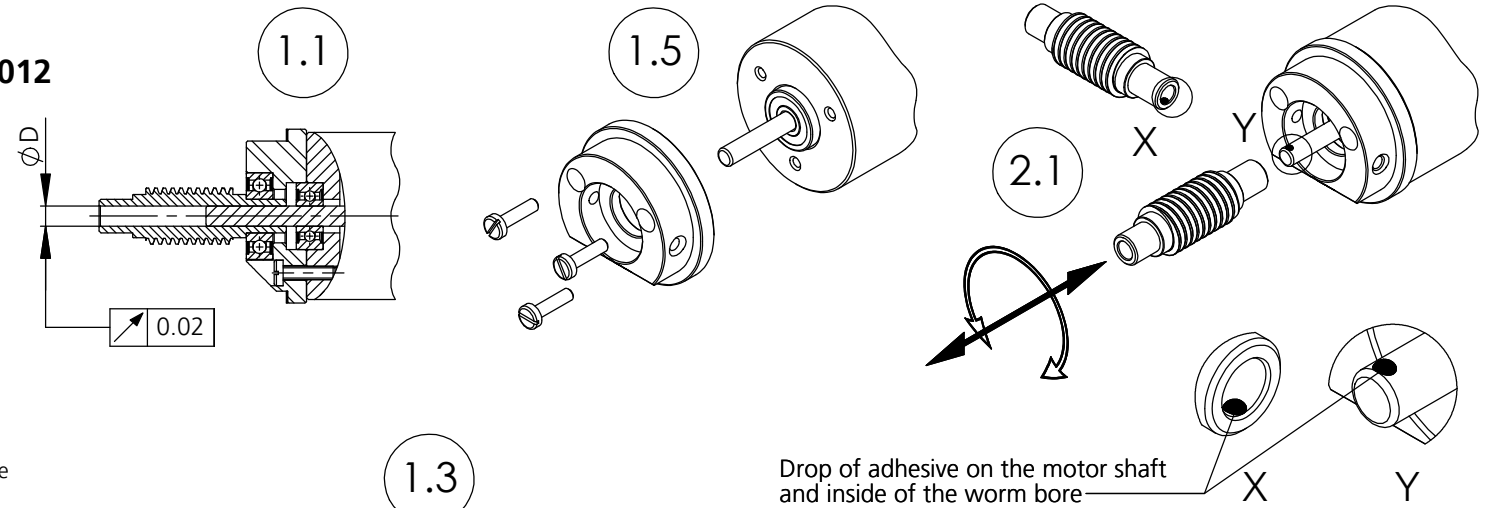


Assembly Instructions Worm Gearbox GSR012

1. Preparation for gluing the worm

Recommended adhesive: LOCTITE 638

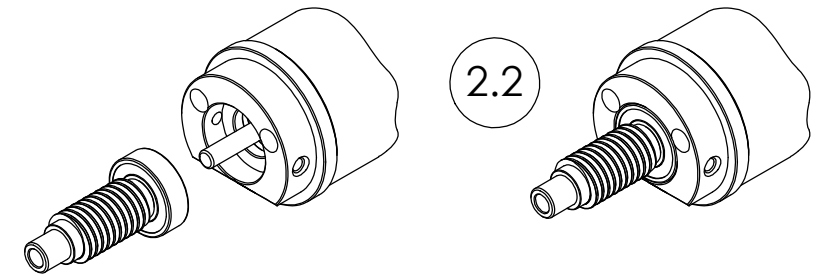
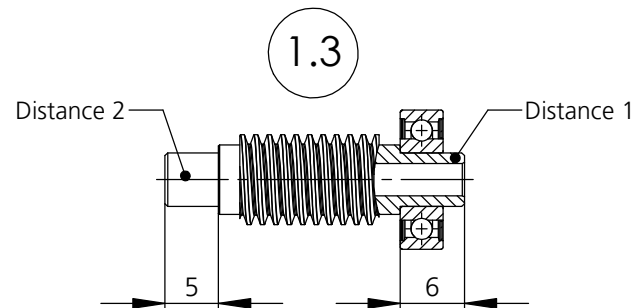
- 1.1. Verify concentricity of motor shaft
 - > Maximal concentricity of the motor shaft: 0.02mm
- 1.2. Verify fit of motor shaft to worm
 - > Tolerance of bore of worm: H8
 - > Optimal play shaft to bore: 0.01- 0.02mm
 - > Maximum play shaft to bore: 0.06mm
- 1.3. Observe direction of installation of the worm
 - > Motor side: Distance 1 of the worm: 6mm
 - > Gearbox side: Distance 2 of the worm: 5mm
- 1.4. Clean and degrease motor shaft and worm
 - > Assemble only parts that are completely free of grease
 - > Please observe the instructions and specifications of the adhesive manufacturer
- 1.5. Mount the adapter plate to the motor. Secure with screws
 - > Do not touch motor shaft
 - > Do not install paper gasket at this point



2. Glue worm onto motor shaft

- 2.1. Application of adhesive onto motor shaft and worm
 - > Apply a drop of adhesive onto bore and onto motor shaft
 - > See detail X and detail Y
 - > Drop size approximately 0.5- 1mm
- 2.2. Worm installation
 - > Temporarily insert worm under continuous rotary and longitudinal motion onto motor shaft to evenly distribute the adhesive onto shaft and bore.
 - > Apply additional adhesive if required. See 2.1
 - > Following the distribution of the adhesive, install ball bearing onto worm
 - > Install the worm with ball bearing even onto motor
- 2.3. 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



3. Assembly of gearbox

- 3.1. Install one piece paper gasket onto adapter plate
- 3.2. Mount gearbox carefully with motor
- 3.3. Secure gearbox with supplied screws (M2.5x6 ISO 14581) to adapter plate

4. Gearbox run-in

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

