

## 702 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 702 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 4-40 or 6-32 screws through the holes in the flex mount and tighten onto the motor to a torque of 115 to 160 oz-in. for the 4-40 screws and 150 to 200 oz-in. for the 6-32 screws. For additional security, a drop of Loctite 242 can be added to the threads of the screws.

### STEP 2

Tighten the screw(s) in the encoder's shaft to a torque of 50 to 80 oz-in. for shaft set screws or 115 to 160 oz-in. for the shaft clamp screw. 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 (Only necessary for adjusting the home position)

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 screws and reposition the encoder until this movement is minimal.

### IN CASE OF DIFFICULTY

Note 1: Make sure the screw(s) in the encoder's bore 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 screw(s), avoid holding the motor shaft with anything that may scar or burr the shaft.

### REMOVAL

1. Loosen (do not remove) the screw(s) 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).

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