



MOTOR MOUNTING INSTRUCTION

1

MOTOR APEX

Double-check the motor and gearbox size
Clean the mounting surface

2

APEX

Remove the plug on the adapter plate
Rotate the set collar till the bolt is line up

3

MOTOR

a

b

a Remove motor key
b Insert balance key, if necessary

4

APEX

Check motor shaft size and insert bushing if necessary

5

MOTOR APEX

1 2 3 4

Set at vertical position, tighten the mounting bolts (including washer) in 1~4 order with wrench to 5% specified torque (see table 1)

Correct Installation

When installing on flatted shafts, be sure to align the collet gap over the flat and the set collar bolt perpendicular to the flat

6

Tighten the set collar bolt with torque wrench to specified torque (see table 2)

7

MOTOR

1 2 3 4

Tighten the mounting bolts in 1~4 order with torque wrench to specified torque (see table 1)

8

Tighten back the screw plug

**MOTOR MOUNTING INSTRUCTION****Table 1** Tightening torque recommended for motor mounting bolt

| Bolt size | Width Across Flats | Strength 8.8 Tightening Torque | | Strength 10.9 Tightening Torque | | Strength 12.9 Tightening Torque | |
|-------------|--------------------|--------------------------------|----------|---------------------------------|----------|---------------------------------|----------|
| | [mm] | [Nm] | [In-lbs] | [Nm] | [In-lbs] | [Nm] | [In-lbs] |
| M3 x 0.5P | 2.5 | 1.3 | 12 | 1.8 | 16 | 2.1 | 19 |
| M4 x 0.7P | 3 | 3 | 27 | 4.1 | 37 | 4.9 | 44 |
| M5 x 0.8P | 4 | 6.1 | 55 | 8.2 | 73 | 9.8 | 87 |
| M6 x 1P | 5 | 11 | 98 | 14 | 124 | 17 | 151 |
| M8 x 1.25P | 6 | 25 | 222 | 34 | 302 | 41 | 364 |
| M10 x 1.5P | 8 | 49 | 434 | 67 | 594 | 80 | 709 |
| M12 x 1.75P | 10 | 85 | 753 | 116 | 1028 | 139 | 1232 |
| M14 x 2P | 12 | 137 | 1214 | 186 | 1648 | 223 | 1976 |
| M16 x 2P | 14 | 210 | 1860 | 286 | 2534 | 343 | 3038 |

Table 2 Tightening torque recommended for set collar bolt

| Gearbox size | | Motor shaft diameter | Bolt size | Width across flats | Tightening torque | |
|-------------------------|---------|----------------------|-------------------|--------------------|-------------------|------|
| | | [mm] | | | [mm] | [mm] |
| AB042 AF042 AE050 | 1-stage | ≤ 11 | M3 x 0.5P x 8L | 2.5 | 2.1 | 19 |
| | 2-stage | ≤ 11 | M3 x 0.5P x 8L | 2.5 | 2.1 | 19 |
| AB060 AF060 AE070 | 1-stage | ≤ 14 | M4 x 0.7P x 12L | 3 | 4.9 | 44 |
| | 2-stage | ≤ 11 | M3 x 0.5P x 8L | 2.5 | 2.1 | 19 |
| AB090 AF075 AE090 | 1-stage | ≤ 19 | M5 x 0.8P x 14L | 4 | 9.8 | 87 |
| | 2-stage | ≤ 14 | M4 x 0.7P x 12L | 3 | 4.9 | 44 |
| AB115 AF100 AE120 | 1-stage | ≤ 32 | M6 x 1P x 16L | 5 | 17 | 151 |
| | 2-stage | ≤ 19 | M5 x 0.8P x 14L | 4 | 9.8 | 87 |
| AB142 AF140 AE155 | 1-stage | ≤ 38 | M8 x 1.25P x 20L | 6 | 41 | 364 |
| | 2-stage | ≤ 32 | M6 x 1P x 16L | 5 | 17 | 151 |
| AB180 AF180 AE205 | 1-stage | ≤ 48 | M10 x 1.5P x 25L | 8 | 80 | 709 |
| | 2-stage | ≤ 38 | M8 x 1.25P x 20L | 6 | 41 | 364 |
| AB220 AF220 AE235 | 1-stage | ≤ 55 | M12 x 1.75P x 30L | 10 | 139 | 1232 |
| | 2-stage | ≤ 48 | M10 x 1.5P x 25L | 8 | 80 | 709 |

Note: Holding torques must be bigger than values shown above. Bolts can be tightened up to 20% higher for increased holding torques.

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