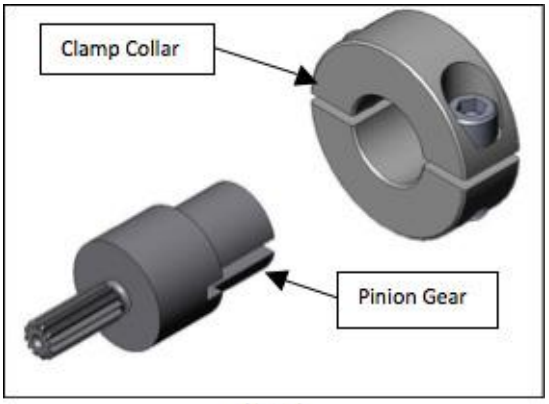
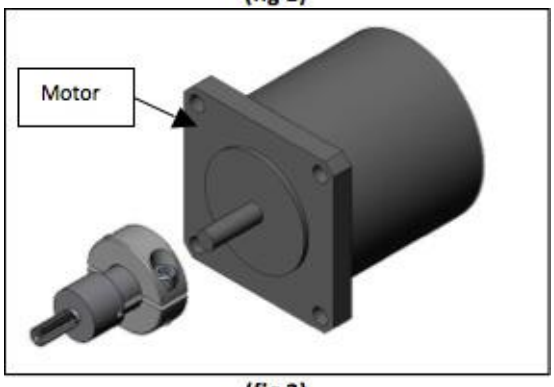
# Mounting Instructions – PL Gearhead

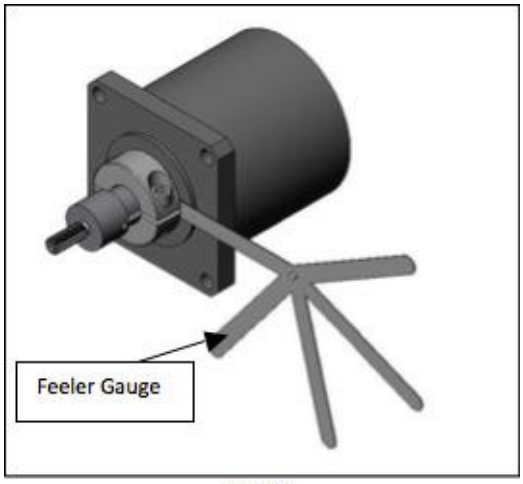
**NOTE:** If the gearhead is to operate with its output shaft pointing upward, call AMP, Inc.'s sales or engineering department for extra grease packets and instructions.




(fig 1)




(fig 2)



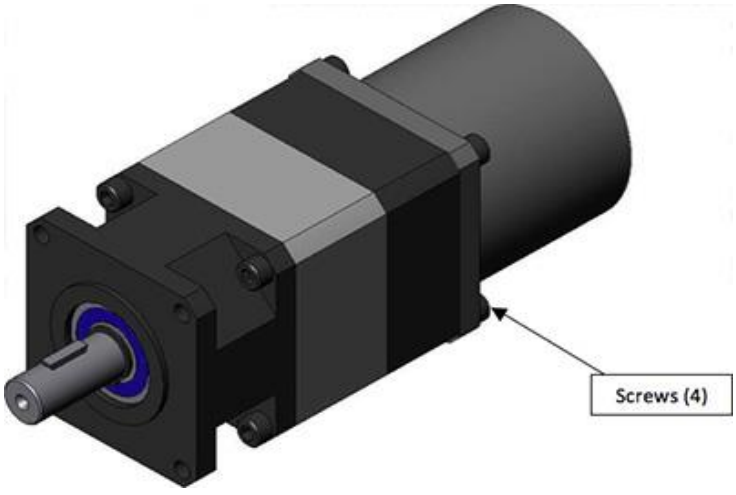

(fig 3)

**CONTENTS**

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).
4. 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

**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