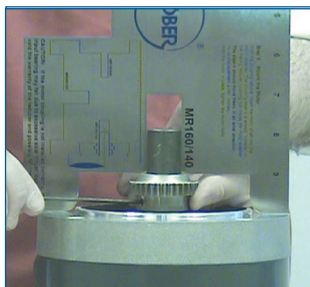


Step 1 Place motor coupling on the motor shaft.

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 1.

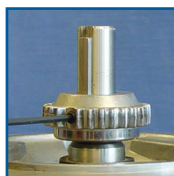
For a fast, accurate alternative mounting method, use the STOBER Motor Hub Mounting Gage.



Step 2 Tighten the setscrew*.

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

** Setscrews are NOT over the key in some sizes.*



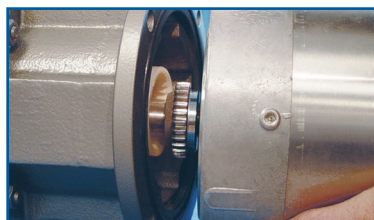
Step 3 Secure the motor key.

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.



Step 4 Mount the motor.

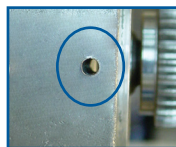
With the coupling secure, insert the motor shaft into the motor adapter. The coupling sleeve is already installed on the mating reducer coupling hub inside the motor adapter.



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.

Important: *Be sure the motor weep hole is plugged during washing or when the unit is in a wet environment.*



WEEP HOLE INFORMATION/PLUGGING NOT APPLICABLE TO cLEAN SYSTEM

Table 1

Adapter Part Number	“XL”*		Set Screw Torque
	mm	inches	Nm
Location of “MR” Motor Coupling			
MR140/050	24	0.94	2
MR160/050	30	1.18	2
MR160/140	29	1.14	2
MR200/050	40	1.57	10
MR200/140	42	1.65	10
MR200/180	36	1.42	10
MR250/180	36	1.42	10
MR250/210	33	1.30	10
MR300/180	56	2.20	10
MR300/210	53	2.09	10
MR300/250	53	2.09	10
MR300/280	53	2.09	10
MR350/320	63	2.48	17
MR350/360	63	2.48	17

Location of “MS-R” Motor Coupling

MS1R050	24	0.94	2
MS2R050	26	1.02	2
MS2R140	29	1.14	2
MS3R050	24	0.94	2
MS3R140	29	1.14	2
MS3R180	36	1.42	10
MS4R050	24	0.94	2
MS4R140	29	1.14	2
MS4R180	36	1.42	10

Location of “ML” Motor Coupling

ML2R050	24	0.94	2
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*“XL” Tolerance = +1mm / -0mm (+0.040 / -0.000 in)

Restriction for Food Duty Speed Reducer Installations

Safety labels cannot be placed on food duty units. These labels are included with the unit and must be placed in an area visible to the equipment operator.



For ease of NEMA/cLEAN motor coupling hub location and installation, the STOBER motor hub mounting gage is designed to fit most sizes of “MR” style motor adapters (used with C, F, K and S units). There is a separate gage for KSS units.

This simple-to-use gage makes it easy to position the motor coupling hub on the shaft quickly and accurately, insuring maximum motor/speed reducer performance and life.

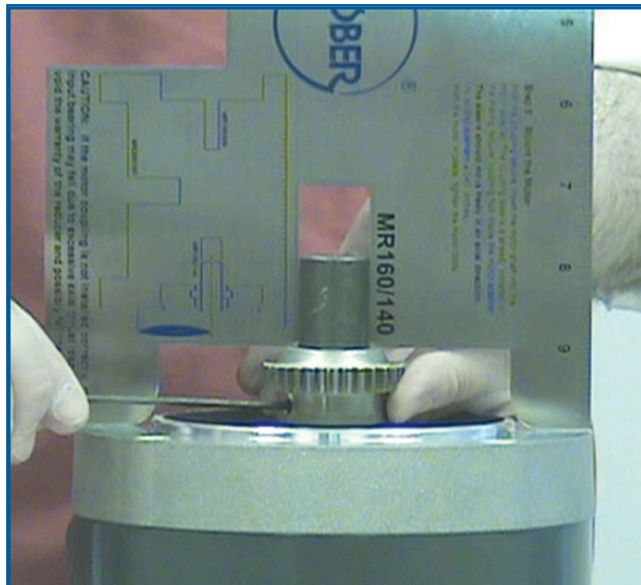
A paper motor hub mounting gage is included with each MGS speed reducer order or cLEAN System order. To order additional gages, paper or stainless steel, use the part numbers listed on the facing page. Contact STOBER to order.

Step 1 Locate the side of the gage that matches the motor adapter of the reducer. The part number on the nameplate will indicate this number.

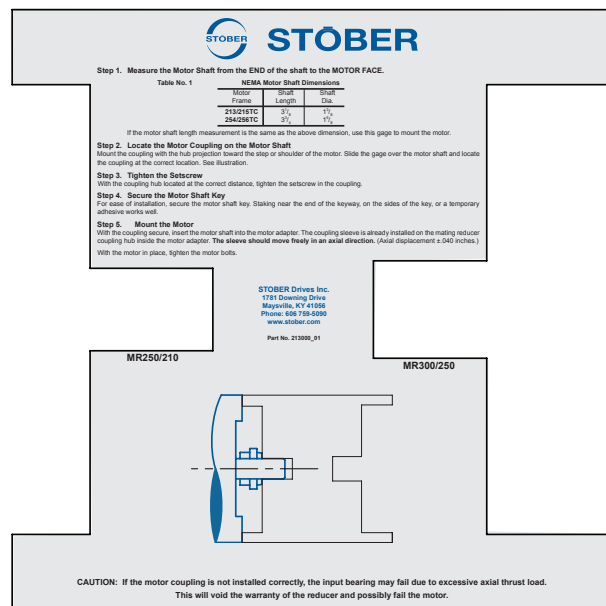
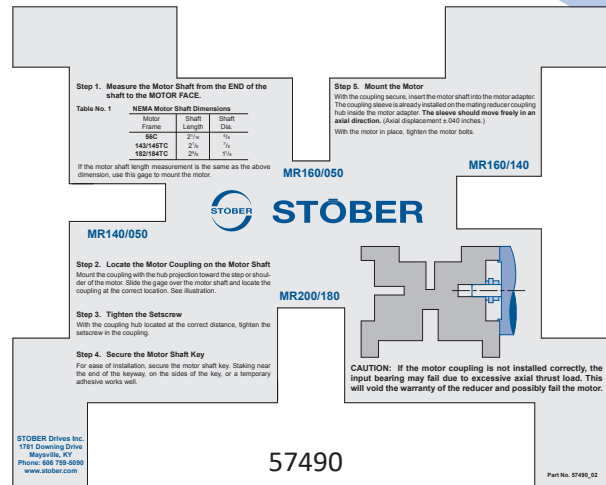
Step 2 Place the coupling hub on the motor shaft.

Step 3 Place the gage on the motor face, over the motor shaft, and hold the coupling flush with the counter-bore of the gage.

Step 4 Tighten the setscrew. Follow the motor mounting instructions.



Paper/Stainless Steel Motor Hub Mounting Gages



Description	Part #	
	Paper	Stainless Steel
Gage for use with MR140/050, MR160/050, MR160/140 and MR200/180 adapters	57490	5000070
Gage for use with MR 250/210 and MR300/250 adapters	213000	5000069
Gages for use with KSS Series all MS style adapters	5000085	5000084