

## Torque-Arm™ Speed Reducer Bottom Motor Mounts

TAB1  
TAB2

TAB3  
TAB4

TAB5  
TAB6

TAB7  
TAB8

TAB9  
TAB10

### Installation and Instruction Manual

These instructions must be read thoroughly before installation or operation. This instruction manual was accurate at the time of printing. Please see [dodgeindustrial.com](http://dodgeindustrial.com) for updated instruction manuals.

**WARNING:** To ensure that drive is not unexpectedly started, turn off and lock out or tag power source before proceeding. Remove all external loads from drive before removing or servicing drive or accessories. Failure to observe these precautions could result in bodily injury.

**WARNING:** Ensure that all guards are properly installed before proceeding. Exercise extreme care to avoid contacting rotating parts. Failure to observe these precautions could result in bodily injury.

## INSTALLATION

**Note:** The motor mount does not limit the position of the reducer. However, it must be installed on input end of reducer as shown in Figure 1

1. Install reducer on driven shaft and detach the Torque-Arm and adapter plates from the reducer by removing the two housing bolts holding the adapter plates in place.
2. Remove up to two additional housing bolts (as required) on input end of reducer. Install back support (2) and front support (1) with new housing bolts (5). Install mounting bolts (8).
3. Disassemble Torque-Arm from adapter plates and reattach to bottom motor mount in one of the three available holes on the front support. Position Torque-Arm between long and short spacer bushings (16 and 17) as shown in Figures 1 and 2. Secure using Torque-Arm bolt (18).
4. Securely fasten Torque-Arm fulcrum and properly tension Torque-Arm. The angle of the Torque-Arm with an imaginary line between the point of attachment to the motor mount and the output hub of the reducer should be  $90^\circ \pm 20^\circ$ .
5. Install mounting plate (3) with adjusting studs (6) as shown in Figure 2.

6. Assemble the front motor rail (4) by loosely bolting through the two front holes on each side of the mounting plate (3) with mounting rail bolts (12).
7. Measure the distance between the front and rear mounting holes of the motor. Position the rear motor rail to this distance and loosely bolt to the mounting plate.
8. Center the motor on the rails. Use a plain washer under each slot in the motor rails when motor mounting bolts are less than 5/8" diameter. Bolt motor snugly to motor rails.
9. Install motor sheave and reducer sheave on their shafts as close as possible to the motor and reducer housings.

**Note:** The motor rails may be moved forward or backward from the position shown in Figure 1 to permit alignment of the V-belt sheaves.

It is permissible for the front motor rail (4) to extend beyond the mounting plate (3). Align the V-belt sheaves carefully and tighten all bolts securely.

10. Install V-belts and adjust belt tension. Figure 1 shows the mount near the minimum center position. To increase the center distance, loosen the four nuts labeled "A" on the adjusting studs and tighten the four nuts labeled "B" alternately and evenly until the belts are properly tensioned.
11. Check all bolts to see that they are securely tightened.

**WARNING:** Because of the possible danger to person(s) or property from accidents which may result from the improper use of products, it is important that correct procedures be followed. Products must be used in accordance with the engineering information specified in the catalog. Proper installation, maintenance and operation procedures must be observed. The instructions in the instruction manuals must be followed. Inspections should be made as necessary to assure safe operation under prevailing conditions. Proper guards and other suitable safety devices or procedures as may be desirable or as may be specified in safety codes should be provided, and are neither provided by Dodge® nor are the responsibility of Dodge. This unit and its associated equipment must be installed, adjusted and maintained by qualified personnel who are familiar with the construction and operation of all equipment in the system and the potential hazards involved. When risk to persons or property may be involved, a holding device must be an integral part of the driven equipment beyond the speed reducer output shaft.

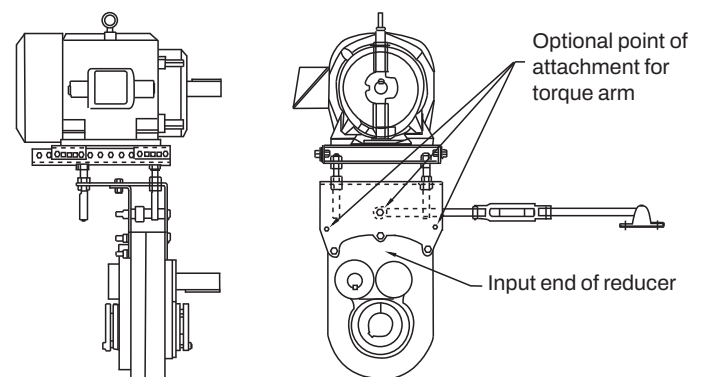
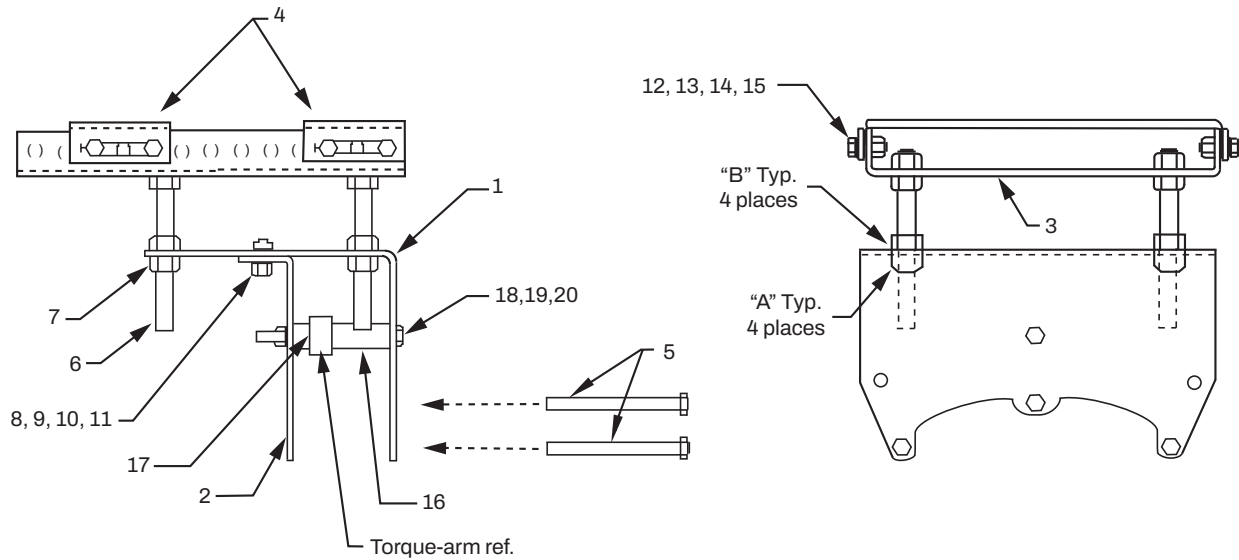


Figure 1 - TAB Bottom Motor Mount



**Figure 2 - TAB Bottom Motor Mount Parts**

Ref. No.	Part Description	Qty.	TAB1	TAB2	TAB3	TAB4	TAB5	TAB6	TAB7	TAB8	TAB9	TAB10
1	Front Mounting Support	1	241423	242423	243406	244406	245407	246394	247406	248408	249406	250412
2	Back Mounting Support	1	241422	242422	243405	244405	245406	246393	247405	248407	249405	250413
3	Bottom Plate	1	241404	241404	245404	245404	245404	245404	245404	248405	248405	248405
4	Motor Rail	2	241405	241405	349002	349002	349002	349002	349002	248404	248404	248404
5	Housing Bolt		411731	411731	411732	411735	411735	411735	411300	411737	411737	411745
6	Threaded Stud	4	408001	408001	408003	408003	408003	408003	408003	408591	408591	408591
7	Hex Nut	16	407122	407122	407279	407279	407279	407279	407279	407281	407281	407281
8	Mounting Support Bolt	2	411072	411072	411099	411099	411099	411102	411102	411102	411102	411102
9	Hex Nut	2	407129	407129	407282	407282	407282	407282	407282	407282	407282	407282
10	Lockwasher	2	419137	419137	419019	419019	419019	419019	419019	419019	419019	419019
11	SAE Washer	2	419071	419071	419078	419078	419078	419078	419078	419078	419078	419078
12	Motor Rail Bolt	8	411072	411072	411102	411102	411102	411102	411102	411105	411105	411105
13	Hex Nut	8	407129	407129	407282	407282	407282	407282	407282	407282	407282	407282
14	Lockwasher	8	419137	419137	419019	419019	419019	419019	419019	419019	419019	419019
15	SAE Washer	16	419071	419071	419078	419078	419078	419078	419078	419078	419078	419078
16	Long Spacer	1	241425	242424	243408	244408	245409	246396	247408	248410	248410	248411
17	Short Spacer	1	241424	242425	243407	244407		246395	247407	248409	248409	248409
18	Torque-Arm Bolt	1	411731	411092	411732	411735	411735	411735	411152	411744	411744	411746
19	Hex Nut	1	407129	407141	407141	407282	407282	407282	407122	407101	407101	407101
20	Lockwasher	1	419137	419139	419139	419019	419019	419019	419138	419141	419141	419141

2 required for TAB1. 3 required for TAB2 thru TAB7. 4 required for TAB8 thru TAB10. 2 of the total Housing Bolts required for TAB2 are supplied with the reducer.

245408 for TXT509B, TXT515B and TXT525B. 245420 for TXT505A.

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