



# Tightening Motor Coupler on Servo Motors

*Elevation coupler is excluded because it is keyed and adjustment should not be needed.*

## For Gripper Coupling (Output):

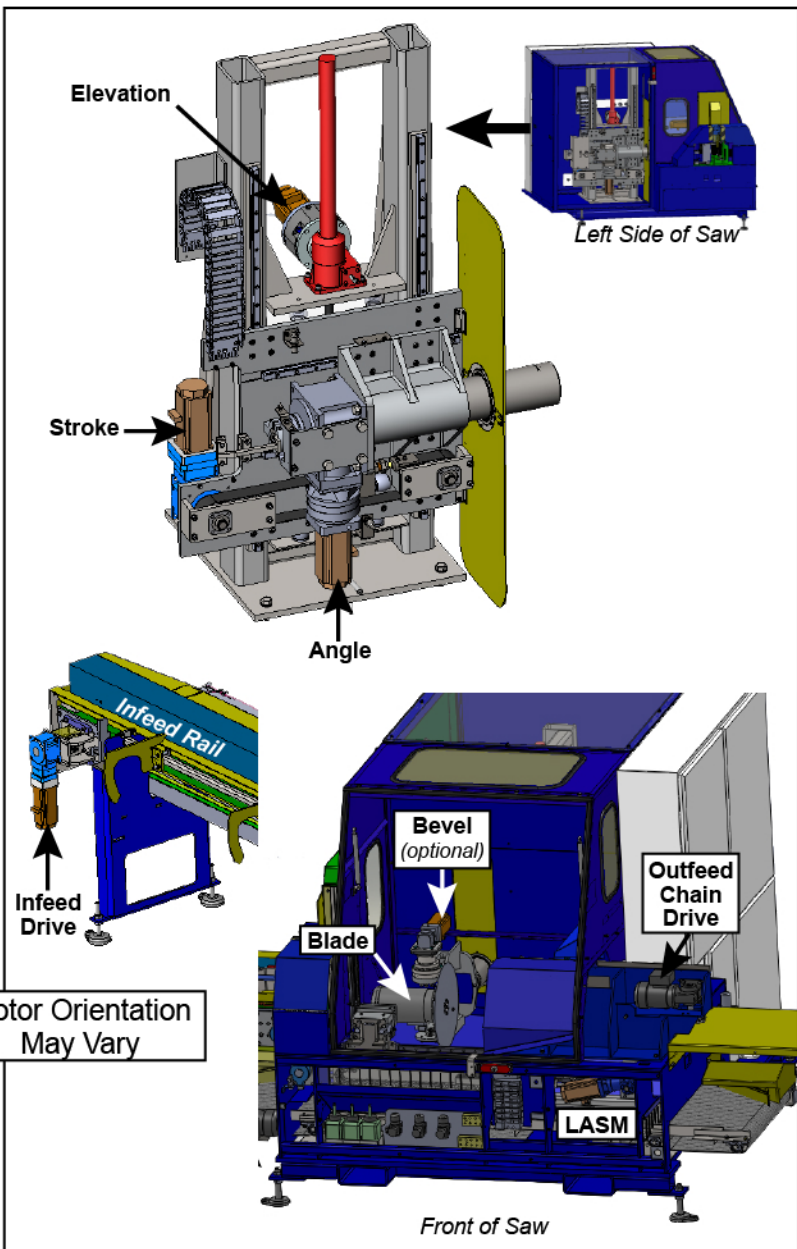
1. Remove the guard to expose the coupling at the Output screws.
2. With E-stop actuated, move axis with your hand.
3. Torque both screws.

## For LASM, Stroke, Gripper, and Angle Servo Motors (Input):

1. Remove the plug labeled INPUT in photo to access the hole.
2. Align the screw with hole by either:
  - a) *For LASM, Stroke, and Gripper only:*  
With E-stop actuated, move axis with your hand.
  - OR
  - b) *This method can be used for all 5 axes:*  
With power on, use the Moving to a Position procedure below.
3. Torque the screw to the appropriate setting using a torque wrench and hex key.

*Gripper motor shown here. Other axes have similar assembly.*

OUTPUT			INPUT		
Motor	Torque	Hex-Head Socket	Motor	Torque	Allen Wrench
LASM	44 in-lbs	-mm	LASM	89 in-lb	4-mm
Stroke	106 in-lbs	-mm	Stroke	159 in-lb	5-mm
Angle	106 in-lbs	-mm	Bevel	50 in-lb	3-mm
Gripper	309 in-lbs (2 places)	6-mm	Angle	177 in-lb	5-mm
			Gripper	89 in-lb	4-mm



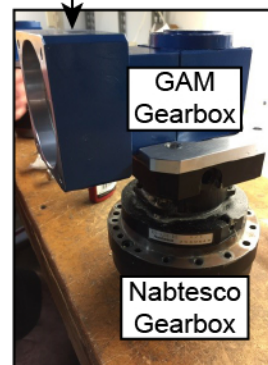
## For Bevel Servo Motors (Input & Output):

Use steps above, but refer to the pictures below.



GAM Input Shaft Coupling Bolt  
50 in-lbs

GAM Output Shaft and Nabtesco Input Shaft Coupling Bolt  
120 in-lbs



## Moving to a Position:

Enter small position changes in *Diagnostics>Detailed Diagnostics>Move To Position* fields to move motor coupler in small increments.