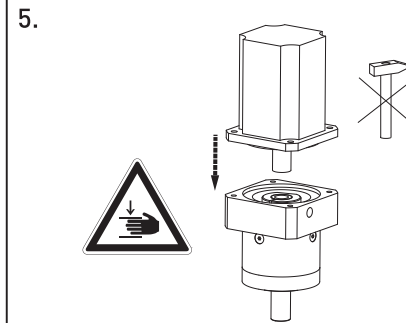
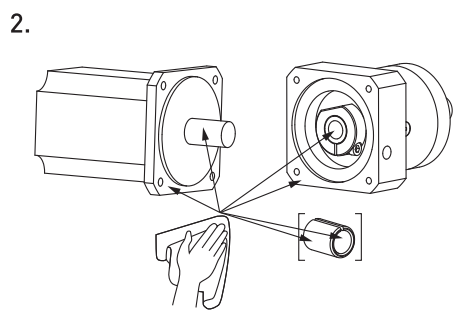


**(EN)** Check the correctness of the motor and gearbox according to the technical documentation.

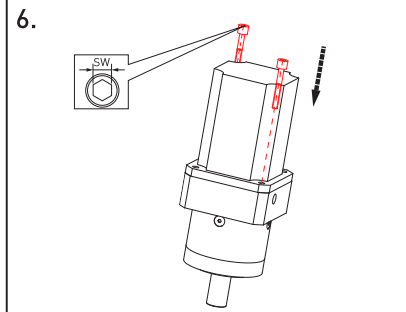


**(EN)** Motor mounting preferred in vertical position, fit the motor in the gearbox.



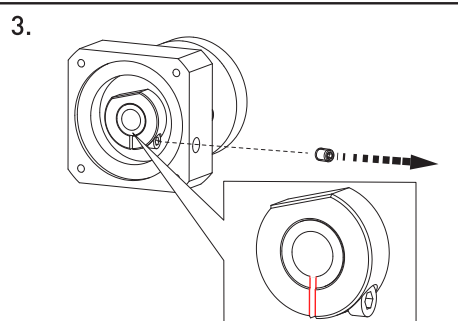
**(EN)** Remove all corrosion inhibitor. We recommend a petroleum hydrocarbon based cold cleaner.

Clean grease free, rectify and damage.

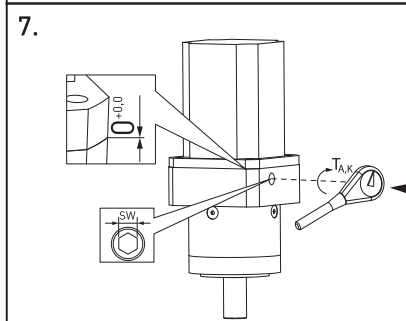


**(EN)** After fitting the motor into the gearbox, use the screws specified in the technical documentation.

Two screws tighten crosswise.



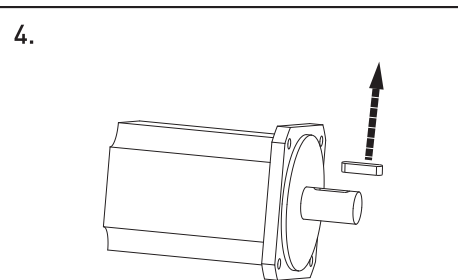
**(EN)** Remove cover screw, adjust position of clamping screw.



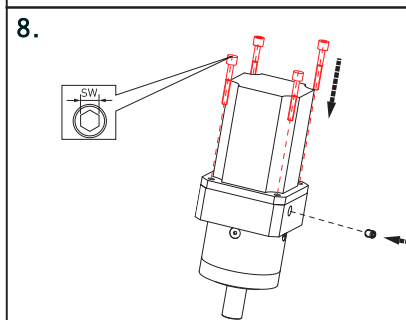
**(EN)** After tightening the screws, check that the motor flange is properly seated against the gearbox flange.

Tighten clamping ring with  $T_{A,K}$  tighten cover screw.

The size of the hex socket head screw SW is defined on page 2.



**(EN)** If the motor has a feather key, remove it.

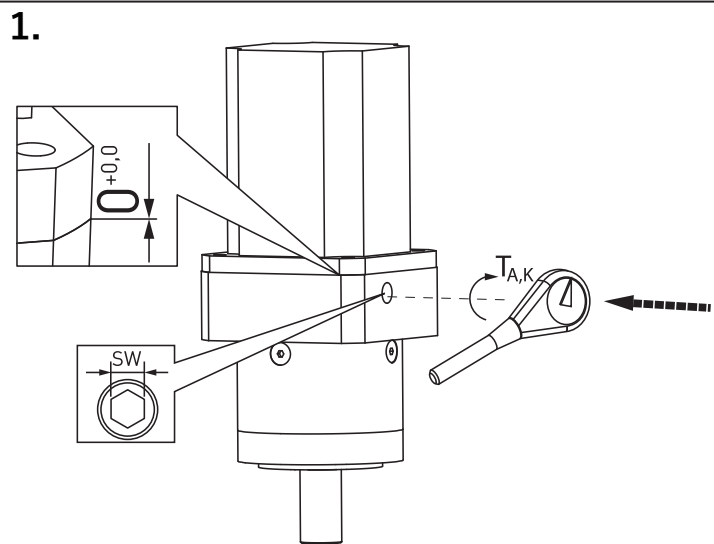


**(EN)** Loosen the two screws tightened in a crosswise.

Apply Loctite 243 to the threads of all four screws and then tighten all screws crosswise using a torque wrench.

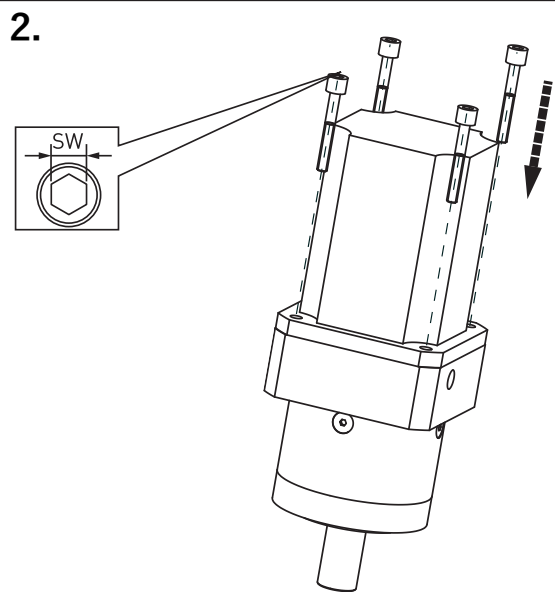
The size of the hex socket head screw SW is defined on page 2.

Apply Loctite 243 to the threads of the cover screw and tighten.



## Screw torque specifications for gearboxes clamping rings

Gearboxes series	040, 050		055, 060, 064, 070		080, 090		110, 115, 120, 140			142, 155, 160, 190, 200			
$T_{A,K}$ (Nm)	2	4,5	4,5	9,5	9,5	16,5	9,5	16,5	40	9,5	16,5	40	75
SW (mm)	2,5	3	3	4	4	5	4	5	6	4	5	6	8



## Screw torque specifications for motor and gearbox flange

SW (mm)	Screw tightening torque by strength grade
	Steel 8.8 (stainless steel A2/A4 70-80)
3	1,3 Nm
4	2,9 Nm
5	5,7 Nm
6	9,9 Nm
7	16,0 Nm
8	26,0 Nm
10	54,0 Nm
12	93,0 Nm
16	—