



MGS Speed Reducer Motor Mounting Instructions



CAUTION: If the motor coupling is not installed correctly, the input bearing may fail due to pre-load. This will void the warranty of the reducer and possibly fail the motor.

Step 1. Locate the Coupling on the Motor Shaft



Accurate placement of the motor coupling on the shaft is vital to mounting the motor correctly. Mount the coupling with the hub projection toward the step or shoulder of the motor. The motor coupling should be located from the motor face the "XL" distance shown in Table No. 1.

Table No. 1 Location of "MR" Motor Coupling

Adapter Part No.	"XL"		Adapter Part No.	"XL"	
	mm	inches		mm	inches
MR140/050	24	.94	MR250/210	33	1.3
MR160/050	30	1.2	MR300/180	56	2.2
MR160/140	29	1.1	MR300/210	53	2.1
MR200/050	40	1.6	MR300/250	53	2.1
MR200/140	42	1.7	MR300/280	53	2.1
MR200/180	36	1.4	MR350/320	63	2.5
MR250/180	36	1.4	MR350/360	63	2.5

Location of "MS-R" Motor Coupling

MS_1R050	24	.94	MS_3R050	24	.94
MS_2R050	26	1.0	MS_3R140	29	1.1
MS_2R140	29	1.1	MS_3R180	36	1.4

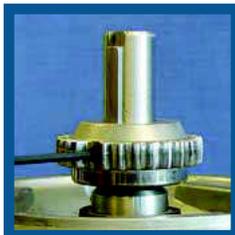
Location of "ML" Motor Coupling

ML2R050	24	.94
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"XL" Tolerance = +1mm / -0mm (+0.040 / -0.000 inches)

Step 2. Tighten the Setscrew¹⁾

With the coupling hub located at the correct distance, tighten the setscrew in the coupling.



Step 3. Secure the Motor Key

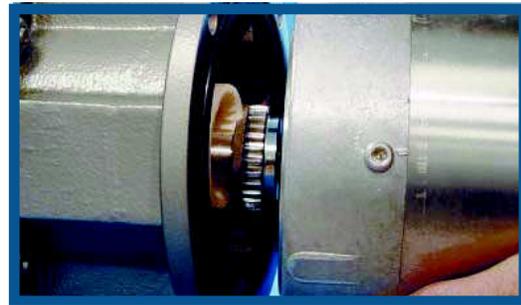


For ease of installation, secure the motor shaft key. Staking near the end of the keyway, on the sides of the key, or a temporary adhesive works well.

¹⁾ Setscrews are NOT located over the key in some sizes.

Step 4. Mount the Motor

With the coupling secure, insert the motor shaft into the motor adapter. The coupling sleeve is already installed on the mating reducer coupling hub inside the motor adapter. **The sleeve should move freely in an axial direction.** (Axial displacement ± 0.040 inches.)



With the motor in place, install and tighten all motor bolts.

Some motor manufacturers provide a weep hole in the mounting face of washdown motors. In some mounting positions, water or other material can enter the reducer through this hole and fail the motor adapter bearing.



Be sure the motor weep hole is plugged during washing or when the unit is in a wet environment. This illustration shows the method that STOBER assembly personnel use to plug the hole.

WHEN INSTALLING A FOOD DUTY REDUCER:

WARNING

The included labels must be affixed onto or near the gear reducer during reducer installation to properly warn the equipment operator of potential danger.



These labels must be clearly visible to the operator when he/she is near the reducer.

Form No. 2030A