

## 755 Flex Mounting Instructions

After carefully unpacking the unit, inspect and ensure that the motor shaft is the correct size and free of all burrs and aberrations.

*The maximum recommended motor axial endplay is  $\pm 0.030$ ". Maximum motor TIR is 0.007".*

### STEP 1

Slide the Model 755A encoder over the motor shaft.

### DO NOT USE UNDUE FORCE

The encoder should be positioned so that the flex mount arms just touch the mounting surface. Install two 4-40 screws through the holes in the flex mount and tighten onto the motor to a torque of 115 to 160 oz-in. For additional security, a drop of Loctite 242 can be added to the threads of the screws.

### STEP 2

Tighten the two set screws in the encoder's shaft to a torque of 50 to 80 oz-in. For additional security, a drop of Loctite 242 can be added to the threads of the set screws. Do not allow Loctite to run into the bore or onto the bearings.

### STEP 3 (Slotted flex mount option only)

For encoders with the slotted flex mount option, the home position can be fine-tuned by loosening the mounting screws and rotating the encoder to the desired position, then retighten the screws.

Alignment note: When turning the motor shaft by hand, the rocking movement of the encoder should be minimal. If it isn't, loosen the encoder bore set screws and reposition the encoder until this movement is minimal.

### IN CASE OF DIFFICULTY

Note 1: Make sure the two set screws in the encoder's shaft are backed off and do not protrude into the bore of the encoder. Clean the shaft of any burrs using fine crocus cloth.

Note 2: When tightening the two set screws, avoid holding the motor shaft with anything that may scar or burr the shaft.

### REMOVAL

1. Loosen (do not remove) the two set screws in the encoder bore. Remove the flex mount screws and slide the encoder off.

If you have questions regarding this Technical Bulletin, please call Technical Support at (800) 366-5412 or email [techsupport@encoder.com](mailto:techsupport@encoder.com).

TB-507.doc, Rev B, 05/02/02