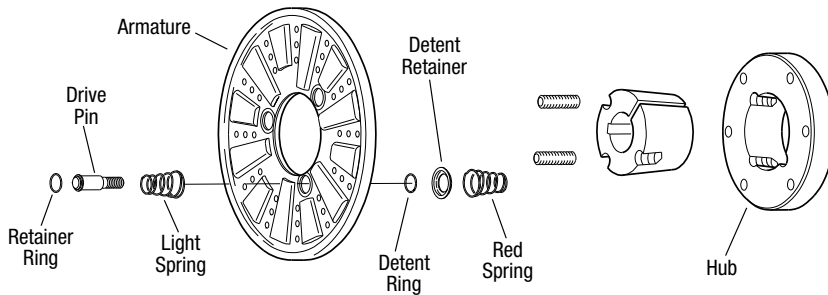


# Autogap Installation for Sizes 825-1225 Motor Brakes

## Installation Instructions

**P-1375-WE**  
**819-0081**



**⚠ WARNING** Failure to follow these instructions may result in product damage, equipment damage, and serious or fatal injury to personnel.

### Assembling the Armature and Hub

Assemble the armature to the armature hub with the autogap mounting accessory. Follow these instructions to assemble the armature and hub.

1. Apply Loctite® #242 (or #290, or equivalent) to drive pin threads. Insert the drive pin into the hub and tighten until the shoulder of the pin is against the hub. (Figure 1)
2. Assemble the red spring over the drive pin. The smaller diameter of the spring should be against the hub.
3. Place the detent retainer over the pin. The cupped-out portion should be against the spring. (Figure 2)
4. Place the detent ring on the pin and press it into the recessed portion of the detent retainer. (Figure 2)
5. Slide the detent ring towards the hub to allow about 1/2" between the ring and head of the pin. (Figure 3)
6. Slide the armature on the pins. The face of the armature should be towards the hub.

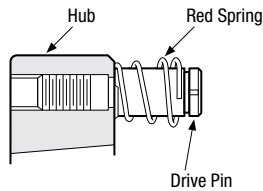


Figure 1

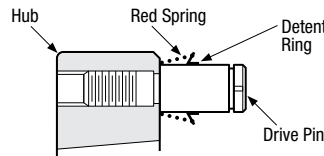


Figure 2

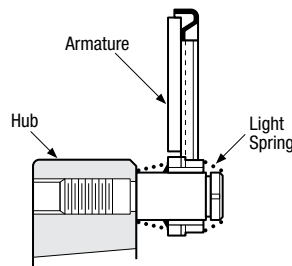


Figure 3

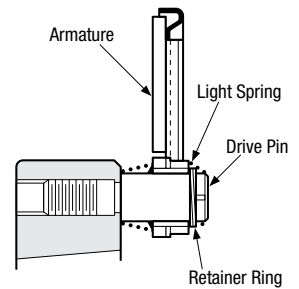


Figure 4

7. Assemble the light spring over the pin. The large diameter of the spring should be against the armature. (Figure 4)
8. Compress the spring to allow the retainer ring to be snapped into the groove at the head of the pin.

### Mounting the Armature-Hub Assembly (See Figure 5)

1. Insert taperlock bushing into the bore of the hub.
2. Loosely insert the locking setscrews and slide the assembly on to the shaft.
3. Position the assembly to allow a gap of 1/16" between the faces of the armature and magnet.
4. Secure the assembly in this position by alternately tightening the locking setscrews. The bushing should be tapped lightly from time-to-time to make sure it seats-in properly.
5. Set the autogap by pressing the armature into contact with the friction face and then releasing the armature. The armature should spring back approximately 1/32". Once this gap is set it will be automatically maintained throughout the life of the unit.
6. Use capscrews and lockwashers to bolt adapter cover.

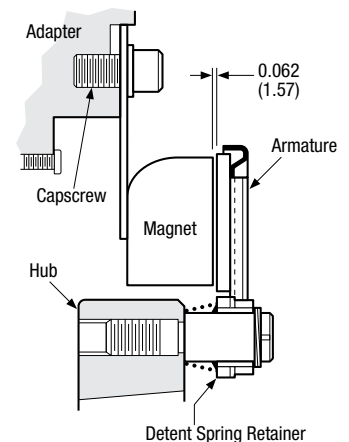


Figure 5

## Warranty

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