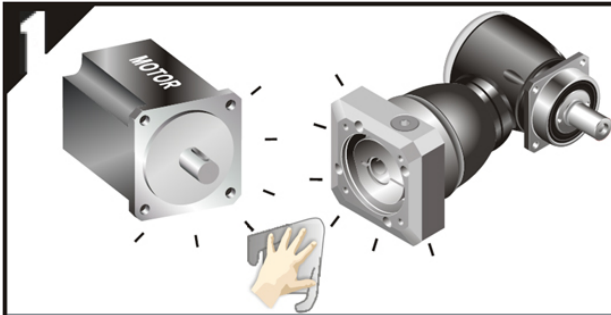
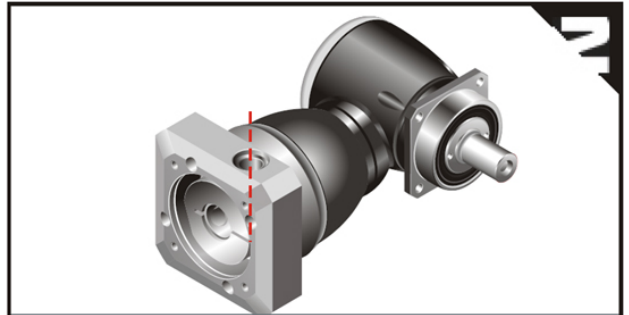




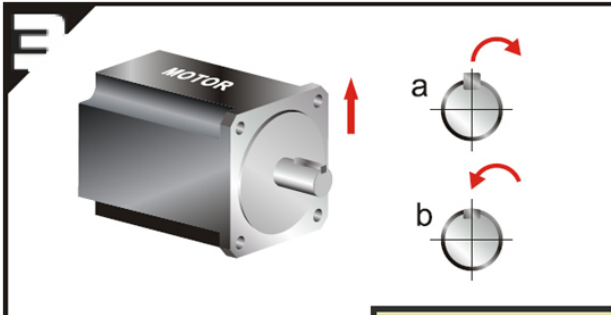
**MOTOR MOUNTING INSTRUCTION**



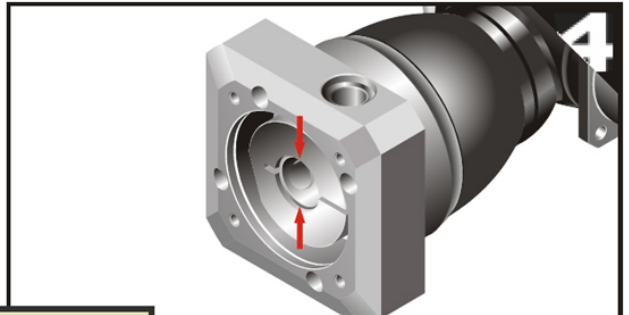
Double-check the motor and gearbox size  
Clean the mounting surface



Remove the plug on the adapter plate. Rotate the set collar until the bolt hole is aligned with access hole



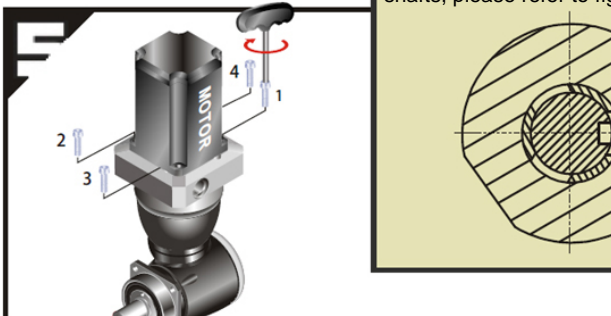
a Remove motor key  
b Insert balance key, if necessary



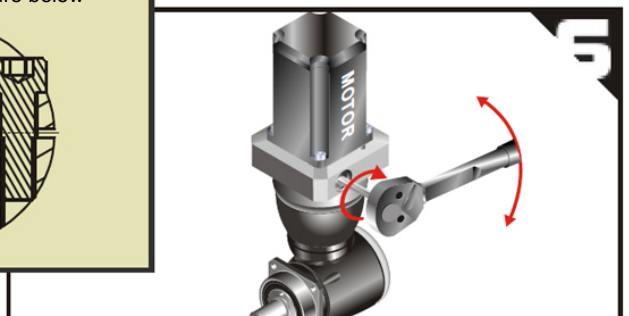
Check motor shaft size and insert bushing if necessary

**Correct Installation**

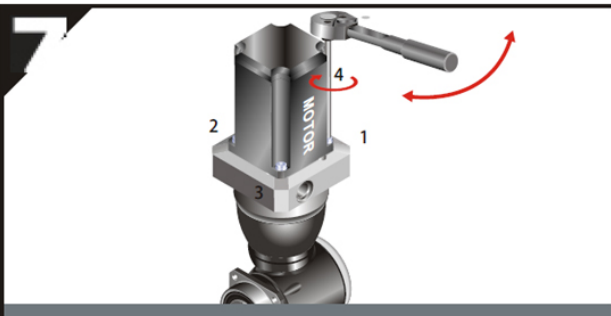
When installing on keyed or flatted shafts, please refer to figure below



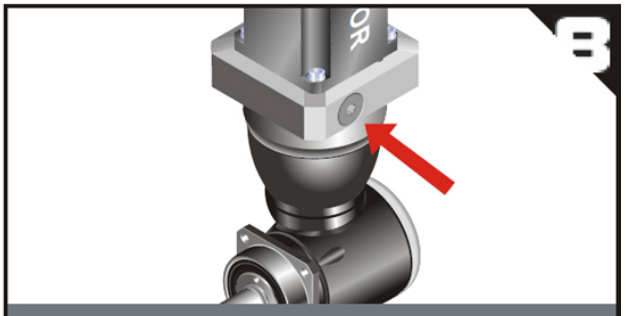
Set at vertical position, tighten the mounting bolts (including washer) in 1~4 order with wrench to 5% specified torque (see table 1)



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)



Tighten back the screw plug



# MOTOR MOUNTING INSTRUCTION

**Table 1** Tightening torque recommended for motor mounting bolt

Bolt Size	Width Across Flats	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

**Table 2** Tightening torque recommended for set collar bolt

Bolt Size	[mm]	M5 x 0,8P	M6 x 1P	M8 x 1,25P	M10 x 1,5P	M12 x 1,75P	M16 x 2P
Width Across Flats	[mm]	4	5	6	8	10	14
Tightening Torque	[Nm]	9,8	17	41	80	139	343
	[In-lbs]	87	151	364	709	1232	3038

Model	KF060		KF075		KF100		KF140		KF180		KF210		KF240	
	KH064		KH090		KH110		KH140		KH200		KH255		KH285	
Ø (C3)	1-st	2-st	1-st	2-st	1-st	2-st	1-st	2-st	1-st	2-st	1-st	2-st	1-st	2-st
8	M5	M5	-	M5	-	-	-	-	-	-	-	-	-	-
11	M5	M5	M5	M5	-	-	-	-	-	-	-	-	-	-
14	M5	M5	M6	M5	-	M6	-	-	-	-	-	-	-	-
19	M6	-	M6	M6	M8	M6	-	M8	-	-	-	-	-	-
24	-	-	M10	-	M10	M10	M10	M10	-	M10	-	-	-	-
28	-	-	-	-	M10	-	M10	M10	-	M10	-	-	-	-
32	-	-	-	-	M10	-	M10	M10	M10	M10	-	M10	-	-
35	-	-	-	-	M12	-	M12	M12	M12	M12	M12	M12	M12	M12
38	-	-	-	-	M12	-	M12	M12	M12	M12	M12	M12	M12	M12
42	-	-	-	-	-	-	M12	-	M12	M12	M12	M12	M12	M12
48	-	-	-	-	-	-	M16	-	M16	M16	M16	M16	M16	M16
55	-	-	-	-	-	-	-	-	-	-	M16	-	M16	-
60	-	-	-	-	-	-	-	-	-	-	-	-	M16	-

**Note:** Holding torques must be bigger than values shown above. Bolts can be tightened up to 20% higher for increased holding torques.

**Apex Dynamics bv**  
Churchillaan 101  
NL-5705 BK Helmond  
The Netherlands

Tel. : +31 (0)492 509 995  
Fax : +31 (0)492 509 997  
E-mail : sales@apexdyna.nl

For more information, please visit our website: [www.apexdyna.nl](http://www.apexdyna.nl)

## High Precision Gearboxes