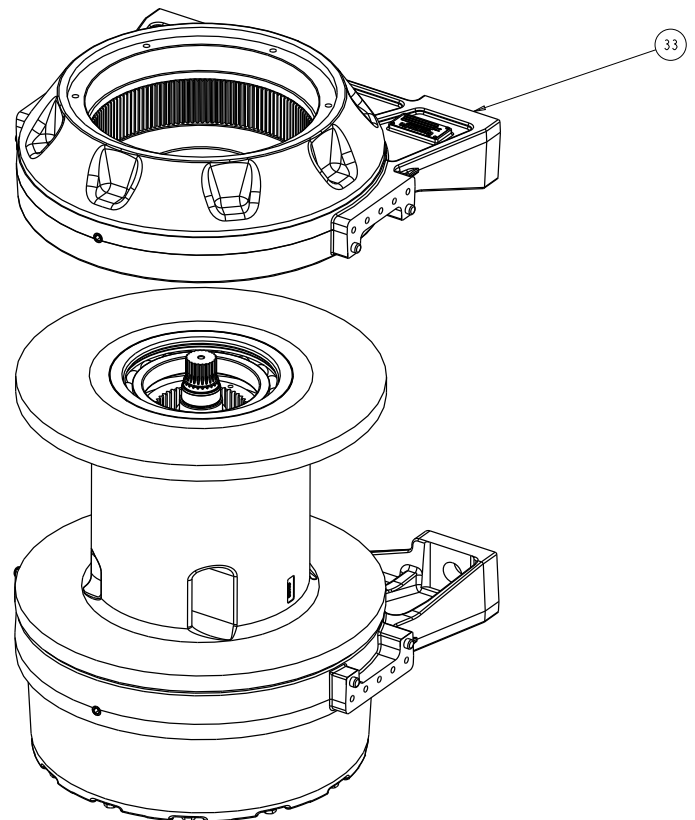
7. Remove the primary sun gear (35), thrust washer (37), primary planet carrier assembly (300), and primary ring gear (36).



8. Mark the tie-plates relative to the side of the hoist to ease reassembly. Remove the capscrews (13) and washers (12) and remove the tie-plates (40). The tie plates have two dowel pins (15) at each end and these are press fitted into the housing (33) at the factory.

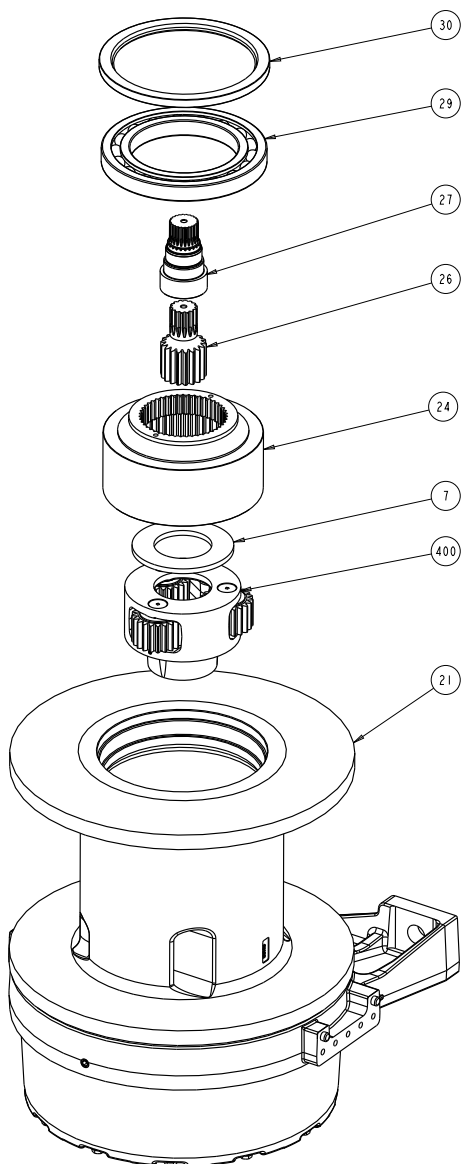


9. Using eyebolts, lift the brake housing (34), which is bolted to the brake housing support (33) straight off the drum. The stainless-steel sleeve (31), V-ring seal (43), oil seal (28), and ball bearing (32) will follow.

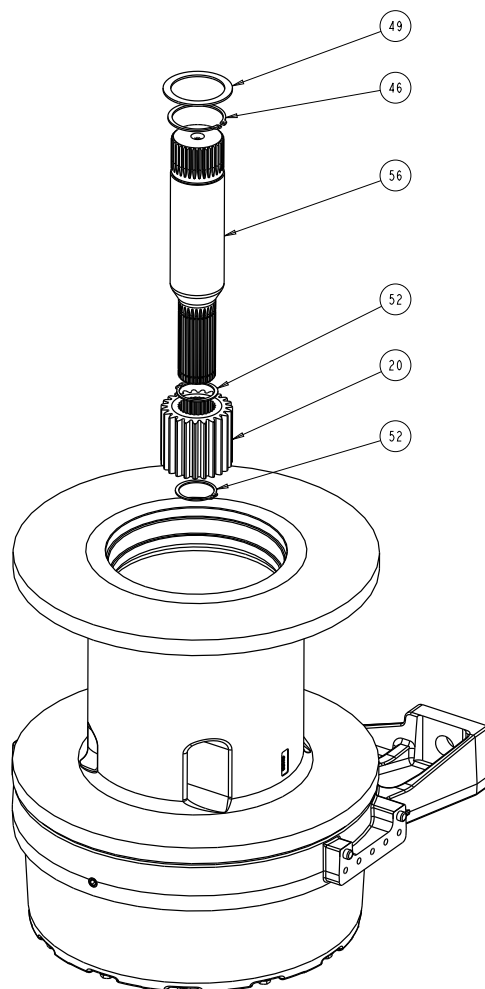


## EQUAL SPEED HOIST DISASSEMBLY

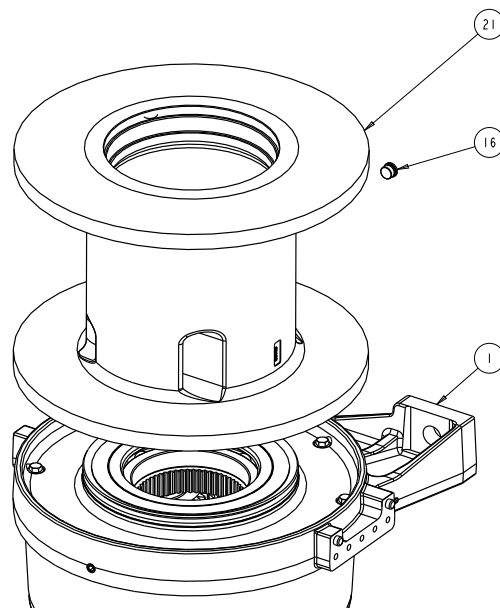
10. Remove and discard the oil seal (30), then remove the ball bearing (29). Remove the secondary sun gear shaft (27) and secondary sun gear (26). Remove the secondary ring gear (24), thrust washer (7), and secondary planet carrier assembly (400).



11. Using a 1/2-13 lifting eye, lift the output shaft (56) out of the drum; the output sun gear (20), thrust washer (49), and snap rings (52) will follow.

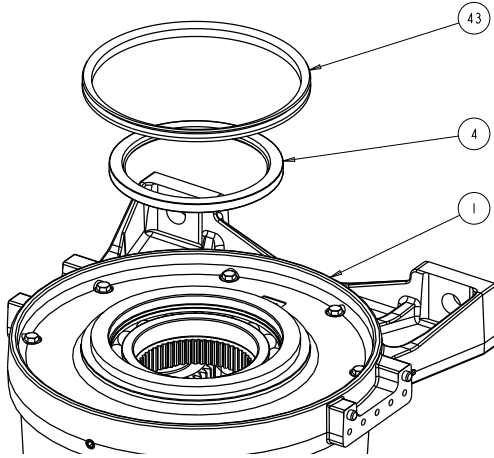


12. Using lifting clamps, lift the drum (21) straight up and off the gear housing support (1); the stainless-steel sleeve (5) will follow and can be set on the deck. If plug (16) was not removed previously, remove it at this time.

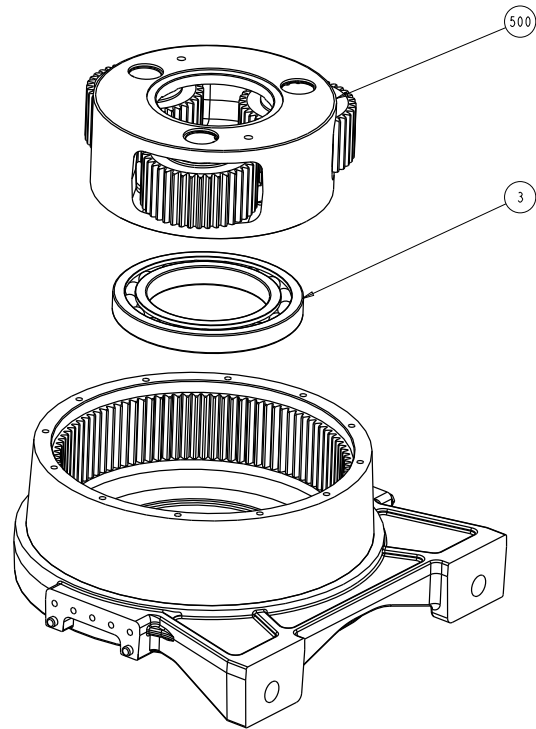


## EQUAL SPEED HOIST DISASSEMBLY

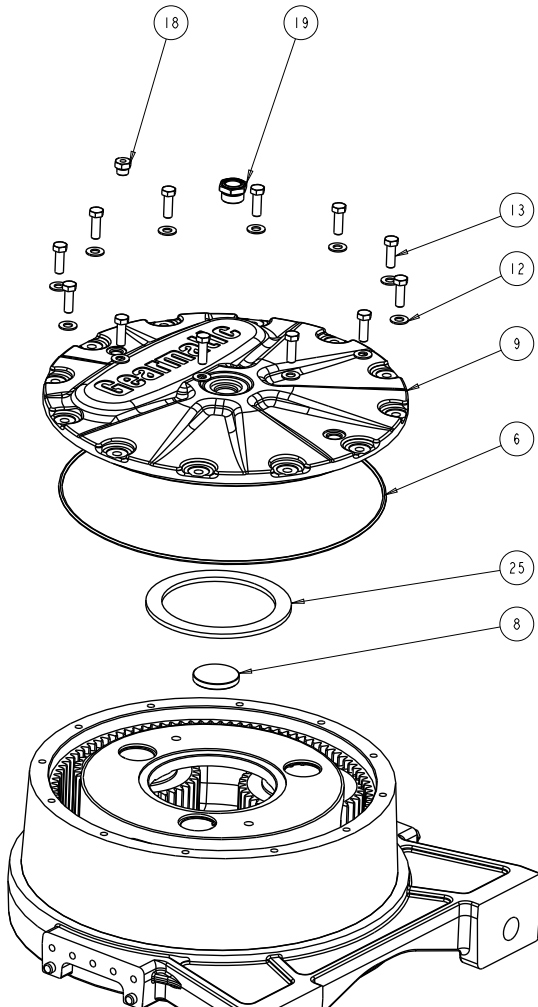
13. Remove the V-ring seal (43), and remove and discard the oil seal (4) located on the gear housing support(1).



15. Using 5/8-11 lifting eyes, lift the output planet carrier assembly (500) out of the output ring gear. Once removed, remove the ball bearing (3).



14. Place the final drive housing with the drum side down and remove capscrews (13) and washers (12) from the housing cover (9). Remove the output housing cover (9); the thrust bearing (25), o-ring (6), sight gauge (19), reducer (18), and thrust button (8) will follow.

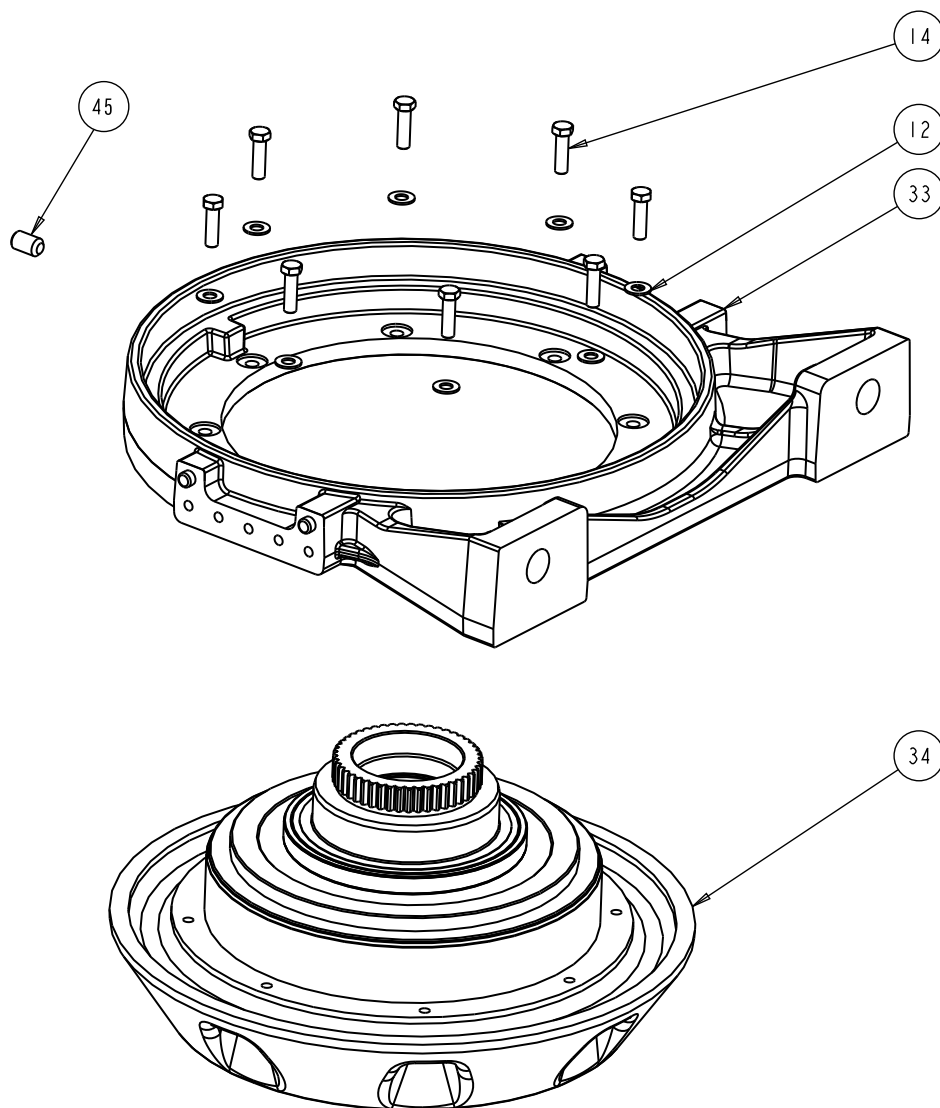


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## BRAKE HOUSING DISASSEMBLY

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With the brake housing support (33) and brake housing (34) resting on the deck, brake housing support larger opening end facing down, remove the capscrews (14) and washers (12) and lift the brake housing support (33) off the brake housing (34). If needed, remove the setscrew (45) and use the 3/4-10 hole for a lifting eye.

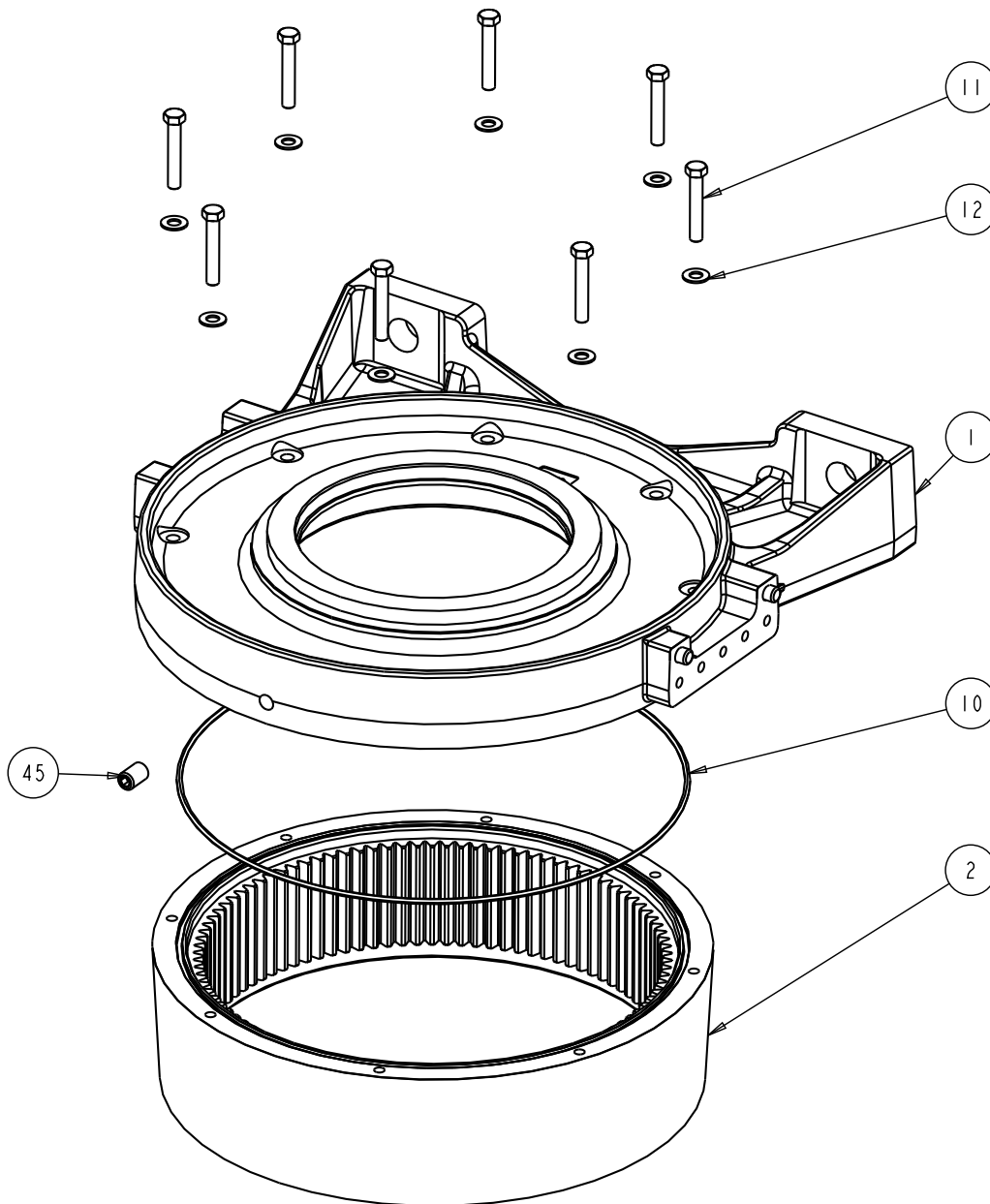


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## GEAR HOUSING DISASSEMBLY

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With the output ring gear (2) and gear housing support (1) resting ring gear face down, remove the capscrews (11) and washers (12). Lift the gear housing support (1) off the ring gear (2). Discard O-ring (10). If needed, remove the setscrew (45) and use the 3/4-10 hole for a lifting eye.

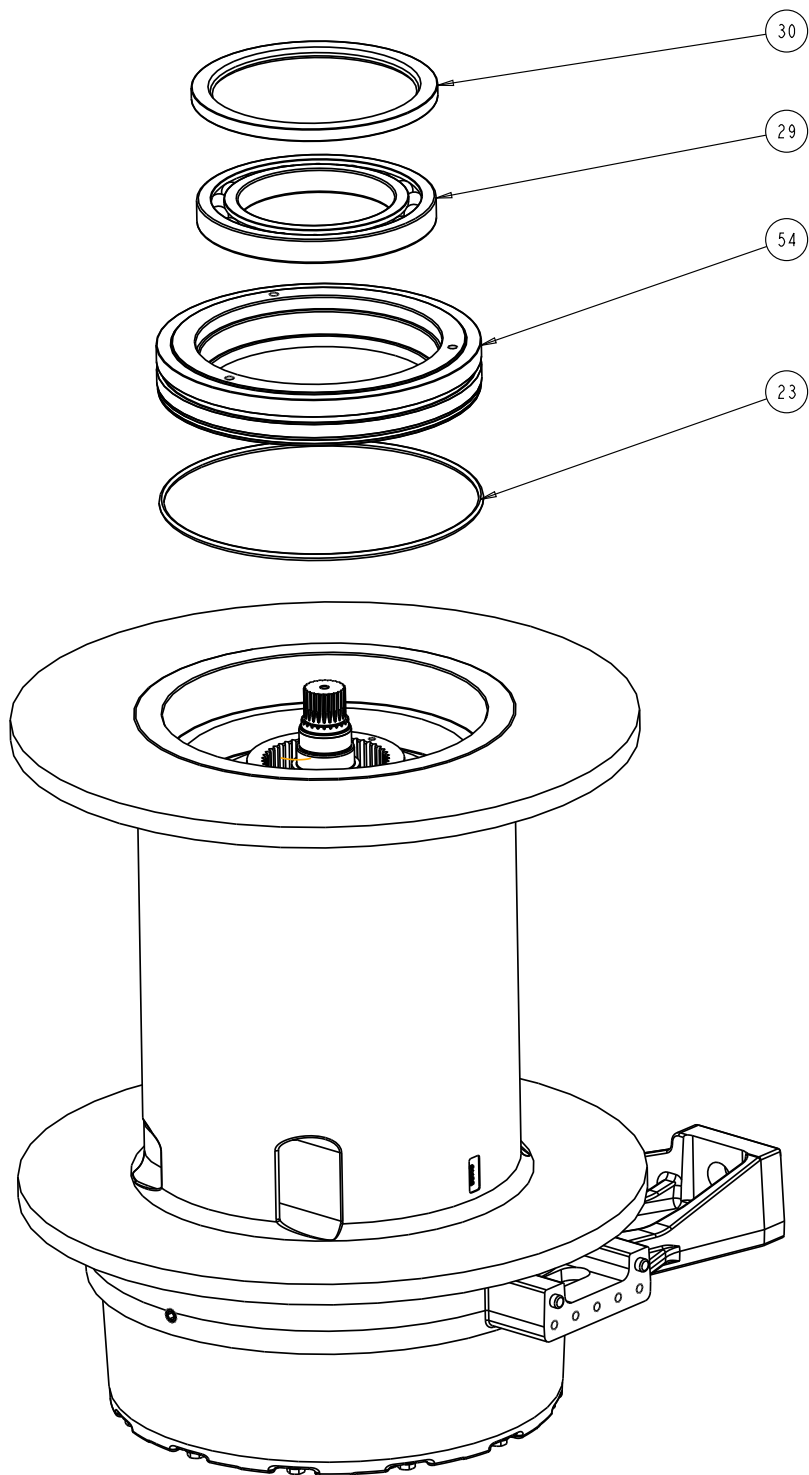


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## -02 CABLE DRUM DISASSEMBLY

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1. Perform steps 1–9 of the Equal Speed Hoist Disassembly procedure.
2. Using lifting eyes, hoist the drum closure (54) out of the drum.
3. Once on the deck, remove and discard the seal sleeve (31) and O-ring (23). Remove the oil seal (30).
4. Perform steps 10–15 of the Equal Speed Hoist Disassembly procedure, or steps 9–15 of the High-Speed Reverse Hoist Disassembly procedure, as applicable.



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## EQUAL SPEED HOIST ASSEMBLY

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1. Assemble the planet carrier assemblies, brake, and brake clutch assembly following the procedures in the applicable subassembly service sections of this manual.
2. If the output ring gear (2) or brake housing (34) was removed from its support, reattach it by applying Loctite 242 (or equivalent) to capscrews (11 and 14) and torque to 75 +/-10 ft/lb.
3. Set the output housing with the drum end down, level and stable. Press ball bearing (3) into gear housing support (1). Carefully lower the output carrier assembly (500) into the output ring gear (2).
4. Apply general-purpose grease to thrust bearing (25) and install it onto housing cover (9). Lightly grease thrust button (8) and install it in the recess in housing cover (9).

**NOTE:** if too much grease is applied, oil will not be able to enter the sight glass for visual inspection.
5. Install O-ring (6) onto housing cover (9) and apply a light coat of grease to the O-ring surface. Verify proper alignment of housing cover (9) on ring gear (2), install the housing cover on the output ring gear (2), and secure it with washers (12) and capscrews (13). Torque to the value specified on the torque chart.
6. Set the output housing on the deck, drum side up, in preparation for installing the seal, V-ring seal, and drum.
7. Apply Loctite Aviation Gasket Sealant (or an equivalent non-hardening sealant) to the outside diameter of the drum seal and install oil seal (4) into gear housing support (1), flush with the output housing. Install V-ring seal (43) onto the output housing.
8. If the stainless-steel sleeve (5) has been removed from the cable drum (21), replace it with a new one and press it onto the seal landing, using Loctite 271 on the drum snout.
9. Apply grease to the inner race of output housing support bearing (3) and to seal (4).
10. Liberally grease the flange near the splined snout of cable drum (21) with marine-grade grease.
11. Using lifting straps or an equivalent lifting device, lower drum (21) onto the housing, aligning the drum splines with the output planet carrier splines.
12. Assemble the output sun gear shaft and sun gear by installing the retaining ring on the output sun gear shaft then slide the output sun gear onto the output sun gear shaft splines then add the last snap ring.
13. Install the secondary planet carrier assembly (400) onto the splined connection on the output sun gear.
14. Apply general-purpose grease to thrust washer (7) and place it in the recess in secondary ring gear (24), then assemble the ring gear onto the secondary planet carrier assembly (400), aligning it with the gears.
15. Press bearing (29) into the cable drum. Install oil seal (30) into cable drum (21), flush with the drum face.
16. Install secondary sun gear (26) into the secondary planet carrier assembly (400), followed by secondary sun gear shaft (27).
17. If the stainless-steel sleeve (31) has been removed from brake housing (34), replace it with a new one and press it onto the seal landing using Loctite 271.
18. Press bearing (32) and seal (28) into brake housing (34), flush with the face.
19. Install V-ring seal (43) onto brake housing (34).
20. Liberally grease the flange near the oil seal of cable drum (21) with marine-grade grease.
21. Lightly grease the inner race of drum bearing (29) and drum seal (30). Using 1/2-13 eyebolts in the tapped holes of the brake housing, slowly lower it onto the drum.
22. Install tie-plates (40), using dowel pins (15) as a guide, then install washers (12) and capscrews (13). Torque to the value specified on the torque chart.
23. Install primary ring gear (36) into brake housing (34) with the counterbore along the ring gear teeth facing the motor side and the cast groove facing the drum.

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## EQUAL SPEED HOIST ASSEMBLY

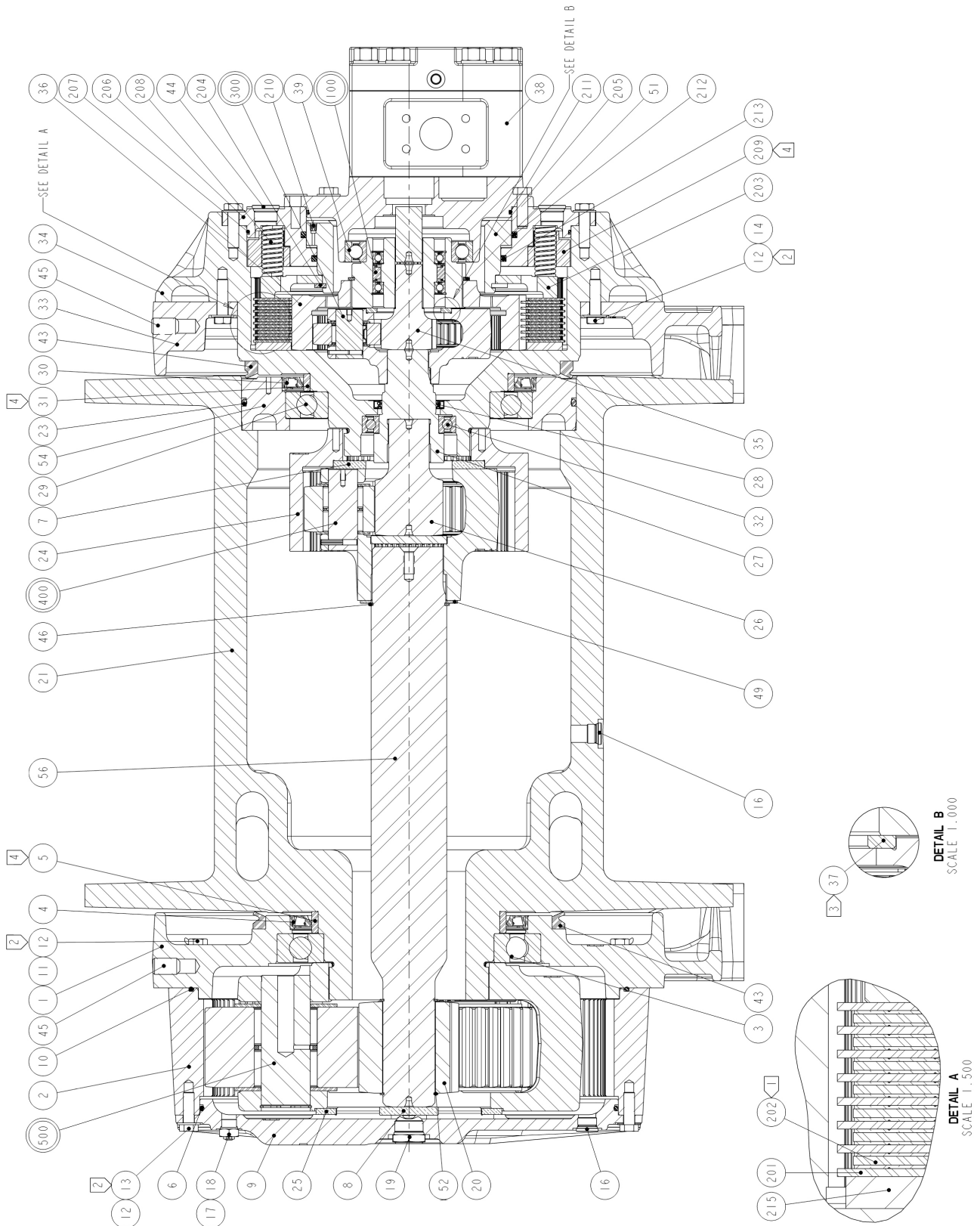
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24. Install primary planet carrier subassembly (300) into the ring gear. Install thrust washer (37) and primary sun gear (35).
25. Install six divider plates (201) and three brake disc (202). Continue alternating plates until the last divider plate is installed.
26. Install the overrunning clutch assembly (100), engaging the splines on the inner race with sun gear (35) and the splines on the outer race with brake disc (202).
27. Install O-ring (207) in primary housing cover (206) and grease lightly. Verify the circulation return port is correctly clocked on the primary housing. Using 1/2-13 eyebolts in the primary housing cover (206), lower the brake assembly into the primary housing. Install capscrews (14) and washers (12) that fasten the housing cover to the primary housing, tightening in a cross pattern one turn at a time to evenly draw the cover down against spring force, then torque to the value specified on the torque chart.
28. Install bearing (39) in the hydraulic motor flange adapter. Install and lightly grease motor adapter O-ring (211) and apply grease to the inner race

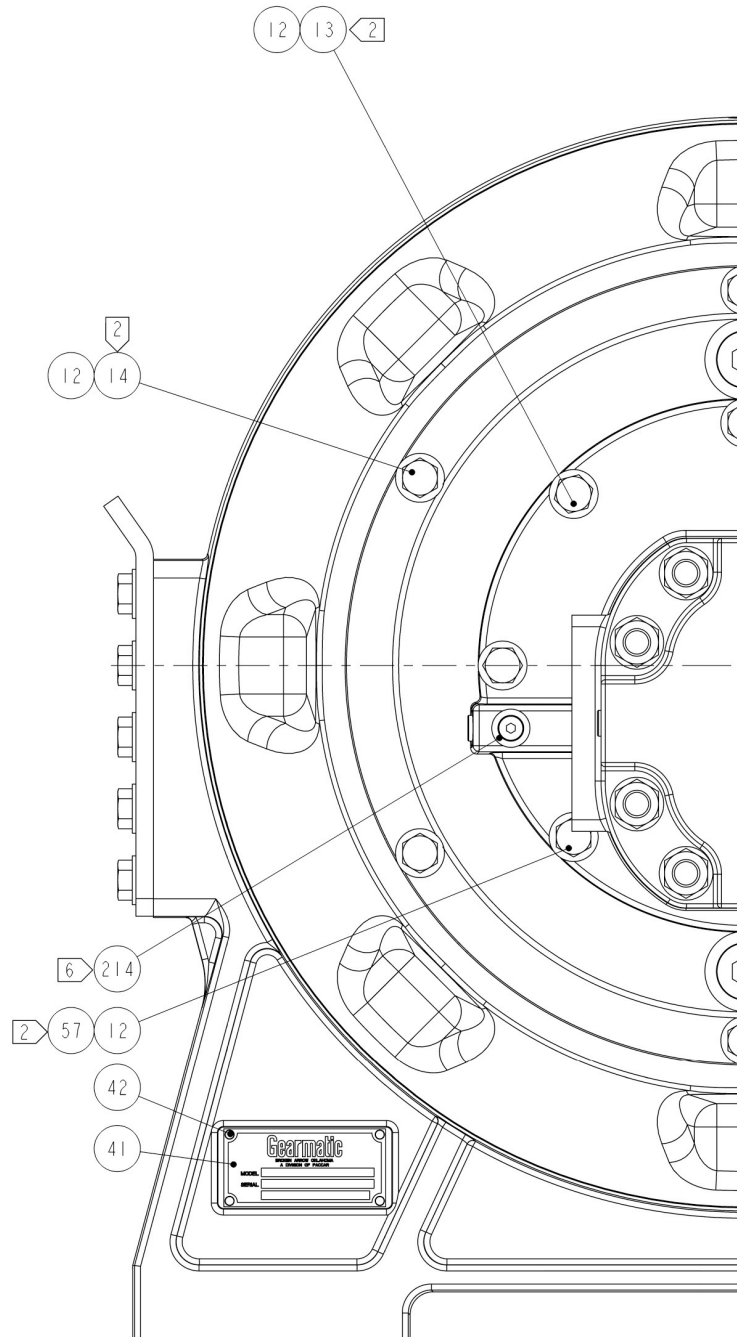
of bearing (39). Slowly lower the motor onto the primary housing — the motor flange adapter bearing (39) inner race contact surface is the brake hub. Tap the motor adapter lightly until seated on the primary housing cover, then install capscrews (13) and washers (12) and torque to the value specified on the torque chart.

**NOTE:** Capscrews in steps 5 and 22 may be torqued after the hoist is fully assembled and set on its mounting feet.

# MAIN ASSEMBLY COMPONENTS - HIGH SPEED REVERSE



## MAIN ASSEMBLY COMPONENTS - HIGH SPEED REVERSE



### NOTES:

1. LUBRICATE FRICTION PLATES (202) WITH HYDRAULIC OIL BEFORE ASSEMBLY.
2. APPLY LOCTITE 242 TO CAPSCREWS (11, 13, 14, & 57) AND TORQUE TO  $75 \pm 10$  FT LBS.
3. INSTALL THRUST WASHER (37) WITH CHAMFER TOWARD CARRIER (300).
4. SPRINGS (208) TO BE INSTALLED EQUALLY SPACED.
5. APPLY LOCTITE 609 TO SEAL SLEEVES (5 & 31) PRIOR TO ASSEMBLY.
6. O-RING (214) IS LOCATED BETWEEN MOTOR (38) AND HOUSING (206).
7. NOT SHOWN: CABLE WEDGE (ITEM 22)

## MAIN ASSEMBLY COMPONENTS - HIGH SPEED REVERSE

| ITEM NO. | PART NO. | DESCRIPTION             | QTY. |
|----------|----------|-------------------------|------|
| 1        | 113804   | GEAR HOUSING SUPPORT    | 1    |
| 2        | 113815   | OUTPUT RING GEAR        | 1    |
| 3        | 113716   | BALL BEARING            | 1    |
| 4        | 113717   | OIL SEAL                | 1    |
| 5        | 113755   | STAINLESS STEEL SLEEVE  | 1    |
| 6        | 113725   | O-RING                  | 1    |
| 7        | 113756   | THRUST WASHER           | 1    |
| 8        | 106841   | BUTTON, THRUST          | 1    |
| 9        | 113733   | HOUSING COVER           | 1    |
| 10       | 26373    | O-RING                  | 1    |
| 11       | 102347   | CAPSCREW *              | 10   |
| 12       | 27248    | WASHER, HARDENED        | 61   |
| 13       | 104322   | CAPSCREW *              | 39   |
| 14       | 104323   | CAPSCREW *              | 14   |
| 15       | 21112    | PIN-DOWEL               | 8    |
| 16       | 101385   | PLUG, ORB -10 FLUSH     | 2    |
| 17       | 18062    | RELIEF VALVE 7.5-15 PSI | 1    |
| 18       | 26868    | REDUCER STR THD ADAPTER | 1    |
| 19       | 25958    | SIGHT GAUGE             | 1    |
| 20       | 113932   | OUTPUT SUN GEAR         | 1    |
| 21       | 113727   | CABLE DRUM              | 1    |
| 22       | 113743   | CABLE WEDGE - GM50A     | 1    |
| 23       | 106718   | O-RING *                | 1    |
| 24       | 113734   | SECONDARY RING GEAR     | 1    |
| 25       | 112903   | THRUST BEARING, BRONZE  | 1    |
| 26       | 113759   | SECONDARY SUN GEAR      | 1    |
| 27       | 113801   | SECONDARY SUN SHAFT     | 1    |
| 28       | 108033   | OIL SEAL *              | 1    |
| 29       | 113715   | BALL BEARING            | 1    |
| 30       | 113718   | OIL SEAL                | 1    |
| 31       | 113760   | STAINLESS STEEL SLEEVE  | 1    |
| 32       | 113866   | BALL BEARING            | 1    |
| 33       | 113876   | BRAKE HOUSING SUPPORT   | 1    |
| 34       | 113808   | BRAKE HOUSING           | 1    |
| 35       | 113761   | PRIMARY SUN GEAR        | 1    |
| 36       | 113737   | RING GEAR, HSR          | 1    |
| 37       | 103975   | THRUST WASHER *         | 1    |

| ITEM NO. | PART NO. | DESCRIPTION                   | QTY. |
|----------|----------|-------------------------------|------|
| 38       | 114111   | HYD GEAR MOTOR, OVERWOUND     | 1    |
| 39       | 105637   | BEARING, BALL *               | 1    |
| 40       | 113817   | TIE PLATE                     | 2    |
| 41       | 76323    | NAMEPLATE                     | 1    |
| 42       | 11842    | DRIVE SCREW                   | 4    |
| 43       | 113722   | V-RING SEAL                   | 2    |
| 44       | 22450    | PLUG                          | 2    |
| 45       | 25170    | S075-12SAK SETSCREW           | 2    |
| 46       | 107034   | RETAINING RING, EXT *         | 1    |
| 49       | 103239   | THRUST WASHER                 | 1    |
| 51       | 106801   | RETAINING RING, EXT *         | 1    |
| 52       | 25528    | SNAP RING                     | 2    |
| 54       | 113742   | DRUM CLOSURE                  | 1    |
| 56       | 113977   | OUTPUT SHAFT                  | 1    |
| 57       | 104320   | CAPSCREW *                    | 2    |
| 100      | 83509    | OVERRUNNING CLUTCH ASSY       | 1    |
| 201      | 72204    | DIVIDER PLATE                 | 8    |
| 202      | 113555   | Brake disc                    | 7    |
| 203      | 113782   | PRESSURE PLATE, HSR           | 1    |
| 204      | 106852   | RETAINING RING, EXT *         | 1    |
| 205      | 113548   | PISTON, BRAKE                 | 1    |
| 206      | 113547   | COVER, PRIMARY HOUSING        | 1    |
| 207      | 25016    | O-RING                        | 1    |
| 208      | 104385   | SPRING, DIE *                 | 18   |
| 209      | 110099   | SPRING SEPARATOR *            | 1    |
| 210      | 76314    | ORIFICE PLUG #46              | 1    |
| 211      | 72109    | O-RING                        | 1    |
| 212      | 111515   | U-CUP SEAL                    | 1    |
| 213      | 111506   | U-CUP SEAL                    | 1    |
| 214      | 24193    | O-RING                        | 2    |
| 215      | 29757    | SPACER                        | 1    |
| 243      | 21335    | PLUG                          | 1    |
| 300      | 85063    | PRIMARY PLANET CARRIER ASSY   | 1    |
| 400      | 85064    | SECONDARY PLANET CARRIER ASSY | 1    |
| 500      | 85065    | OUTPUT PLANET CARRIER ASSY    | 1    |
| -        | 109880   | SHIPPING PLATE                | 2    |

## STAINLESS STEEL LAND

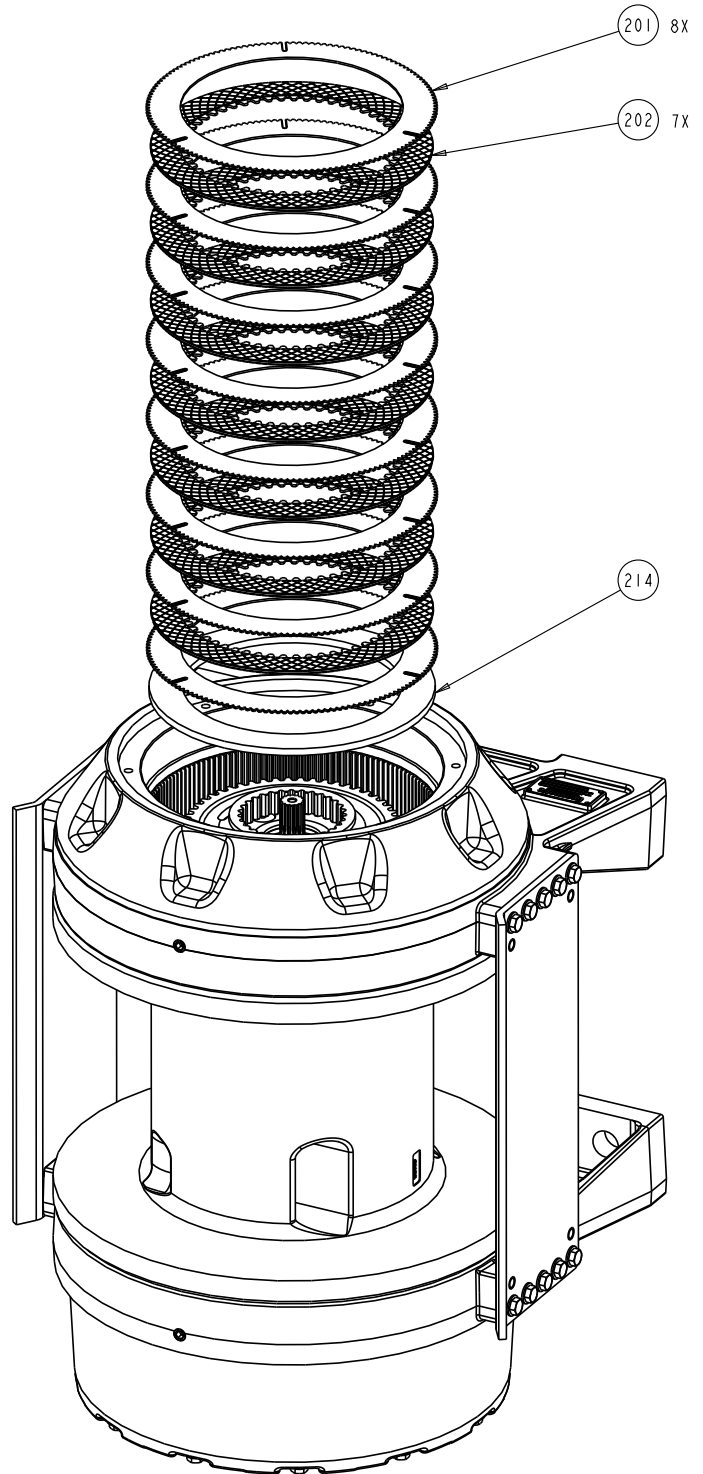
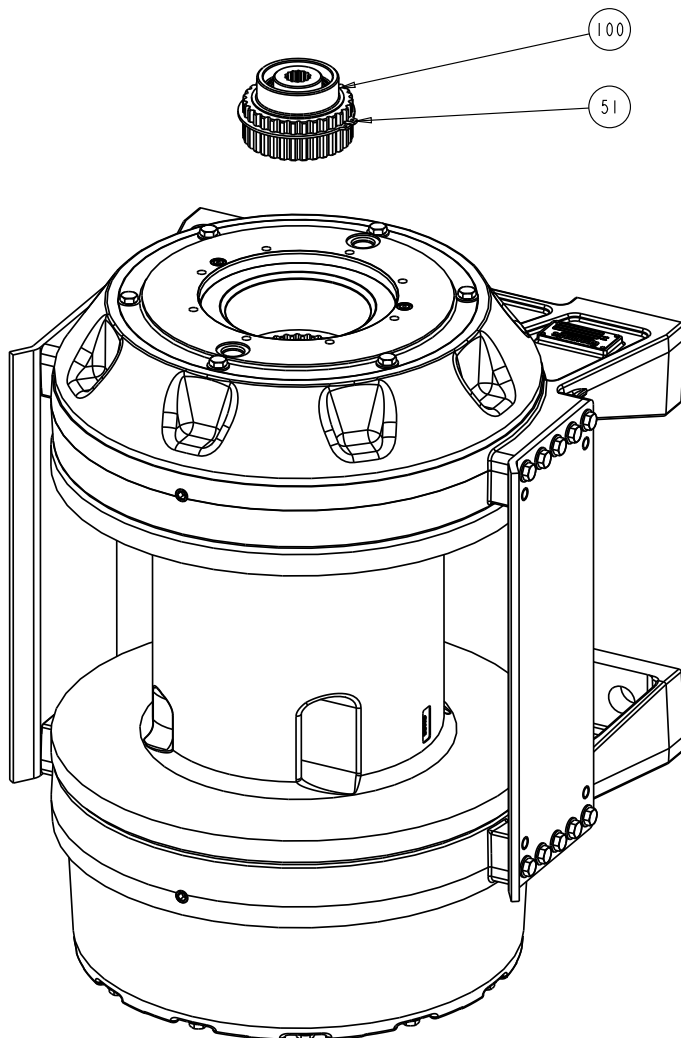
The stainless-steel seal sleeves are press fitted onto the cable drum and brake housing at the factory and are used to reduce wear and contamination that might occur during operation in the marine environment.

## HIGH SPEED REVERSE HOIST DISASSEMBLY

1. Remove the wire rope from the hoist. Drain the oil from the output gear side of the hoist by removing drain plug (16). Remove relief valve (17) to improve oil flow while draining. Drain the hydraulic oil from the motor side of the hoist using drain plug (44) at the bottom of the motor. Dispose of oil in an environmentally responsible manner.
2. Remove the hydraulic hoses and mounting bolts. Clean the outside surface of the hoist in preparation for disassembly. To ease alignment of parts on reassembly, mark the hoist bolted connections with a paint pen or scribe line.
3. Stand the hoist with the motor end up and secure it to prevent falling. Remove the capscrews (13 and 57) and washers (12) that secure the motor (38) to the primary housing cover (206) and lift the motor off the hoist, turning it with a slight rotary motion as it clears the housing. Remove and discard the motor flange O-ring (211) and brake release O-ring (214).
4. Remove the overrunning clutch assembly (100);

retaining ring (51) will follow.

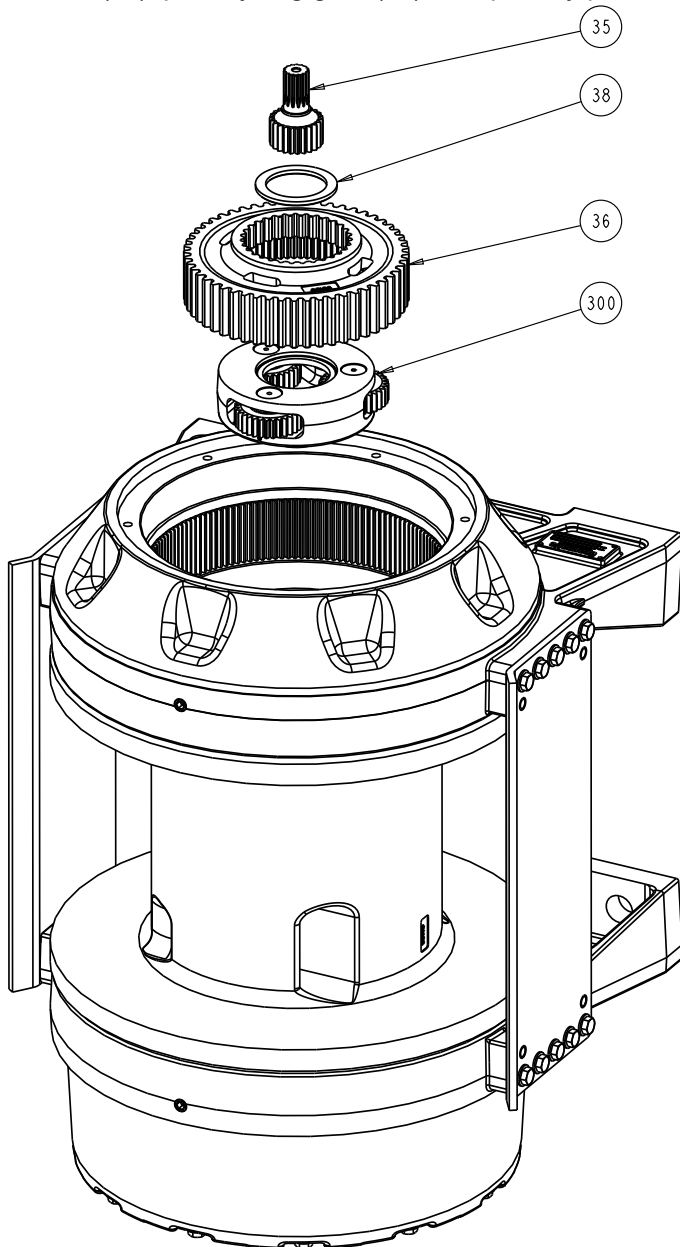
5. Remove the spring tension from the primary housing cover (206) by loosening the six capscrews (14) one turn each, alternating across the housing. Remove the primary housing cover, turning it with a slight rotary motion when lifting it out of the housing. Remove and discard O-ring (207) on the motor mount.
6. Remove the divider plates (201), brake discs



## HIGH SPEED REVERSE HOIST DISASSEMBLY

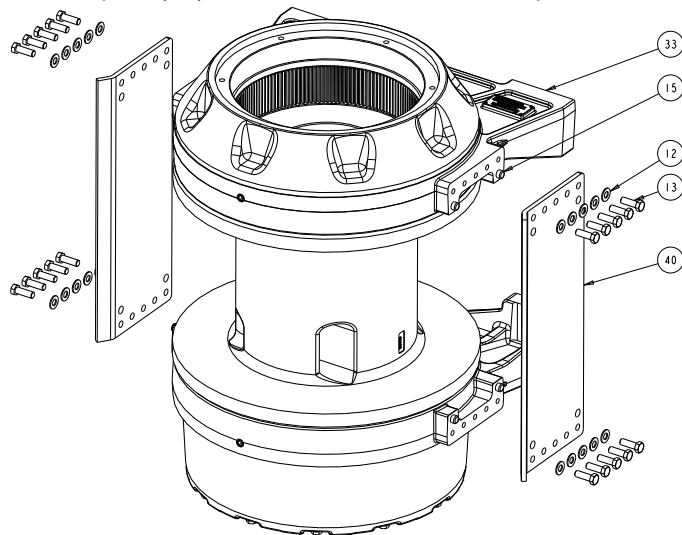
(202), and spacer (215).

7. Remove the primary sun gear (35), thrust washer (37), primary ring gear (36), and primary planet



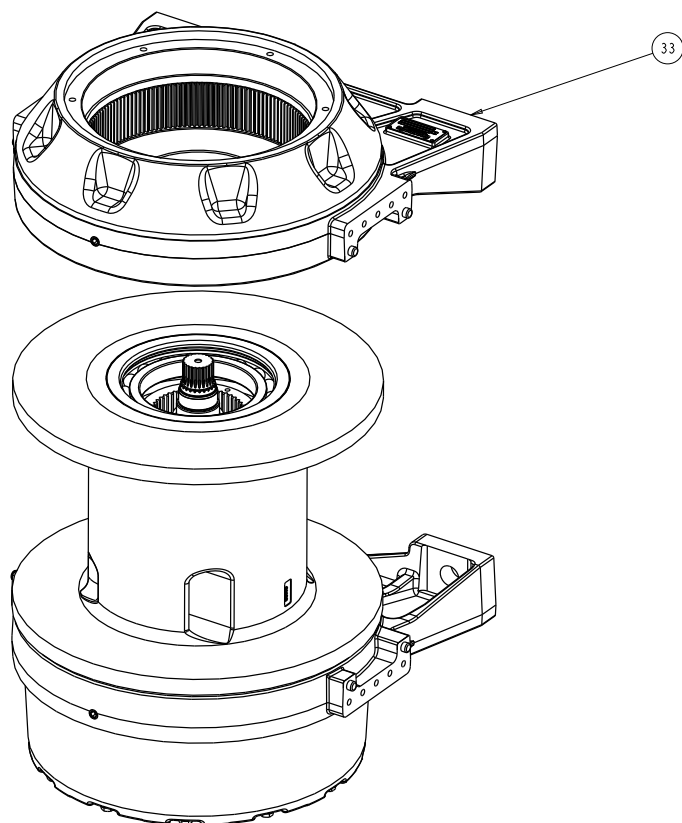
carrier assembly (300).

8. Mark the tie-plates relative to the side of the hoist to ease reassembly. Remove the capscrews (13) and washers (12) and remove the tie-plates (40). The tie plates have two dowel pins (15) at each end and these are press fitted



into the housing (33) at the factory.

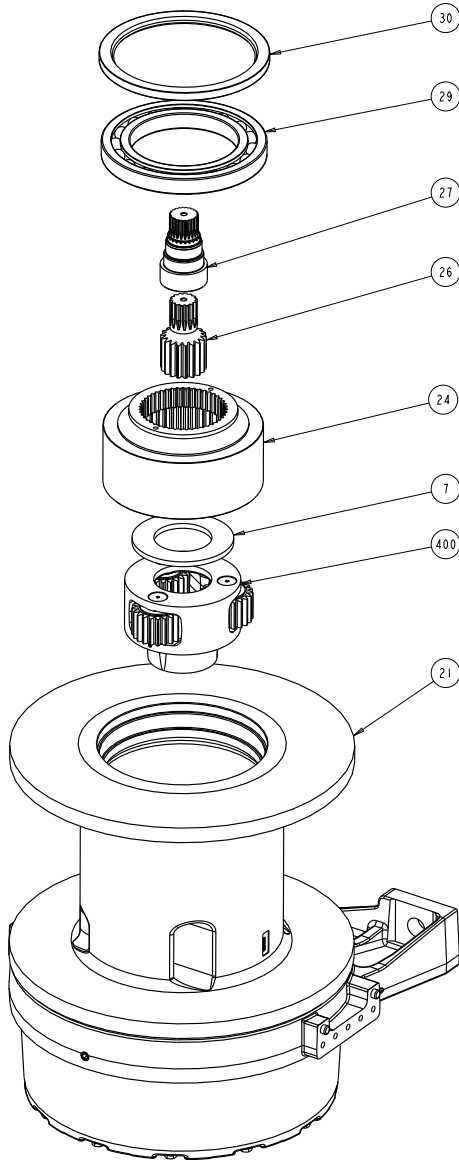
9. Using eyebolts, lift the brake housing (34), which is bolted to the brake housing support (33) straight off the drum. The stainless-steel sleeve (31), V-ring seal (43), oil seal (28), and ball



# HIGH SPEED REVERSE HOIST DISASSEMBLY

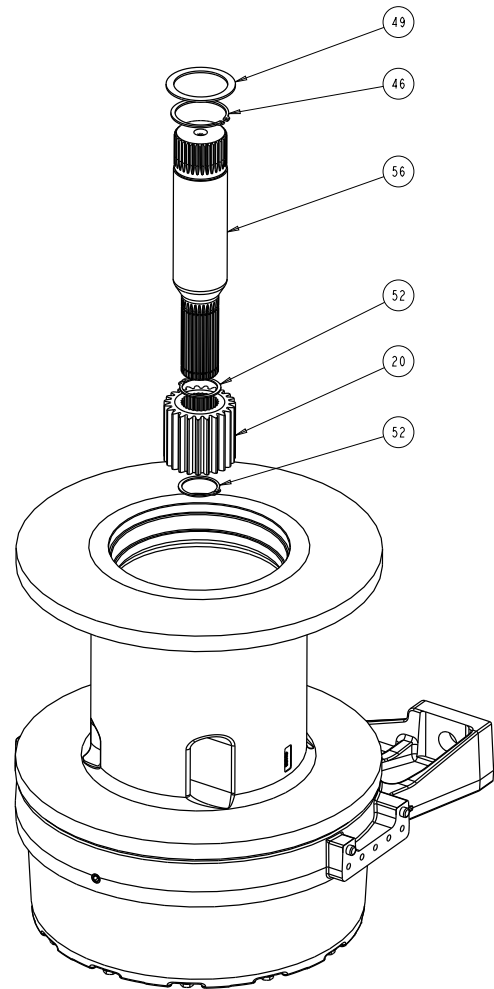
bearing (32) will follow.

10. Remove and discard the oil seal (30), then remove the ball bearing (29). Remove the secondary sun gear shaft (27) and secondary sun gear (26). Remove the secondary ring gear



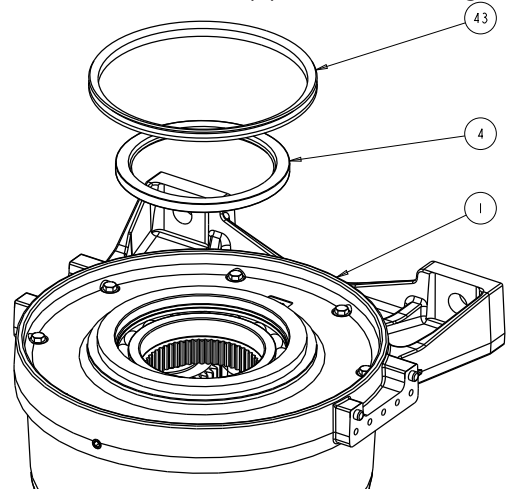
(24), thrust washer (7), and secondary planet carrier assembly (400).

11. Using a ½-13 lifting eye, lift the output shaft (56) out of the drum; the output sun gear (20), thrust



washer (49), and snap rings (52) will follow.

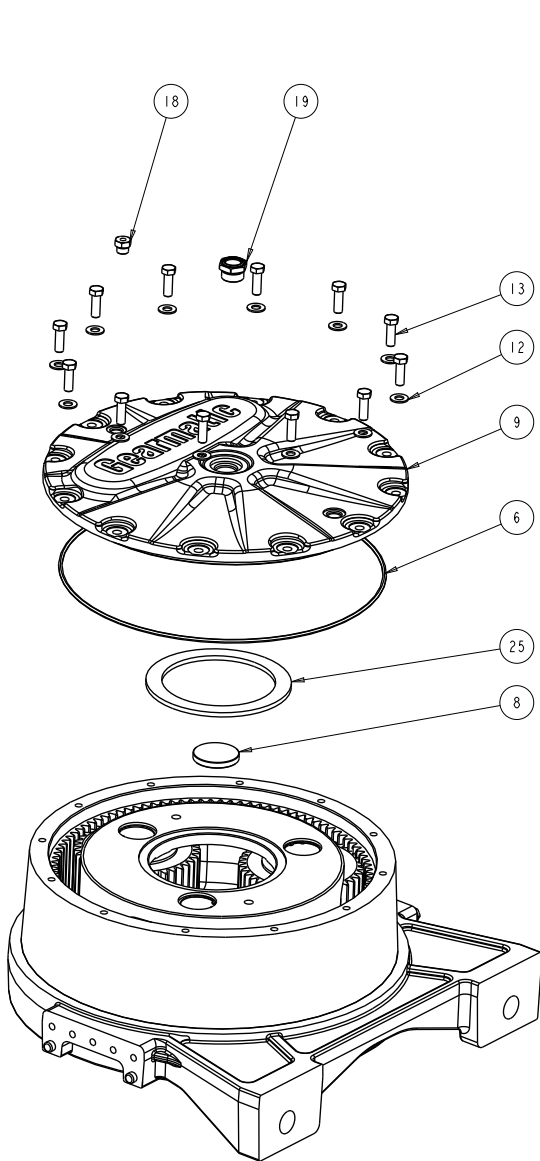
12. Using lifting clamps, lift the drum (21) straight up and off the gear housing support (1); the stainless-steel sleeve (5) will follow and can be set on the deck. If plug (16) was not removed previously, remove it at this time.
13. Remove the V-ring seal (43), and remove and discard the oil seal (4) located on the gear



## HIGH SPEED REVERSE HOIST DISASSEMBLY

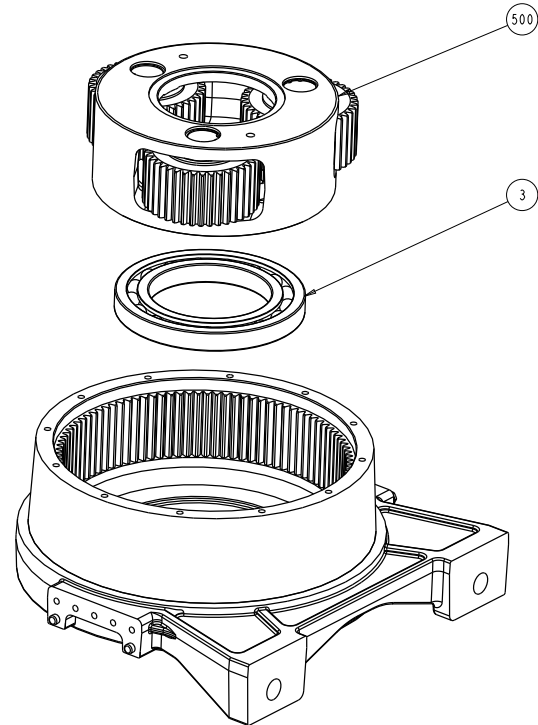
housing support (1).

14. Place the final drive housing with the drum side down and remove capscrews (13) and washers (12) from the output housing cover (9). Remove the output housing cover (9); the thrust bearing (25), o-ring (6), sight glass (19), plug (18), relief



valve (17), and thrust button (8) will follow.

15. Using 5/8-11 lifting eyes, lift the output planet carrier assembly (500) out of the output ring gear. Once removed, remove the ball bearing (3).



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## HIGH SPEED REVERSE HOIST ASSEMBLY

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1. Assemble the planet carrier assemblies, brake, and brake clutch assembly following the procedures in the applicable subassembly service sections of this manual.
2. If the output ring gear (2) or brake housing (34) was removed from its support, reattach it by applying Loctite 242 (or equivalent) to capscrews (11 and 14) and torque to 75 +/-10 ft/lb.
3. Set the output housing with the drum end down, level and stable. Press ball bearing (3) into gear housing support (1). Carefully lower the output carrier assembly (500) into the output ring gear (2).
4. Apply general-purpose grease to thrust bearing (25) and install it onto housing cover (9). Lightly grease thrust button (8) and install it in the recess in housing cover (9).  
**NOTE:** if too much grease is applied, oil will not be able to enter the sight glass for visual inspection.
5. Install O-ring (6) onto housing cover (9) and apply a light coat of grease to the O-ring surface. Verify proper alignment of housing cover (9) on ring gear (2), install the housing cover on the output ring gear (2), and secure it with washers (12) and capscrews (13). Torque to the value specified on the torque chart.
6. Set the output housing on the deck, drum side up, in preparation for installing the seal, V-ring seal, and drum.
7. Apply Loctite Aviation Gasket Sealant (or an equivalent non-hardening sealant) to the outside diameter of the drum seal and install oil seal (4) into gear housing support (1), flush with the output housing. Install V-ring seal (43) onto the output housing.
8. If the stainless-steel sleeve (5) has been removed from the cable drum (21), replace it with a new one and press it onto the seal landing, using Loctite 271 on the drum snout.
9. Apply grease to the inner race of output housing support bearing (3) and to seal (4).
10. Liberally grease the flange near the splined snout of cable drum (21) with marine-grade grease.
11. Using lifting straps or an equivalent lifting device, lower drum (21) onto the housing, aligning the drum splines with the output planet carrier splines.
12. Assemble the output sun gear shaft and sun gear by installing the retaining ring on the output sun gear shaft then slide the output sun gear onto the output sun gear shaft splines then add the last snap ring.
13. Install the secondary planet carrier assembly (400) onto the splined connection on the output sun gear.
14. Apply general-purpose grease to thrust washer (7) and place it in the recess in secondary ring gear (24), then assemble the ring gear onto the secondary planet carrier assembly (400), aligning it with the gears.
15. Press bearing (29) into the cable drum. Install oil seal (30) into cable drum (21), flush with the drum face.
16. Install secondary sun gear (26) into the secondary planet carrier assembly (400), followed by secondary sun gear shaft (27).
17. If the stainless-steel sleeve (31) has been removed from brake housing (34), replace it with a new one and press it onto the seal landing using Loctite 271.
18. Press bearing (32) and seal (28) into brake housing (34), flush with the face.
19. Install V-ring seal (43) onto brake housing (34).
20. Lightly grease the inner race of drum bearing (29) and drum seal (30). Using 1/2-13 eyebolts in the tapped holes of the brake housing, slowly lower it onto the drum.
21. Install tie-plates (40), using dowel pins (15) as a guide, then install washers (12) and capscrews (13). Torque to the value specified on the torque chart.
22. Install primary ring gear (36) into brake housing (34) with the counterbore along the ring gear teeth facing the motor side and the cast groove facing the drum.
23. Install primary planet carrier subassembly (300) into the ring gear. Install thrust washer (37) and primary sun gear (35).

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## HIGH SPEED REVERSE HOIST ASSEMBLY

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24. Install spacer (215), divider plate (201) then friction disc (202). alternate divider plate and friction disc until last divider plate is installed.
25. Install the overrunning clutch assembly (100), engaging the splines on the inner race with sun gear (35) and the splines on the outer race with brake disc (202).
26. Install O-ring (207) in primary housing cover (206) and grease lightly. Verify the circulation return port is correctly clocked on the primary housing. Using ½-13 eyebolts in the primary housing cover (206), lower the brake assembly into the primary housing. Install capscrews (14) and washers (12) that fasten the housing cover to the primary housing, tightening in a cross pattern one turn at a time to evenly draw the cover down against spring force, then torque to the value specified on the torque chart.
27. Install bearing (39) in the hydraulic motor flange adapter. Install and lightly grease motor adapter O-ring (211) and apply grease to the inner race of bearing (39). Slowly lower the motor onto the primary housing — the motor flange adapter bearing (39) inner race contact surface is the

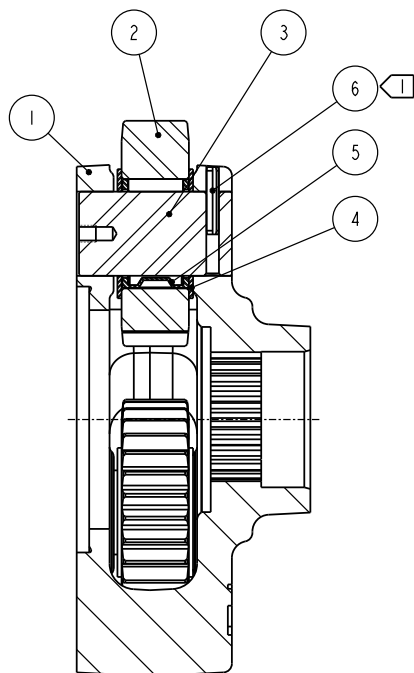
brake hub. Tap the motor adapter lightly until seated on the primary housing cover, then install capscrews (13) and washers (12) and torque to the value specified on the torque chart.

**NOTE:** Capscrews in steps 5 and 22 may be torqued after the hoist is fully assembled and set on its mounting feet.

# PRIMARY PLANET CARRIER SERVICE AND ASSEMBLY

## Disassembly

1. Mark each gear, pin, and carrier bore so each gear and pin is reassembled into the same bore from which it was removed.
2. Remove the planet gears by first driving the roll pins (6) into the center of the primary planet pin (3).
3. Use a punch to drive the roll pins out of the planet gear shafts. Do not reuse the roll pins.
4. Remove the primary planet pin (3), bearings (5), thrust washers (4), and gears (2). Thoroughly clean all parts and inspect for damage and wear. Bearing rollers should show no irregularities; replace the bearing if rollers show spalling, corrosion, discoloration, material displacement, or abnormal wear. Inspect the cage for unusual wear or deformation, particularly the cage bars; replace the bearing if damage would impair the cage's ability to separate, retain, and guide the rollers. Thrust washer contact surfaces should be free of irregularities that could cause abrasion or friction. Inspect gears and shafts for abnormal wear or pitting and replace as necessary.

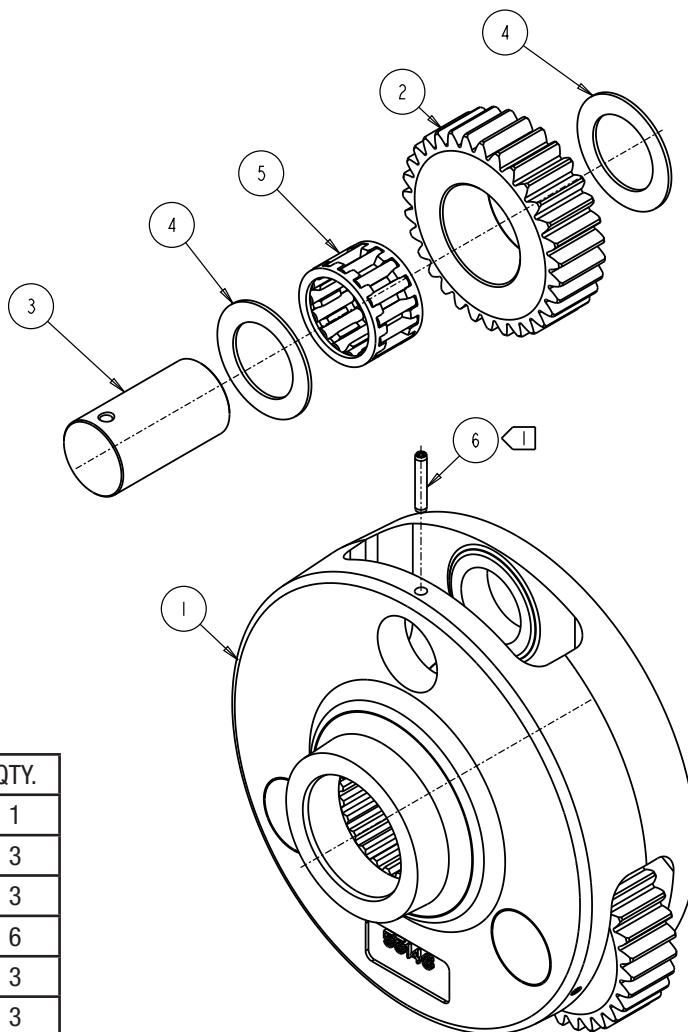


## Assembly

1. Install a bearing (5) into a planet gear (2) and place a thrust washer (4) on each side of the gear. Position this assembly into an opening in the carrier (1). Slide a primary planet pin (3) through the carrier (1), thrust washer (4), bearing (5), and remaining thrust washer (4).
2. Carefully align the pin hole in the carrier (1) with the hole in the primary planet pin (3) and drive a new roll pin (6) into place.
3. The roll pin (6) should sit slightly recessed in the carrier when properly installed. Using a center punch, stake the carrier (1) next to the pin hole to distort the hole and prevent the pin from backing out during operation. Repeat these steps for each of the three planet gears.



Always use new roll pins during reassembly.

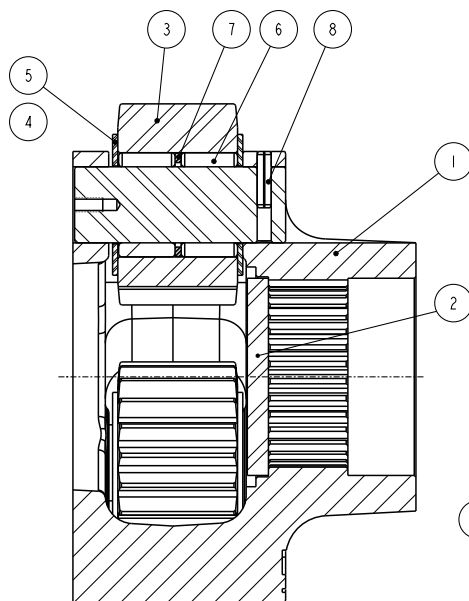


| ITEM NO. | PART NO. | DESCRIPTION            | QTY. |
|----------|----------|------------------------|------|
| 1        | 113729   | PRIMARY PLANET CARRIER | 1    |
| 2        | 113744   | PRIMARY PLANET GEAR    | 3    |
| 3        | 113745   | PRIMARY PLANET PIN     | 3    |
| 4        | 24306    | THRUST WASHER          | 6    |
| 5        | 25292    | ROLLER BEARING         | 3    |
| 6        | 23584    | PIN-SPIROL             | 3    |

## SECONDARY PLANET CARRIER SERVICE AND ASSEMBLY

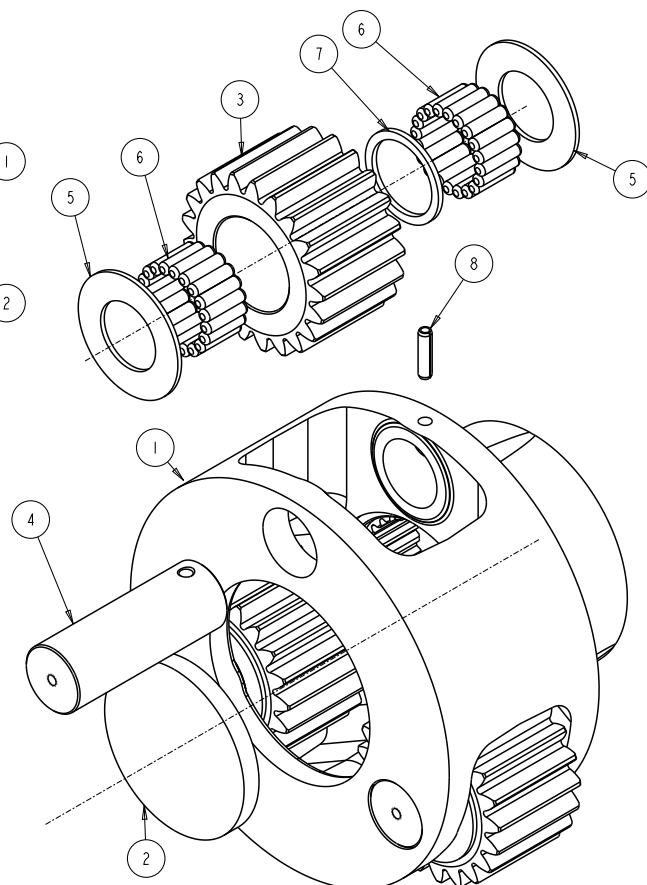
### Disassembly

1. Mark each gear, pin, and carrier bore so each gear and pin is reassembled into the same bore from which it was removed.
2. Remove the planet gears by first driving the roll pins (8) into the center of the planet gear pin (4).
3. Use a punch to drive the roll pins out of the planet gear shafts. Do not reuse the roll pins.
4. Remove the planet gear pin (4), loose roller bearings (6), thrust washers (5), and gears (3). Thoroughly clean all parts and inspect for damage and wear. Bearing rollers should show no irregularities; replace the bearing if rollers show spalling, corrosion, discoloration, material displacement, or abnormal wear. Inspect the cage for unusual wear or deformation, particularly the cage bars; replace the bearing if damage would impair the cage's ability to separate, retain, and guide the rollers. Thrust washer contact surfaces should be free of irregularities that could cause abrasion or friction. Inspect gears and shafts for abnormal wear or pitting and replace as necessary.



### Assembly

1. Place the secondary planet carrier (1) on a clean work surface with the drive pins facing down.
2. Install thrust plate (2) into the secondary planet carrier (1).
3. Apply a liberal coat of oil-soluble grease to a thrust washer (5) and center it on one side of a planet gear (3), placed thrust-plate-side down on a clean work surface. Apply a liberal coat of oil-soluble grease to the bore of gear (3). Stack a row of loose roller bearings (6) into the planet gear, using the grease to hold them in position (20 rollers per row). Install bearing spacer (7), then stack a second row of loose roller bearings (6) on top of the spacer. Place a second thrust washer (5) on the planet gear. Carefully slide the planet gear (3), bearings (6), and thrust washers (5) into the carrier (1). Install a planet gear shaft (4) into the carrier (1) and through the planet gear bearings.
4. Follow steps 2 and 3 of the Primary Planet Carrier assembly procedure to install and stake a new roll pin in the carrier. Repeat this procedure for each planet gear.

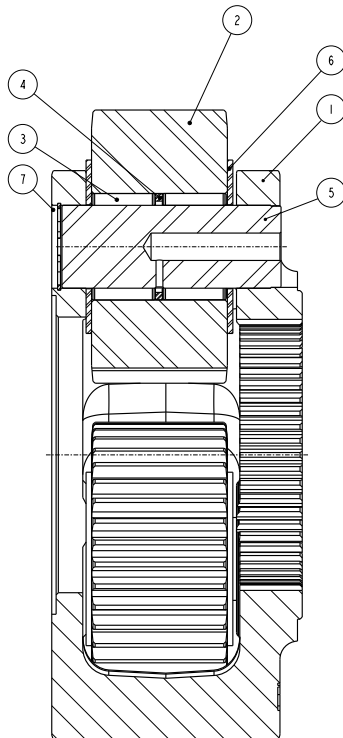


| ITEM NO. | PART NO. | DESCRIPTION              | QTY. |
|----------|----------|--------------------------|------|
| 1        | 113730   | SECONDARY PLANET CARRIER | 1    |
| 2        | 103279   | OUTPUT THRUST PLATE      | 1    |
| 3        | 113747   | SECONDARY PLANET GEAR    | 3    |
| 4        | 113748   | SECONDARY PLANET PIN     | 3    |
| 5        | 28729    | THRUST WASHER            | 6    |
| 6        | 28859    | NEEDLE ROLLER            | 120  |
| 7        | 113750   | SECONDARY ROLLER SPACER  | 3    |
| 8        | 70862    | SPRING PIN               | 3    |

# OUTPUT PLANET CARRIER SERVICE

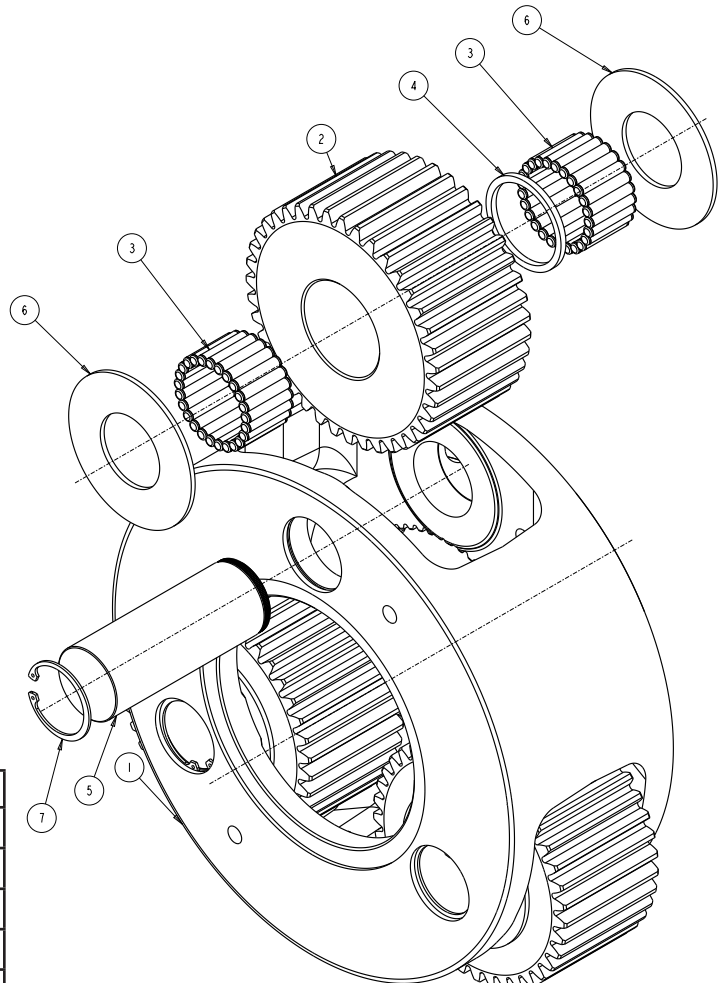
## DISASSEMBLY

1. Mark each gear (2), pin (5), and output planet carrier (1) so each gear and pin is reassembled into the same bore from which it was removed.
2. Remove the retaining ring (7) holding the planet gear shaft (5) in the carrier. Remove the planet gear shaft (5) from the carrier (1).
3. Slide the planet gear (2), thrust washer (6), and bearings (3) out of the carrier (1). Remove the thrust washers (6), loose roller bearings (3), and bearing spacer (4) from the gear (2). Repeat this procedure for each planet gear.
4. Thoroughly clean all parts and inspect for damage and wear. Bearings (3) should show no irregularities; replace if they show spalling, corrosion, discoloration, material displacement, or abnormal wear. Thrust washer (6) contact surfaces should be free of irregularities that could cause abrasion or friction. Inspect gears (2) and shafts (5) for abnormal wear or pitting and replace as necessary.



## ASSEMBLY

1. Apply a liberal coat of oil-soluble grease to a thrust washer (6) and center it on one side of a planet gear (2), placed thrust-washer-side down on a clean work surface. Apply a liberal coat of oil-soluble grease to the bore of gear (2). Stack a row of loose roller bearings (3) into the planet gear, using the grease to hold them in position (25 rollers per row). Install bearing spacer (4), then stack a second row of loose roller bearings (3) on top of the spacer. Place a second thrust washer (6) on the planet gear. Carefully slide the planet gear (2), bearings (3), and thrust washers (6) into the carrier (1). Install a planet gear shaft (5) into the carrier (1) and through the planet gear bearings — the shaft may need to be driven in slightly to clear the retaining ring groove in the carrier. Install retaining ring (7) into the carrier. Repeat this procedure for each planet gear.



| ITEM NO. | PART NO. | DESCRIPTION           | QTY. |
|----------|----------|-----------------------|------|
| 1        | 113731   | OUTPUT PLANET CARRIER | 1    |
| 2        | 113751   | OUTPUT PLANET GEAR    | 3    |
| 3        | 102139   | NEEDLE ROLLER         | 150  |
| 4        | 113752   | BEARING SPACER        | 3    |
| 5        | 113753   | OUTPUT PLANET PIN     | 3    |
| 6        | 113754   | THRUST WASHER         | 6    |
| 7        | 113720   | RETAINING RING, INT   | 3    |

## BRAKE PARTS GROUP SERVICE

### DISASSEMBLY

1. A hydraulic press or spring compressor tool is required to disassemble the brake subassembly. Place the brake subassembly on the press with the primary housing cover (206) facing down. Place a heavy steel bar across the large diameter of the pressure plate (203) and compress the springs until spring force is removed from retaining ring (204). Remove the retaining ring with retaining ring pliers, then slowly release the press force on the pressure plate.
2. Remove the pressure plate (203), spring separator (209), and springs (208).
3. Remove the brake piston (205) from the primary housing cover (206). Remove the u-cup seals (212 and 213) from the brake piston (205).

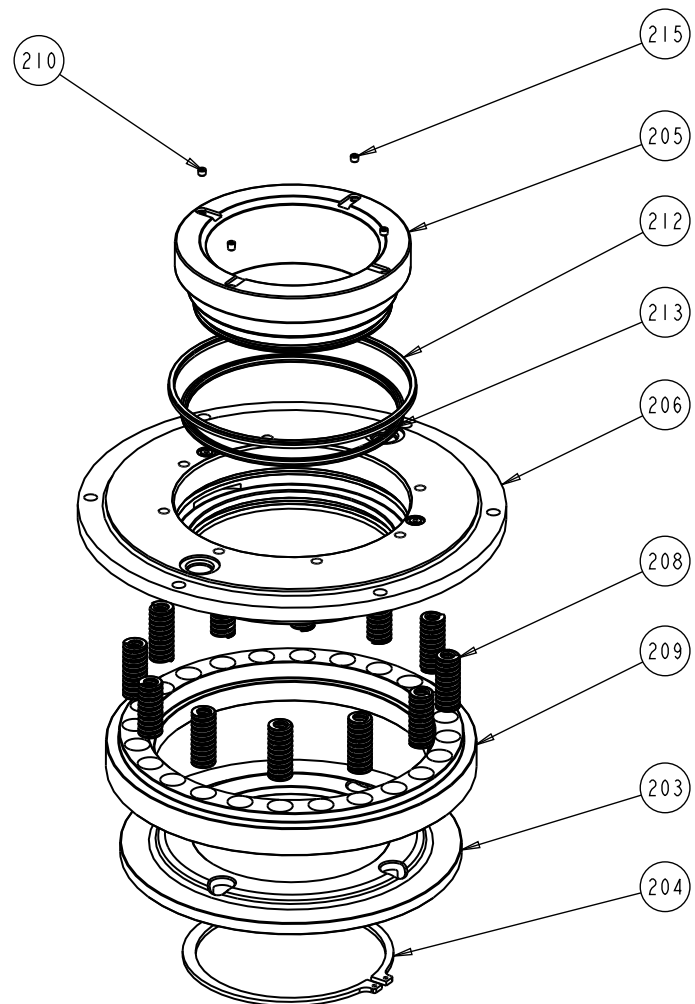
### CLEAN AND INSPECT

1. Thoroughly clean and inspect all parts. Check the sealing surfaces on the primary housing cover and brake piston. Ensure the brake release port is clean and free of debris.
2. Place the brake disc on a flat surface and check for distortion with a straightedge. Friction material should appear even across the entire surface with the groove pattern visible. Replace brake discs or divider plates if distorted, burned, unevenly worn, or if the splines are worn to a point.
3. Check brake spring free length. Minimum free length is 2.910 in. If measurement requires replacement of one spring, replace all springs.

### ASSEMBLY

1. A hydraulic press or spring compressor tool is required to assemble the brake subassembly. Place the primary housing cover (206) on a clean work surface, motor side up, and support it at least 2 in. off the table with wood or metal blocks to provide clearance for pressure plate (203) installation.

2. Install the polypaks (212 and 213) in the piston. Lightly grease the polypaks.
3. Lightly grease the housing cover at the piston seating surface and install the brake piston in the primary housing cover (206); tap lightly to seat it in the housing cover if necessary.
4. Place the primary housing cover on the press table, motor side down. Place a spacer under the piston to keep it raised in the housing cover.
5. Install the spring separator (209), seated on the piston. Install the springs (208) in the spring separator and space them evenly.
6. Install the pressure plate (203) onto the springs with the flat surface facing the springs.
7. Place a heavy steel bar across the outside diameter of the pressure plate. Use the press to compress the springs until there is clearance to install retaining ring (204) into the groove in the piston, then install the retaining ring.



## BRAKE CLUTCH SERVICE

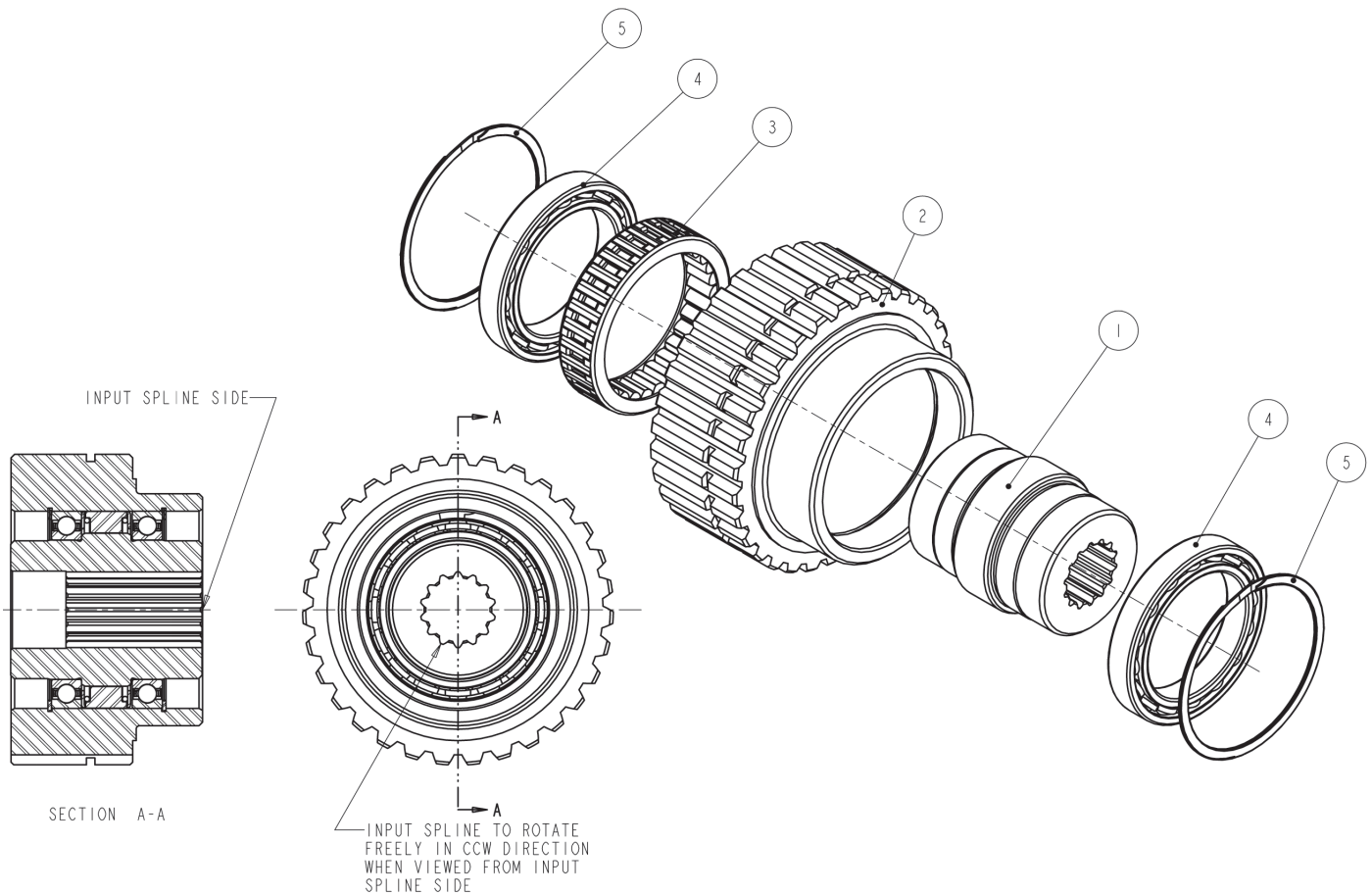
### DISASSEMBLY

1. Remove one of the retaining rings (5) from the outer race (2). Push the inner brake race (1), ball bearings (4), and overrunning clutch (3) through the outer race (2).
2. Use a small punch and hammer to tap one of the bearings (4) off the inner race. The overrunning clutch can then be removed from the inner race. Closely inspect the overrunning clutch and the polished surfaces of the inner and outer races, and the bearings, for wear, cracks, pitting, corrosion, heat discoloration, or mechanical damage.

### ASSEMBLY

1. If both bearings (4) have been removed from the inner race, install one of them now.
2. Install the overrunning clutch onto the inner race, rotating the inner race slightly to start the clutch onto it.
3. Install the other bearing onto the inner race.
4. With one retaining ring (5) installed in one end of the outer race, carefully slide the inner race — with bearings and clutch — into the outer race. Install the other retaining ring into the outer race.

**NOTE:** On the GM50A, the input shaft turns free in the direction of drum rotation. Refer to the applicable parts drawing for standard setup.



| ITEM NO. | PART NO. | DESCRIPTION        | QTY. |
|----------|----------|--------------------|------|
| 1        | 106799   | INNER BRAKE RACE   | 1    |
| 2        | 106800   | OUTER BRAKE RACE   | 1    |
| 3        | 107624   | OVERRUNNING CLUTCH | 1    |
| 4        | 103104   | BALL BEARING       | 2    |
| 5        | 103110   | RETAINING RING     | 2    |

# REVERSING DIRECTION OF DRUM ROTATION

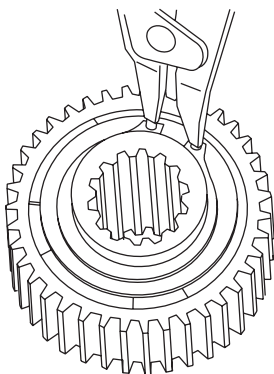
## GENERAL INFORMATION

To change the direction of the hoist, the following changes are required.

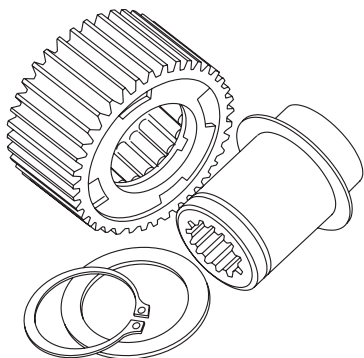
1. Reversing the brake clutch (sprag) operation.
2. Reversing the hydraulic motor direction.
3. Reassembly.

## REVERSING BRAKE CLUTCH

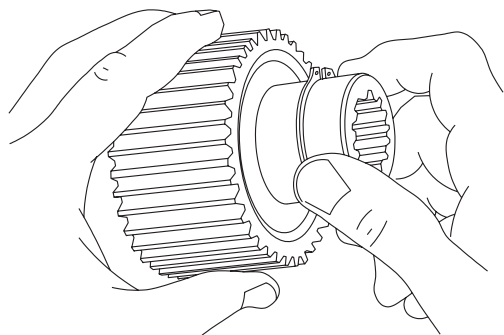
Modify the brake clutch assembly per the instructions below. This will ensure that the brake clutch operates properly for the new direction of rotation.



1. Remove the snap ring and sprag bushing retainer from one end only of the brake clutch assembly.

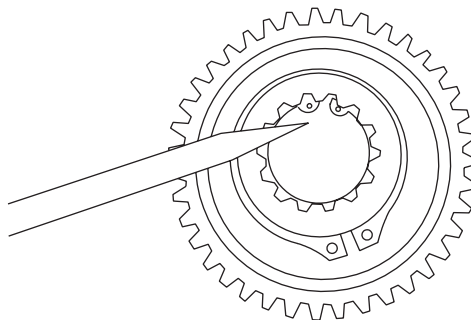


2. Pull the inner race out. Examine the race for scoring, wear or indentations caused by the sprag cams. If the inner race is not completely smooth, the assembly should be replaced.



3. Turn the sprag assembly around and slide the inner race (with 1 snap ring and bushing retainer) through the bushings and sprag clutch (the race will have to be rotated in the free-wheeling direction to start it through

the sprag clutch). Install the remaining bushing retainer and snap ring. Make certain the snap ring is properly seated in the groove.



## ! WARNING !

Be certain the snap ring is seated in the groove in the splined bore of the inner race. This snap ring will keep the brake clutch assembly correctly positioned in the center of the friction brake pack. Binding of the brake or brake failure may occur if this snap ring is omitted.

## REVERSING MOTOR DIRECTION

Refer to Hydraulic Circuit on page 11 for view.

1. Remove both SAE -4 ORB plugs on the outer diameter of the motor flange.

**NOTE:** The SAE -4 ORB ports on the motor flange face boss do not need to be removed.

2. Insert an allen key into the brake release port cavity and remove the 1/16-27 NPT pipe plug.

**NOTE:** For CW rotation the 1/16-27 NPT pipe plug is in the "Lower" port side, for CCW rotation the 1/16-27 NPT pipe plug is in the "Hoist" port side

3. Clean the pipe plug.
4. Insert the pipe plug into the opposite brake release port cavity and tighten.
5. Insert both SAE-4 ORB plugs into the ports on the outer diameter of the motor face flange.

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## REVERSING DIRECTION OF DRUM ROTATION

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### REASSEMBLY

1. Install a new O-rings on the motor pilot and brake release port.
2. Install and tighten motor capscrews to recommended torque.
3. Connect Hoist and Lower hoses to their correct ports.
4. Operate the hoist slowly in both directions and check for oil leaks and/or unusual sounds. The hoist should operate smoothly in both directions. Refer to "WIRE AND SYNTHETIC ROPE INSTALLATION" and properly install rope onto the hoist drum.
5. Before returning the hoist to full service, a light load should be lifted and held three feet (1 meter) off the ground to be sure the static brake is functioning properly. The hoist should also be able to slowly lower the load in a smooth and controlled manner. If the hoist does not perform either of these functions, refer to "TROUBLESHOOTING" for additional information.

### SERVICE PART INFORMATION

114111: Counter-clockwise standard hydraulic motor\*

114112: Clockwise hydraulic motor\*

\*When viewed from the motor end of the winch.

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## NOTES

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## NOTES

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