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F O R M
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TorqTaper® Plus Motor Mount Installation Instructions

⚠ WARNING

- Read and follow all instructions carefully.
- Disconnect and lock-out power before installation and maintenance. Working on or near energized equipment can result in severe injury or death.
- Do not operate equipment without guards in place. Exposed equipment can result in severe injury or death.

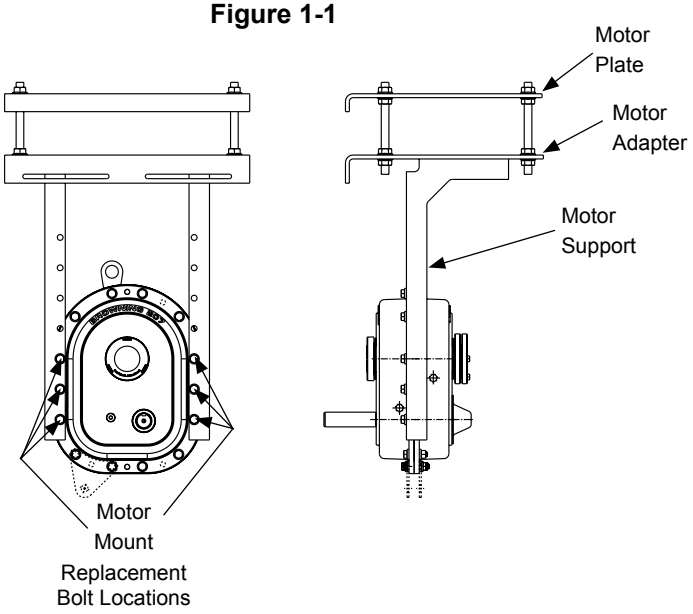
⚠ CAUTION

- Periodic inspections should be performed. Failure to perform proper maintenance can result in premature product failure and personal injury.

1. Motor Mount Installation Instructions

1.1 Top (6 O'clock) or Bottom (12 O'clock) Motor Mount Installation Instructions (Size 107 through 315)

Figure 1-1



1.1.1 Remove the three housing flange bolts and washers on each side as shown in Figure 1-1.

1.1.2 Install the motor supports, using the longer bolts furnished with the motor mount kit. One support is used on each side of the unit on the input shaft side of flange. Additional holes are provided for various center distances.

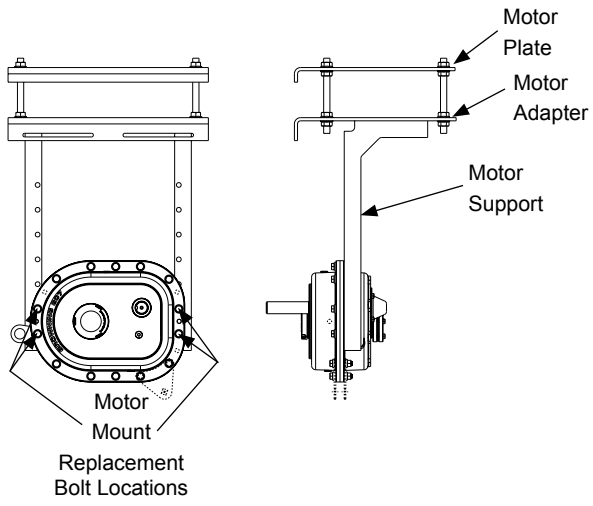
1.1.3 Install all flange bolts and washers against flange at this time but do not tighten.

1.1.4 Install the motor adapter; using the capscrews provided, tightening the capscrews to the recommended torque. (See bolt torque specifications section 2.)

1.1.5 Tighten the reducer flange bolts to the recommended torque. (See bolt torque specifications section 2.)

1.2 Side Motor Mount Installation Instruction (3 O'clock or 9 O'clock) (Size 107 through 315)

Figure 1-2



1.2.1 Remove the housing flange bolts as shown in Figure 1-2.

1.2.2 Install the motor supports, using the longer bolts furnished with the motor base adapter. One support is used on each side of the unit on the side of flange opposite the input shaft.

1.2.3 Install all flange bolts at this time but do not tighten.

1.2.4 Install the motor adapter; using the capscrews provided, tighten the capscrews to the recommended torque. (See bolt torque specifications section 2.)

1.2.5 Tighten the reducer flange bolts to the recommended torque. (See bolt torque specifications section 2.)

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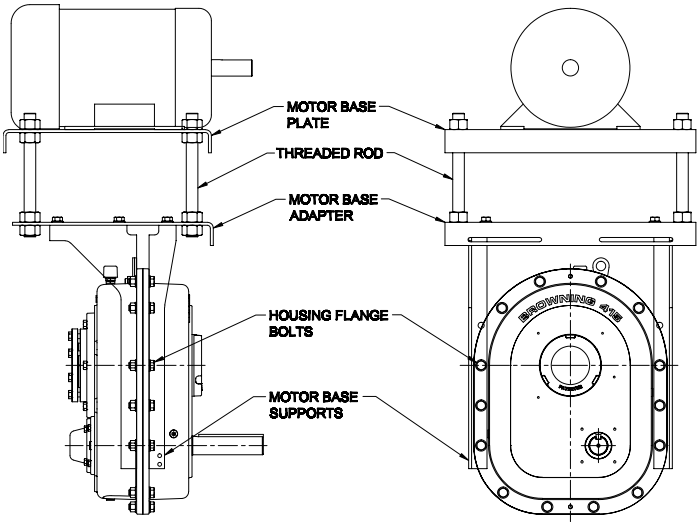
1.3 Top (6 O'clock) or Bottom (12 O'clock) Motor Mount Installation Instructions

(Size 407 through 800)

1.3.1 Remove the housing flange bolts along the sides only of the reducer.

1.3.2 Install the motor base supports, using the longer bolts furnished with the motor base adapter. Two supports are used on each side unit of the 407 - 608 reducers. (See Figure 1-3.)

Figure 1-3



1.3.3 Install all flange bolts at this time but do not tighten.

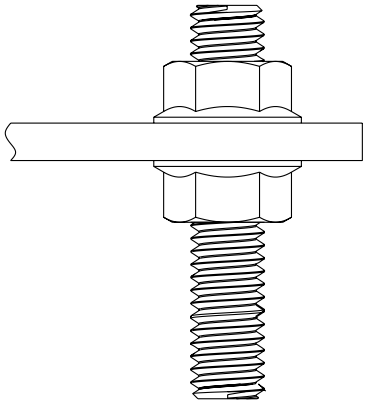
1.3.4 Install the motor base adapter; using the capscrews provided, tightening the capscrews to the recommended torque. (See Table No. 7.)

1.3.5 After completing step 1.3.4, tighten the reducer flange bolts to the recommended torque. (See Table No. 1.)

1.4 Motor Plate Installation Instructions

1.4.1 Install a nut on each end of the four threaded rods and position nuts approximately 2" from each rod end. (Refer to Figure 1-4 for correct installation of flange nuts.)

Figure 1-4
Detail of flanged nut installation on threaded rod.



1.4.2 Insert threaded rods in the four corner holes of the motor base adapter that match holes in motor base plate and install bottom nut flange end first on each rod but do not tighten.

1.4.3 Position motor base plate over threaded rods and install top nuts, flange end but do not tighten.

1.4.4 Mount motor using holes in motor base plate that match the holes in the base of the motor following motor manufacturer's recommendations.

1.4.5 Using adjusting nuts, lower motor to its lowest position. This can be done by either letting the threaded rods extend above the motor base plate or below the motor base adapter. Either way is acceptable, but nearly equal amounts of threads should be showing.

1.4.6 Mount and align sheaves on motor and input shaft of reducer.
Note: The sheave should be positioned as closely to the reducer housing as possible to reduce overhung load on the input bearings.

1.4.7 Adjust the belt alignment by sliding the motor base plate to the correct position. Mount and adjust belts to the recommended tension by raising the motor equally at all four adjusting rods to assure that the motor base plate remains parallel to the input shaft at the final adjustment. Tighten the flanged nuts.

1.4.8 Recheck to be sure all nuts and bolts are tight, sheaves are in alignment and belts are properly tensioned.

2. Bolt Torque Specifications

REDUCER SIZE	HOUSING FLANGE		MOTOR ADAPTOR	
	BOLT SIZE	FT. LBS	BOLT SIZE	FT. LBS
107	5/16-18	16	5/16-18	16
115	3/8-16	29	3/8-16	29
203	7/16-14	46	7/16-14	46
207	1/2-13	70	1/2-13	70
215	1/2-13	70	1/2-13	70
307	5/8-11	140	1/2-13	70
315	5/8-11	140	1/2-13	70
407	5/8-11	140	3/4-10	250
415	3/4-10	250	3/4-10	250
507	3/4-10	250	3/4-10	250
608	3/4-10	250	3/4-10	250
800	1-8	600	3/4-10	250

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