Work instruction

[Fit the motor to the gearbox]

Document no.	*[WI-0001]*	**Revision**	*[A]*
Product / part no.	*[Product name, part number]*	**Effective date**	*[date]*
Station / cell	*[Station or cell]*	**Takt / cycle time**	*[x]* minutes
Prepared by	*[name]*	**Approved by**	*[name, role]*

Purpose and scope

Purpose: *[What this instruction is for, and the result when it is done right.]*

Scope: *[Which products, models and stations it covers, and which it doesn't.]*

Safety

- *[Wear safety glasses and gloves at this station.]*
- *[Isolate the air supply before working on the press.]*
- *[Lift parts over 20 kg with the hoist, not by hand.]*
- *[Report any damaged tool or part to the team leader before carrying on.]*

Personal protective equipment: *[Safety glasses, cut-resistant gloves, safety boots]*

Tools, equipment and settings

Tool or equipment	Setting	Note
[Torque driver]	*[2.5 N·m]*	*[Calibrated, in date]*
[Hex key]	*[4 mm]*	*[ ]*
[Press fixture]	*[Fixture no. F-12]*	*[ ]*

Parts and materials

Item	Part no.	Description	Qty
1	*[PN-1001]*	*[Gearbox housing]*	*[1]*
2	*[PN-1002]*	*[Motor]*	*[1]*
3	*[PN-2001]*	*[M4 × 12 socket cap screw]*	*[4]*
4	*[PN-2002]*	*[M4 spring washer]*	*[4]*

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Steps

Step	Picture	What to do
1	*[Picture for step 1: the parts this step uses, highlighted. If you have the CAD model as a STEP file, lineplate.com draws these for you.]*	*[Place the gearbox housing (1) in the fixture, output shaft facing down.]* **Key point:** *[The housing sits flat on all three locating pins.]* **Check:** *[Housing doesn't rock.]*
2	*[Picture for step 2]*	*[Offer the motor (2) to the housing, aligning the shaft key with the coupling slot.]* **Key point:** *[Don't force it: turn the shaft slightly until the key drops in.]* **Check:** *[Motor face is flush with the housing.]*
3	*[Picture for step 3]*	*[Fit the four screws (3) with washers (4), finger tight, then torque in a cross pattern.]* **Key point:** *[Torque to 2.5 N·m, in two passes.]* **Check:** *[All four screws marked with paint pen after torquing.]*

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Step	Picture	What to do
4	*[Picture for step 4]*	*[Turn the output shaft by hand through two full turns.]* **Key point:** *[It turns smoothly, with no tight spots or noise.]* **Check:** *[Record pass or fail on the traveller.]*

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Quality checks

☐ *[All fixings torqued and marked.]*
☐ *[No damage to the housing or the motor cable.]*
☐ *[Output shaft turns freely by hand.]*
☐ *[Serial number recorded on the traveller.]*

If something is wrong

[If a check fails: stop, tag the unit with a red tag, put it in the quarantine area and tell the team leader. Don't rework it unless this instruction says how.]

Revision history

Rev.	Date	Change	By
[A]	*[date]*	*[First issue]*	*[name]*

Training sign-off

Role	Name	Signature	Date
Operator trained	*[name]*	*[signature]*	*[date]*
Trainer	*[name]*	*[signature]*	*[date]*

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