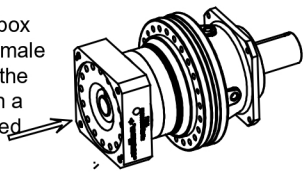
GEARBOX COMMISSIONING INSTRUCTIONS

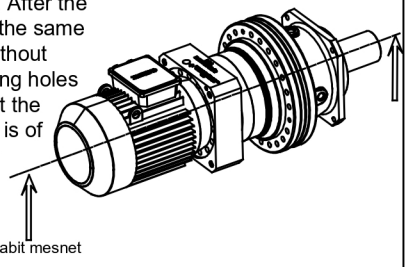
Please read operation instructions before operating!

1-**GEARBOX MOTOR CONNECTION**: While the motor is mounted on the gearbox input body, it should sit in a comfortable position without straining in the female-male connections. Even if the gearbox will operate horizontally as much as possible, the motor connection should be made in a vertical position. Fixing bolts should be in a slightly tight position by taking their mutual gaps, the gear unit should be operated at idle and the noise of the gearbox should be checked. If there is no contrary situation, the other bolts should be tightened and fixed.

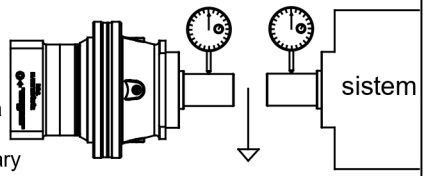


2-GEARBOX OPERATION: After the gear unit motor connection is made as above, the gear unit should be operated for 20 minutes in increments of 1/4 of its operating speed in 5 minute periods without being exposed to any load. The noise and temperature of the gearbox should be checked during operation.

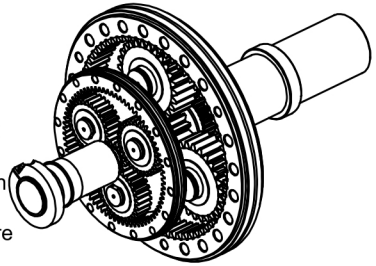
3-GEARBOX FIXING: If the working position is horizontal after the motor is mounted on the gearbox input body, it must be fixed by the motor feet. After the motor is fixed from the foot, it must be ensured that the centers are at the same height to the gearbox fixing point and that the gearbox is connected without straining. While it is fixed to the surface where it will sit through the fixing holes on the gearbox, it should be fixed in the same way by making sure that the tightening torques are equal and that it does not contract. If the output is of spindle-spline type, it should be at least -1mm in length from the slot it sits on. If the output thread is of spline/slot type, the same dimension gap must be checked.



4- GEARBOX COMMISSIONING: After the gearbox system connection is made, depending on the type of use, when transmission such as coupling, chain, belt is used, after the transmission of the movement, the oscillation of the link to which the movement is transferred with the oscillation of the gearbox output must be absolutely checked. If the axis is parallel, only the runout control will be sufficient. If the axes are not on a single axis such as a chain or a timing belt, a bearing must be made against the gearbox shaft and the system shaft. Stretching the belts and chains more than necessary during the transmission will damage the system dynamics and cause oil leaks and bearing-gear failures in the future. Please consider the connection type as well as the catalog values while making your product selection. The same parameters are valid in cases where the motion does not pass directly from the motor to the gearbox. In case of pulley-chain-belt in the inlet section, counter bearing must be applied and it must be ensured that the movement without runout is transferred to the gearbox.



coupling or parallel axis
chain – belt connection



5-GEARBOX CONTROL: Gearbox oil levels should be filled to the maximum level in the vertical position, at least half full in the horizontal positions, during the first start-up. Oil expansion tank must be used in vertical positions. The cooler must be integrated into the system at high speeds. The gear unit will have completed its acclimatization period after 5 working days after commissioning. After this process, since there will be metal dust in the oil in the gearbox, the first commissioning oil should be drained and replaced with new oil. It should be checked that the plugs on the gearbox are closed and it should be ensured that there is no leakage.

6- WARNING : In case of noise or oil leakage from the gear unit after all gear unit commissioning procedures are performed, the body parts of the gear unit should not be disassembled and any part on the gear unit should not be deformed. Gearbox assembly that is not done in accordance with the assembly instructions is entirely at the discretion of the customer and PDS Planetary Gearbox Systems is not responsible for any malfunctions or system problems.

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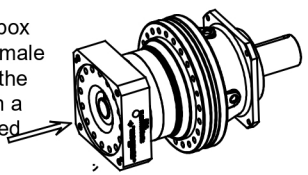

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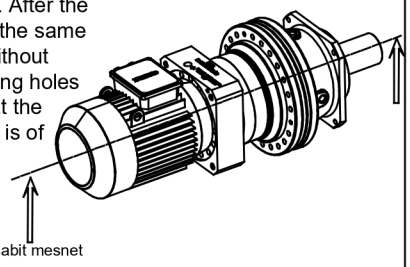

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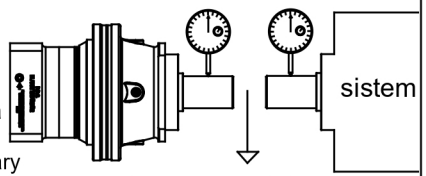
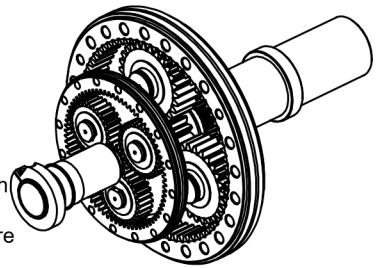


coupling or parallel axis
chain – belt connection



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2023