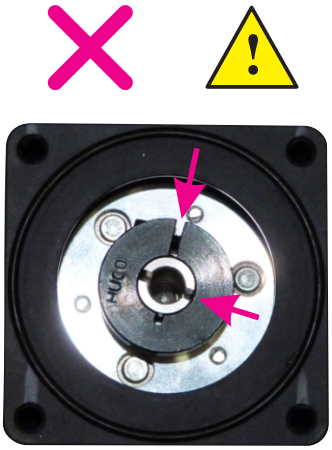
Mounting Instruction

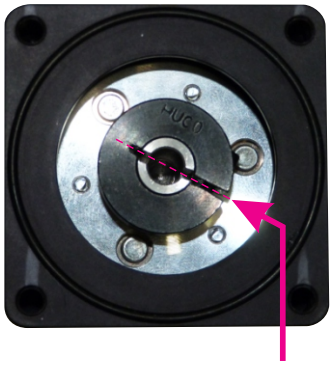
How to mount a gear or a brake on a JVL motor

When a gear or a brake is to be mounted to the front of a motor it is very important that this is done in the right way since a wrong way of mounting may have fatal influence at lifetime of the motor or gear/brake and performance. Always: First: flange bolts, and then second: collar screw.
The purpose is to make sure that there are no axial pressure on the motor bearings.
Please follow this instruction step by step to make sure that the mounting is done with a good result.

1 Make sure that the **shaft collar** is oriented correctly in order to assure that the right tension around the motor shaft is possible.
(On MAB17x brake, the shaft should pulled out a bit before mounting.)
Hint: Tighten the shaft collar gently just to keep it in the right position.

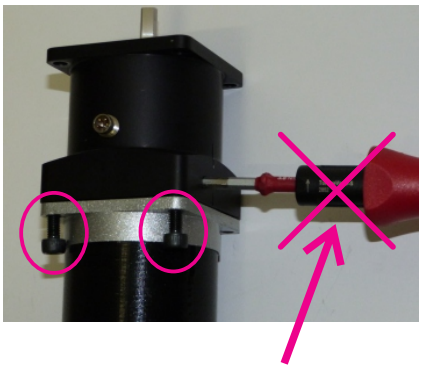


The inner and outer slit is NOT aligned. Make sure they are aligned as shown at right illustration



The inner and outer slit is aligned as they should.

2 Mount the gear or brake to the motor and **fasten the 4 flange bolts first**, before fastening the shaft collar.
Its recommended to use Locktite 278 in the threats to make sure that the bolts stay in place.



Do **NOT** tighten the shaft collar before the flange bolts are tightend

Flange bolts properly mounted and tightend.

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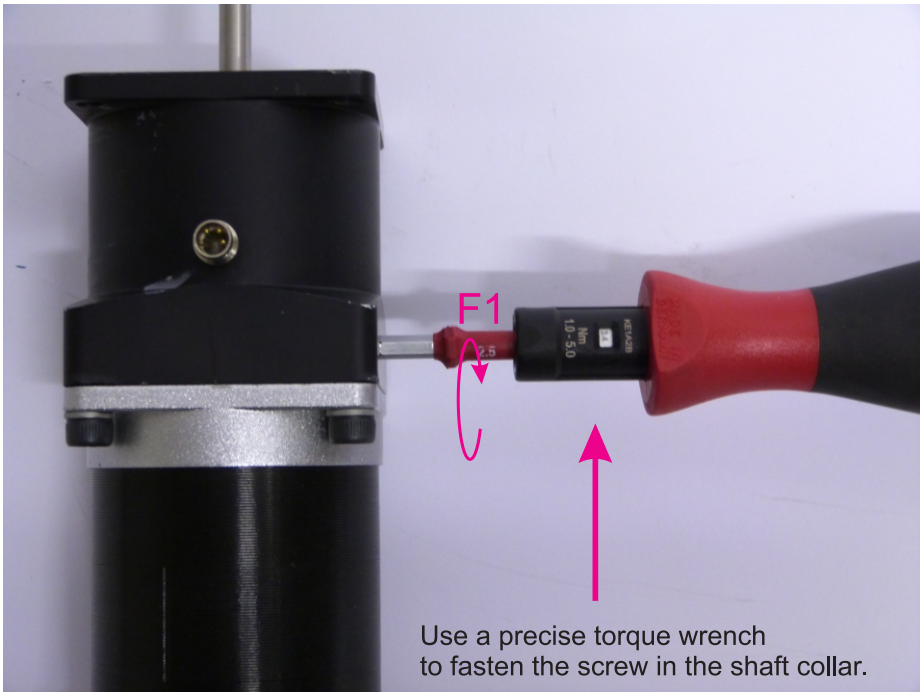
Literature no.: **LS0004-08GB**

3 After the flange bolts are tightened, fasten the shaft collar with a torque of according to the scheme below.
Please notice that it can be fatal not to use the specified torque since the shaft may slip over time and cause a position offset.



Use a precise torque wrench to fasten the screw in the shaft collar.

Gears Recommended Torque for Shaft Collar Screw:

Series	Used with motor type	Shaft	Hex	Bolt	Torque (F1)
HTRG05	MAC050 to MAC141	6.35	3.0	M4	**4 Nm**
HTRG05	MIS23x	6.35	3.0	M4	**4 Nm**
HTRG06#	MAC050 to MAC141	6.35	3.0	M4	**4 Nm**
HTRG06	MAC400-402	14	3.0	M6	**10 Nm**
HTRG08	MIS340-341	9.53	4.0	M4	**4 Nm**
HTRG08	MIS342	14	5.0	M6	**10 Nm**
HTRG08	MAC800	19	5.0	M6	**10 Nm**
HTRG10	MAC800	19	5.0	M6	**10 Nm**
HLMT...NE17	MIS17x	8.0	2.5	M3	**2 Nm**
HLMT...NE23	MIS23x	6.35	3.0	M4	**4 Nm**
HLMT...NE34	MIS34x	9.53	4.0	M4	**4 Nm**
HLMT...0400	MAC400-402	14	3.0	M6	**10 Nm**

Brakes Recommended Torque for Shaft Collar Screw:

Series	Used with motor type	Shaft	Hex	Bolt	Torque (F1)
MAB17x	MIS17x	8.0	3.0	M4	***3 Nm****
MAB23x#	MAC050-MAC141/MIS23x	6.35	2.5	M3	**2 Nm**
MAB23x	MIS23x	6.53	2.5	M3	**2 Nm**
MAB34x	MIS34x	9.53	T25	M5	**5 Nm**
MAB34x	MIS34x	14.0	T25	M5	**5 Nm**

* MAB17x brake - pull the shaft out on the brake before mounting, and observe that it is not pushed in when mounting it the flange.
# External Brakes and Gears on MAC100 series (Stainless Steel) must be mounted with silicone to ensure water tightness.