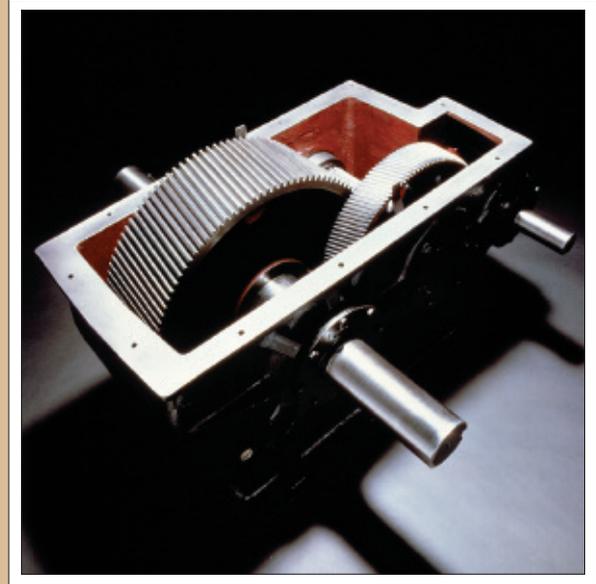
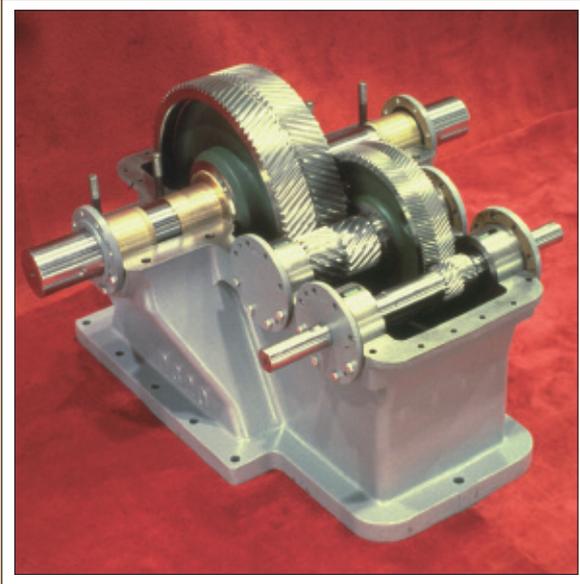


LUFKIN

GEAR REDUCER AND LUBRICATION DATA



Lufkin designed and manufactured herringbone gears (double helical) have proven to be the standard of excellence for pumping unit gear reducers. Herringbone gears are less sensitive to misalignment and resist torque reversals better than other types of gears. Heavy-duty sleeve bushings on the crankshaft and straight roller bearings on the high speed and intermediate shafts need no adjustment at assembly or when field service is required. The nodular iron gears with high strength alloy pinion used by most manufacturers of pumping units were pioneered by Lufkin in 1951. The rugged two-piece housing is manufactured specifically for oilfield pumping applications.

Churchill's precision-cut helical gears are encased in a strong, heavy-walled, cast-iron gear reducer housing. For smaller, beam balanced pumping units, these gear reducers are the most economical and reliable available. Incorporated into the high speed end of the gear reducer is Churchill's unique StepDown™ design, which minimizes shaft deflection and improves proper gear meshing. Positive lubrication of the heat treated, nodular gears and steel alloy pinions is ensured by a wiper-type system. A built-in sight gauge allows immediate visual inspection of the oil level in the gear reducer housing. All tapered roller bearing cups are mounted in bearing carriers, a unique configuration which minimizes field replacement time and also prevents damage to the housing should a bearing fail.

Lufkin Gear Reducer Data

Gear Reducer Size	Peak Torque Rating (in. lbs.)	Gear Ratio	Crankshaft Diameter Conventional / Mark II (inches)	Sheave Bore Dia. (inches)	Sheave Options		Gear Reducer Oil Capacity (gallons)
					Belt Section / Pitch Dia.** (inches)	Belt Section / Pitch Dia.** (inches)	
2560D	2,560,000	34.53:1	11.75	6.50	12D / 55, 68	-	235
1824D	1,824,000	28.33:1	9 / 10.5	4.94	10D / 55, 68	-	165
1280D	1,280,000	28.05:1	8.5 / 10.5	4.94	8D / 35, 68	10C / 36 , 68	120
912D	912,000	28.72:1	7 / 9*	4.19	6D / 33 , 40 , 48 , 55.2	8C / 50 , 55.2	107
640D	640,000	28.60:1	7 / 9	3.44	5D / 22 , 27 , 33 , 48 , 55.4	6C / 24 , 36 , 44 , 50 , 55.6	70
456D	456,000	29.04:1	7 / 9	3.44	4D / 22 , 27 , 33 , 48	6C / 24 , 36 , 44 , 50	55
320D	320,000	30.12:1	6.44 / 8.5	2.94	-	5C / 24 , 30 , 36 , 44 , 47	50
228D	228,000	28.45:1	6 / 7	2.44	-	4C / 24 , 30 , 36 , 41	34
160D	160,000	28.67:1	5.44 / 7	2.19	-	3C / 20 , 24 , 30 , 36 , 38	22
114D	114,000	29.40:1	4.44 / 6.44	1.94	-	2C / 20 , 24 , 30 , 33.6	17
80D	80,000	29.40:1	4.44	1.94	-	2C / 20 , 24 , 30 , 33.6	17
57D	57,000	29.32:1	4	1.94	3B / 20 , 25 , 27.6	2C / 20 , 24 , 27	13

* 10.5 for 912DS Mark II

** **Bold Face** type indicates standard size sheave. All other sizes are available for a nominal fee.

Lufkin Double Reduction Gear Reducers

All Lufkin gear reducers have been designed to exceed API and AGMA specifications. Lufkin is authorized to display the API monogram and is licensed under specification 11E. Lufkin precision-cut, herringbone gears are encased in a strong, heavy-walled, cast-iron gear reducer housing. Operating in an oil bath ensures positive lubrication of the heat-treated, nodular gears and steel alloy pinions. An oil wiper system continuously supplies oil to the bearings. An oil gauge dip stick allows easy inspection of the oil level in the gear reducer housing. Special features of these rugged oilfield reducers include:

- Horizontally split gear housing designed for easy field maintenance
- Precision-cut Lufkin herringbone gears
- All shafts made from alloy steel, heat treated and precision turned to tight tolerances
- Four oversized bronze bushings on crankshafts that seldom require replacement
- Positive lubrication system (no oil pumps required)
- Intermediate and high speed roller bearings.



Lubrication Instructions

Gear Reducer. For temperatures down to 0°F, use an AGMA No. 5EP (ISO VG 220) premium mild extreme pressure lubricant (preferably a sulphur-phosphorous type) with rust and oxidation inhibitors and an anti-foam agent. Pour point of the oil should be 5°F or lower. For temperatures down to -30°F, use an AGMA No. 4 EP (ISO VG 150) premium mild extreme pressure lubricant (preferably sulphur-phosphorous type) with rust and oxidation inhibitors and an anti-foam agent. Pour point of the oil should be -15°F or less. Do not use multi-viscosity oils.

If desired, units can be shipped with the gear reducer filled with oil that complies with the above specifications.

To obtain long life from a pumping unit reducer, it is necessary that the oil be of suitable viscosity and free from foreign material, sludge and water. Check for possible dirt, sludge, water emulsion or other forms of contamination every six months, or when the reducer has been exposed to flooding. If the lubricant has an abnormal appearance or smell, consider replacement.

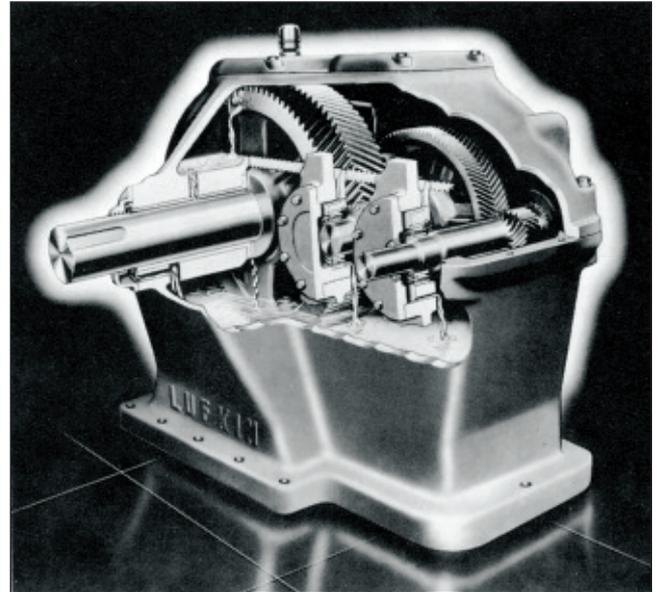
Structural Bearings. All structural bearings are lubricated at the factory. However, structural bearings do require periodic relubrication.

In **warm climates** (lowest annual temperature above 0°F), roller bearings (except tapered roller crank pin bearings) should be lubricated every six months. Use a premium NLGI No. 1 lithium soap base grease with an extreme pressure additive and a base oil viscosity equivalent to AGMA No. 7 (414-506 cSt. at 40°C). Do not use soda soap grease.

Bronze bearings and tapered roller crank pin bearings should be lubricated as required to maintain oil level. Use an EP140 extreme pressure oil with an extreme pressure additive and a pour point of +15°F or lower. If available, the use of a heavier oil (viscosity up to 6600 SUS at 100°F) is recommended.

In **cold climates** (lowest annual temperature down to -30°F), roller bearings (except tapered roller crank pin bearings) should be lubricated every six months. Use a premium NLGI No. 0 lithium soap base grease with an extreme pressure additive and a base oil viscosity equivalent to AGMA No. 5 (198-242 cSt. at 40°C). Do not use soda soap grease.

Bronze bearings and tapered roller crank pin bearings should be lubricated as required to maintain oil level by removing the fill plug and adding oil until the reservoir is full. Use EP80 or EP90 extreme pressure oil with an extreme pressure additive and a pour point of -10°F or lower.



As long as the oil is maintained at the proper level, the slow speed and high speed gears dip in oil and provide continuous lubrication to the gear mesh. Large oil wipers direct a flood of oil into oversized oil troughs which in turn provide each individual bearing with more than adequate lubrication above five SPM.



Consistent lubrication is essential even at low speed operation (below 5 SPM). This can be accomplished with the addition of optional high speed gear wipers for reducer sizes 912 and below. High speed gear wipers are standard equipment on reducer sizes 1280 and above.

Churchill Gear Reducer Data

Gear Reducer Size	Peak Torque Rating (in. lbs.)	Gear Ratio	Sheave Pitch Dia. (inches)	Sheave Belt Section	Gear Reducer Oil Capacity (gallons)	Gear Design	Crankshaft Bearings	Intermediate & High Speed Bearings
B-114	114,000	30:48:1	20, 24, 30	3-C	9	Double Helical	Tapered Roller	Cylindrical Roller
B-80	80,000	30.06:1	24	4-B, 3-C	13	Helical	Tapered Roller	Tapered Roller
B-57	57,000	31.57:1	24	4-B, 3-C	13	Helical	Tapered Roller	Tapered Roller
B-50	50,000	31.11:1	18.4	3-B	4	Helical	Tapered Roller	Tapered Roller
B-40	40,000	31.11:1	18.4	3-B	4	Helical	Tapered Roller	Tapered Roller
B-25	25,000	31.14:1	18.4	2-B	2	Helical	Tapered Roller	Tapered Roller

Churchill Helical Gear Reducers

Lufkin's Churchill brand gear reducers are also designed to exceed API and AGMA specifications. The precision-cut helical gears are encased in a heavy-walled cast-iron housing built to the same rugged standards as the larger Lufkin units. All tapered roller bearing cups are mounted in bearing carriers. This unique configuration minimizes field replacement time and prevents damage to the housing should a bearing fail. Special features include:

- Unique StepDown™ housing design, which minimizes shaft deflection and improves proper gear meshing.
- Positive lubrication by integral wiper system
- Built-in oil level sight gauge
- Precision-cut Lufkin helical gears
- All shafts made from high grade steel, heat treated and precision turned to tight tolerances

Lubrication Instructions

The proper care and lubrication of your Churchill brand pumping unit will assure many trouble-free years of operation.

Gear Reducer. For temperatures down to 0°F, use an AGMA No. 5EP (ISO VG 220) premium mild extreme pressure lubricant (preferably a sulphur-phosphorous type) with rust and oxidation inhibitors and an anti-foam agent. Pour point of the oil should be 5°F or lower. For temperatures down to -30°F use an AGMA No. 4 EP (ISO VG 150) premium mild extreme pressure lubricant (preferably a sulphur-phosphorous type) with rust and oxidation inhibitors and an anti-foam agent. Pour point of the oil should be -15°F or less. Do not use multi-viscosity oils.

If desired, units can be shipped with the gear reducer filled with oil that complies with the above specifications.

To obtain long life from a pumping unit reducer, it is necessary that the oil be of suitable viscosity and free from foreign material, sludge and water. Check for possible dirt, sludge, water emulsion or other forms of contamination every six months, or when the reducer has been exposed to flooding. If the lubricant has an abnormal appearance or smell, consider replacement.

Structural Bearings. All structural bearings are lubricated at the factory prior to shipment. However, structural bearings do require periodic relubrication.

The center, equalizer and crank pin bearings, in warm climates (lowest annual temperature above 0°F), should be lubricated with a premium NLGI No. 1 lithium soap base grease with an extreme pressure additive and a base oil viscosity equivalent to AGMA No. 7 (414-506 cSt. at 40°C). In cold climates (lowest annual temperature down to -30°F), use a premium NLGI No. 0 lithium soap base grease with an extreme pressure additive and a base oil viscosity equivalent to AGMA No. 5 (198-242 cSt. at 40°C). Do not use soda soap grease.

Each bearing assembly has a ground level grease fitting for easy lubrication with a grease gun. The bearing assemblies should be lubricated at six month intervals. In some environments, more frequent lubrication may be required.

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Fax: 281/875-4236
www.lufkin.com

ORDERING INSTRUCTIONS AND WARRANTIES



ORDERING INSTRUCTIONS

To size and/or order a Lufkin pumping unit, contact the nearest Lufkin representative or sales office. When ordering replacement parts, be sure to include the unit model number, unit serial and order number, a complete part description and, if known, the casting number or part number.

LIMITED WARRANTY*

ALL NEW LUFKIN INDUSTRIES, INC. ("LUFKIN") oilfield machinery and equipment ("products") are sold by LUFKIN or its dealer upon the following warranty and agreement given by LUFKIN or its authorized dealer. THE WARRANTIES SET FORTH ARE EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES AND CONDITIONS WHETHER STATUTORY, EXPRESS OR IMPLIED, INCLUDING WARRANTIES OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, AND WARRANTIES ARISING FROM COURSE OF DEALING, USAGE, OR TRADE and are exclusive and in lieu of any other obligation on the part of LUFKIN or its authorized dealer. LUFKIN neither assumes nor authorizes any person to assume for it any other liability in connection with the sale of such products. The obligation of LUFKIN or its authorized dealer under this warranty, is limited to the following:

LUFKIN warrants to the ORIGINAL PURCHASER ("PURCHASER") of the pumping unit, subject to the conditions herein stated, that the pumping unit shall be, upon delivery, free from manufacturing defects. This Warranty shall run for a period of five (5) years from the date of shipment from LUFKIN's plant. In the event the pumping unit fails to operate properly due to a manufacturing defect (or) a manufacturing defect is discovered during the warranty period, LUFKIN shall only be obligated to repair or replace the pumping unit, at LUFKIN's option, free of charge, F.O.B. LUFKIN's plant, or other designated place of repair or replacement. Repair or replacement by LUFKIN shall not extend the warranty period. LUFKIN will have no liability under this Warranty unless LUFKIN receives written notice from PURCHASER of the defect within thirty (30) days after discovery of the defect. LUFKIN may waive the requirement of written notice and accept oral notice of a timely reported defect. LUFKIN shall not be liable under this Warranty and this Warranty will be null and void if the pumping unit, or any part thereof, was damaged, subjected to abuse, altered, misused or if the pumping unit, or any part thereof was improperly stored, installed, maintained, repaired or operated. Repair or replacement of the pumping unit, or any part thereof, shall fulfill all obligations of LUFKIN. The Warranty provided in this paragraph is subject to the following exceptions.

LUFKIN's warranty is limited to one (1) year (subject to the terms and conditions stated above) with respect to parts that are subject to wear under normal operating conditions (including, but not limited to contact type oil or grease seals, hoses, belts, elastomeric parts, wireline, brake lining, brake cables, etc.).

LUFKIN extends no warranties with respect to the design of the pumping unit or the component parts, materials or accessories manufactured, furnished or supplied by individuals or entities other than LUFKIN (including, but not limited to prime movers, compressors, valves, electrical components, etc.). LUFKIN agrees that any warranty which is given to LUFKIN on such components by the manufacturer thereof shall be extended to the PURCHASER but only to the extent permitted by the terms of such warranties.

The remedies provided above are the exclusive remedies of PURCHASER for failure of LUFKIN to meet its warranty obligations, whether claims of PURCHASER are based on contract, in tort (including negligence) or otherwise. Upon expiration of the applicable warranty period, all obligations of LUFKIN for breach of warranty will terminate. The provisions of this Warranty shall be governed in accordance with the laws of the State of Texas.

Subject to and without waiving the foregoing, Purchaser agrees that neither LUFKIN, nor its affiliates, vendors, suppliers, agents, or subcontractors, either individually or jointly, shall be liable to PURCHASER, its affiliates, or any other person or entity whether due to LUFKIN's negligence or otherwise, and will not be responsible to PURCHASER in contract, in tort (including negligence) or otherwise for loss of use of equipment or plant, loss of profits or revenues, claims of any customers of PURCHASER, or any special, indirect, incidental or consequential loss of damage whatsoever. The obligation of LUFKIN arising out of the work performed hereunder, will be limited to remedies under the limited warranty set forth above. IN NO EVENT SHALL THE PURCHASER OR ANY OTHER PERSON OR ENTITY BE ENTITLED TO RECOVER FOR INDIRECT, SPECIAL, EXEMPLARY, INCIDENTAL OR CONSEQUENTIAL DAMAGES, INCLUDING BUT NOT LIMITED TO INCONVENIENCE, RENTAL OF REPLACEMENT EQUIPMENT, LOSS OF PROFITS OR OTHER COMMERCIAL OR ECONOMIC LOSS.

PURCHASER agrees to protect, defend, indemnify and save LUFKIN, its subcontractors and affiliates and their employees performing services under this Agreement harmless from and against all liabilities, loss, expense, claims, demands, and causes of action of every kind and character arising out of or in connection with this Agreement, or the work to be performed hereunder, without limit and without regard to the cause or causes of action thereof OR THE NEGLIGENCE OF ANY PARTY OR PARTIES, INCLUDING LOSSES ATTRIBUTABLE TO LUFKIN'S NEGLIGENCE, arising in connection herewith in favor of PURCHASER or third parties on account of bodily injury, death or damage to property.

PURCHASER agrees that whenever any representative of LUFKIN shall be on the premises of PURCHASER or at any place other than LUFKIN's facility, for the purpose of inspecting, repairing or servicing of the equipment sold herewith, the PURCHASER shall indemnify and hold LUFKIN harmless from all claims, suits or actions arising from or growing out of the inspecting, repairing or servicing of such equipment and from all expenses of defending against such claims, suits or actions.

PURCHASER acknowledges and agrees, on its own behalf and on the behalf of its assigns and successors, that the Texas Deceptive Trade Practices—Consumer Protection Act, Subchapter E of Chapter 17 of the Texas Business and Commerce Code (the "DTPA"), is not applicable to this transaction. As such, PURCHASER's and LUFKIN's rights and remedies with respect to this transaction, and with respect to all acts or practices of the other, past, present or future, in connection with this transaction, shall be governed by legal principles other than the DTPA. Accordingly, PURCHASER acknowledges and agrees as follows:

PURCHASER HEREBY IRREVOCABLY WAIVES, TO THE FULL EXTENT PERMITTED BY LAW, ANY AND ALL RIGHTS AND CLAIMS THAT PURCHASER MAY NOW HAVE, OR TO WHICH IT MAY OTHERWISE IN THE FUTURE HAVE BEEN ENTITLED, UNDER THE TEXAS DECEPTIVE TRADE PRACTICES—CONSUMER PROTECTION ACT, TEX. BUS. AND COM. CODE § 17.41 ET SEQ., ("DTPA"), ARISING OUT OF ANY ACT, CONDUCT, REPRESENTATION OR OMISSION OF LUFKIN, ITS EMPLOYEES OR AGENTS, HERETOFORE OR HEREAFTER TAKEN, DONE OR OMITTED TO BE DONE IN CONNECTION WITH THIS TRANSACTION OR SUBSEQUENT RELATED TRANSACTIONS.

*This Limited Warranty does not apply to the Churchill pumping unit or Lufkin Automation product lines. For information on the Churchill warranty, see page 40. For information on the Lufkin Automation warranty, refer to www.lufkinautomation.com.

SALES AND SERVICE LOCATIONS

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www.lufkin.com

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2500 Parker Lane
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*Also includes Lufkin Automation