
 AB.MA.GT.035.004.06.08	<b>Installation instruction for IEC motors on IEC - adapters IAK100 – IAK180</b> Article number: BM.WMBA.GMKA100-180	 MAS	Revision date: 12.06.2008 Page: 1/1
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**ATTENTION:**

In case of independent pinion assembling (7) the bearing (9) on the gearside must to be filled with the amount of grease mentioned below before assembling the seal ring (8).

Size of adapter (IAK)	Amount of grease NLGI 1 – DIN 51818
100/112	6 g
132	0 g
160/180	20 g

**1. Installing an IEC motor onto the Watt IEC coupling adapter (IAK):**

Watt Drive supplies IEC adapters in sizes 100/112, 132, 160, 180 with an integrated, play-free claw coupling. Motors with connection dimensions conforming to DIN EN 50347 IM B5 can be fitted onto the adapters. The IEC adapters have an oil-tight design, with the interface being sealed between the gears and the adapter. The motor threaded union on the adapter is to be connected using screws with a strength rating of 8.8 (or higher), and the tightening torques specified by the manufacturer must be observed.

The correct assembly position must be observed when fitting the half coupling supplied onto the motor shaft.

**Assembly procedure:**

1. Remove the adapter cover (1) and remove the half coupling provided (3).
2. Clean the motor shaft (2) and the flange surfaces on the motor and adapter.
3. Heat the half coupling (3) to approx. 80°C (176°F) and fit onto the motor shaft.
4. The half coupling is fitted flush to the shaft panel with the end of the bore hole (see diagram!).
5. Secure the key (4) and the fitted half coupling using a set pin (5) using the specified tightening torque  $T_A$  (M5 → approx. 2.5Nm, M8 → approx. 10Nm). Use a "medium-tight" screw locking adhesive for this purpose.
6. Check that the half coupling is seated correctly.
7. Fit the motor onto the adapter; the coupling claws must engage with the coupling star (6) on both sides.
8. Fasten the motor onto the adapter using the appropriate fastening screws (observe screw tightening torques see table 1, minimum strength class 8.8).

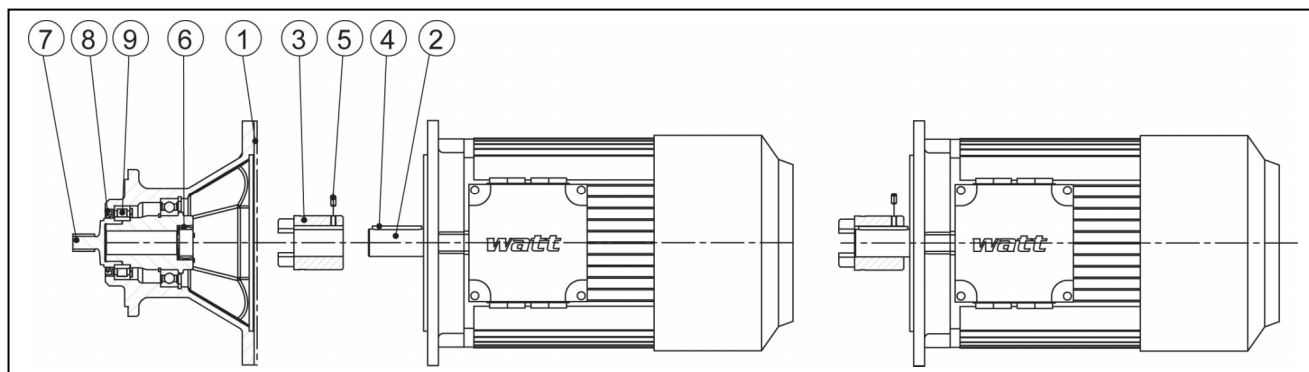


Figure 1: Installing an IEC motor

Screw property class 8.8	
Thread	Tightening torque Ma [Nm] - tolerance +10%
M5	5,5
M6	10
M8	25
M10	45
M12	75
M16	190
M20	380
M24	650

Table 1: screw tightening torques