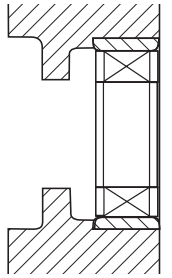


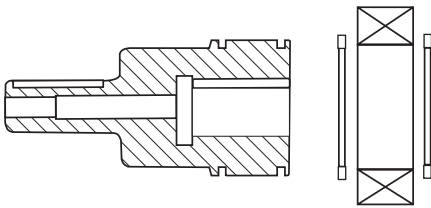
### 1 — Gear Drive Shaft Rotation



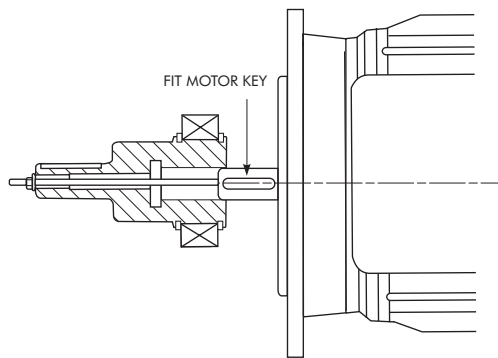
**Preparation:** Check Backstop Free Wheel Direction Prior to Fitting

- Check backstop unit in housing as shown above for correct rotation.
- If free rotation is wrong, backstop should be reversed.
- Put indelible mark on backstop to indicate backstop free rotation.
- Remove backstop from housing to assemble on to the motor shaft, see Section 2.

### 2 — Assemble Sprag



- Assemble sprag onto shaft using two (2) circlips.  
**NOTE:** Make sure the free rotation direction will be correct using the indelible mark from Section 1(c).



### 3 — Shaft Key

- Fit motor shaft key.
  - Pull backstop module on to motor using a puller as shown.★
- ★ Alternatively, backstop module may be pressed onto the motor shaft. **NOTE:** Non-drive end of motor must be supported.

**TABLE 1 — IEC B5 Flange**

Motor Frame Size	Kit Number	Shaft End Tappings †
<b>100/112</b>	MB100/112D	M10 X 1.5
<b>132</b>	MB132D	M12 X 1.75
<b>160</b>	MB160D	M16 X 2
<b>180</b>	MB180D	M16 X 2
<b>200</b>	MB200D	M20 X 2.5

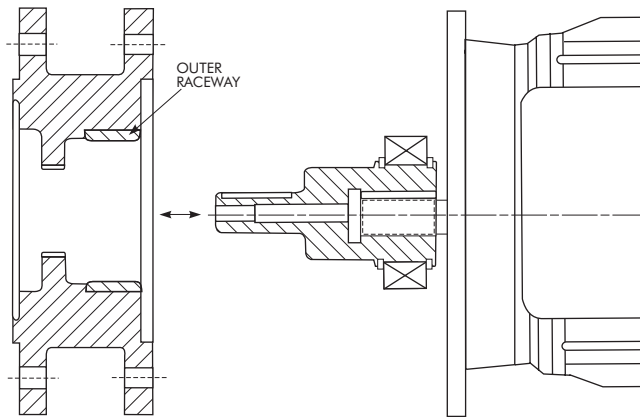
† Shaft end tapping can vary between different motor manufacturers.

**TABLE 2 — NEMA C-Flange**

Motor Frame Size	Kit Number	Shaft End Tappings †
<b>183TC / 184TC</b>	MB182/4TC	†
<b>213TC / 215TC</b>	MB213/5TC	†
<b>254TC / 256TC</b>	MB254/6TC	†
<b>284TC / 286TC</b>	MB284/6TC	†
<b>324TC / 326TC</b>	MB324/6TC	†

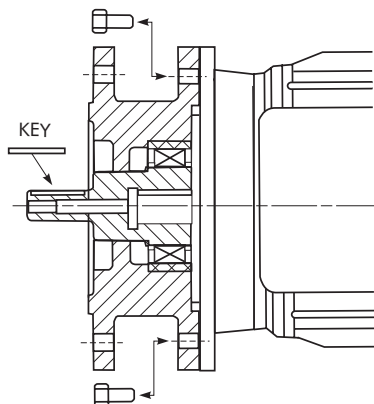
† Shaft end tapping can vary between different motor manufacturers.

### 4 — Housing



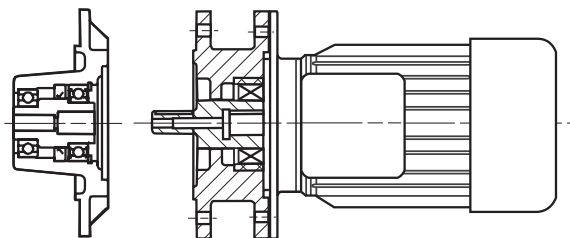
- Fit housing over backstop. Take care engaging backstop sprags in outer raceway.
- Rotate motor shaft by hand in direction of free rotation and sprags will drop into raceway bore.

**5 — Secure**



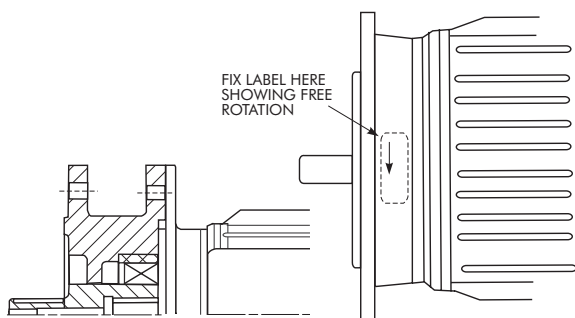
- a) Bolt backstop module to motor.
- b) Fit Key

**7 — Assemble**



- a) Assemble backstop and motor assembly to motor adaptor and gear drive following standard motor assembly instructions.

**6 — Label**



- a) Place label on backstop module, or motor, specifying backstop fitted and direction of free rotation.