



Motor mounting instruction PFI 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

5

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 3)

7

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

8

Tighten back the plug

9

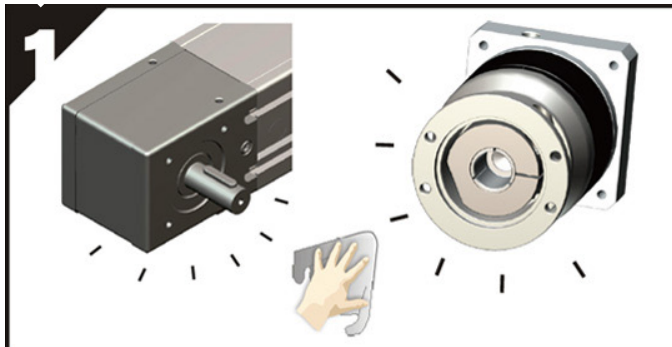
Tighten the mounting bolts in 1 - 4 order with torque wrench to specified torque (see table 1)

10

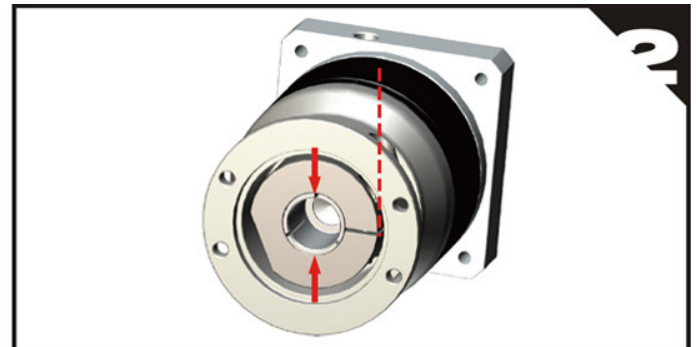
Tighten back the plug



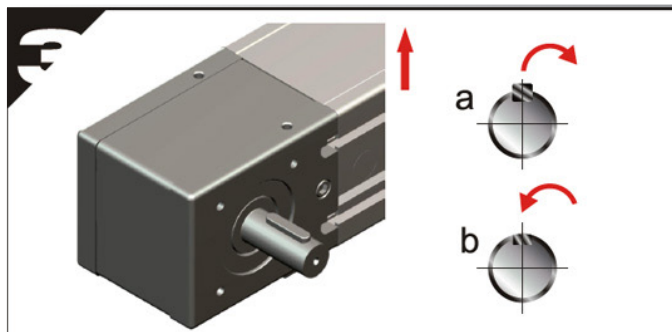
Mounting Gearbox to Actuator PFI series



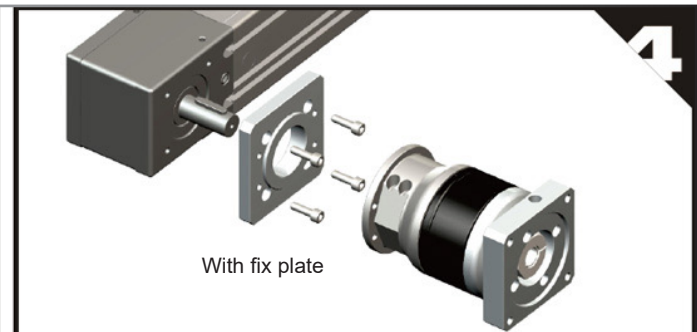
1 Double-check the actuator and gearbox size and spec, Clean the both mounting surface.



2 Rotate the set collar till the bolts line up with hole. Check actuator shaft size and insert bushing if necessary.



3 a. Remove actuator key.
b. Insert balance key if necessary.

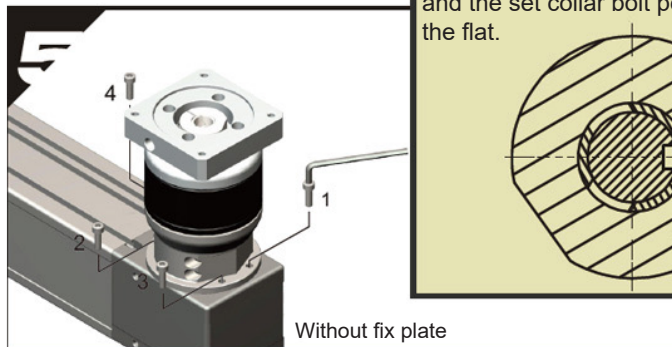


With fix plate

4 a. Clean the fix plate surface, secure the fix plate to the actuator. Tighten the bolts as noted in Table 1, step to follow 6.
b. Without fix plate, step to follow 5.

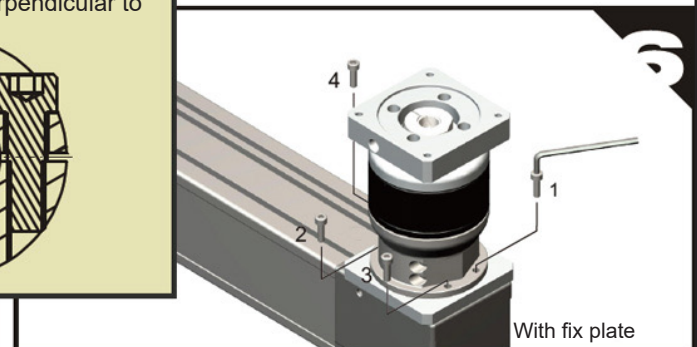
Correct installation

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



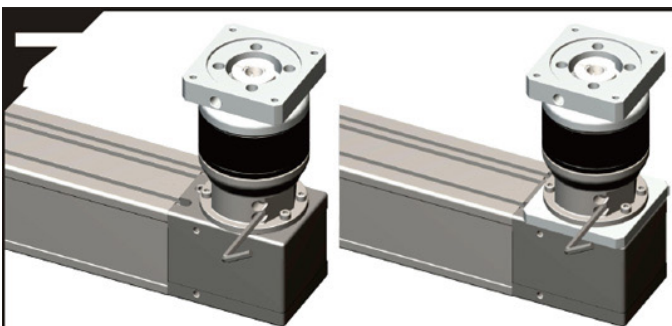
Without fix plate

5 Set at vertical position. Tighten the mounting bolts (including washer) on following order(1 to 4) with wrench to 5% specified torque.(Please refer to Table 1)

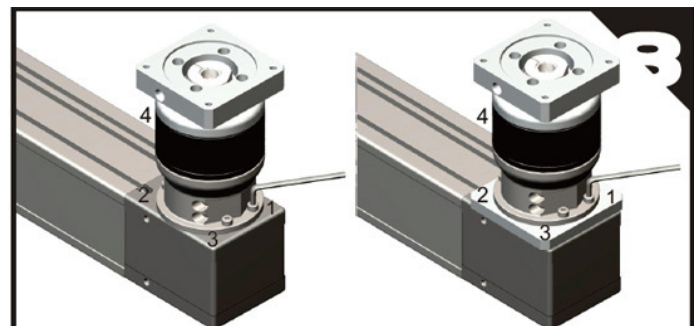


With fix plate

6 Set at vertical position. Tighten the mounting bolts (including washer) on following order(1 to 4) with wrench to 5% specified torque.(Please refer to Table 1)



7 Tighten the two set collar bolts alternately, with torque wrench to specified torque.(Please refer to Table 3)



8 Tighten the mounting bolts with following order(1 to 4) by torque wrench to specific torque.(Please refer to Table 1)

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

Tabel 2 Tightening Torque Recommended for Output Set Collar Bolt

Gearbox size	Bolt size	Width across flats	Tightening torque	
	[mm]	[mm]	[Nm]	[In-lbs]
PFII070	M5 x 0.8P x 16L	4	9.8	87
PFII090	M6 x 1P x 20L	5	17	151
PFII120	M8 x 1.25P x 25L	6	41	364

Table 3 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]
PFII070	≤ 8	M5 x 0.8P x 16L	4	9.8	87
	≤ 11	M5 x 0.8P x 16L	4	9.8	87
	≤ 14	M5 x 0.8P x 16L	4	9.8	87
	≤ 19	M8 x 1.25P x 25L	6	41	364
PFII090	≤ 14	M5 x 0.8P x 16L	4	9.8	87
	≤ 19	M8 x 1.25P x 25L	6	41	364
	≤ 24	M8 x 1.25P x 25L	6	41	364
	≤ 28	M8 x 1.25P x 25L	6	41	364
PFII120	≤ 19	M8 x 1.25P x 25L	6	41	364
	≤ 24	M8 x 1.25P x 25L	6	41	364
	≤ 28	M8 x 1.25P x 25L	6	41	364
	≤ 32	M10 x 1.5P x 25L	8	80	709
	≤ 35	M10 x 1.5P x 25L	8	80	709
	≤ 38	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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