PMK - Installation Instructions

Assembly Overview

Step 1:
- Attach the motor and actuator to the mounting plate using the bolts provided as shown.
- Use the four flat washers between the lock nuts and the mounting plate.
- Fully tighten actuator bolts per Table 1.
- Do not fully tighten the motor bolts.

NOTE: The 8 holes in the mounting plate (actuator side) allow universal orientation (horizontal and vertical).

Step 2:
- Install the belt and pulleys to the motor and actuator shafts. Ensure the pulleys are mounted as close to the mounting plate as possible without interference.
- Check that both pulleys are at an equal distance from the mounting plate.
- Tighten the bolts on each pulley as noted in Table 2.

Step 3:
- Tension the belt by pulling the motor away from the actuator as noted in Table 3.

NOTE: To ensure proper operation, measure tension using a belt tension gauge.
- While maintaining tension on the belt, fully tighten the motor bolts as noted in Table 3.

Step 4:
- Secure the cover plate to the mounting plate using bolts provided.

Item | Description
--- | ---
1 | Motor (Not Included)
2 | Mounting Bolts
3 | Mounting Plate
4 | Flat Washers
5 | Lock Nuts
6 | Motor Pulley
7 | Cover Plate
8 | Flat Head Bolt
9 | Bearing Washer
10 | Bearing Support Housing with Bearing (supplied by GAM as determined by application)
11 | Actuator Pulley
12 | Belt
13 | Actuator (Not Included)

NOTE - For kits that include the bearing support, the pulley with the shaft extension mounts on the actuator shaft and the standard pulley mounts on the motor.

See steps 2a-2d for bearing support mounting instructions on the back page.
PMK - Installation Instructions

Torque / Tension Information

<table>
<thead>
<tr>
<th>Table 1</th>
<th>Table 2</th>
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<tbody>
<tr>
<td><strong>Bolt</strong></td>
<td><strong>Recommended Tightening Torque</strong></td>
</tr>
<tr>
<td>M4</td>
<td>4Nm (35 in-lbs)</td>
</tr>
<tr>
<td>M5</td>
<td>8Nm (71 in-lbs)</td>
</tr>
<tr>
<td>M6</td>
<td>13Nm (115 in-lbs)</td>
</tr>
<tr>
<td>M8</td>
<td>31Nm (274 in-lbs)</td>
</tr>
<tr>
<td>M10</td>
<td>62Nm (549 in-lbs)</td>
</tr>
<tr>
<td>M12</td>
<td>108Nm (956 in-lbs)</td>
</tr>
</tbody>
</table>

**Step 2a:**
- Position the bearing support housing with the shaft extension on the actuator side.
- Align the center of the flat head bolt and bearing washer with the bearing.
- Apply Loctite at the end of the bolt thread before installing.

**Step 2b:**
- Tighten the flat head bolt into the thread on the shaft.
- Tightening the flat head bolt will press the bearing onto the shaft extension and draw the bearing support housing towards the mounting plate.
- Stop tightening when the bolt bottoms out.
**NOTE** - The bearing support housing may not yet be flush with the mounting plate.

**Step 2c:**
- Insert the three mounting bolts for the bearing support housing.
**NOTE** - The additional holes in the bearing support housing are back-out holes for dis-assembly.

**Step 2d:**
- Tighten the mounting bolts in a diagonal pattern and tighten to 1.4Nm (12 in-lbs).
- The bearing support housing should now be secure to the mounting plate.
- Continue to Step 3 on the first page.

**Torque / Tension Information**

<table>
<thead>
<tr>
<th>Table 3</th>
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</thead>
<tbody>
<tr>
<td><strong>PMK Size</strong></td>
</tr>
<tr>
<td>31</td>
</tr>
<tr>
<td>41</td>
</tr>
<tr>
<td>51</td>
</tr>
<tr>
<td>61</td>
</tr>
</tbody>
</table>

* Measure belt tension with a belt tension gauge to ensure proper operation