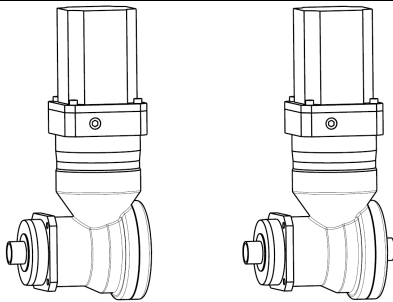




# Assembly Instructions – Shrink disc

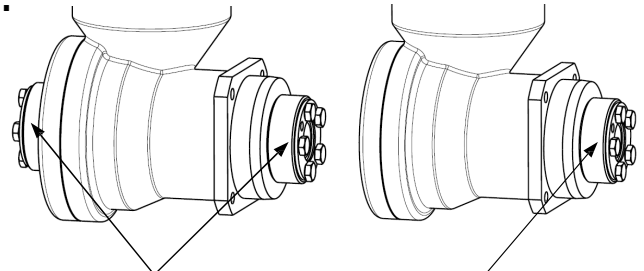
## 8GA75 single / double hollow shaft

1.



Was the gearbox properly mounted onto the motor?  
8GA75 double -sided: Included assembly instructions  
8GA75 single hollow shaft: Included assembly instructions

2.

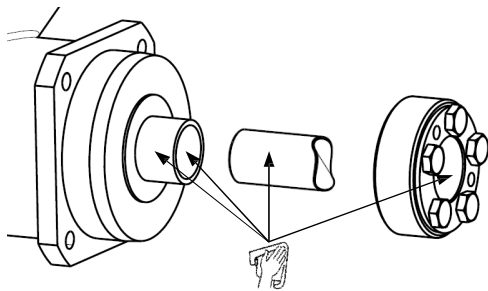


double - sided

single hollow shaft

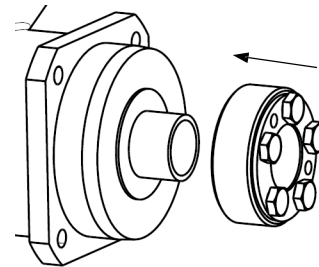
Attachment options for the shrink disc.

3.



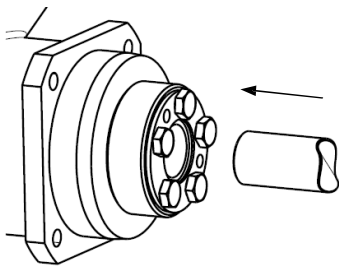
Check the shaft for diameter tolerance h6.  
Clean the components free of grease as shown in the figure.

4.



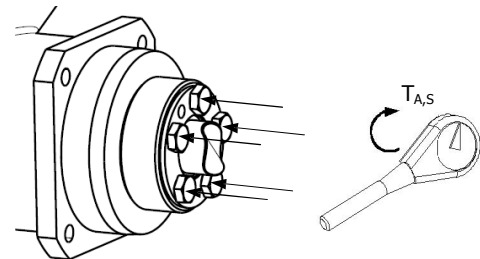
Pushing the shrink disc onto the gearbox's hollow shaft.

5.



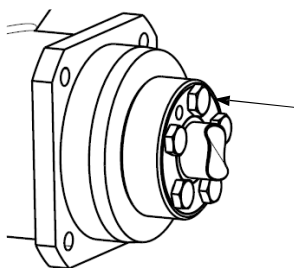
Push in the shaft (h6) at least to the minimum fitting length (see data sheet). Caution: The tensioning screws of the shrink disc may not be tightened as long as there is no shaft in the gearbox's hollow shaft. Tightening the tensioning screws without a shaft would deform the gearbox's hollow shaft.

6.



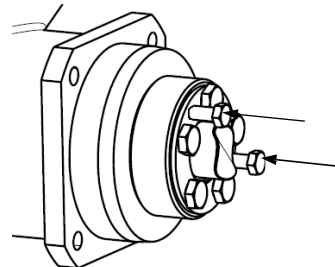
Tighten the shrink disc's tensioning screws evenly in stages one after the other in several circuits up to the maximum permitted tightening torque  $T_{A,S}$ .

7.



Check whether the front surfaces of the outer and inner rings are aligned. Only when this is the case, has the correct tightening state of the shrinkage disk been achieved. It is recommended to check all tensioning screws one after the other twice with maximum tightening torque  $T_{A,S}$ .

8.



Disassembly:  
Loosen all tensioning screws in stages in several circuits. Do not screw the tensioning screws out of the thread completely. Screw in separate screws into the forcing thread until the outer and inner rings are separated.

Shrink disc for gearbox	8GA75-070	8GA75-090	8GA75-115	8GA75-142
Screw size M	6	6	8	8
$T_{A,S}$ [Nm]	12	12	30	30
SW* [mm]	10	10	13	13

\* Wrench width