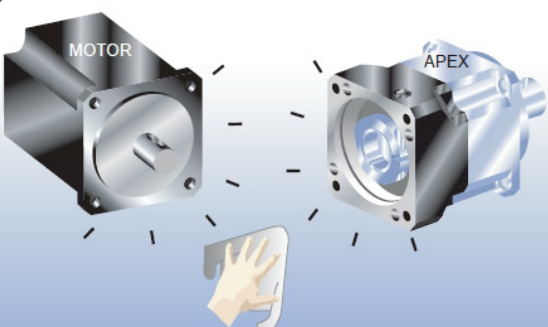


# Motor mounting instruction AFX series

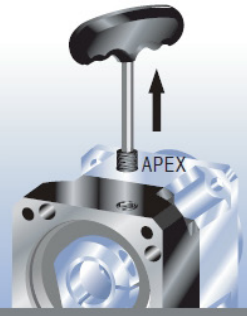
**1**



MOTOR APEX

Double-check the motor and gearbox size.  
Clean the mounting surface

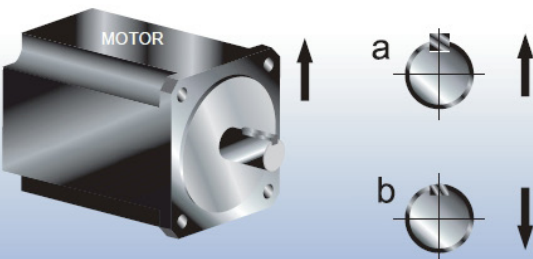
**2**



APEX

Remove the plug on the adapter plate.  
Rotate the set collar till the bolt lines up.

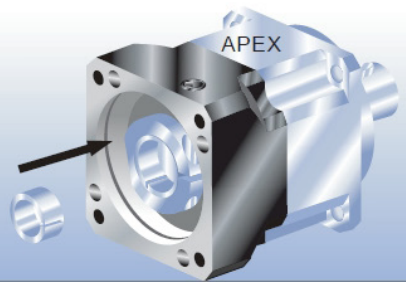
**3**



MOTOR

a. Remove the motor key  
b. Insert balance key if necessary


**4**



APEX

Check motor shaft size and insert bushing if necessary

**5**



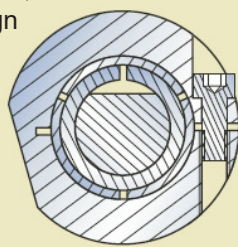
MOTOR APEX

2 3 1 4

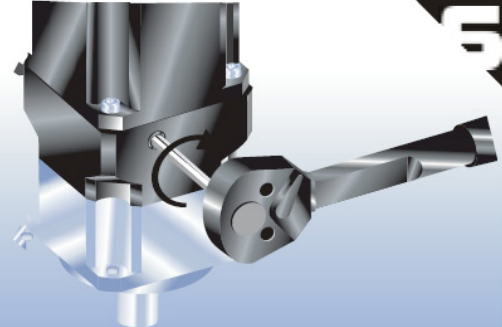
Set at vertical position, tighten the mounting bolts (including washer) in 1 - 4 order with wrench to 5% specified torque (see table 1)

**Correct Installation**

When installing on flatted shafts, be sure to align the collet gap over the flat and the set collar bolt perpendicular to the flat

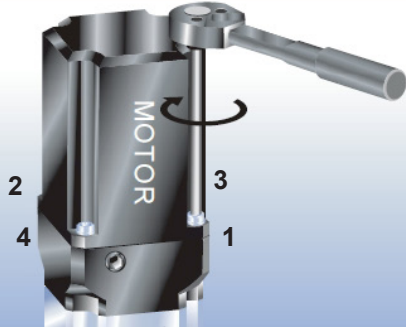


**6**



Tighten the set collar bolt with torque wrench to specified torque (see table 2)

**7**

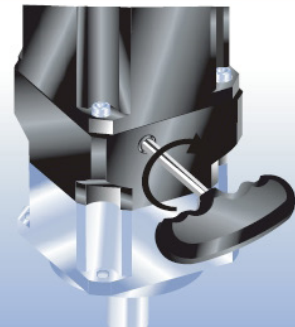


MOTOR

2 3 1 4

Tighten the mounting bolts in 1 - 4 order with torque wrench to specified torque (see table 1)

**8**



Tighten back the screw plug



**Table 1** Tightening torque recommended for motor mounting bolt

| Bolt size   | Width across flat | Strength 8.8 Tightening torque |          | Strength 10.9 Tightening torque |          | Strength 12.9 Tightening torque |          |
|-------------|-------------------|--------------------------------|----------|---------------------------------|----------|---------------------------------|----------|
|             | [mm]              | [Nm]                           | [In-lbs] | [Nm]                            | [In-lbs] | [Nm]                            | [In-lbs] |
| M3 x 0.5P   | 2.5               | 1.3                            | 12       | 1.8                             | 16       | 2.1                             | 19       |
| M4 x 0.7P   | 3                 | 3                              | 27       | 4.1                             | 37       | 4.9                             | 44       |
| M5 x 0.8P   | 4                 | 6.1                            | 55       | 8.2                             | 73       | 9.8                             | 87       |
| M6 x 1P     | 5                 | 11                             | 98       | 14                              | 124      | 17                              | 151      |
| M8 x 1.25P  | 6                 | 25                             | 222      | 34                              | 302      | 41                              | 364      |
| M10 x 1.5P  | 8                 | 49                             | 434      | 67                              | 594      | 80                              | 709      |
| M12 x 1.75P | 10                | 85                             | 753      | 116                             | 1028     | 139                             | 1232     |
| M14 x 2P    | 12                | 137                            | 1214     | 186                             | 1648     | 223                             | 1976     |
| M16 x 2P    | 14                | 210                            | 1860     | 286                             | 2534     | 343                             | 3038     |

**Table 2** Tightening torque recommended for set collar bolt

| Gearbox size |         | Motor shaft diameter | Bolt size         | Width across flats | Tightening torque |          |
|--------------|---------|----------------------|-------------------|--------------------|-------------------|----------|
|              |         | [mm]                 | [mm]              | [mm]               | [Nm]              | [In-lbs] |
| AFX042       | 1-Stage | ≤ 11                 | M3 x 0.5P x 8L    | 2.5                | 2.1               | 19       |
|              | 2-Stage | ≤ 11                 | M3 x 0.5P x 8L    | 2.5                | 2.1               | 19       |
| AFX060       | 1-Stage | ≤ 14                 | M4 x 0.7P x 12L   | 3                  | 4.9               | 44       |
|              | 2-Stage | ≤ 11                 | M3 x 0.5P x 8L    | 2.5                | 2.1               | 19       |
| AFX060A      | 2-Stage | ≤ 14                 | M4 x 0.7P x 12L   | 3                  | 4.9               | 44       |
| AFX075       | 1-Stage | ≤ 19                 | M5 x 0.8P x 14L   | 4                  | 9.8               | 87       |
|              | 2-Stage | ≤ 14                 | M4 x 0.7P x 12L   | 3                  | 4.9               | 44       |
| AFX075A      | 2-Stage | ≤ 19                 | M5 x 0.8P x 14L   | 4                  | 9.8               | 87       |
| AFX100       | 1-Stage | ≤ 32                 | M6 x 1P x 16L     | 5                  | 17                | 151      |
|              | 2-Stage | ≤ 19                 | M5 x 0.8P x 14L   | 4                  | 9.8               | 87       |
| AFX100A      | 2-Stage | ≤ 32                 | M6 x 1P x 16L     | 5                  | 17                | 151      |
| AFX140       | 1-Stage | ≤ 38                 | M8 x 1.25P x 20L  | 6                  | 41                | 364      |
|              | 2-Stage | ≤ 32                 | M6 x 1P x 16L     | 5                  | 17                | 151      |
| AFX140A      | 2-Stage | ≤ 38                 | M8 x 1.25P x 20L  | 6                  | 41                | 364      |
| AFX180       | 1-Stage | ≤ 48                 | M10 x 1.5P x 25L  | 8                  | 80                | 709      |
|              | 2-Stage | ≤ 38                 | M8 x 1.25P x 20L  | 6                  | 41                | 364      |
| AF220        | 1-Stage | ≤ 55                 | M12 x 1.75P x 30L | 10                 | 139               | 1232     |
|              | 2-Stage | ≤ 48                 | M10 x 1.5P x 25L  | 8                  | 80                | 709      |

**Note:** Bolts can be tightened up to 20% higher for increased holding torques

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