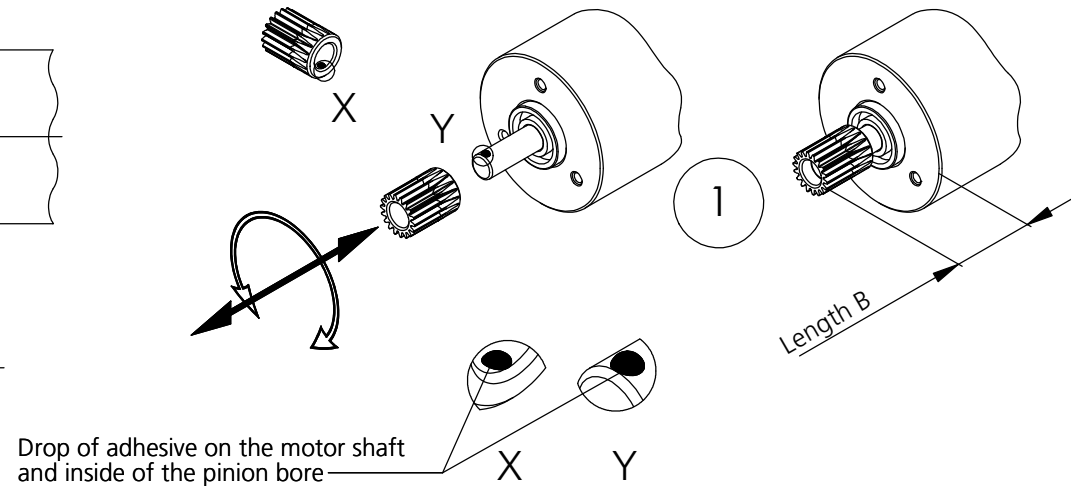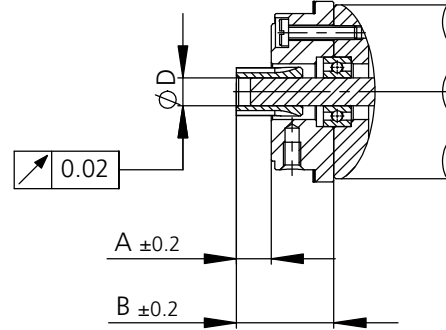# Assembly Instructions Planetary Gearbox GPL026
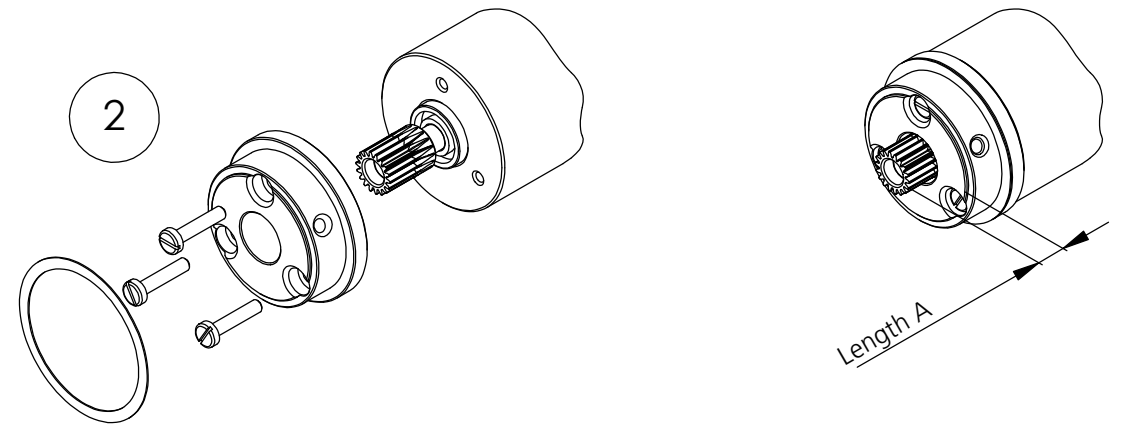
1. Glue motor pinion onto motor shaft

Recommended adhesive: LOCTITE 638

1.1. Verify concentricity of motor shaft
  - Maximum concentricity of the motor shaft: 0.02mm

1.2. Verify fit of motor shaft to motor pinion
  - Tolerance of bore of pinion: H7
  - Optimal play shaft to bore: 0.01- 0.02mm
  - Maximum play shaft to bore: 0.06mm

1.3. Observe the mounting dimensions
  - Length **A** with adapter plate: **5 ±0.2mm**
  - Length **B** without adapter plate: **14 ±0.2mm**

1.4. Clean and degrease motor shaft and motor pinion
  - Assemble only parts that are completly free of grease
  - Please observe the instructions and specification of the adhesive manufacturer

1.5. Application of adhesive onto motor shaft and motor pinion
  - Apply a drop of adhesive into bore and onto motor shaft
  - See detail X and detail Y
  - Drop size approximately 1- 2mm

1.6. Motor pinion installation
  - Install pinion under continous rotary and longitudinal motion onto motor shaft to evenly distribute the adhesive onto shaft and bore. Apply additional adhesive if required
  - Following the distribution of the adhesive install the motor pinion in accordance with the applicable mounting dimension

1.7. Curing of adhesive bond
  - Please observe the specification of the adhesive manufacturer
  - Keep the motor in horizontal position during curing
  - Observe and await firmness of bond before continuing. Firmness of Loctite 638 is achieved after approximately 15 to 30 min under optimal conditions
  - Remove excess adhesive from motor shaft and bore if applicable

2. Assembly of accessories

2.1. Mount the adapter plate to the motor. Secure with screws

2.2. Install one piece paper gasket onto adapter plate

3. Assembly of Gearbox to Motor

3.1. Mount gearbox carefully onto motor

3.2. Secure gearbox with supplied screws (M2.5x6 ISO 14581) to adapter plate

4. Gearbox run-in

4.1. Run the gearbox assembly at no load for 15 min for optimal distribution of the lubrication

$\varnothing D$

$\boxed{\nearrow \; 0.02}$

A ±0.2

B ±0.2

X   Y

①

Length B

Drop of adhesive on the motor shaft and inside of the pinion bore

X   Y

②

Length A

③

④