

# Gear Box Installation Instructions

These installation instructions are intended to help in the use of this gear box as well as to maximize its life. Gear box technical specifications can be found on the MPG Gear Box page. These specifications provide important information regarding the limitations and ratings of the gearbox.

All gear units are supplied filled with lubrication. They are lubricated for life and no oil change is necessary. The gear unit may also be mounted in any orientation without any concern for lubrication.

To avoid any distortion or damage to the input clamping element of the gear unit, assembly to the motor should be performed in the vertical position. This will also help with aligning the motor to the gear unit.



**Step 1:** Rotate input clamping element until the bolt is visible through the access hole.



**Step 2:** Ensure all mounting surfaces are clean. With the motor and gearbox. VERTICAL, insert the motor into the gearbox.



**Step 3:** Using the 4 bolts provided, tighten the motor to the gearbox adapter. Tightening torques can be found in table 2.



**Step 4:** Tighten the clamping element onto the motor shaft. The proper tightening torque can be found in table 1. Finally, insert the provided plug into the access hole.

**Table 1: Tightening Values for Gearbox Input Shaft Collar**

	Size	Bolt Size	Hex Size	Torque (in-lb)
MPG	062, 064	M5	4mm	53
	082, 084	M6	4mm	80
	118	M8	5mm	177

**Table 2: Tightening Values for Motor to Adaptor**

	Bolt Size	Hex Size	Torque (in-lb)
Motor Adapter	M4	3mm	39
	M5	4mm	77
	M6	5mm	133
	M8	6mm	319
	M10	8mm	637
	M12	10mm	1106
	M16	14mm	2743

**Table 3: Tightening Values Gearbox Output Coupling to Macron Actuator**

	Size	Bolt Size	Hex Size	Torque (in-lb)
MPG	062, 064	4 x M10	5mm	124
	082, 084	4 x M10	5mm	267
	118	4 x M10	5mm	443



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