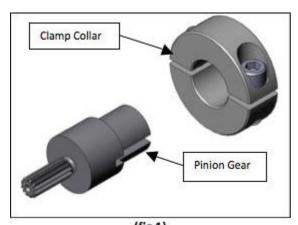
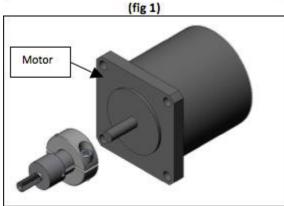
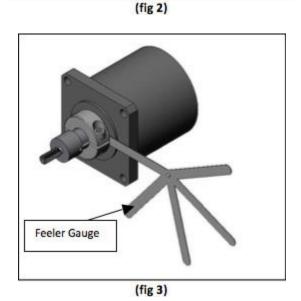


Mounting Instructions – PL Gearhead

NOTE: If the gearhead is to operate with its output shaft pointing upward, call AMP, Inc.'s sales or engineering department for extra grease packets and instructions.







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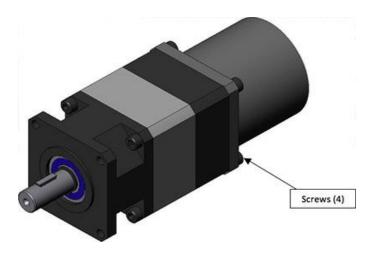




- 1. PL planetary gearhead.
- 2. Pinion gear with balanced clamp collar.
- 3. Four (4) allen head cap screws for mounting the motor to the gearhead.
- 4. Woodruff key.
- 5. Allen wrench(es).
- 6. This instruction sheet.

ASSEMBLY SEQUENCE

- 1. Slide the clamp collar fully onto the pinion gear (fig 1).
- 2. Gently tighten the two (2) screws on the clamp to remove any loose clearance keep the distance of the gap at each end approximately equal.
- 3. Slide the pinion gear with the clamp onto the motor shaft (fig 2).
- Insert the proper thickness feeler gauge (see: Table A, Pinion Gear Positioning, on back) between the pinion gear and motor pilot (fig 3). Note: feeler gauge not supplied.
- 5. Tighten the two (2) clamp screws evenly and firmly; then remove feeler gauge.
- 6. **IMPORTANT:** Tighten the two (2) screws on the clamp to the proper torque (see: Table A, Clamp Screw Torques).
- 7. Position the motor/pinion assembly vertically on a bench with the pinion gear upwards. NOTE: if the gearhead requires sealing to the motor face, apply a thin film of Loctite 515 "Gasket Eliminator" or equivalent to the entire mounting surface of the motor to achieve a positive seal.
- 8. Lift and vertically orient the gearhead over the motor. Carefully and slowly lower the gearhead onto the pinion gear. Proper alignment will be necessary.
- 9. When the gearhead makes contact with the pinion gear, rotate the gearhead to allow the teeth to align themselves. The unit will find its alignment – then lower the gearhead fully into position.
- 10. Lay the assembly horizontal on a flat surface and install the motor mounting screws tighten with allen wrench (fig 4).



(Fig 4)

Completed Assembly PL Planetary Gearhead with Motor

TABLE A

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Pinion Gear Positioning and Clamp Screw Torques for Standard Nema Gearheads

UNIT SIZE	WRENCH SIZE	SCREW TORQUE (NOM)	DISTANCE	
SIZE 17	#4-40	10 LB. IN.	.047	
SIZE 23	#8-32	28 LB. IN.	.047	
SIZE 34	#10-32	45 LB. IN.	.094	
SIZE 42	1/4-28	110 LB. IN.	.094	
SIZE 56	1/4-28	110 LB. IN.	.094	
SIZE 75	1/4-28	110 LB. IN.	.094	

Additional Clamp Screw Torques

SCREW SIZE	SCREW TORQUE (NOM.)
#6-32	15 LB. IN.
3/8-24	436 LB. I

Customers will need a torque wrench with the proper Allen tip

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