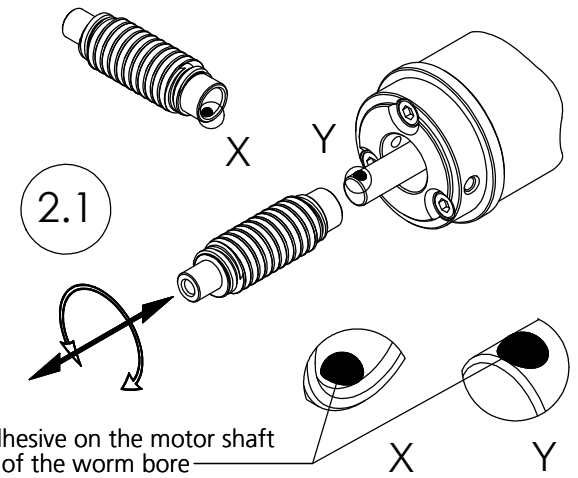
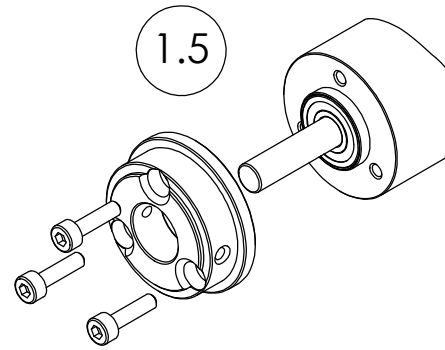
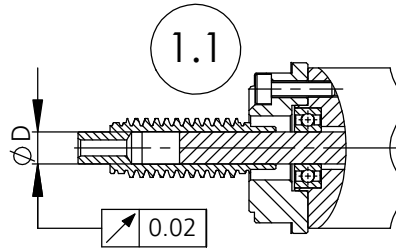


Assembly Instructions Worm Gearbox GSR017

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

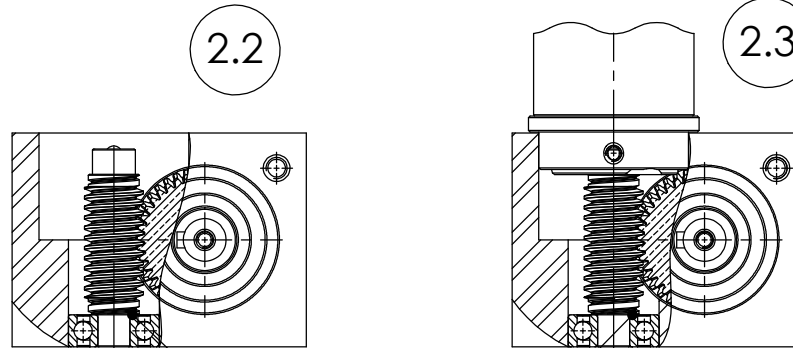


Drop of adhesive on the motor shaft and inside of the worm bore

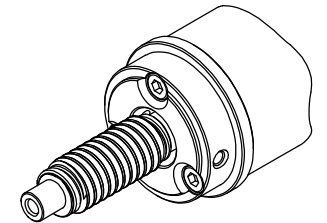
2. Glue worm onto motor shaft

- 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

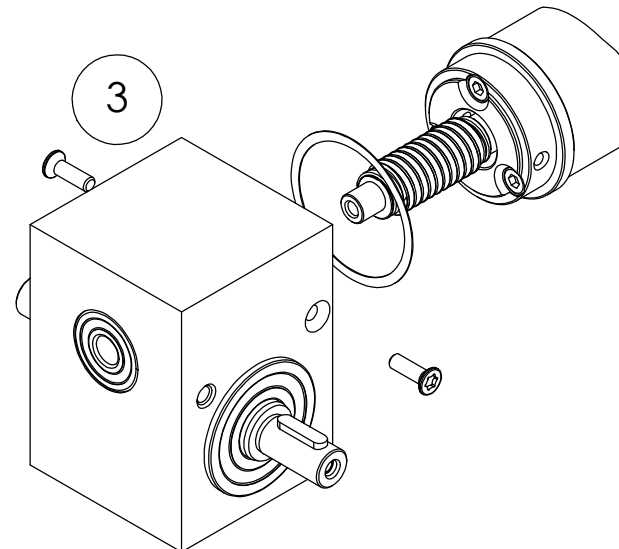


Worm align to ball bearing



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

