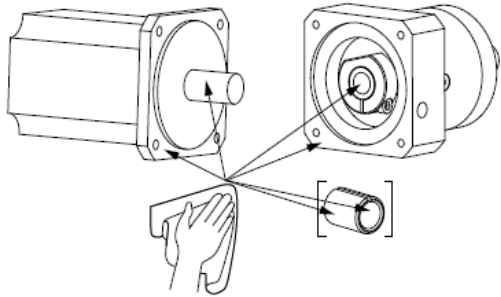


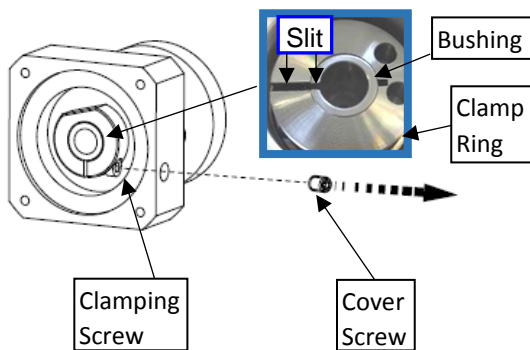
# Oriental motor

## PLE Assembly onto AZ Series Motor

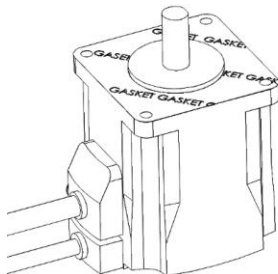
1. Ensure you have the correct motor and gearhead. Clean the following surfaces as shown.



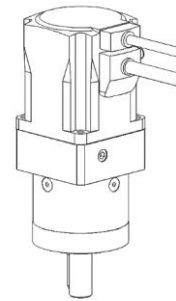
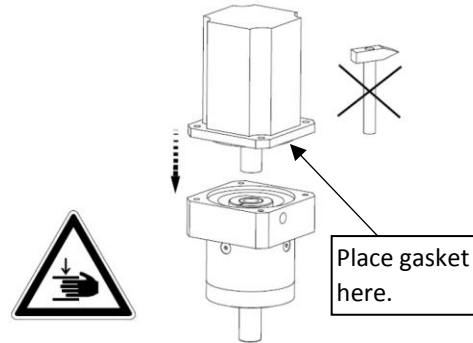
2. Remove cover screw from gearhead and adjust position of clamping screw. Slip bushing into the clamp ring. Ensure the slit of the clamp ring and bushing are in the same direction.



3. Place gasket on the motor with lettering face up. Gasket holes should be aligned with motor mounting holes.

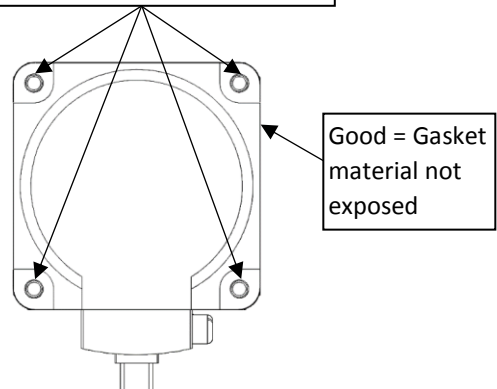


4. Mount motor to the gearhead in a vertical operation. Ensure the gasket is between the motor and gearhead with proper alignment. Do not force the motor into the gearbox.

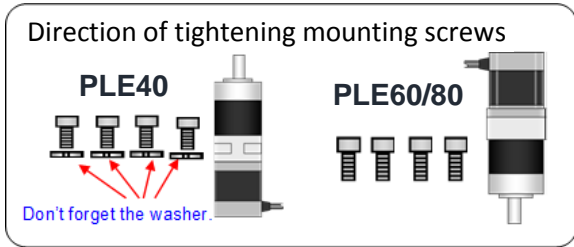


5. Verify gasket holes are aligned with the motor. There should be no gasket material extruding from the motor frame or inside the hole.

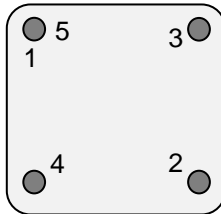
Good = Mounting hole is clear



6. Apply Loctite onto last 3 threads of screws and place into each hole. Tighten supplied mounting screws in the following pattern and appropriate torque as shown below.

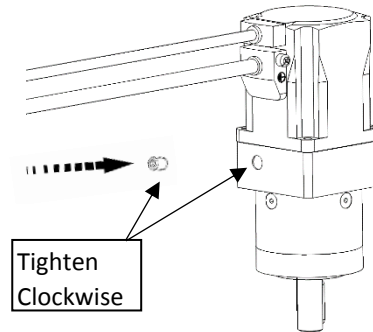


### Tightening order



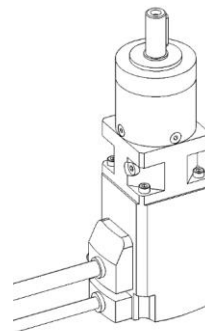
Mounting Screws		
Gearbox	Screw size	Torque (Nm)
PLE040	M3	1.8
PLE060	M4	4
PLE080	M6	14.5

7. Tighten the clamp ring with the clamp screw to appropriate torque first as shown below. Then tighten cover screw and add Loctite onto threads if desired.

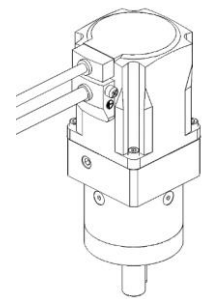


Clamp ring			
Gearbox	PLE040	PLE060	PLE080
Screw Size	M3	M4	M5
Torque (Nm)	2	4.5	9.5
Cover Screw			
Gearbox	PLE040	PLE060	PLE080
Screw Size	M6	M8	M8
Torque (Nm)	1.4	2.5	2.5

8. Untighten mounting screws and retighten to appropriate pattern and torque specs in step 6. This is to realign the clamp ring and gearbox to the motor shaft.



PLE40



PLE60/80