

# Gear Reducer Installation Instructions

Table 3: Lubrication Amounts

Size	Type	Name	Qty (mL)
140 1-Stage	Synth. Oil	Fuchs Renolin PG 220	150
140 2-Stage			300
180 1-Stage			220
180 2-Stage			440

Size	Type	Name	Qty (L)
090	Synth. Oil	Mobil SHC XMP 150	0.06
115			0.12
140			0.29
170			0.53
215			1.10
260			2.30

GTMG



GTEG



GTMR



These installation instructions are intended to help in the use of this gear unit as well as to maximize the life of the gearbox. The required technical specifications can be found online at [www.boschrexroth-us.com](http://www.boschrexroth-us.com). In addition, online documentation contains important information regarding the limitations and ratings of the gearbox.

**All gear units supplied are filled with lubrication.** They are lubricated for life and no oil change is necessary. However, to extend the life of the gearbox, lubrication can be changed every 10,000 hours of operation. Consult Bosch-Rexroth for lubrication changing procedure. Oil quantities for some gearboxes can be found in table 3 of these instructions. The gear unit may also be mounted in any orientation without any concern for lubrication.

To avoid any distortion or damage to the input clamping element of the gear unit, assembly to the motor should be performed in the vertical position. This will also help with aligning the motor to the gear unit.

**Rexroth**  
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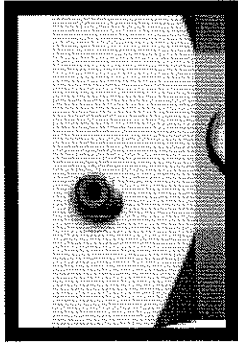
[www.boschrexroth-us.com](http://www.boschrexroth-us.com)

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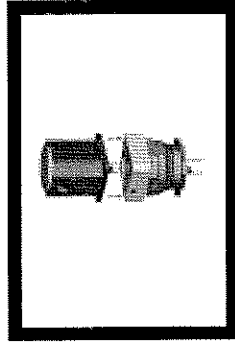
**Step 1**

Rotate input clamping element until the bolt is visible through the access hole.



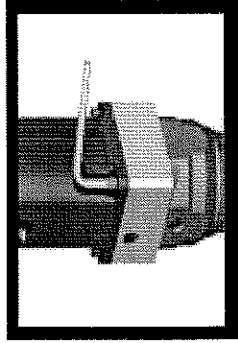
**Step 2**

Ensure all mounting surfaces are clean. With the motor and gearbox **VERTICAL**, insert the motor into the gearbox.



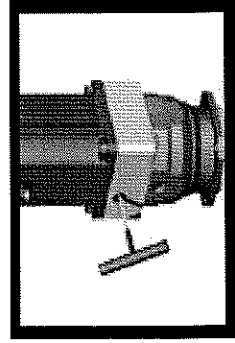
**Step 3**

Using the 4 bolts provided, tighten the motor to the gearbox adapter. Tightening torques can be found in Table 2.



**Step 4**

Tighten the clamping element onto the motor shaft. The proper tightening torque can be found in table 1. Finally, insert the provided plug into the access hole.



**Table 1: Tightening Values for Gearbox Input**

Size	Bolt Size	Hex Size	Torque (in-lb)
140	M8	6 mm	310
180 1-Stage	M12	10 mm	1018
180 2-Stage	M8	6 mm	310
065	M5	4 mm	53
085	M6	4 mm	80
120	M8	5 mm	177
GTRM	M3	2.5 mm	18
	M4	3 mm	44
	M5	4 mm	88
	M5	4 mm	88
	M6	5 mm	124
	M6	5 mm	159
	M8	6 mm	266
	M8	6 mm	354
	M10	8 mm	575
	M12	10 mm	1018
GTMG	M8	6 mm	354
	M10	8 mm	708
260	M12	10 mm	1018

**Table 2: Tightening Values for Motor to Adapter**

Bolt Size	Hex Size	Torque (in-lb)
M4	3 mm	39
M5	4 mm	77
M6	5 mm	133
M8	6 mm	319
M10	8 mm	637
M12	10 mm	1106
M16	14 mm	2743