

# JIANGYIN GEARBOX

INDUSTRIAL GEAR TRANSMISSION SOLUTION PROVIDER



Jiangyin Gearbox  
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江阴齿轮箱制造有限公司

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# JIANGYIN GEARBOX



## ZLYJ系列高强度硬齿面减速器

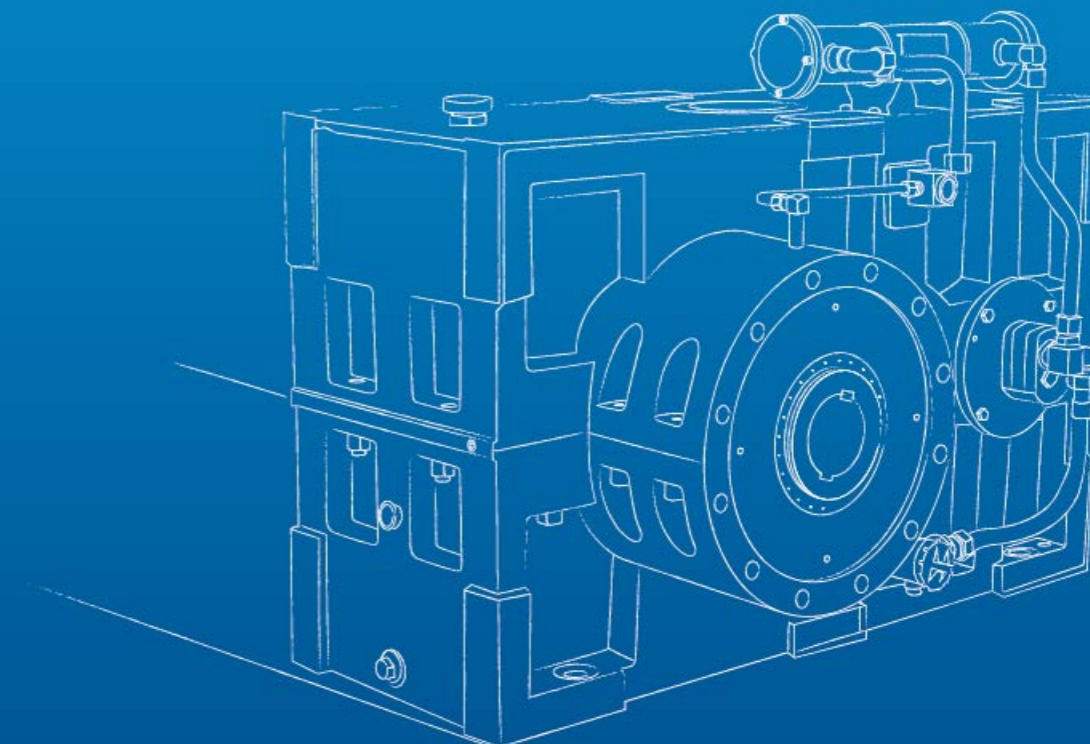
ZLYJ Series High Strength Hard Surface Gear Reducer

## 说明书

## INSTRUCTION MANUAL



工业齿轮传动解决方案提供商  
INDUSTRIAL GEAR TRANSMISSION  
SOLUTION PROVIDER



江阴齿轮箱制造有限公司

JIANGYIN GEARBOX MANUFACTURING CO.,LTD.

# COMPANY PROFILE

## 公司简介



江阴齿轮箱制造有限公司注册于1979年，三十年来专注于工业齿轮箱产品的研发与制造，依靠业内积累的丰富经验，致力于为客户提供最具性价比的硬齿面齿轮传动解决方案。

公司厂区占地86700平方米，装备有数控成型砂轮磨齿机、数控加工中心、箱

式多用炉和井式气体渗碳炉生产线、齿轮检测中心、加载实验平台等先进的加工和检测设备。

公司主要产品主要有通用型圆柱齿轮减速器、圆锥圆柱齿轮减速器、标准模块化减速器、行星齿轮减速器、斜齿轮-锥齿轮减速器，以及为橡塑、港口、冶金、矿

用、建材、石化等行业设备配套的专用齿轮箱。

江齿公司以持续不断的研究开发投入为基础，通过精心制造、严格检验，确保每件出厂产品的卓越品质。并利用江齿公司遍布全国各地的销售和服务网络，为客户提供尽善尽美的专业服务。

Founded in 1979, Jiangyin Gearbox Manufacturing Co., Ltd has specialized exclusively in the development, designing and fabrication of industrial gearboxes product. Relying on more than 30 years extensive experience in the industry, we are committed to providing customers with the most cost-effective hard tooth surface gear transmission solution.

The company occupies an area of 86700 sq. m. There are CNC gear profile grinding machines and CNC machining center in the

company. The company also introduced the large well type gas carburizing furnace production lines and box-type multi-purpose furnace. Moreover, the company is equipped with detecting and testing equipment center, load test platform and other advanced processing and testing equipment.

The company mainly products including cylinder gearbox series, conical cylinder gear reducer series, standard modularized combined gear units series, planetary gear reducer series, helical-bevel speed reducer

series and some dedicated gearboxes which are widely applied in rubber and plastics, ports, metallurgy, mining, building materials, petrochemical and other industries.

On the basis of continuous research and development investment, the company ensures each gearbox product excellent quality by careful manufacturing and rigorous testing. Through country-wide marketing and service network, we are always dedicated to provide customers with perfect professional services.

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## BRIEF INTRODUCTION

### 概述

ZLYJ系列减速器是为塑料螺杆挤出机配套设计的高精度硬齿面带推力座的传动装置。产品设计采用JB/T 9050.1-1999规定的各项技术规范。其特点是齿轮和轴类零件采用了高强度合金钢材质。齿轮经渗碳、淬火、磨齿工艺加工。齿轮精度为GB/T 10095.1-2008, 6级。齿面硬度HRC54~62。在空心输出轴前端配置有超规格的推力轴承, 随螺杆的工作后座力。轴承和油封等主要标准件皆采用国内优质产品, 也可按用户需要, 原装进口产品。整机具有体积小、承载能力高、传动平稳、噪声低、效率

ZLYJ series gear reducers are high precision hardening tooth flank transmission part with thrust bearing housing. They are designed for plastic screw-rod extruder according to JB/T 9050.1-1999. The gears and shaft parts are made of high strength alloy steel. The gears are manufactured by way of carburizing quenching, and precision grinding. Its precision is up to Class 6(GB10095.1-2008). Hardness of tooth flank is HRC54-62. Thrust bearing is in front of output hollow shaft to

高等特点。产品性能已达到国际先进水平, 可替代同类型进口产品使用。

本系列产品中的规格和传动比为现有用户的常用数据。用户在选用时, 可将螺杆的实际传动扭矩与表(2)所列许用输出扭矩为准选型。若需与橡胶挤出机配套, 因橡胶挤出机冲击力较塑料强, 请用户提出具体技术参数, 向我厂咨询后再确定选型。

carry back blow of screw. Bearings, oil seals and some other standard units are domestic quality products and they can also use imported goods as required by customers.

This kind of gear reducer has the characteristic of small volume, high load capacity, stable drive, low noise, and high efficiency. The performance of this products reach levels of foreign products of the same kind and it can take place of them.

## WORKING CONDITIONS

### 适用条件

- 减速器高速轴转速不大于1500r/min
- 工作环境温度为0~35℃。当温度范围超出本规定时, 可按用户要求, 另行配置润滑加热或冷却装置。
- The input shaft speed of the gearbox is normally not more than 1500r/min.
- The operating ambient temperature is 0~35℃. If ambient temperature is lower than 0℃, pre-heating of the lubricant will be necessary before start-up, while cooling is suggested in case of a temperature higher than 35℃.

## IDENTIFICATION CODE

### 减速器代号和标志

- 在减速器代号中, 包括型号、输出级中心距、公称传动比、装配型式。
- The product mark consists of product type, centre distance of low speed stage (mm), nominal ratio and assembly type.

### 标记示例 Marking Example



## OVERALL DIMENSIONS AND ASSEMBLY TYPE

### 减速器代号和标志

- 外型尺寸见图(1)和表(1)
- Overall dimensions (Figure 1 and Table 1)
- 装配型式见图(2)
- Assembly Type (Figure 2)

图(2) | Figure 2

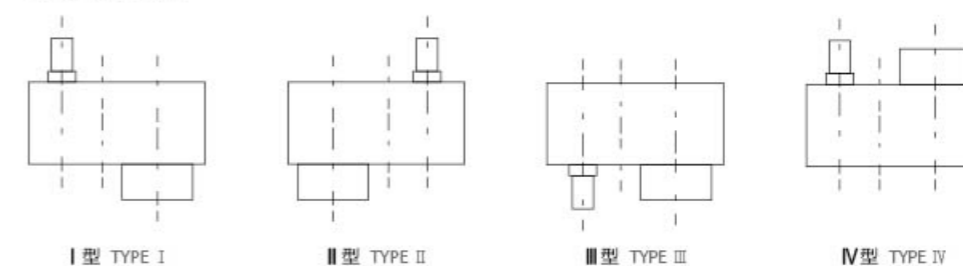




图 (1) | Figure 1

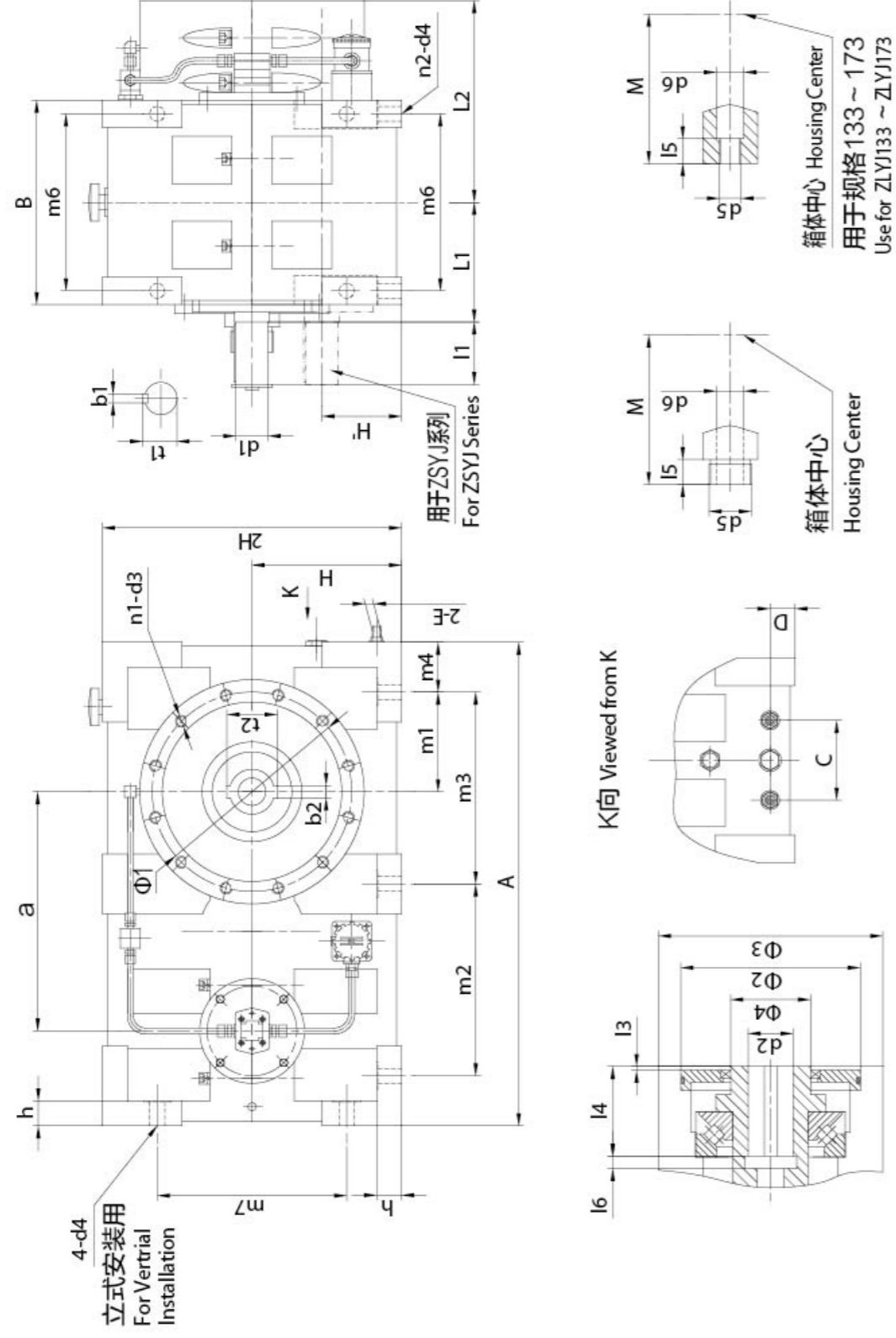


表 (1) | Table (1)

规格 Specs	a	H	H'	h	A	B	L1	L2	d1 (m6)	t1	b1	d2 (H8)	14	t2	B2(F9)	d3	n1	Φ1
ZLYJ133	218	140	/	20	478	215	125	205	28	31	8	38	80	41.3	10	M12	8	205
ZLYJ146	256	160	/	22	560	250	148	245	32	35	10	38	120	41.3	10	M12	8	230
ZLYJ173	285	170	/	21	576	256	148	250	38	41	10	50	140	57.6	14x2	M16	8	260
ZLYJ200	340	240	/	40	750	340	200	330	45	48.5	14	60	150	68.8	18x2	M16	12	300
ZLYJ225	385	250	/	35	800	360	205	355	55	59	16	70	170	78.8	18x2	M20	12	370
ZLYJ250	430	280	/	40	930	380	220	380	60	64	18	80	180	90.8	22x2	M20	12	370
ZLYJ280	480	300	/	50	970	410	240	405	65	69	18	90	180	100.8	25x2	M24	12	400
ZLYJ315	539	350	/	55	1160	450	250	440	75	79.5	20	100	175	112.8	28x2	M24	12	405
ZLYJ330	575	350	/	50	1160	450	260	445	85	90	22	110	220	122.8	28x2	M24	12	450
ZLYJ375	625	400	/	55	1280	466	265	445	85	90	22	110	220	122.8	28x2	M24	12	450
ZLYJ395	660	425	/	60	1310	507	285.5	493.5	95	100	25	110	255	122.8	28x2	M24	12	500
ZLYJ420	695	460	/	60	1420	550	310	535	95	100	25	120	220	134.8	32x2	M30	12	580
ZLYJ450	765	500	/	60	1550	600	350	600	100	106	28	170	220	188.8	40x2	M30	12	610
ZLYJ630	1070	630	/	80	2000	770	430	760	120	127	32	180	300	200.8	45x2	M36	12	720
ZSYJ450	765	500	276	60	1550	600	350	600	75	79.5	20	170	250	188.8	40x2	M36	12	610
ZSYJ560	960	580	324	80	1850	610	355	670	95	100	25	160	300	178.8	40x2	M36	12	720
ZSYJ630	1070	630	350	80	2000	770	430	760	110	116	28	180	340	200.8	45x2	M36	12	720



续表 (1) | Continue Table (1)

规格 Specs	Φ2 (H7)	13	Φ3	d4	n2	* 225 -12.5	* 250 -16	* 280 -16	* 315 -16	* 330 -16	* 375 -16	* 395 -20	* 420 -16	* 450 -20	* 560 -20	* 630 -20	* 630 -44	d6	15	M	
ZLYJ33	180	8	230	16	4	104	185	61	180	184	/	/	/	/	/	/	/	M18	20	/	137
ZLYJ46	200	8	260	16	6	118	190	72	210	210	85	38	38	38	38	38	38	M18	20	/	167
ZLYJ73	230	8	300	17.5	4	113.5	220	68	225	214	/	/	/	/	/	/	/	M20	25	/	147
ZLYJ200	270	8	350	18	4	150	/	100	290	310	120	40	40	40	40	40	40	M85*4	40	50	250
ZLYJ225	330	10	420	26	4	165	/	90	315	330	140	50	50	50	50	50	50	M85*4	55	50	265
ZLYJ250	330	8	420	26	6	205	360	105	330	340	160	50	50	50	50	50	50	M90*4	60	60	285
ZLYJ280	360	8	450	30	6	200	385	100	355	380	160	50	50	50	50	50	50	M90*4	60	60	300
ZLYJ315	365	8	450	30	6	261	450	130	390	460	160	55	55	55	55	55	55	M90*4	60	60	335
ZLYJ330	400	10	500	30	6	225	450	130	390	425	160	55	55	55	55	55	55	M90*4	60	60	350
ZLYJ375	400	10	500	33	6	250	475	165	400	500	160	55	55	55	55	55	55	M90*4	60	60	330
ZLYJ395	450	10	570	32	6	300	530	115	447	570	/	/	/	/	/	/	/	M90*4	60	60	363.5
ZLYJ420	500	10	660	32	6	305	580	150	480	/	/	/	/	/	/	/	/	M90*4	60	60	370
ZLYJ450	500	15	700	32	8	300	600	190	520	/	200	60	60	60	60	60	60	M90*4	60	60	425
ZLYJ630	650	25	805	48	8	400	850	200	670	/	300	80	80	80	80	80	80	M90*4	60	60	500
ZSYJ450	500	10	700	32	8	300	600	190	520	/	200	60	60	60	60	60	60	M90*4	60	60	425
ZSYJ560	620	25	805	48	8	390	730	170	510	/	270	80	80	80	80	80	80	M90*4	60	60	435
ZSYJ630	650	25	805	48	8	400	850	200	670	/	300	80	80	80	80	80	80	M90*4	60	60	500

▲ 注：表内尺寸仅供参考，若有更改恕不另行通知，请订货时核实。

The dimensions in table are for reference only. Specific mode may be determined when the product is ordered.

## LOAD CAPACITY 减速器的承载能力

表 (2) | Table (2)

型号 Type	ZLYJ																	ZSYJ						
	113 -8	146 -10	173 -10	* 200 -12.5	* 225 -12.5	* 250 -16	* 280 -16	* 315 -16	* 330 -16	* 375 -16	* 395 -20	* 420 -16	* 450 -20	* 560 -20	* 630 -20	* 630 -44	* 450 -32	* 560 -57	* 630 -44					
一般可靠 General reliability	22	30.8	39	55	82.5	75	116	171	/	260	220	315	303	600	825	240	240	240	240	370				
高可靠 High reliability	15	18.3	30.8	45	67	60	75	116	207	207	200	250	266	550	675	200	200	220	220	315				
公称输入功率 Nominal input power (KW)	输入转速 Input speed = 1500r/min																							
允许输出扭矩 Allowable output torque (N·m)	1165	1962	2484	4379	6568	7643	11822	17427	/	26497	28025	32102	38599	76433	105095	48917	87134	103694						
高可靠 High reliability	764	1165	1962	3583	5334	6306	7643	11822	21000	22110	25478	25478	33885	70063	85978	40764	79873	88280						
轴向推力 Axial thrust force	39	54	110	155	180	192	258	287	390	390	430	430	500	700	770	500	700	770	770	770				
螺杆直径 Diameter of screw (mm)	45 / 50	55	65	75	90	100	105 / 110	120	130 / 150	150 / 160	165	165	165	190	200	165	190	220	220	220				
输入功率 Input power (kW)	8	11	18.5	26	45	45	55	75	132	132	132	160	213	440	540	200	220	315	315	315				
输入转速 Input speed (r/min)	800	900	900	1000	1000	1120	960	960	960	960	1200	960	1200	1200	1200	1500	1500	1500	1500	1500				
输出转速 Output speed (r/min)	100	90	90	80	80	70	60	60	60	60	60	60	60	60	60	47	60	26	26	26				
推荐配置 Recommendation station	允许输出轴向推力 Allowable output axial trust force (KN)																							

**▲ 注:**

- “\*”号——带冷却管，“※”号——带冷却管和强制循环。型号ZLYJ112、133、146、173按高可靠预选用时不需带冷却管。
- 表列输入功率和输出扭矩已考虑工况系数，可直接选用。
- 表列输出扭矩是主要选取型依据。传动比可按用户需要调整。ZLYJ的*i*为6.3-20；ZSYJ的*i*为22.4-100。
- 当取轴承负荷系数 $f_a=1.5$ 时，按表列许用轴向推力和输出轴给定转速计算。推力轴承的理论计算寿命，除ZLYJ133、146两型为1.2万小时左右，其余各型皆在2.5万小时左右。
- 以下两种情况应对减速器的冷却设计参数校核：  
按高可靠数据选取用，但输出转速超过表(2)时（即加大了输入功率）  
当内冷却方式散热面积不足时，采用带油泵的外置式油冷却器。采用外冷却器时在订货时另外提供简图。
- 用户可按表列数据作初步选型。在订货时，我厂将对用户选型按实际工况条件作详细校核，以确保选用的可靠性。

**Attention:**

- “\*”——equipped with forced cooling device, “※”——equipped with cooling and forcible circulation. ZLYJ 112,133,146 and 173 does not need forced cooling when designed for high reliability.
- The input power and output torque listed in the table has allowed for working condition factor and may be selected directly.
- You can place an order on the basis of output torque listed and the ratios may be adjusted as required by the user. For ZLYJ series, the Ratio(*i*) is from 6.3 to 20. While for ZSYJ series, the Ratio(*i*) is from 22.4 to 100.
- When load coefficient of bearing ( $f_a$ ) is 1.5, the thrust bearing theoretical service life reach about 25,000 hours in accordance with axial thrust force and output shaft rotation speed listed (Table 2) except ZLYJ 133 and ZLYJ 146 whose service lives are about 12,000 hours.
- In the following two cases, dealing with cooling design parameters of gear reducer checking:  
According to the high reliable data to choose, but the output speed is over the data of Table(2). (i.e. increasing the input power)  
When inside cooling heat dissipation areas is insufficient, USES the external type oil cooler with oil pump. Please provide brief with order, when using external cooler.
- The user is to make preliminary selection according to the listed data. When the product is ordered, we will make detail and careful verification for use's selection to enhance the reliability.

当环境温度低于0℃时，需在油池中增加电热管，对润滑油进行了预热。

当温度环境高于35℃时，我厂将按用户提供的温度值进行热平衡计算，以确定是否增加冷却装置。

强制润滑油路的示意图见图(3)。

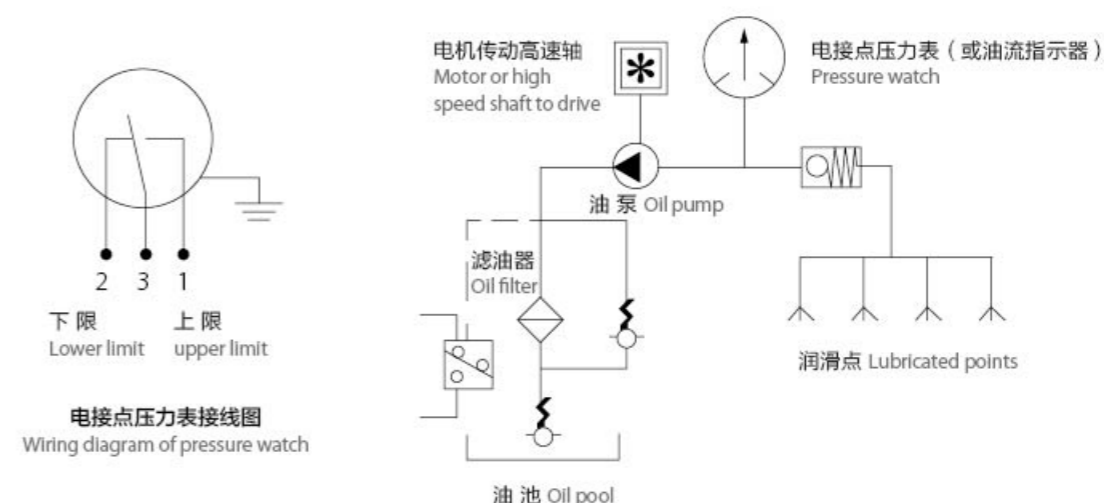
Gears and bearings are lubricated by soaking and splashing. The bearings of ZLYJ 280,315,375,420,450,560,630&ZSYJ 450,560,630 are taken a forced lubrication with oil pump besides soaking and splashing.

Type of lubricant is gear oil N220 or other gear oils having the same viscosity as N220.

It is necessary for oil sump to be equipped with electric heat pipe when ambient temperature is below 0℃.It can preheat the lubricant.

When ambient temperature is above 35℃,the manufacturer should take heat balance calculation according to temperature offered by customer to decide whether the gear reducer is equipped with cooling system or not.

润滑油路示意图 Diagram of lubrication (Figure 3)



# LUBRICATION, COOLING AND HEATING

## 润滑与冷却、加热

齿轮和轴承均采用油池浸润和飞溅浸润。ZLYJ280及以上规格的轴承除飞溅润滑以外，还增加了油泵润滑系统强制循环供油润滑。

润滑油牌号为中级压齿轮油N220或其它粘度相似的优质润滑油。

**▲ 注:**

- 450以上规格齿轮泵用电机拖动。
- 电接点压力表按用户特殊要求另行配置。

**Attention:**

- Oil pumps mounted on gear reducers ranging from ZLYJ450 to ZSYJ630 are driven by motor.
- YTX pressure watch with some electric equipment which can control the pressure and sound alarm automatically is equipped according to customer's special demand.



# INSTALLATION, OPERATION & MAINTENANCE

## 安装使用和维护

· 减速器应安装在平整的基础上。在地脚螺钉均匀紧固的情况下，应保证插入输出轴中的螺杆能无卡滞地均匀回转，以免给输出轴与轴承增加附加力而影响轴承寿命。不得采用强力装拆螺杆。

420以上(含420)规格的减速器的动力输入只允许用联轴器输入动力。在安装时，应在地脚螺钉紧固的情况下，确保联轴器的安装误差不超过允许范围。不允许在未调平地脚支撑时，先对中联轴器、后紧固地脚螺钉，以免给输入轴造成过大的附加力矩。如用户确实需要采用三角带输入动力时，请在订货时明确提出此项要求!

375以下(含375)规格，允许用三角带输入动力。请尽量采用高强度窄V形带!且三角带轮应全部车削加工，回转平衡。高强度窄V带的使用，可减小张紧力并使用合力中心靠近输入轴内侧。对减小作用于前承支点外侧截面的附加弯矩十分有利。三角带在初装时，三角带紧边中点在2~3公斤外力下压，以产生8~10mm变形量为宜。

由于硬齿面减速器的中心距较小，无法配置较大的轴承，轴颈也较细。联轴器的对中和三角带的张紧是否符合上述要求，将会直接影响输入轴和轴承，以至整机的寿命!

· 在减速器安装完毕后，注润滑油至油镜中心上部。该油位应在润滑油在箱内分布均匀后确定，减速器运转后，油位应经常检查，任何情况下，油位不应低于油镜位置中心下部。首次使用300~600小时后，应换油一次。以后每3000小时换油一次。更换应在减速器停车，润滑油尚未冷却时排放。箱体应用同品质的油冲洗干净。若因油粘度

高不宜冲洗可先加热。

在有强制润滑的抽路中，配置有功能极先进完善的TF型箱外自封式吸油过滤器。该滤清器具有以下功能：(1)打开前盖，拆下滤芯时，内装的自封阀自行关闭，切断油路，防止油池中存油外流。(2)带有绿、黄、红三色的发讯器，可随时显示滤芯堵塞状态(绿——通畅，黄——局部堵塞，红——较严重堵塞)。当出现较严重堵塞时，发讯器会发出讯号(请将发讯器两输出线端接人报警线路)，提醒用户停机清洗或更换滤芯。(3)在发讯后用户仍不清洗，滤芯堵塞后，滤清器中的旁路自行打开，润滑油将不经过滤芯循环。

按用户特殊要求配置的电接点压力表，可监控油泵的工作状态。当油泵损坏，油路停止供油，电接点压力表失压时，压力表会有电信号输出。此时控制电路会自动报警，切断电源，停机检修，以免轴承缺油而烧损。

在电机控制回路中，设置延时继电器，以保证电机正常启动。

电接点压力表，在出厂前，已把下压指针调至0.3~0.4Mpa处(上压指针不用调整)，在运行一段时间后，因因油热而粘度下降，可能油压会下降，影响正常工作。此时松开表座一侧的锁紧螺母。用螺丝刀调整调压螺钉(旋入)，使油压升高。在调高压力后请锁紧螺母。以上所述的报警控制电路，皆需用户自行配置。本设备只提供可输出电讯号的相关元件

· 装有油泵强制润滑的减速器，在开车初始阶段，可能会因油粘度过，油泵吸油阻力大而造成进油不足，发出过高的噪声。该现象一般在润滑油温度升高后，自行消失。

在正常运转中，如出现油泵噪声增高，一般情况可能

· The gear reducer should be fixed on the flat base. After ground screws are tightened uniformly, the screw-rod inserted into the output shaft must run smoothly so that there is no additional force acting on bearings mounted on output shaft to reduce their service lives. Assembling or disassembling the bolt in violent force is not permitted.

Power must be transferred to the gear reducer ranging from ZLYJ240 to ZSYJ 630 by shaft coupling. Installation error of the shaft coupling is assured not to exceed permitted range after ground screws are tightened. It is not right to install a shaft coupling ahead of tightening ground screws when the base is not flat. If you do like this, input shaft will be burdened with an additional torque. Please tell us your demand in your order if you do need v-belt to transfer power.

It is possible for reducers from ZLYJ133 to ZLYJ375 to be equipped with V-belt. We recommend you high strength narrow v-belt. The corresponding sheave must be turned to turn round balance. Use of this kind of v-belt can reduce tension force and make centre of join force close to input shaft inside, which will decrease additional torque acting on cross-sections outside of front bearing fulcrum. If middle point of tight side of v-belt is pressed by force ranging from 2-3kg, it will become out of shape ranging from 8-10mm.

It is impossible for hard surface gear reducer to be equipped with large bearing and axis because of its short

是油路阻力过大。此时情况请清洗滤清器及其他相关部件。

无论那种规格的减速器，在长期不用或气温过低时启动使用，都应空车运转一段时间，待各轴承处充分润滑后方可加载运转。

centre distance. Input shaft and bearings service lives are up to installation of shaft coupling and tension of v-belt introduced above.

· Fill the recommended oil to gearbox until the oil level is up to upper line of oil gauge. The oil level is assured after lubricant is uniform in gearbox and it should always be checked up. Under no circumstance will oil level be low to the lower line of oil gauge. The first oil change must be made after about 300 to 600 hours of operation. Subsequent oil changes must be carried out every 3000 hours of operations oil change is made only after reducer stop working and lubricant is still warm. The oil to clean gearbox is same as lubricant. If this oil is not suitable for cleaning for its high viscosity, it can also be preheated.

In forced lubrication system, there is a TF self-closing oil filter with excellent performance. The oil filter has so many functions as following. (1) When you open front lid and disassemble oil filter wick to clean, self-closing valve inside filter will close of itself to cut off oil line preventing oil in sump from flowing. (2) Signal generator with green, yellow, red three colors can show at any time what condition oil filter wick is in. (green-unobstructed, yellow-partial obstructed, red-seriously obstructed). When it is in seriously obstructed, the signal generator will signal the user to stop the reducer to clean or change filter wick (please connect output terminals of generator to alarm circuit). (3) If the user does not clean wick after seeing the signals, a bypass in oil filter will be in work. The oil will not

pass the wick.

Pressure watch installed according to customer's special requirement can monitor oil pump. When there is something wrong with oil pump, no oil is supplied and pressure watch is out of pressure, pressure watch will give out electrical signals. At this time, the control circuit will sound the alarm automatically, cut off power, and remind users of repair to protect bearing from being harmed for lack of lubricant.

In order to stop pressure watch from cutting off power because of no enough pressure at beginning in circuit, we suggest you set a time-delay relay in control circuit to ensure motor's successful starting.

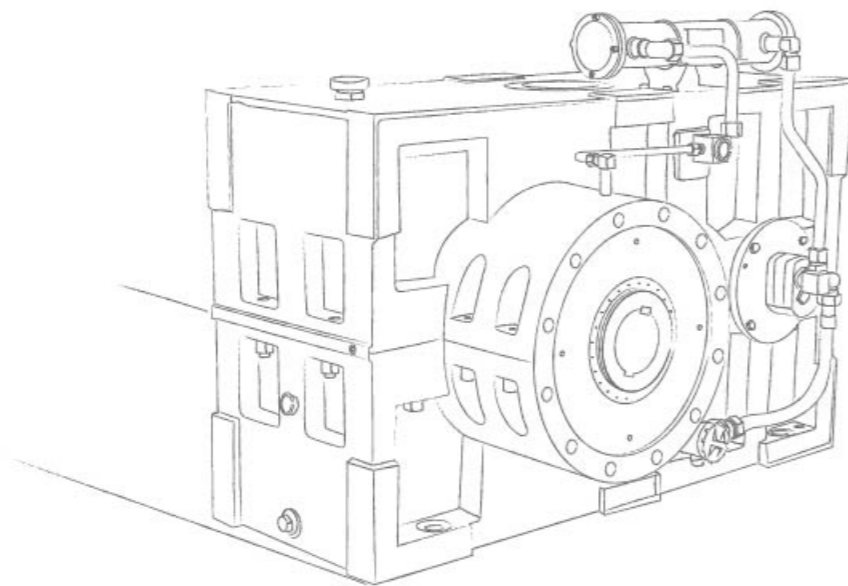
The pressure watch's lower pressure pointer has been adjusted to pressure covering from 0.3 to 0.4 Mpa before it is delivered to customer (upper pressure doesn't need modulating). Oil pressure may become lower than usual after hours of operation because oil viscosity decrease caused by oil heat. At this time, you should loose the nut at one side of

watch base to modulate the screw which can control the pressure with screwdriver (to drive in) for higher oil pressure, and then you must tighten the nut. The alarm circuit introduced above is fixed by customers themselves. Our equipment only supplies components which can give out electrical signals.

- The gear reducer with oil pump forced lubrication may have a lot of noise at beginning of running because there is not adequate input oil caused by high viscosity, high resistance of absorption of oil. But this phenomenon will disappear when lubricant temperature rises.

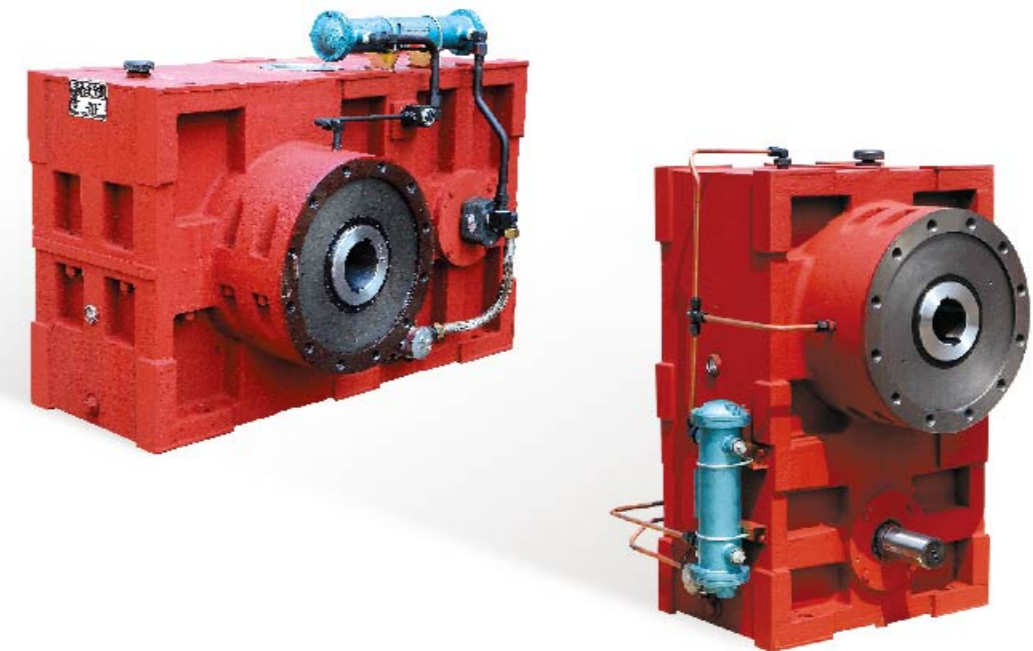
If there is still loud noise in oil pump after reducer running a long time, you should clear oil filter and some other components concerned because of high resistance in oil line.

If ambient temperature is low or it is not used for a long time, the gear reducer must run without any load for some time until all bearings are lubricated fully.



# JIANGYIN GEARBOX

INDUSTRIAL GEAR TRANSMISSION SOLUTION PROVIDER



Jiangyin Gearbox Manufacturing Co.,Ltd.  
江阴齿轮箱制造有限公司

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