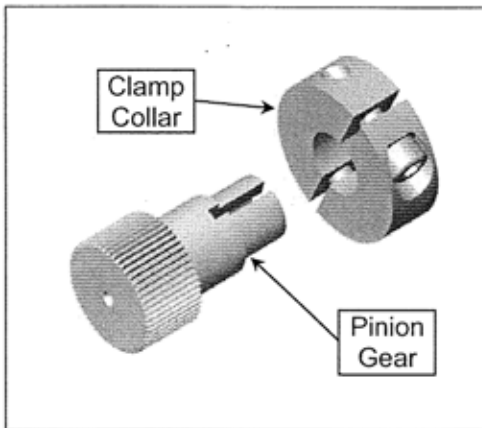
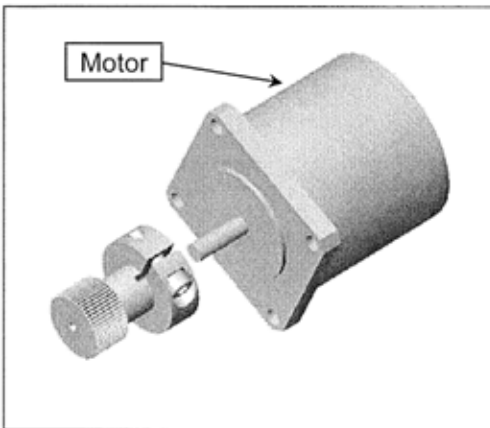


Planetary Gearhead Installation Instructions for GC, GCP Series with and without Right Angle

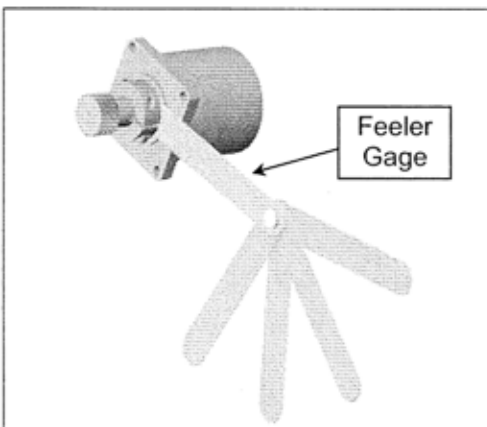
NOTE: if the gearhead is to operate with its output shaft pointing upward, call Dynetic Systems Sales or Engineering Departments for extra grease packets and instructions on how to seal the gearhead to the motor's mounting surface.



(Fig 1)



(Fig 2)



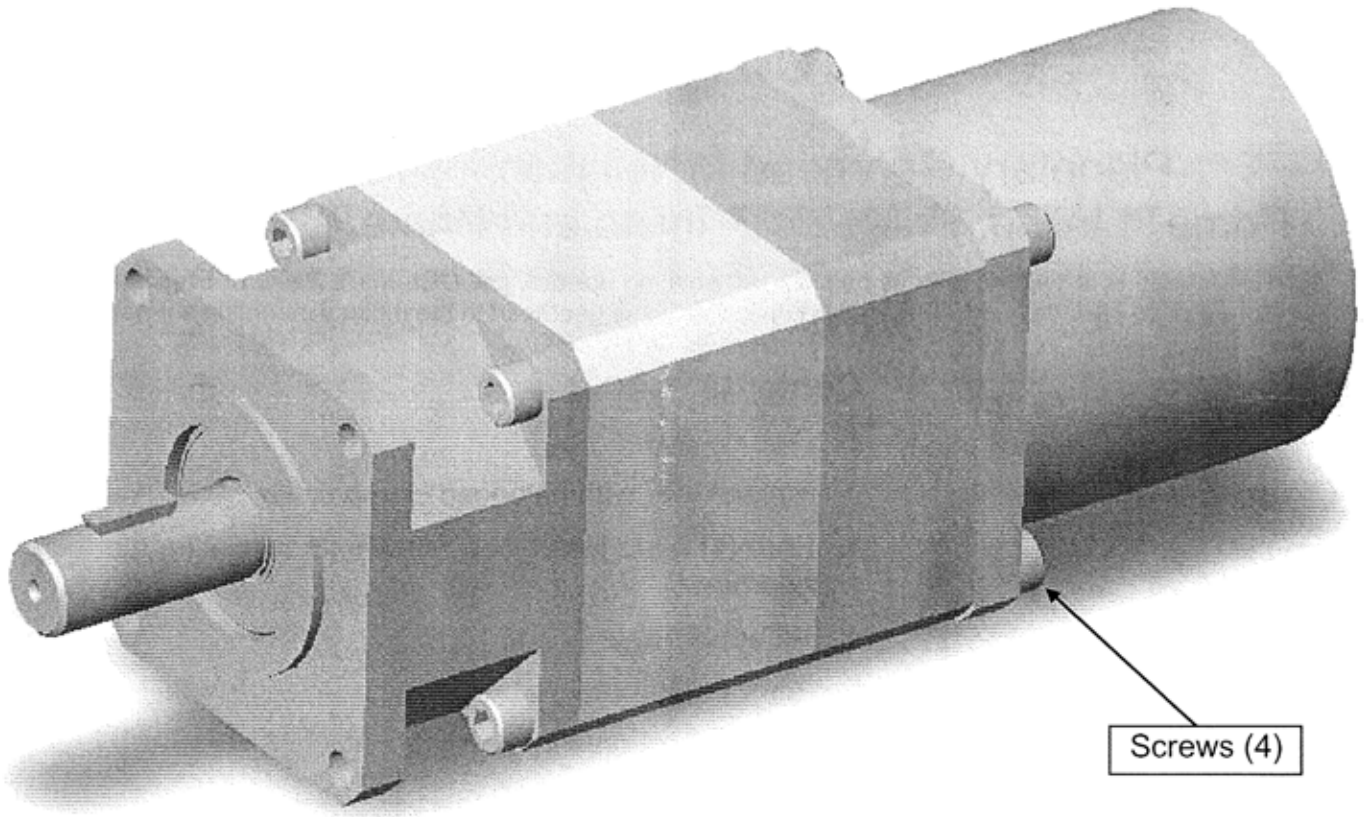
(Fig 3)

Contents

1. Planetary Gearhead.
2. Pinion Gear with balanced clamp collar.
3. Four (4) Allen Head Cap Screws for mounting the motor to the gearhead.
4. Woodruff Key.
5. Allen Wrench(es).
6. This Instruction sheet.

Assembly Sequence

1. Slide the clamp collar fully onto the Pinion Gear (fig 1).
2. Gently tighten the two (2) screws on the clamp to remove any loose clearance – keep the distance of the gap at each end of the clamp approximately equal.
3. Slide the Pinion Gear with the clamp onto motor shaft (fig 2).
4. Insert the proper thickness feeler gage (see: Table A, Clamp Screw Torques, on back) between the Pinion Gear and motor pilot (fig 3). Note: Feeler Gage not supplied.
5. Tighten the two (2) clamp screws evenly and firmly; then remove the feeler gage.
6. **IMPORTANT:** Torque the two (2) screws on the clamp to the proper torque. (see: Table A, Clamp Screw Torques, on back).
7. Position the motor/pinion assembly vertically on a bench with the Pinion Gear upwards.
8. Lift and vertically orient the gearhead over the motor. Carefully and slowly lower the gearhead onto the Pinion Gear. Proper alignment will be necessary.
9. When the Gearhead makes contact with the Pinion Gear, rotate the gearhead to allow the gear teeth to align themselves. The unit will find its alignment quickly – then lower the gearhead fully into position.
10. Lay the assembly on a flat surface and install the motor mounting screws – tighten with Allen Wrench (fig 4, on back).



(Fig. 4)
 Completed Assembly
 GC Gearhead with Motor

Table A
Pinion Gear Positioning and Clamp's Screw Torques

Unit Size	Screw Size	Screw Torque (Nom.)	Distance
Size 17	4-40	10 lb·in	.047
Size 23	8-32	28 lb·in	.047
Size 34	10-32	45 lb·in	.094
Size 42	¼-28	110 lb·in	.094
Size 56	¼-28	110 lb·in	.094
Size 75	¼-28	110 lb·in	.094

Customers will need a torque wrench with the proper Allen Wrench tip.