

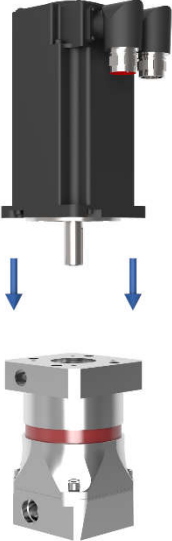
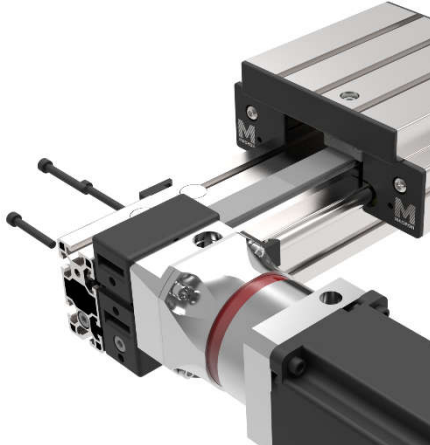
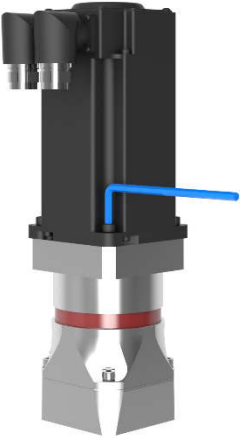
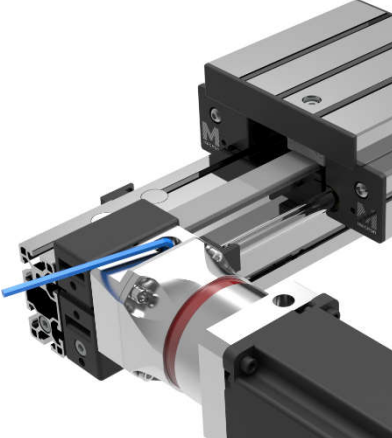


# Macron MPG & MRG Installation and Assembly

	<p><b>Step 1:</b> Align clamp: Rotate input clamping elements until the bolts are visible through the access holes on both the input and output.</p>		<p><b>Step 4:</b> Tighten the clamping element onto the motor shaft as noted in <a href="#">Table 2</a>. Finally, insert the provided plug into the access hole.</p>
	<p><b>Step 2:</b> Ensure all mounting surfaces are clean. With the motor and gearbox VERTICAL, insert the motor into the gearbox.</p>		<p><b>Step 5:</b> Ensure all mounting surfaces are clean. Using the 4 bolts provided, tighten the gearbox to the actuator. Fully tighten the bolts as noted in <a href="#">Table 1</a>.</p>
	<p><b>Step 3:</b> Using the 4 bolts provided, tighten the motor to the gearbox adapter. Fully tighten the bolts as noted in <a href="#">Table 1</a>.</p>		<p><b>Final Step:</b> Tighten the clamping element onto the actuator shaft as noted in <a href="#">Table 3</a>. Finally, insert the provided plug into the access hole.</p>

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**Table 1**

Bolt Size	Hex Size	Torque (in-lbs)
M4	3mm	40
M5	4mm	80
M6	5mm	130
M8	6mm	320
M10	8mm	640
M12	10mm	1100

**Table 3**

Part Number	Output Clamping Torque (in-lbs)
MPG-062	120
MPG-014	120
MPG-064	280
MPG-084	280
MPG-114	280
MPG-088	280
MPG-118	280

**Table 2**

Part Number	Motor Clamping Torque (in-lbs)
MPG-062	53
MPG-014	53
MPG-064	53
MPG-084 (motor shaft diameter 19mm or less)	80
MPG-084 (motor shaft diameter greater than 19mm)	177
MPG-114	177
MPG-088 (motor shaft diameter 19mm or less)	80
MPG-088 (motor shaft diameter greater than 19mm)	177
MPG-118	177