

AM - Series

APEX.AM.EN.2012.001

MOTOR MOUNTIN INSTRUCTION

Micro Planetary Gearbox Installation Manual

» AM013 Assemble Procedures:

- 1. Check motor shaft runout. 90.02 A
- 2. Clean the grease or oil on motor shaft. Apply Loctite 638 on motor shaft (please see apply glue procedures).
- 3. Slide and rotate the sun gear on motor shaft.
- 4. Bolts the adapter on motor.
- 5. Put washer on adapter surface.
- 6. Screw the gearbox on adapter all the way and verify is seal tight.

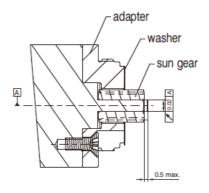
AM016 / 022 / 026 / 032 Assemble Procedures:

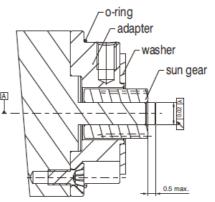
- 1. Check motor shaft runout.

 ✓ 0.02 A
- 2. Clean the grease or oil on motor shaft. Apply Loctite 638 on motor shaft (please see apply glue procedures).
- 3. Slide and rotate the sun gear on motor shaft.
- 4. Bolts the adapter on motor.
- 5. Put washer on adapter surface, check o-ring position.
- 6. Bolts the gearbox and motor together. Verify is seal tight.

» Apply Glue Procedures:

- 1. Check motor shaft and sun gear hole tolerance within 0.02mm. (sun gear hole tolerance is H7).
- 2. Clean the grease or oil in sun gear hole and motor shaft.
- 3. Sun gear can rotate or slide on motor shaft.
- 4. Minimum dry time for Loctite 638 is 4 hours. Keep the assembly in horizontal position.
- 5. After dried, under no-load test run for 15 minutes.





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