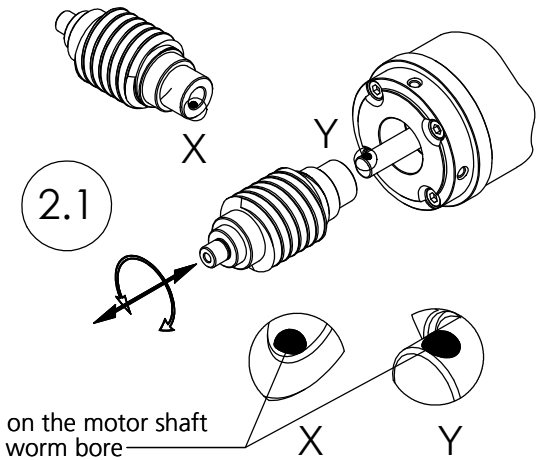
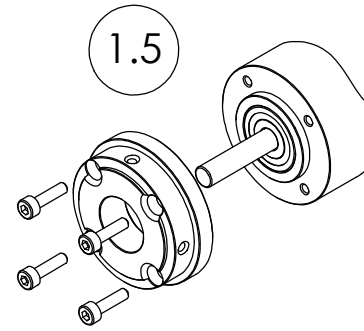
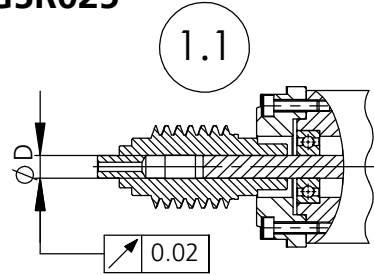


## Assembly Instructions Worm Gearbox GSR025

### 1. Preparation for gluing the worm

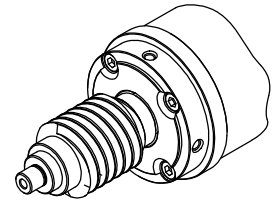
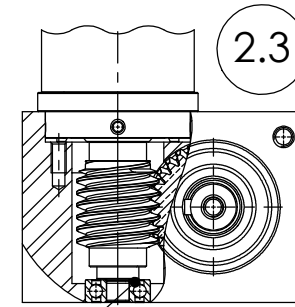
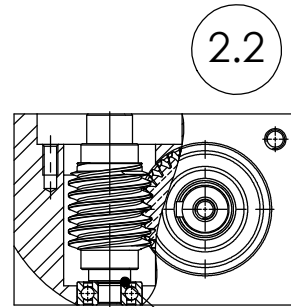
Recommended adhesive: LOCTITE 638

- 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: H7
  - > Optimal play shaft to bore: 0.01- 0.02mm
  - > Maximum play shaft to bore: 0.06mm
- 1.3. Observe installation position of the worm
  - > Installation position without adapter plate: See 2.2
- 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



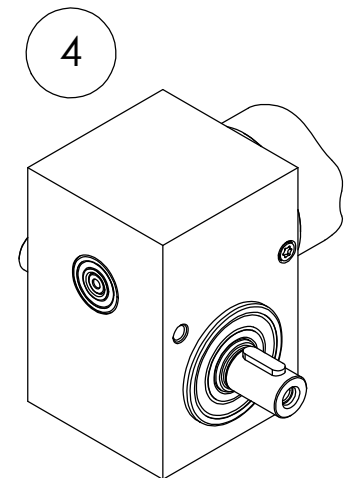
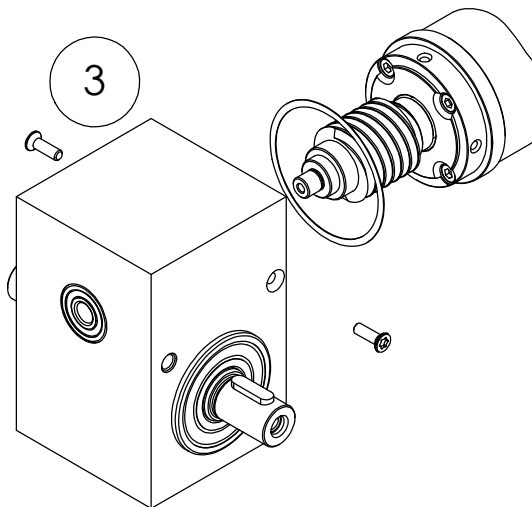
### 2. Glue worm onto motor shaft

- 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 1- 2mm
- 2.2. Worm installation
  - > Install 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, position the worm into the ball bearing and insert the motor into the gearbox housing
- 2.3. Curing of adhesive bond
  - > Please observe the specification of the adhesive manufacturer
  - > Keep the motor in vertical 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. Remove motor from housing
- 3.2. Install one piece paper gasket onto adapter plate
- 3.3. Mount gearbox carefully with motor
- 3.4. Secure gearbox with supplied screws (M3x10 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