



MOTOR MOUNTING INSTRUCTIONS

1

Double-check the motor and gearbox size.
Clean the mounting surface.

2

Remove the plug on the adapter plate.
Rotate the set collar till the bolt is line up.

3

a. Remove motor key.
b. Insert balance key.

4

Check motor shaft size and
insert bushing if necessary.

Correct installation.

When installing on flatted shafts,
be sure to align the collet gap over
the flat and the set collar bolt
perpendicular to the flat.

5

Adapted the motor. Tighten with 5%
torque according recommend list.

6

Tighten the mounting bolt (including washer)
in 1~4 order with torque wrench to specified
torque. (See Table 1)

7

Tighten the set collar bolt with torque
wrench to specified torque. (See Table 2)

8

Tighten back the screw plug.

Table 1 Tightening Torque Recommended for Motor Mounting Bolt

Bolt Size	Width Across Flats	Strength 8.8 Tightening Torque		Strength 10.9 Tightening Torque		Strength 12.9 Tightening Torque	
	[mm]	[Nm]	[In-lbs]	[Nm]	[In-lbs]	[Nm]	[In-lbs]
M3 x 0.5P	2.5	1.3	12	1.8	16	2.1	19
M4 x 0.7P	3	3	27	4.1	37	4.9	44
M5 x 0.8P	4	6.1	55	8.2	73	9.8	87
M6 x 1P	5	11	98	14	124	17	151
M8 x 1.25P	6	25	222	34	302	41	364
M10 x 1.5P	8	49	434	67	594	80	709
M12 x 1.75P	10	85	753	116	1028	139	1232
M14 x 2P	12	137	1214	186	1648	223	1976
M16 x 2P	14	210	1860	286	2534	343	3038

Table 2 Tightening Torque Recommended for Set Collar Bolt

Gearbox Size		Motor Shaft Dia.	Bolt Size	Width Across Flats	Tightening Torque	
		[mm]	[mm]	[mm]	[Nm]	[In-lbs]
AB042 / ABR042 AF042 / AFR042 AE050	1 stage	≤11	M3 x 0.5P x 8L	2.5	2.1	19
	2 stage	≤11	M3 x 0.5P x 8L	2.5	2.1	19
AB060 / ABR060 AF060 / AFR060 AE070	1 stage	≤14	M4 x 0.7P x 12L	3	4.9	44
	2 stage	≤11	M3 x 0.5P x 8L	2.5	2.1	19
AB090 / ABR090 AF075 / AFR075 AE090	1 stage	≤19	M5 x 0.8P x 14L	4	9.8	87
	2 stage	≤14	M4 x 0.7P x 12L	3	4.9	44
AB115 / ABR115 AF100 / AFR100 AE120	1 stage	≤32	M6 x 1P x 16L	5	17	151
	2 stage	≤19	M5 x 0.8P x 14L	4	9.8	87
AB142 / ABR142 AF140 / AFR140 AE155	1 stage	≤38	M8 x 1.25P x 20L	6	41	364
	2 stage	≤32	M6 x 1P x 16L	5	17	151
AB180 / ABR180 AF180 / AFR180 AE205	1 stage	≤48	M10 x 1.5P x 25L	8	80	709
	2 stage	≤38	M8 x 1.25P x 20L	6	41	364
AB220 / ABR220 AF220 / AFR220 AE235	1 stage	≤55	M12 x 1.75P x 30L	10	139	1232
	2 stage	≤48	M10 x 1.5P x 25L	8	80	709

Note : Holding torques must bigger then values shown above. Bolts can be tightened up to 20% higher for increased holding torques.