

## Assembly Instructions Planetary Gearbox GPL016

### 1. Glue motor pinion onto motor shaft

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 motor pinion

- Tolerance of bore of pinion: H8
- Optimal play shaft to bore: 0.01- 0.02mm
- Maximum play shaft to bore: 0.06mm

#### 1.3. Observe the mounting dimensions

- Length **A** with adapter plate: **3 ±0.1mm**
- Length **B** without adapter plate: **7.2 ±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 specification of the adhesive manufacturer

#### 1.5. Application of adhesive onto motor shaft and motor pinion

- Apply a drop of adhesive into bore and onto motor shaft
- See detail X and detail Y
- Drop size approximately 0.5-1 mm

#### 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

### 2. Assembly of accessories

2.1. Mount the adapter plate to the motor. Secure with screws

### 3. Assembly of Gearbox to Motor

3.1. Mount gearbox carefully onto motor

### 4. Gearbox run-in

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

