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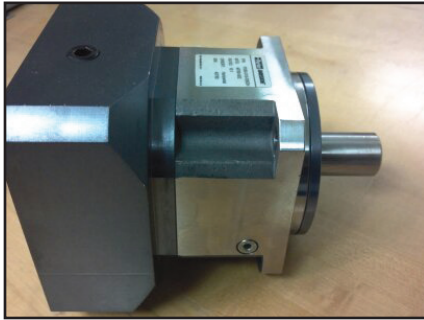
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Service Bulletin HY08-0890-T1
XFC Parallel
Gear Installation
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Gear Installation on motor or gear box for XFC parallel units

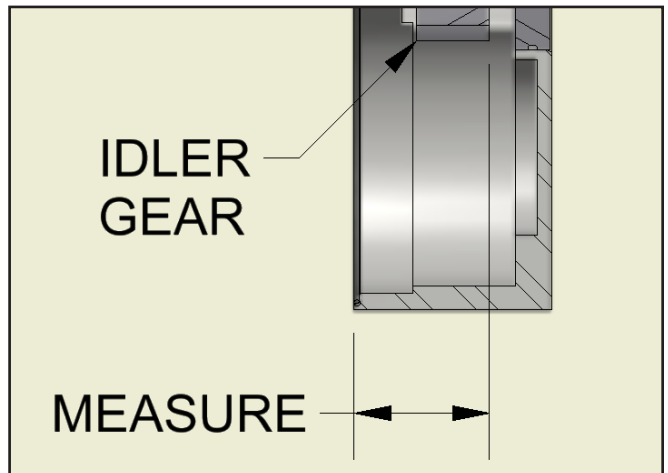
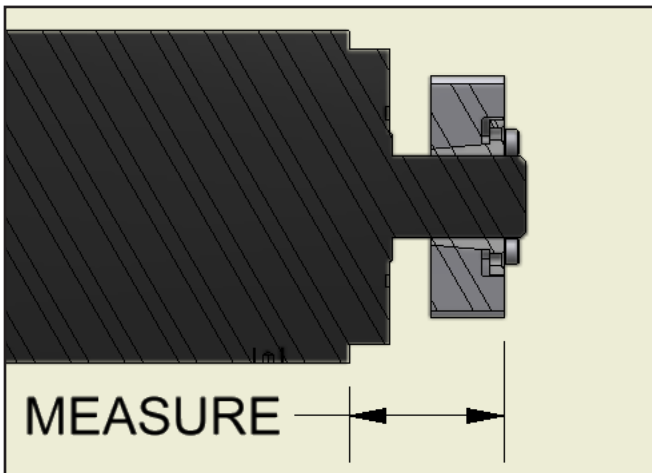
Clean the gear box or motor shaft and the inside of the spur gear and gear hub. Insert the gear hub into the spur gear and slide it over the end of the shaft to any position. Make sure to align the screw holes, then slightly thread on all socket head cap screws to hold the hub to the spur gear.

⚠ WARNING: DO NOT APPLY GREASE TO THE GEAR BOX SHAFT, MOTOR SHAFT, GEAR HUB, OR INSIDE OF GEAR!!



Measure the distance from the outside face of the parallel gear housing or adapter plate to the back of the idler gear. For a given combination, the table shown below should have a value close to the measured value.

Take that measurement and move the gear on the motor shaft to that same dimension from the motor flange face to the front of the gear.



Typical Measurement Values in mm	Gear Box Model					Motor Model			
	PS90	PS115	PS142	PS180	PS220	MPP115	MPP142	MPP190	MPP270
XFC075	48	53				41			
XFC090	37	59				49	53		
XFC115		44	73				60	69	
XFC140			56	75				76	
XFC165			69	88					94
XFC190				75	111				

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Once the gear is positioned in the proper location, tighten all of the screws in a cross pattern. Torque the screws in a crossing pattern to the appropriate value



Grease all the gear teeth. Grease should fill the gap between each tooth.

Install the o-ring (lightly greased) or gasket on to the gear box (or motor) pilot.

based on the chart below. Go around the pattern 3 to 4 times to ensure all screws are properly torqued.

Gear Hub Torques	
XFC075	35 lb-in
XFC090	35 lb-in
XFC115	70 lb-in
XFC140	130 lb-in
XFC165	130 lb-in
XFC190	25 lb-ft (300 lb-in)

Mount the gear box (or motor) to the actuator. Thread each bolt until the pilot properly seats into the mating counterbore and is fully seated. Fully tighten the bolts in a crossing pattern.

