



REPLACEMENT INSTRUCTIONS

MOTOR REPLACEMENT KIT P/Ns 12-8064-01, -11

MOTOR P/Ns 20-2703-50, -51

PURPOSE

The purpose of these instructions is to provide a step-by-step method for removing and replacing the Group 42 motor assembly. Beck Group 42 motors are unitized assemblies that include the Self-Locking Mechanism (SLM).

Maintenance should be performed in a clean working environment. If possible, the drive should be removed from its mounting point and taken to a maintenance room or workstation.

REQUIRED TOOLS

- 1/2" socket or wrench
- 7/16" socket or wrench
- Scotch™ 847 gasket adhesive or equivalent
- Torque wrenches appropriate for 10 lb-ft and 72 lb-in

WARNING

Electrical shock hazard—disconnect power before proceeding. Remove the drive from line voltage and shut off any external power sources feeding the auxiliary switches.

PROCEDURE

Remove the old motor:

1. Remove power from the drive.
2. Remove the drive from its mounting position.
3. Remove the terminal enclosure cover by loosening the (6) 5/16-18 hex head captive screws (on Option 9 drives) or the (4) 5/16-18 hex head screws from the resistor cover (Option 7, 5, or 3 drives).
4. Remove the (4) 1/4-20 hex head screws from the capacitor cover and remove the cover.
5. Remove the (4) 5/16-18 hex head screws retaining the motor and carefully pull the motor away from the drive.
6. The motor wire connections can be accessed through the capacitor cover. There are three wires leading from the motor to connections within the drive; one black, one red, and one green. Record the connections of each of the three wires for installation purposes.
7. Disconnect the motor wires.

Inspect the drive gaskets:

8. Inspect the terminal enclosure cover gasket (or the resistor cover gasket) and the capacitor cover gasket and replace them, if necessary. If the gaskets are in good condition, skip to step 13.
9. Clean the gasket face on the drive body to remove all gasket material and adhesive. Inspect the cover mating face to ensure no gasket material exists, clean as necessary.
10. Apply a thin film of gasket adhesive to the mating face of the drive body.
11. Firmly press the new gasket into place and allow time for the adhesive to set before continuing.
12. Repeat steps 9–11 to replace any additional gaskets, if necessary.

Install the new motor:

13. Feed the motor wires into the drive and connect the motor wires to the appropriate leads on the drive (recorded in Step 6).
14. Reinstall the motor. Turn the Handwheel as necessary to allow the pinion to slide into and mesh with the gearing. Be careful not to pinch the motor wires between the drive body and the motor during installation. Screw the (4) 5/16-18 hex head screws into the mounting holes and tighten them to 10 lb-ft torque in a crosswise pattern.
15. Reinstall the capacitor cover and torque the (4) 1/4-20 hex head cap screws to 72 lb-in.
16. Reinstall the terminal enclosure cover (or the resistor cover) and torque the 5/16-18 hex head screws to 10 lb-ft.

Continued

Test for proper drive response:

17. If the drive has been removed from its mounting location for maintenance, reinstall it.
18. Connect power to the drive.
19. Operate the Handswitch to observe the motor and drive for proper operation.
20. If the drive responds correctly, return the drive to service.

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