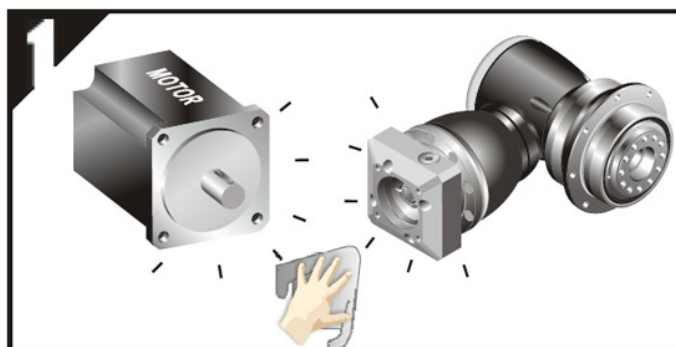
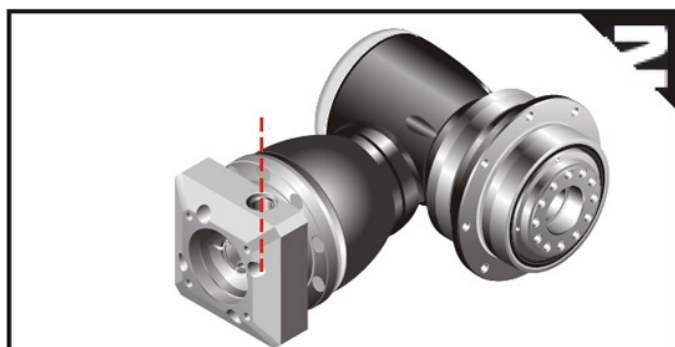




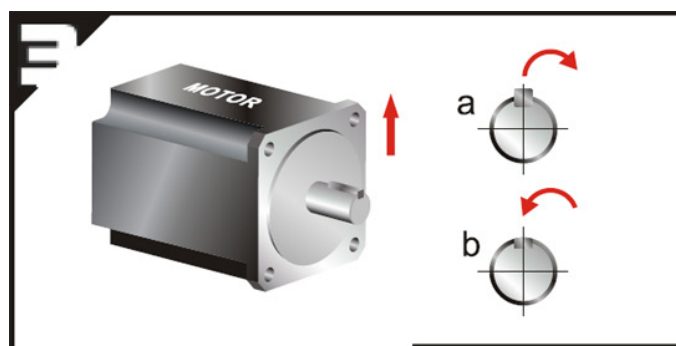
# Motor mounting instruction AHKA series



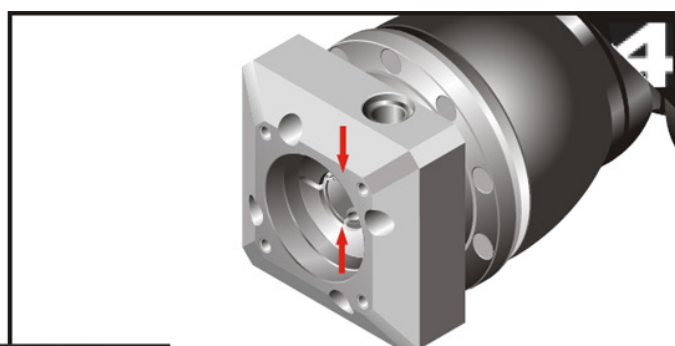
1 Double-check the motor and gearbox size.  
Clean the mounting surface



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



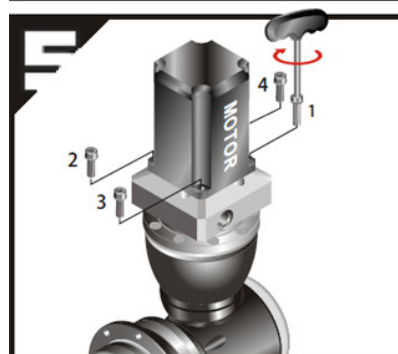
3 a. Remove the motor key  
b. Insert balance key if necessary



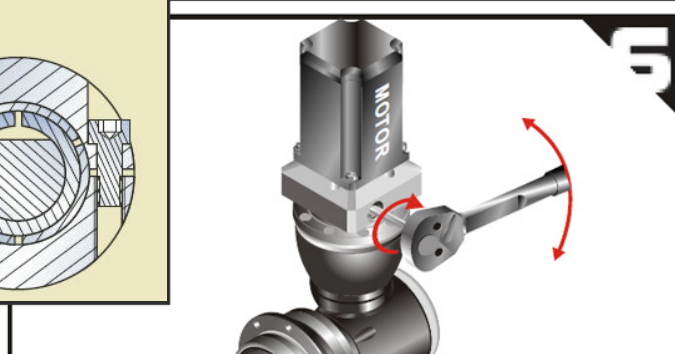
4 Check motor shaft size and insert bushing if necessary

**Correct Installation**

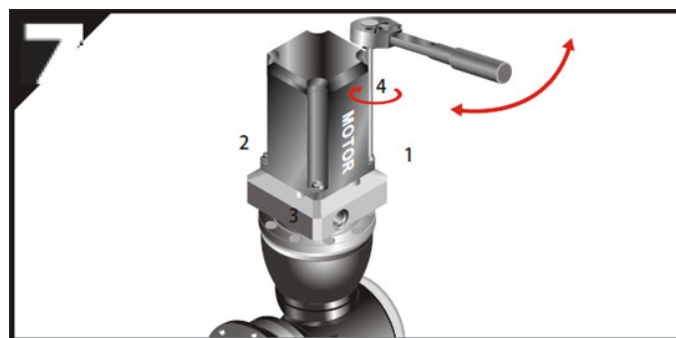
When installing on flatted shafts, be sure to align the collet gap over the flat and the set collar bolt perpendicular to the flat



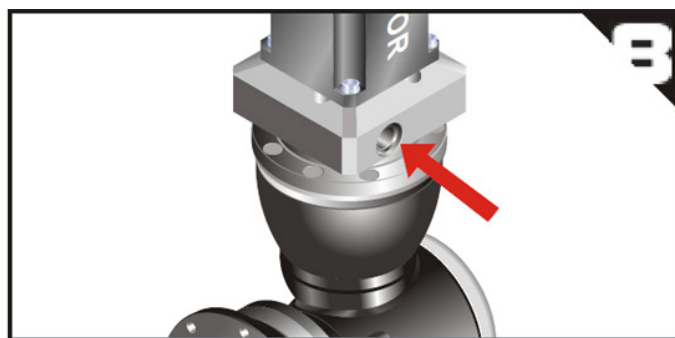
5 Set at vertical position, tighten the mounting bolts (including washer) in 1 - 4 order with wrench to 5% specified torque (see table 1)



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



7 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		8	11	14	19	24	28	32	35	38	42	48	55
AHKA285	3-Stage	-	-	-	-	-	-	M10	M12	M12	M12	M16	-
AHKA355	3-Stage	-	-	-	-	-	-	M10	M12	M12	M12	M16	-
AHKA450	3-Stage	-	-	-	-	-	-	-	M12	M12	M12	M16	M16

Bolt size	[mm]	M5 x 0.8P	M6 x 1P	M8 x 1.25P	M10 x 1.5P	M12 x 1.75P	M16 x 2P
Width across flats	[mm]	4	5	6	8	10	14
Tightening Torque	[Nm]	9.8	17	41	80	139	343
	[In-lbs]	87	151	364	709	1232	3038

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

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