



Spider Installation Tips

While installing the spiders to the drive motors it is important to understand and follow these points.

1. Never use any type of anti-seize or lubricant when installing the tapered fit components of the spider onto the drive motor shaft. The use of anti-seize lubricants on the tapered shaft will result in an incorrect torque value of the bolt and does not allow for a true interference fit of the tapered components.
2. Before assembling, ensure that both tapered components are clean. Use a brake cleaner spray to remove any contaminants on the surfaces and blow dry using compressed air.
3. Before installing the main spider retaining bolt, the bolt thread surface and threads in the drive motor shaft should be cleaned with brake clean and blown dry with compressed air.
4. Before assembly, apply Loctite primer and Loctite 271 red to the fastener's thread and to the female thread inside the blind hole of the shaft.
5. Replace the spider retaining bolt and lock washer. Do not reuse the spider retaining bolt. Once the bolt is torqued it has been stretched and needs to be replaced. Replacing the bolt will ensure the bolt can maintain its correct clamping force.
6. Tighten the spider retaining bolt to 350 ft-lbs.
7. Immediately run the unit on the floor for 10-15 minutes this will allow movement of the spider onto the tapered shaft. Check and retorqued to 350 ft. lbs after running.

