



Macron MPG Gear box - Installation and Assembly Instructions



Step 1:

Rotate input clamping elements until the bolts are visible through the access holes on both the input and output.



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. Fully tighten the bolts as noted in Table 1.



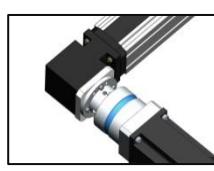
Step 4:

Tighten the clamping element onto the motor shaft as noted in Table 2. Finally, insert the provided plug into the access hole.



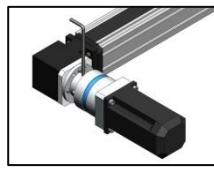
Step 5:

Ensure all mounting surfaces are clean. Using the 4 bolts provided, tighten the slide adapter to the slide. Fully tighten the bolts as noted in Table 1.



Step 6:

Ensure all mounting surfaces are clean. With the slide and gearbox VERTICAL, insert the gearbox onto the slide. Using the 4 bolts provided, tighten the gearbox to the slide. Fully tighten the bolts as noted in Table 1.



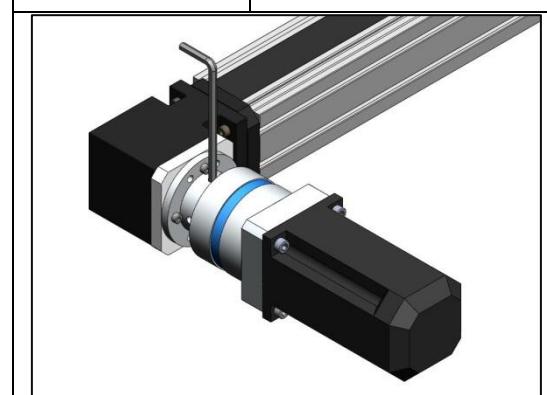
Final Step:

Tighten the four screws on the output clamping element onto the slide shaft in a star pattern as noted in Table 3. Finally, insert the provided plugs into the access holes.

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 2		
Macron Part Number	Input Clamping Torque (in-lbs)	Output Clamping Torque (in-lbs)
MPG-062	53	124
MPG-084	80	266
MPG-118	177	442

First Round Torque	MPG-062 = 62 in-lbs MPG-084 = 133 in-lbs MPG-118 = 221 in-lbs
*Second Round Torque	MPG-062 = 124 in-lbs MPG-084 = 266 in-lbs MPG-118 = 442 in-lbs



**Repeat Second Round Torque stage until torque value listed is confirmed at each bolt.*