

IFP BMG HIGH TORQUE LOW SPEED MOTORS



High Performance in an economical package

International BMG motors provide high output torque from an efficient compact design. Motors are available with displacements from 3.2 - 23.5 c.i.r (51.7 -386.2 c.c.r) BMG motors provide smooth low speed performance while maintaining high output torque. Motors can be connected together in series, or parallel and there shaft seal design allow the motor to withstand high back pressures without an external case drain. When operated within there rated conditions these motors provide a long trouble free service life.

Features:

- * High volumetric efficiency
- * High starting torque
- * Series - Parallel installation
- * Compact design



Model code

BMG - 30 - 2 - S K

Series Model Mounting Porting Shaft

Code	Mounting
2	SAE A 2 Bolt Flange
4	Square 4 Bolt Flange
6	SAE A Bolt Flange (Magneto mount)

Code	Porting
S	7/8-14 SAE
P	1/2" NPT
B	1/2" BSP
F	Flange Mount

Code	Shaft
K	1" Keyed
S	1" 6 tooth Spline

Other shafts available
See page: D1.3

Model		BMG 30	BMG 49	BMG 61	BMG 76	BMG 98	BMG 122	BMG 152	BMG 192	BMG 244
Displacement in ³ /rev (cm ³ /rev)		3.2 (51.7)	4.7 (77.7)	5.9 (96.2)	7.2 (117.9)	9.5 (155.5)	11.6 (189.9)	14.1 (231)	19.0 (311.7)	23.5 (386.2)
Speed RPM	Continuous	879	740	589	475	370	296	237	189	149
	Intermittent	975	827	673	594	463	370	297	236	185
Torque in-lb (Nm)	Continuous	716 (81)	1141 (129)	1424 (161)	1787 (202)	2168 (245)	2531 (286)	3186 (360)	3593 (406)	3850 (435)
	Intermittent	929 (108)	1513 (171)	1885 (213)	2371 (268)	3026 (342)	3451 (390)	4035 (456)	4469 (505)	4717 (533)
Power H.P.(kW)	Continuous	9.3 (7)	12.2 (9.1)	12.1 (9)	12.2 (9.1)	11.6 (8.7)	10.9 (8.1)	11.0 (8.2)	9.7 (7.2)	8.2 (6.1)
	Intermittent	11.9 (8.9)	15.8 (11.8)	16.0 (11.9)	15.8 (11.8)	16.0 (11.9)	14.6 (10.9)	13.5 (10.1)	11.5 (8.6)	9.7 (7.2)
Pressure PSI(Mpa)	Continuous	1810 (12.5)	1810 (12.5)	1810 (12.5)	1810 (12.5)	1810 (12.5)	1595 (11)	1595 (11)	1595 (11)	1450 (10)
	Intermittent	2393 (16.5)	2393 (16.5)	2393 (16.5)	2393 (16.5)	2393 (16.5)	2393 (16.5)	2030 (14)	1810 (12.5)	1520 (10.5)
Flow GPM (LPM)	Continuous	12 (45)	12 (45)	16 (60)	16 (60)	16 (60)	16 (60)	16 (60)	16 (60)	16 (60)
	Intermittent	13.2 (50)	20 (75)	20 (75)	20 (75)	20 (75)	20 (75)	20 (75)	20 (75)	20 (75)
Weight Lbs (kg)		12.3 (5.6)	12.6 (5.7)	13.0 (5.9)	13.2 (6)	13.7 (6.2)	14.1 (6.4)	14.6 (6.6)	15.2 (6.9)	16.3 (7.4)

Continuous operation: Motor may be run continuously at these ratings

Intermittent operation: Motor May be run 10% of every minute at these ratings

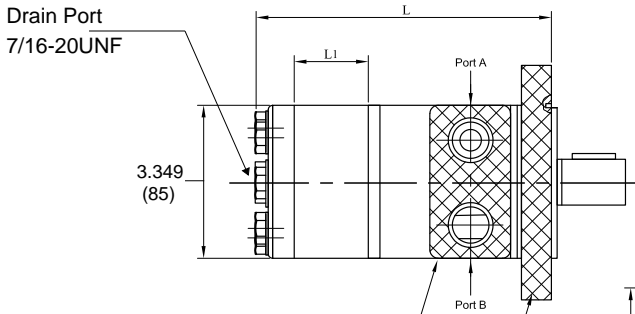
Intermittent speed & intermittent pressure must not occur simultaneously

Recommended fluids: Premium quality, anti-wear type hydraulic oil

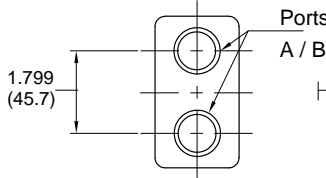
Recommended Temperature: 180 F { 82 C }

Recommended filtration: per ISO Cleanliness code level 18/13

IFP BMG HIGH / TORQUE LOW / SPEED MOTORS



Porting: Threaded

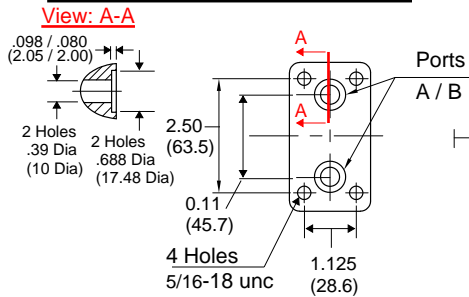


Code: S = A / B ports 7/8-14 UNF

Code: P = A / B ports 1/2 NPTF

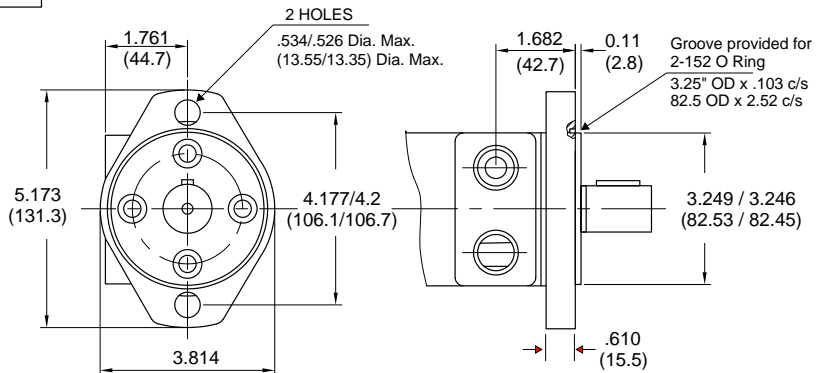
Code: B = A / B ports 1/2 BSP

Porting: Flanged

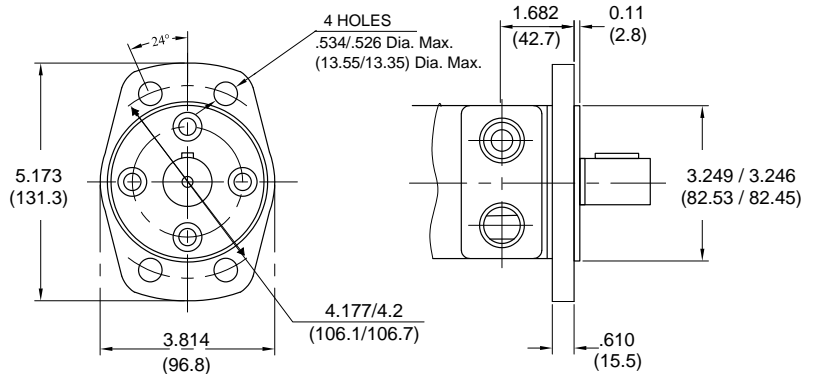


Mounting

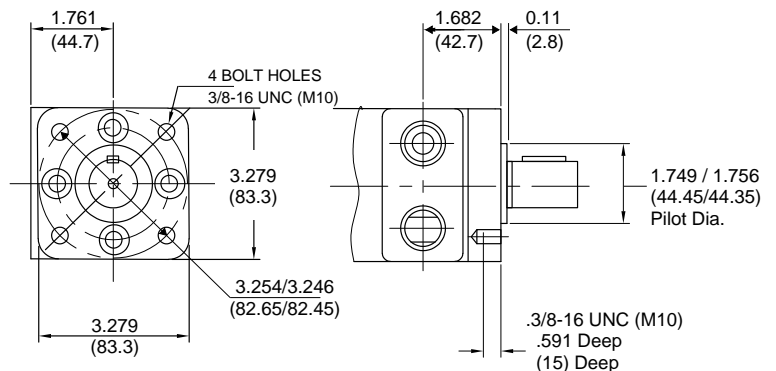
Code: 2
SAE-A 2 Bolt



Code: 6
Magneto Mount / 4 Bolt



Code: 4
Square Mount 4 Bolt



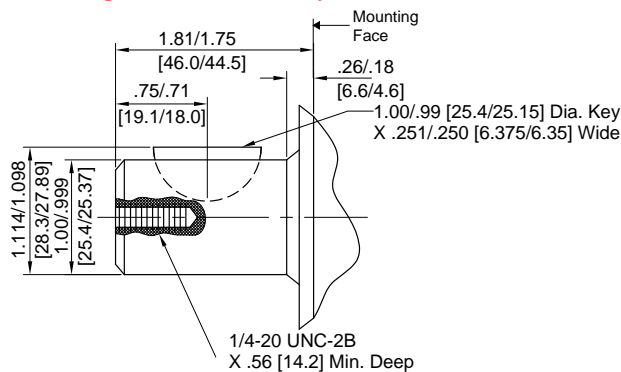
Dimensions: Inches (millimeters)

Code	Dimension L	Dimension: L1
BMG30	5.55 (141)	.27 (7)
BMG49	5.68 (144.5)	.41 (10.5)
BMG61	5.78 (147)	.51 (13)
BMG76	5.90 (150)	.62 (16)
BMG98	6.10 (155)	.82 (21)
BMG122	6.29 (160)	1.02 (26)
BMG152	6.53 (166)	1.25 (32)
BMG192	6.92 (176)	1.65 (42)
BMG244	7.32 (186)	2.04 (52)

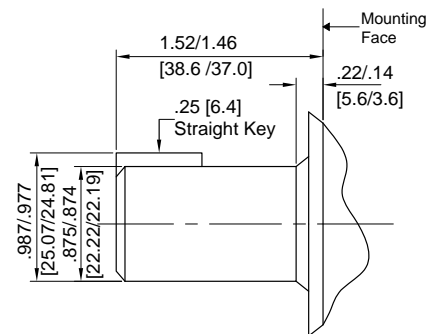
IFP BMG MOTOR DRIVE SHAFT SPECIFICATIONS



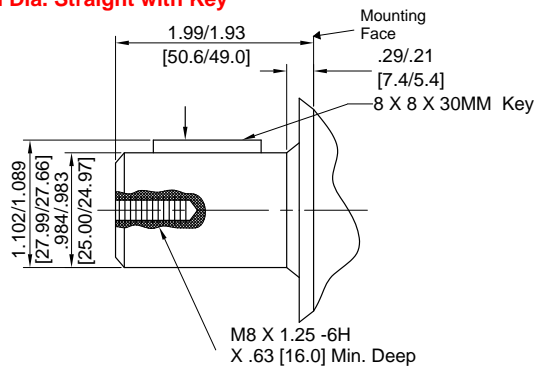
Code: K ** Standard shaft **
1 Inch Dia. Straight with Woodruff Key



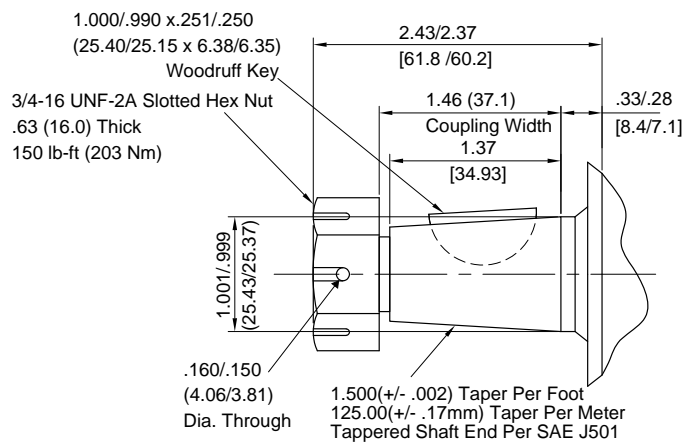
Code: D ** Special Order **
7/8 Inch Dia. Straight Shaft with Key



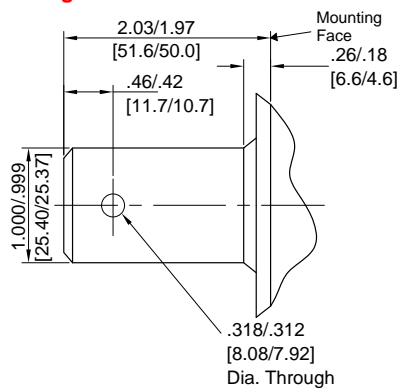
Code: A ** Special Order **
1 Inch Dia. Straight with Key



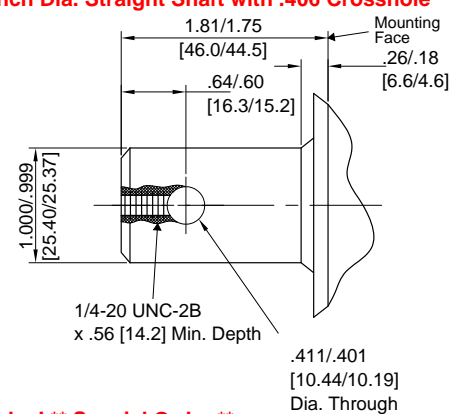
Code: T2 ** Special Order **
1 Inch Dia. Tapered Shaft With Woodruff Key & Nut



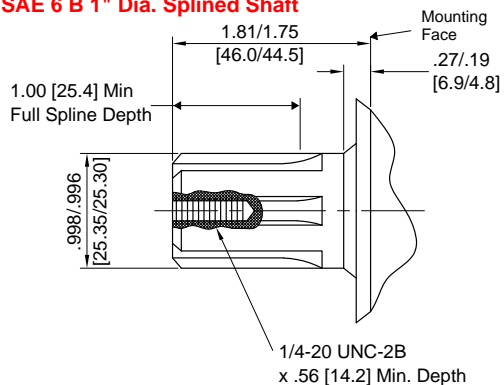
Code: H1 ** Special Order **
1 Inch Dia. Straight Shaft with .315 Crosshole



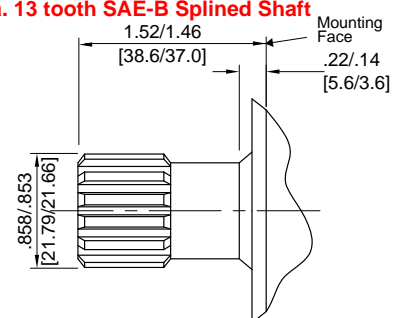
Code: H ** Special Order **
1 Inch Dia. Straight Shaft with .406 Crosshole



Code: S ** Special Order **
SAE 6 B 1" Dia. Splined Shaft



Code: I ** Special Order **
7/8" Dia. 13 tooth SAE-B Splined Shaft



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BMG30: 3.2 in3/rev {51.7 cm3/rev}

BMG49: 4.7 in3/rev {77.7 cm3/rev}

		Pressure- PSI {Mpa}							max. Cont.	max. Int.
		435 {3}	870 {6}	1015 {7}	1160 {8}	1450 {10}	1595 {11}	1812 {12.5}	2393 {16.5}	
Flow GPM {LPM}	2 {8}	150 {17}	336 {38}	389 {44}	443 {50}	558 {63}	620 {70}	700 {79}	920 {104}	
	4 {15}	168 {19}	336 {38}	389 {44}	443 {50}	556 {64}	628 {71}	708 {80}	929 {105}	
	5.3 {20}	150 {17}	336 {38}	389 {44}	451 {51}	566 {64}	628 {71}	708 {80}	947 {107}	
	8 {30}	141 {16}	327 {37}	389 {44}	443 {50}	566 {64}	628 {71}	716 {81}	955 {108}	
	9.3 {35}	132 {15}	318 {36}	380 {43}	443 {50}	557 {63}	628 {71}	708 {80}	947 {107}	
Max. Cont.	12 {45}	123 {14}	300 {34}	371 {42}	433 {49}	557 {63}	620 {70}	708 {80}	947 {107}	
Max. Int.	13.2 {50}	115 {13}	292 {33}	363 {41}	424 {48}	548 {63}	601 {68}	699 {79}		

		Pressure- PSI {Mpa}							max. Cont.	max. Int.
		435 {3}	870 {6}	1015 {7}	1160 {8}	1450 {10}	1595 {11}	1812 {12.5}	2393 {16.5}	
Flow GPM {LPM}	2 {8}	256 {29}	531 {60}	619 {70}	708 {80}	894 {101}	982 {111}	1132 {128}	1486 {168}	
	4 {15}	256 {29}	539 {61}	628 {71}	717 {81}	894 {101}	1008 {114}	1141 {129}	1504 {170}	
	5.3 {20}	247 {28}	531 {60}	628 {71}	717 {81}	894 {101}	991 {112}	1141 {129}	1504 {170}	
	8 {30}	221 {25}	513 {58}	610 {69}	699 {79}	885 {100}	982 {111}	1132 {128}	1513 {171}	
	9.3 {35}	212 {24}	504 {57}	601 {68}	690 {78}	876 {99}	973 {110}	1115 {126}	1513 {171}	
Max. Cont.	12 {45}	194 {22}	478 {54}	584 {66}	681 {77}	858 {97}	964 {109}	1097 {124}	1495 {169}	
Max. Int.	13.2 {50}	177 {20}	469 {53}	566 {64}	663 {75}	849 {96}	947 {107}	1088 {123}	1486 {168}	
Max. Cont.	16 {60}	168 {19}	460 {52}	558 {63}	655 {74}	840 {95}	947 {107}	1088 {123}	1486 {168}	
	20 {75}	141 {16}	415 {47}	522 {59}	637 {72}	805 {91}	929 {105}	1070 {121}		

Torque - lb-in {Nm}
Speed - RPM

BMG61: 5.9 in3/rev {96.2 cm3/rev}

BMG76: 7.2 in3/rev {117.9 cm3/rev}

		Pressure- PSI {Mpa}							max. Cont.	max. Int.
		435 {3}	870 {6}	1015 {7}	1160 {8}	1450 {10}	1595 {11}	1812 {12.5}	2393 {16.5}	
Flow GPM {LPM}	2 {8}	318 {36}	663 {75}	778 {88}	893 {101}	1115 {126}	1247 {141}	1416 {160}	1858 {210}	
	4 {15}	309 {35}	663 {75}	787 {89}	893 {101}	1132 {128}	1247 {141}	1416 {160}	1885 {213}	
	5.3 {20}	292 {33}	655 {74}	778 {88}	893 {101}	1115 {126}	1239 {140}	1424 {161}	1876 {212}	
	8 {30}	274 {31}	637 {72}	752 {85}	867 {98}	1088 {123}	1212 {137}	1389 {157}	1885 {213}	
	9.3 {35}	256 {29}	610 {69}	734 {83}	849 {96}	1070 {121}	1194 {135}	1371 {155}	1876 {212}	
Max. Cont.	12 {45}	247 {28}	584 {66}	716 {81}	832 {94}	1053 {119}	1177 {133}	1354 {153}	1840 {208}	
Max. Int.	13.2 {50}	212 {24}	575 {65}	690 {78}	823 {93}	1035 {117}	1168 {132}	1345 {152}	1832 {207}	
Max. Cont.	16 {60}	203 {23}	557 {63}	681 {77}	814 {92}	1026 {116}	1159 {131}	1336 {151}	1832 {207}	
	20 {75}	177 {20}	504 {57}	655 {74}	778 {88}	1000 {113}	1141 {129}	1327 {150}		

		Pressure- PSI {Mpa}							max. Cont.	max. Int.
		435 {3}	870 {6}	1015 {7}	1160 {8}	1450 {10}	1595 {11}	1812 {12.5}	2393 {16.5}	
Flow GPM {LPM}	2 {8}	398 {45}	831 {94}	982 {111}	1124 {127}	1398 {158}	1557 {176}	1778 {201}	2327 {263}	
	4 {15}	389 {44}	831 {94}	982 {111}	1124 {127}	1416 {160}	1566 {177}	1787 {202}	2363 {267}	
	5.3 {20}	371 {42}	823 {93}	973 {110}	1124 {127}	1407 {159}	1557 {176}	1787 {202}	2371 {268}	
	8 {30}	354 {40}	805 {91}	955 {108}	1097 {124}	1380 {156}	1548 {174}	1752 {198}	2371 {268}	
	9.3 {35}	336 {38}	787 {89}	938 {106}	1074 {122}	1363 {154}	1522 {172}	1734 {196}	2363 {267}	
Max. Cont.	12 {45}	327 {37}	752 {85}	911 {103}	1062 {120}	1336 {151}	1504 {170}	1717 {194}	2327 {263}	
Max. Int.	13.2 {50}	292 {33}	743 {84}	885 {100}	1044 {118}	1318 {149}	1478 {167}	1619 {192}	2301 {260}	
Max. Cont.	16 {60}	283 {32}	717 {81}	876 {99}	1026 {116}	1301 {147}	1469 {166}	1690 {191}	2292 {259}	
	20 {75}	230 {26}	663 {75}	823 {93}	973 {110}	1256 {142}	1407 {159}	1637 {185}		

Torque - lb-in {Nm}
Speed - RPM

Continuous -
Intermittent -

IFP BMG MOTOR PERFORMANCE DATA



BMG98: 9.5 in3/rev {155.5 cm3/rev}

BMG122: 11.6 in3/rev {189.9 cm3/rev}

		Pressure- PSI {Mpa}						max. Cont.	max. Int.
		435 {3}	870 {6}	1015 {7}	1160 {8}	1450 {10}	1595 {11}	2030 {14}	2393 {16.5}
Flow GPM {LPM}	2 {8}	504 {57}	1070 {121}	1256 {142}	1433 {162}	1787 {202}	1991 {225}	2150 {243}	2956 {334}
	4 {15}	495 {56}	1070 {121}	1256 {142}	1433 {162}	1805 {204}	2009 {227}	2168 {245}	3018 {341}
	5.3 {20}	486 {55}	1062 {120}	1239 {140}	1433 {162}	1796 {203}	2000 {226}	2159 {244}	3026 {342}
	8 {30}	477 {54}	1035 {117}	1230 {139}	1416 {160}	1778 {201}	1982 {224}	2141 {242}	3009 {340}
	9.3 {35}	460 {52}	1017 {115}	1212 {137}	1407 {159}	1761 {199}	1947 {220}	2141 {242}	2982 {337}
	12 {45}	442 {50}	991 {112}	1185 {134}	1380 {156}	1734 {196}	1947 {220}	2106 {238}	2964 {335}
	13.2 {50}	398 {45}	973 {110}	1168 {132}	1354 {153}	1734 {196}	1911 {216}	2062 {233}	2920 {330}
	Max. Cont. 16 {60}	389 {44}	938 {106}	1150 {130}	1336 {151}	1734 {196}	1894 {214}	2044 {231}	2903 {328}
Max. Int. 20 {75}	283 {32}	849 {96}	1053 {119}	1256 {142}	1610 {182}	1814 {205}	1964 {222}		

		Pressure- PSI {Mpa}						max. Cont.	max. Int.
		435 {3}	870 {6}	1015 {7}	1160 {8}	1450 {10}	1595 {11}	2175 {15}	
Flow GPM {LPM}	2 {8}	646 {73}	1354 {153}	1584 {179}	1805 {204}	2265 {256}	2504 {283}	3407 {385}	
	4 {15}	646 {73}	1345 {152}	1593 {180}	1814 {205}	2292 {259}	2531 {286}	3451 {390}	
	5.3 {20}	628 {71}	1336 {151}	1575 {178}	1805 {204}	2265 {256}	2522 {285}	3451 {390}	
	8 {30}	601 {68}	1318 {149}	1548 {175}	1787 {202}	2248 {254}	2504 {283}	3434 {388}	
	9.3 {35}	575 {65}	1292 {146}	1531 {173}	1770 {200}	2230 {252}	2487 {281}	3416 {386}	
	12 {45}	557 {63}	1256 {142}	1504 {170}	1734 {196}	2186 {247}	2451 {277}	3380 {382}	
	13.2 {50}	513 {58}	1221 {138}	1469 {166}	1708 {193}	2159 {244}	2407 {272}	3345 {378}	
	Max. Cont. 16 {60}	495 {56}	1203 {136}	1442 {163}	1690 {191}	2133 {241}	2380 {269}	3319 {375}	
Max. Int. 20 {75}	371 {42}	1070 {121}	1327 {150}	1566 {177}	2000 {226}				

Torque: lb-in {Nm}
Speed: RPM

BMG152: 14.1 in3/rev {231 cm3/rev}

		Pressure- PSI {Mpa}						max. Cont.	max. Int.
		435 {3}	870 {6}	1015 {7}	1160 {8}	1450 {10}	1595 {11}	2030 {14}	
Flow GPM {LPM}	2 {8}	823 {93}	1725 {195}	2000 {226}	2292 {259}	2876 {325}	3159 {357}		
	4 {15}	814 {92}	1699 {192}	2000 {226}	2301 {260}	2876 {325}	3186 {360}	4035 {456}	
	5.3 {20}	796 {90}	1690 {191}	1991 {225}	2283 {258}	2849 {322}	3150 {356}	4027 {455}	
	8 {30}	761 {86}	1663 {188}	1956 {221}	2256 {255}	2823 {319}	3133 {354}	4000 {452}	
	9.3 {35}	725 {82}	1628 {184}	1920 {217}	2221 {251}	2805 {317}	3097 {350}	3965 {448}	
	12 {45}	699 {79}	1584 {179}	1894 {214}	2177 {246}	2761 {312}	3053 {345}	3912 {442}	
	13.2 {50}	654 {74}	1540 {174}	1849 {209}	2150 {243}	2708 {306}	3000 {339}	3876 {438}	
	Max. Cont. 16 {60}	628 {71}	1513 {171}	1823 {206}	2115 {239}	2681 {303}	2973 {336}	3832 {433}	
Max. Int. 20 {75}	469 {53}	1354 {153}	1672 {189}	1956 {221}	2478 {280}	2761 {312}			

Continuous -
Intermittent -

IFF BMG MOTOR PERFORMANCE DATA



BMG192: 19 in³/rev {311.7 cm³/rev}

	Pressure- PSI {Mpa}						max. Cont.	max. Int.
	435 {3}	870 {6}	1015 {7}	1160 {8}	1450 {10}	1812 {12.5}		
2 {8}	1026 {116}	2150 {243}	2495 {282}	2770 {313}	3434 {388}			
4 {15}	1017 {115}	2150 {243}	2513 {284}	2867 {324}	3593 {406}	4451 {503}		
5.3 {20}	1008 {114}	2141 {242}	2495 {282}	2858 {323}	3584 {405}	4469 {505}		
8 {30}	964 {109}	2097 {237}	2451 {277}	2823 {319}	3549 {401}	4434 {501}		
9.3 {35}	929 {105}	2053 {232}	2416 {273}	2779 {314}	3513 {397}	4398 {497}		
12 {45}	876 {99}	2000 {226}	2371 {268}	2734 {309}	3460 {391}	4345 {491}		
13.2 {50}	814 {92}	1929 {218}	2318 {262}	2690 {304}	3398 {384}	4301 {486}		
Max. Cont. {60}	787 {89}	1902 {215}	2283 {258}	2646 {299}	3354 {379}	4239 {479}		
Max. Int. {75}	610 {69}	1717 {194}	2097 {237}	2460 {278}	3142 {355}			

BMG244: 23.5 in³/rev {386.2 cm³/rev}

	Pressure- PSI {Mpa}						max. Cont.	max. Int.
	435 {3}	870 {6}	1015 {7}	1160 {8}	1232 {8.5}	1812 {12.5}		
2 {8}	1301 {147}	2690 {304}	3133 {354}					
4 {15}	1301 {147}	2726 {308}	3177 {359}	3611 {408}	3850 {435}	4708 {532}		
5.3 {20}	1274 {144}	2699 {305}	3168 {358}	3602 {407}	3850 {435}	4717 {533}		
8 {30}	1230 {139}	2664 {301}	3115 {352}	3557 {402}	3805 {430}	4690 {530}		
9.3 {35}	1177 {133}	2602 {294}	3053 {345}	3504 {396}	3743 {423}	4646 {525}		
12 {45}	1106 {125}	2540 {287}	3000 {339}	3442 {389}	3681 {416}	4575 {517}		
13.2 {50}	1035 {117}	2460 {278}	2920 {330}	3380 {382}	3619 {409}	4505 {509}		
Max. Cont. {60}	991 {112}	2425 {274}	2885 {326}	3336 {377}	3575 {404}	4469 {505}		
Max. Int. {75}	778 {88}	2177 {246}	2637 {298}	3106 {351}	3327 {376}			

Torque: lb-in { Nm }
Speed: RPM

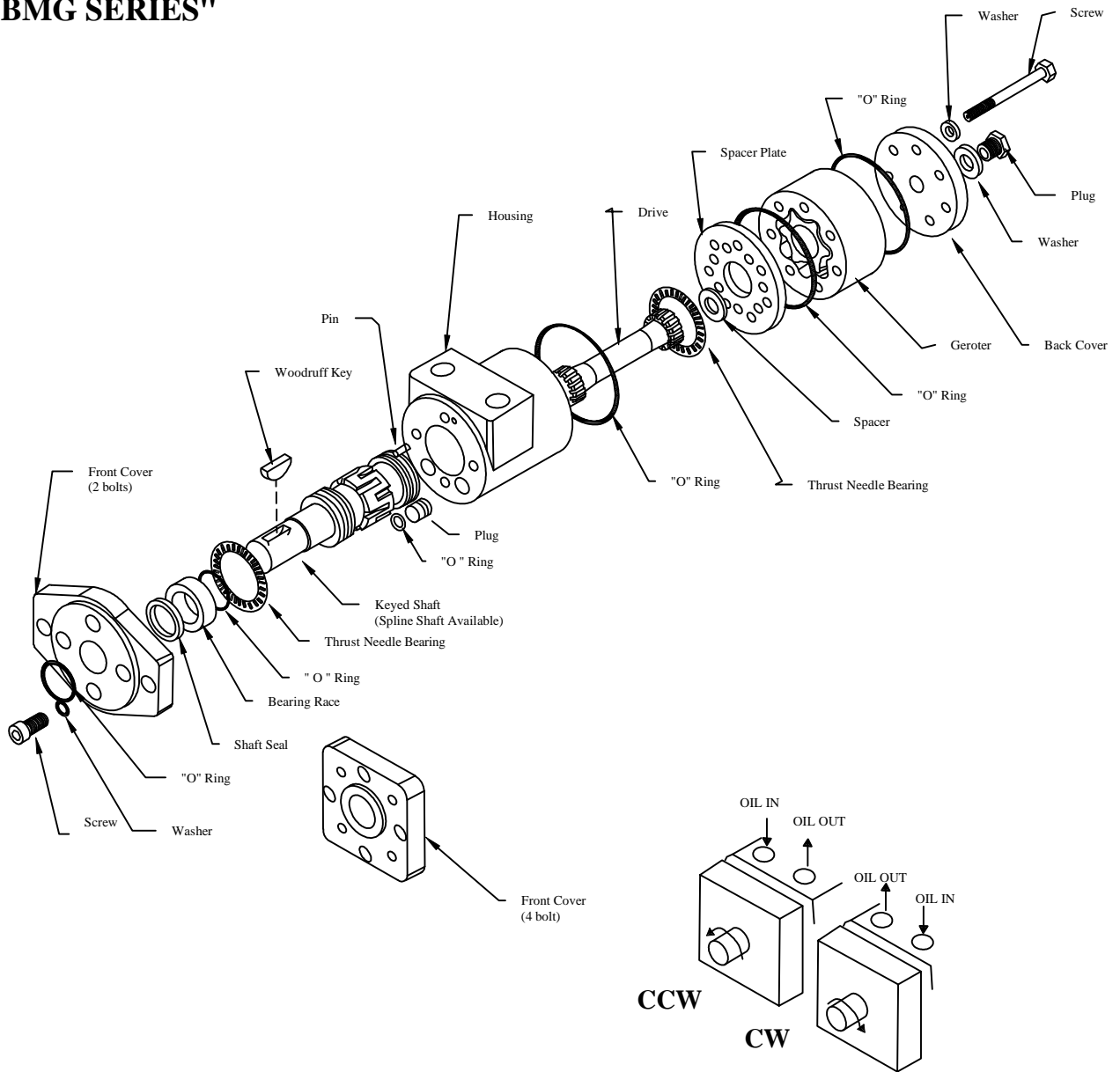
Continuous -
Intermittent -

IFP HIGH TORQUE GEROTER MOTORS

Parts Service Information



"BMG SERIES"



MOTOR ROTATION

FACTORY TIMING OF MOTOR WILL PRODUCE FOLLOWING ROTATIONS WHEN INLET AND OUTLET PORTS ARE ORIENTATED AS SHOW AS ABOVE DIAGRAMS

CROSS REFERENCE BMG GEROTOR SERIES



*INDICATES STANDARD STOCK UNITS
STANDARD 4 BOLT/KEYED SHAFT(SPLINE SHAFTS AVAILABLE)

IFP MODEL	DISPL in/rev	CHARLYNN "H" MODEL	DISPL in/rev	DANFOSS "OMP" MODEL	DISPL in/rev	PORTS SIZE
		101-1753 101-1749	2.2			1/2 NPTF SAE 7/8-14
BMG030-4PK *BMG030-4SK	3.0	101-1001 101-1009	2.8	151-2041 151-2121	3.0	1/2 NPTF SAE 7/8-14
BMG030-4PK *BMG030-4SK	3.0	101-1754 101-1750	3.6	151-2041 151-2121	3.0	1/2 NPTF SAE 7/8-14
BMG049-4PK *BMG049-4SK	4.9	101-1002 101-1010	4.5	151-2122 151-2042	4.7	1/2 NPTF SAE 7/8-14
BMG061-4PK *BMG061-4SK	6.1	101-1003 101-1011	5.9	151-2123 151-2043	5.9	1/2 NPTF SAE 7/8-14
BMG076-4PK *BMG076-4SK	7.6	101-1755 101-1751	7.3	151-2124 151-2044	7.6	1/2 NPTF SAE 7/8-14
		101-1756 101-1752	8.9			1/2 NPTF SAE 7/8-14
BMG098-4PK *BMG098-4SK	9.8	101-1004 101-1012	9.7	151-2125 151-2045	9.5	1/2 NPTF SAE 7/8-14
BMG122-4PK *BMG122-4SK	12.2	101-1005 101-1013	11.3	151-2026 151-2046	11.9	1/2 NPTF SAE 7/8-14
BMG152-4PK *BMG152-4SK	15.2	101-1006 101-1014	14.1	151-2127 151-2047	14.8	1/2 NPTF SAE 7/8-14
BMG192-4PK *BMG192-4SK	19.2	101-1007 101-1015	17.9	151-2128 151-2048	18.7	1/2 NPTF SAE 7/8-14
BMG244-4PK *BMG244-4SK	24.4	101-1008 101-1016	22.6	151-2129 151-2049	23.7	1/2 NPTF SAE 7/8-14

STANDARD 2 BOLT/KEYED SHAFT(SPLINE SHAFTS AVAILABLE)

IFP MODEL	DISPL in/rev	CHARLYNN "H" MODEL	DISPL in/rev	DANFOSS "OMP" MODEL	DISPL in/rev	PORTS SIZE
		101-1704 101-1700	2.2			1/2 NPTF SAE 7/8-14
BMG030-2PK *BMG030-2SK	3.0	101-1025 101-1033	2.8	151-2081 151-2001	3.0	1/2 NPTF SAE 7/8-14
BMG030-2PK *BMG030-2SK	3.0	101-1705 101-1701	3.6	151-2084 151-2001	3.0	1/2 NPTF SAE 7/8-14
BMG049-2PK *BMG049-2SK	4.9	101-1026 101-1036	4.5	151-2082 151-2002	4.7	1/2 NPTF SAE 7/8-14
BMG061-2PK *BMG061-2SK	6.1	101-1027 101-1035	5.9	151-2083 151-2003	5.9	1/2 NPTF SAE 7/8-14
BMG076-2PK *BMG076-2SK	7.6	101-1706 101-1702	7.3	151-2084 151-2004	7.6	1/2 NPTF SAE 7/8-14
		101-1707 101-1703	8.9			1/2 NPTF SAE 7/8-14
BMG098-2PK *BMG098-2SK	9.8	101-1028 101-1036	9.7	151-2085 151-2005	9.5	1/2 NPTF SAE 7/8-14
BMG122-2PK *BMG122-2SK	12.2	101-1029 101-1037	11.3	151-2086 151-2006	11.9	1/2 NPTF SAE 7/8-14
BMG152-2PK *BMG152-2SK	15.2	101-1030 101-1038	14.1	151-2087 151-2007	14.8	1/2 NPTF SAE 7/8-14
BMG192-2PK *BMG192-2SK	19.2	101-1031 101-1039	17.9	151-2088 151-2008	18.7	1/2 NPTF SAE 7/8-14
BMG244-2PK *BMG244-2SK	24.4	101-1032 101-1040	22.6	151-2089 151-2009	23.7	1/2 NPTF SAE 7/8-14

IFP BMG HIGH TORQUE LOW SPEED MOTORS



TIMING PROCEDURE

STANDARD ROTATION

Motor rotation will be as shown in Figure #1 when the following timing procedure is used

- Position tooth slot#1 on shaft assembly in line with tooth slot#3 highest point of geroter

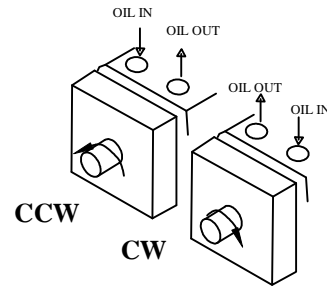
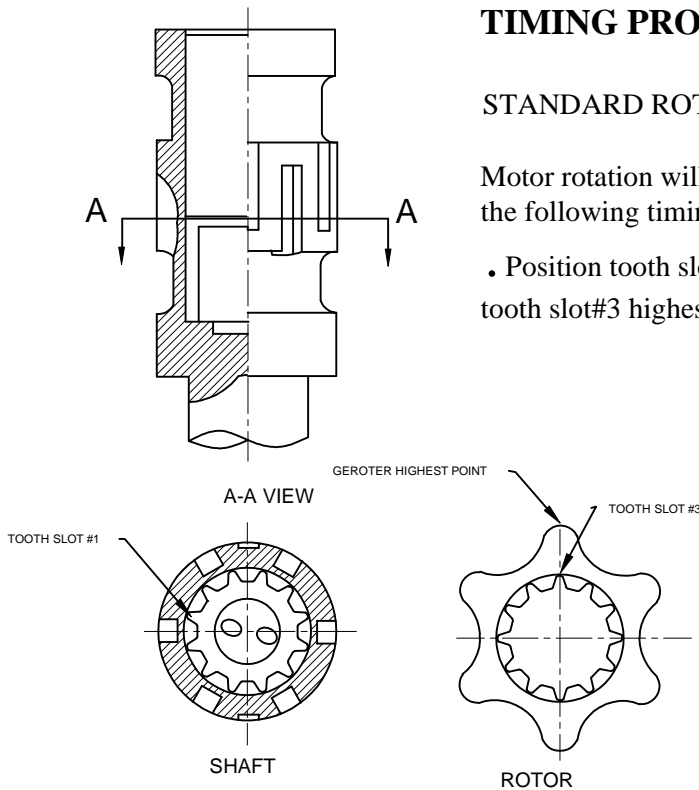


Figure #1

When timing is orientated as shown

TIMING PROCEDURE

REVERSE ROTATION

Motor rotation will be as shown in Figure #2 when the following timing procedure is used

- Position tooth slot#2 on shaft assembly in line with tooth slot#3 highest point of geroter

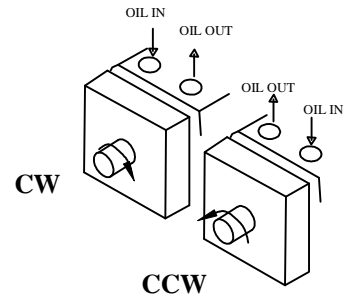
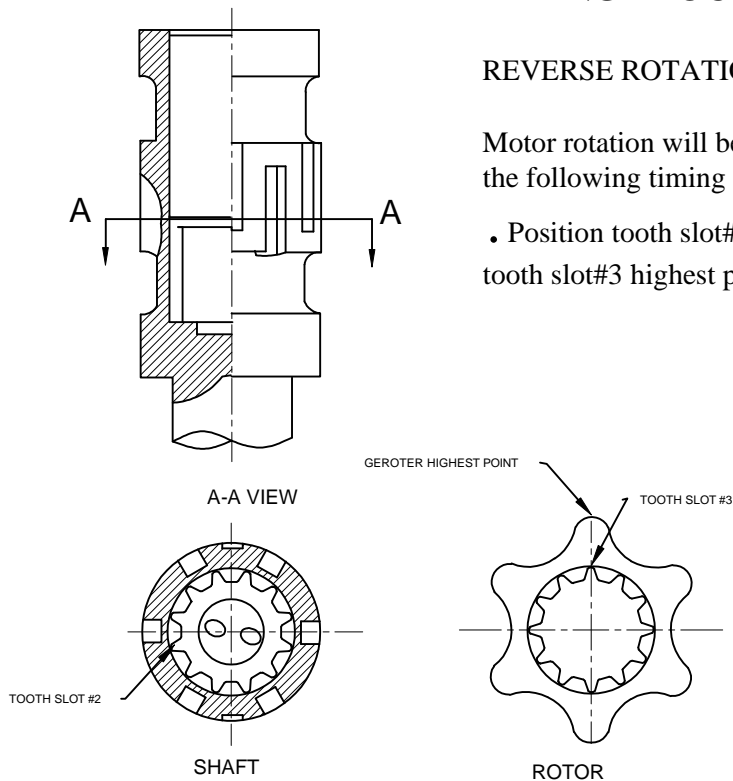


Figure #2

When timing is orientated as shown