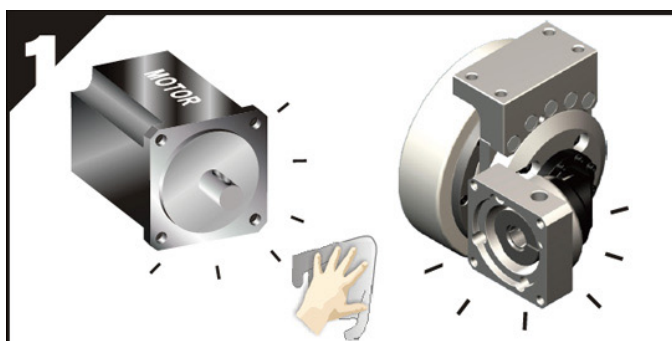
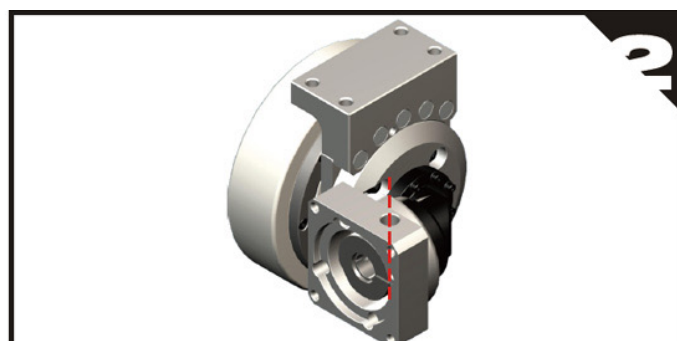


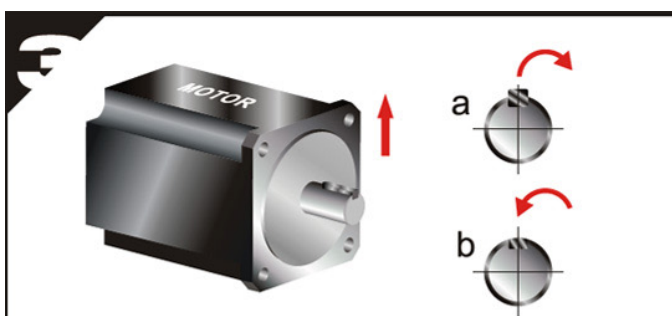
# Motor mounting instruction GVR series



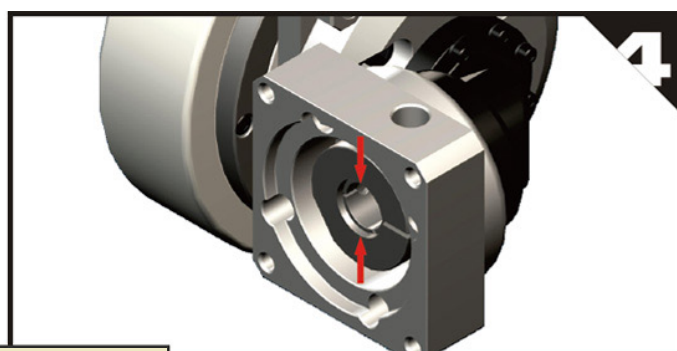
Double-check the motor and gearbox size.  
Clean the mounting surface



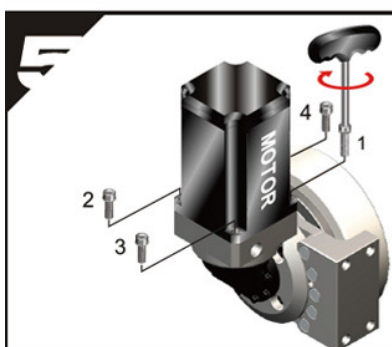
Rotate the set collar till the bolt line up with plug hole.



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



Check motor shaft size and insert bushing if necessary

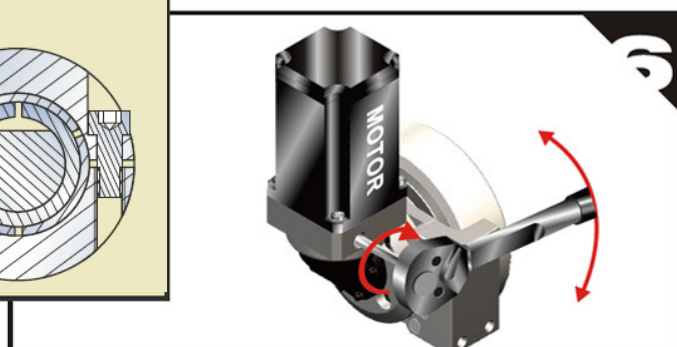
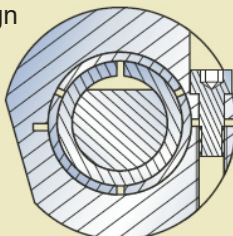


Set at vertical position. Tighten the mounting bolts (including washer) on following order(1 to 4) with wrench to 5% specified torque.(Please refer to Table 1)

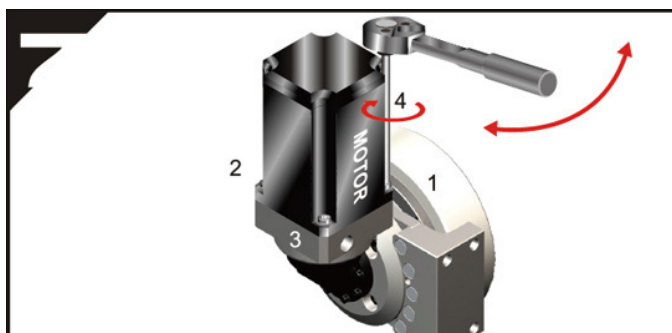


## Correct Installation

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



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



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



Insert the plug



Table 1 Tightening torque recommended for motor mounting bolt

| Bolt size   | Width across flat | Strength 8.8<br>Tightening torque |          | Strength 10.9<br>Tightening torque |          | Strength 12.9<br>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] |
| GVR098       | ≤ 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       |
| GVR130       | ≤ 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      |
| GVR165       | ≤ 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      |

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