Introduction

Taconite seals may be used in high dust operating environments. They use a grease purging system to prevent outside contaminants from entering the speed reducer/gearmotor. Figure 1 below details the taconite seal assembly as utilized in the 4-Series Bevel Buddybox.

![Taconite Seal Assembly](image)

**Figure 1: Taconite Seal Assembly**

Procedure

Please follow these instructions to maintain lubrication of the Taconite Seal system:

a. Unless otherwise specified, the Taconite output seals are each packed with NLGI #2 EP mineral grease prior to unit shipment from the factory location.

b. **Grease does not need to be added to the seals prior to unit start-up.**

c. Add grease to the seals according to the guidelines indicated in Table 1. Refer to Table 2 for recommended greases.

<table>
<thead>
<tr>
<th>Output Shaft RPM</th>
<th>Hours of Operation</th>
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<tbody>
<tr>
<td>&gt;200</td>
<td>5,000</td>
</tr>
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</table>

Please note that a highly contaminated environment may require a more frequent lubrication cycle.

d. If the unit will not be operated for a period greater than 6 months, apply a thin layer of grease to the outside surface of the seals to prevent dry-out. Before starting the unit, check the seals’ integrity and replace if required. If seal replacement is required, purge and add grease to the newly installed seals prior to unit operation.
Procedure (Continued)

e. If the unit will not be operated for a period greater than 6 months, apply a thin layer of grease to the outside surface of the seals to prevent dry-out. Before starting the unit, check the seals' integrity and replace if required. If seal replacement is required, purge and add grease to the newly installed seals prior to unit operation.

f. Units may be equipped with either a spring loaded grease relief fitting, or a plug in the grease purge port.
   - If your unit has a plug, begin by removing the plug.
   - While rotating the reducer shafts to ensure even grease distribution, slowly add grease until new grease begins to come out of the grease purge port. **NOTE: Rotate shafts by hand in this process. Exercise caution in rotating shaft in order to avoid injury.**
   - Wipe away excess grease and reinstall plug if necessary.

Table 2: Recommended NLGI#2 Mineral Greases

<table>
<thead>
<tr>
<th>Grease</th>
<th>BP</th>
<th>Castrol</th>
<th>Chevron/Texaco</th>
<th>Exxon/Mobil</th>
<th>Shell</th>
<th>Total</th>
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<tbody>
<tr>
<td>Food Grade</td>
<td></td>
<td></td>
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