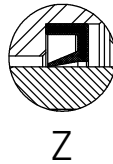
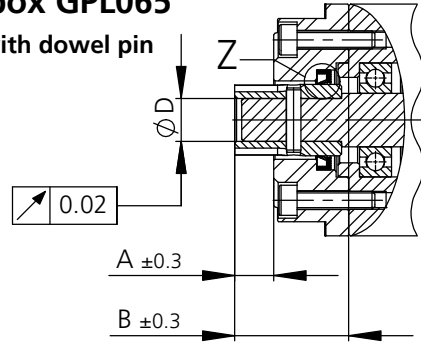


## Assembly instructions Planetary Gearbox GPL065

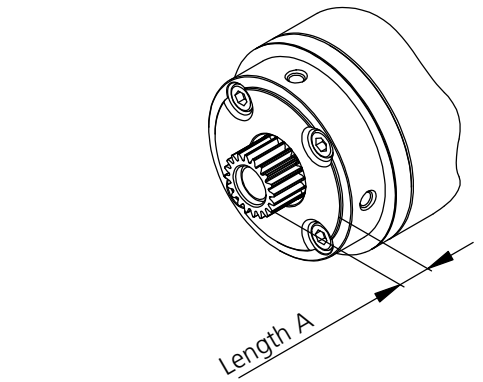
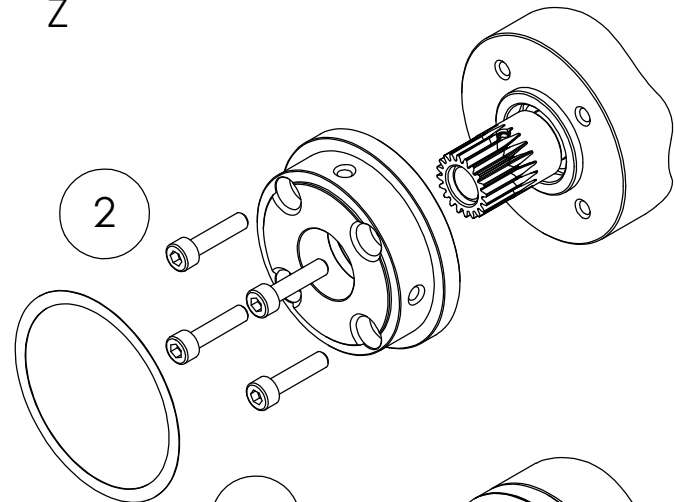
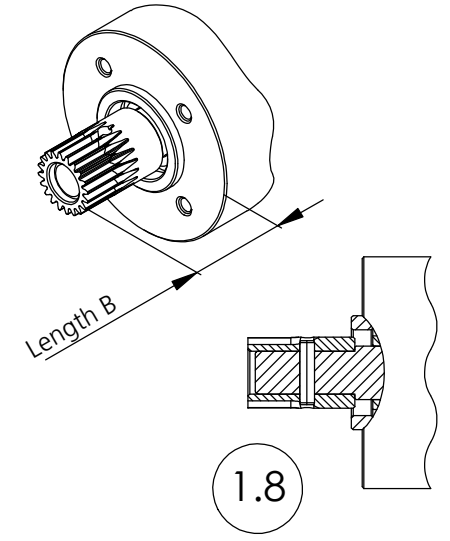
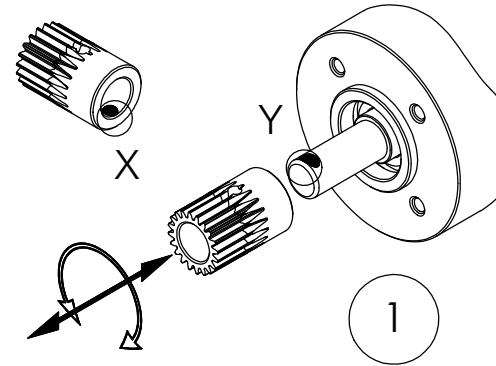
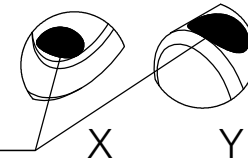
### 1. Glue motor pinion onto motor shaft and secure with dowel pin

Recommended adhesive: LOCTITE 638

- 1.1. Verify concentricity of motor shaft
  - Maximum concentricity of the motor shaft: 0.02mm
- 1.2. Verify fit of motor shaft to pinion bore
  - Tolerance of bore of pinion: H7
  - Optimal play shaft to bore: 0.01- 0.03mm
  - Maximum play shaft to bore: 0.06mm
- 1.3. Observe the mounting dimensions
  - Length **A** with adapter plate
    - Single stage: **13 ±0.3mm**
    - Multiple stage: **11 ±0.3mm**
  - Length **B** without adapter plate
    - Single stage: **34 ±0.3mm**
    - Multiple stage: **32 ±0.3mm**
- 1.4. Clean and degrease motor shaft and motor pinion
  - Assemble only parts that are completely free of grease
  - Please observe the instructions and specifications of the adhesive manufacturer
- 1.5. Application of adhesive onto motor shaft and motor pinion
  - Apply adhesive into pinion bore and onto motor shaft
  - See detail X and detail Y
- 1.6. Motor pinion installation
  - Install pinion under continuous rotary and longitudinal motion onto motor shaft to evenly distribute the adhesive onto shaft and bore.
  - Apply additional adhesive if required
  - Following the distribution of the adhesive install the motor pinion in accordance with the applicable mounting dimension
- 1.7. Curing of adhesive bond
  - Please observe the specification of the adhesive manufacturer
  - Keep the motor in horizontal position during curing
  - Observe and await firmness of bond before continuing
  - Firmness of Loctite 638 is achieved after approximately 15 to 30 min under optimal conditions
  - Remove excess adhesive from motor shaft and bore if applicable
- 1.8. Secure motor pinion with dowel pin
  - Gear teeth must not be damaged
  - Support the motor with motor pinion during drilling and installation of dowel pin
  - Drill the motor shaft from both sides. The motor pinion is pre-drilled
  - Pin must not protrude after installation



Drop of adhesive on the motor shaft and inside of the pinion bore



### 2. Assembly of accessories

- 2.1. Insert radial shaft seal ring (optional) into adapter plate
  - Observe direction of installation. See detail Z
  - Apply a small amount of gear grease onto surface of motor pinion
- 2.2. Mount the adapter plate to the motor. Secure with screws
- 2.3. Install one piece paper gasket onto adapter plate

### 3. Assembly of Gearbox to Motor

- 3.1. Mount gearbox carefully onto motor
- 3.2. Secure gearbox with supplied screws (M5x12 ISO 14581) to adapter plate

### 4. Gearbox run-in

- 4.1. Run the gearbox assembly at no load for 15 min for optimal distribution of the lubrication

