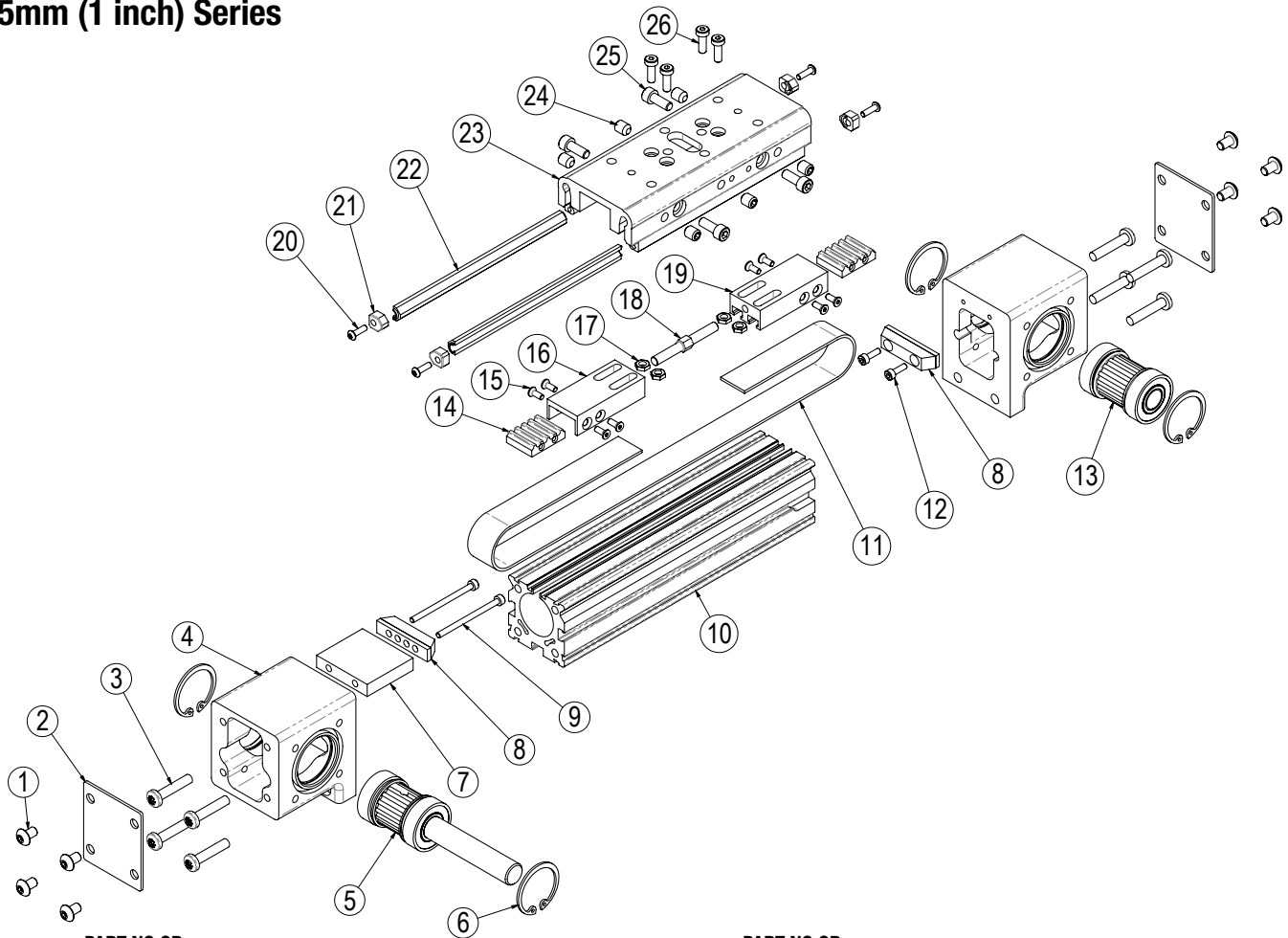


## MXB25S Solid Bearing, Belt-Drive Actuators

## 25mm (1 inch) Series



ITEM	PART NO OR CONFIG. CODE	DESCRIPTION	QTY.
1.	0510-1370	BUTTON HEAD CAP SCREW	8
2.	0825-1020	END COVER PLATE	2
3.	8325-1023	HEAD SCREWS	8
4.	8525-1047	HEAD	2
5.	8525-9026	DRIVE PULLEY ASSEMBLY	1
	8525-9027	DRIVE PULLEY ASSEMBLY, DUAL	1
6.	2309-1035	RETAINING RING	4
7.	8525-1048	SPACER	1
8.	8516-9018	BUMPER	2
9.	8516-1050	SOCKET HEAD CAP SCREW	2
10.	RTBMXB25_SK_	TUBE (US CONV)	1
	RTBMXB25_SM_	TUBE (METRIC)	1
11.	RBMXB25_SK_	BELT (US CONV)	1
	RBMXB25_SM_	BELT (METRIC)	1
12.	0602-3012	SOCKET HEAD CAP SCREW	2
13.	8525-9028	IDLE PULLEY ASSEMBLY	1

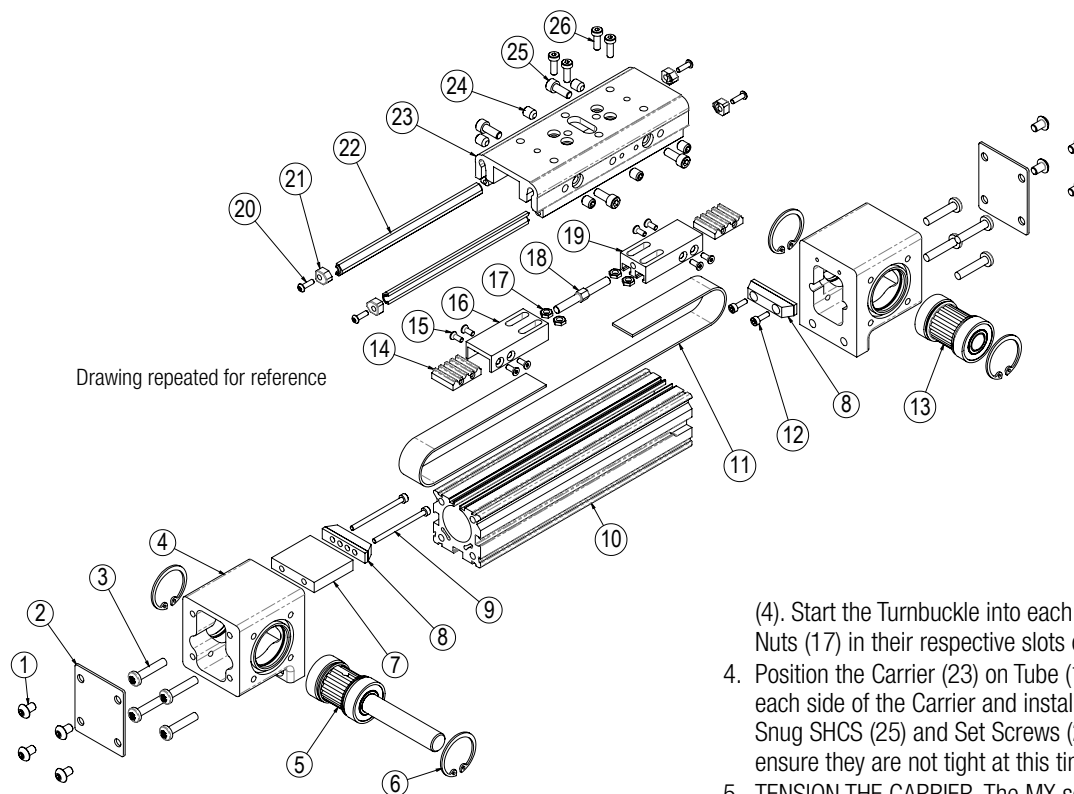
ITEM	PART NO OR CONFIG. CODE	DESCRIPTION	QTY.
14.	8525-1005	BELT CLAMP, BOTTOM	2
15.	8125-1074	FLAT HEAD CAP SCREW	8
16.	8525-1004	BELT CLAMP, LH	1
17.	0602-2089	HEX NUT	4
18.	8525-1006	TURNBUCKLE	1
19.	8525-1003	BELT CLAMP, RH	1
20.	0603-1036	BUTTON HEAD CAP SCREW	4
21.	8125-1031	BEARING END CAP	4
22.	8125-1030	CARRIER BEARING	2
23.	8125-1513	CARRIER (US CONV)	1
	8125-1013	CARRIER (METRIC)	1
24.	8125-1579	SET SCREW (US CONV)	6
	8125-1079	SET SCREW (METRIC)	6
25.	6000-1463	SOCKET HEAD CAP SCREW (US CONV)	4
	8125-1071	LOW HEAD CAP SCREW (METRIC)	4
26.	3410-3096	LOW HEAD CAP SCREW	4

<sup>1</sup> Replacement ordering method using config code: 

**EXAMPLE:** RTB MXB25 SBWS18 SK21.25 DC7

Tube (RTB) or Belt (RB)      Model & Size      Bearing Style      Belt Size      Stroke Length      Aux. Carrier

**Auxiliary Carrier Option Note:** If replacing a Tube (10.) or Belt (11.) on an actuator that has an Auxiliary Carrier, add "DC \_ \_ \_" between Stroke Length and Motor Code. "DC" indicates the need for additional length and "\_ \_ \_" indicates the measurement of space between carriers (in inches [SK] or millimeters [SM] as indicated earlier in the configuration string).



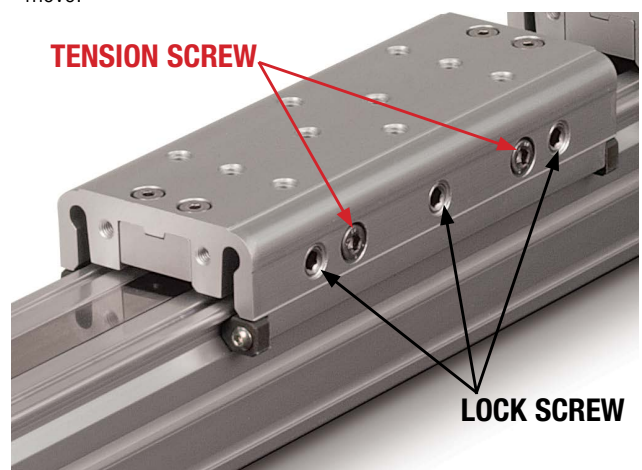
### GENERAL ACTUATOR DISASSEMBLY

1. Remove LHCS (26) from top of carrier (23) to free it from the belt clamp assembly. Loosen the Turnbuckle (18) removing all belt tension. Slightly loosen the Carrier Tension Screws (25) and Set Screws (24). Remove Bearing End Caps (21) from the Bearings (22) and slide the Bearings out. The Carrier can now be removed.
  - a. Note: If the stroke of the actuator is too short to allow removal of the Carrier Bearings, it is necessary to remove the Non-Drive End Head (4) from the Tube (10).
2. Remove the Belt (11) from the Belt Clamps (16, 19) by removing Fasteners (15) and Belt Clamp Bottom (14). The Belt can now be removed from the actuator.
3. Remove the Retaining Rings (6) from each of the Heads (4). Note that the Bearing/Pulley Assemblies (5, 13) are slip fit into the Head, but are bonded in the bore w/ Loctite 641, so it may be necessary to press the Pulley Assemblies out of the Head.
4. Remove the Heads (4) from the Tube (10) by removing Fasteners (3).

### GENERAL ACTUATOR ASSEMBLY

1. Install the Drive and Idle Heads (4) to the Tube (10). Note that the Bumper Spacer (7) installs onto the Drive End Head.
2. Install one Retaining Ring (6) into each Head (4). Apply a light coating of Loctite 641 to the OD of the bearings of the Pulley Assemblies (5, 13) and to the ID of the bearing bores of the Head. Install the Drive and Idle Pulley/Bearing Assemblies into the Heads.
  - a. NOTE THAT ORIENTATION OF THE DRIVE SHAFT IS DETERMINED BY THIS ASSEMBLY STEP. Install the remaining Retaining Ring into each Head.
3. Feed the Belt (11) into the Tube (10) from one end of the actuator. Install a Belt Clamp (16, 19) to each end of the Belt with Belt Clamp Bottoms (14) and Fasteners (15). NOTE THAT ONE BELT CLAMP (16) WILL HAVE LEFT HAND THREADS FOR THE TURNBUCKLE (18). Assemble so that Belt Clamp LH (16) is nearest the drive end Head

- (4). Start the Turnbuckle into each of the Belt Clamps. Position Hex Nuts (17) in their respective slots of the Belt Clamps.
4. Position the Carrier (23) on Tube (10). Position the Bearings (22) on each side of the Carrier and install the Bearing End Caps (21). Snug SHCS (25) and Set Screws (24) then back off 1/8 turn to ensure they are not tight at this time.
5. TENSION THE CARRIER. The MX solid bearing carrier will provide best performance when properly adjusted. The carrier design contains both Tension (25) and Lock Screws (24). The Tension Screws control the amount of pressure placed on the Carrier Bearings. The Lock Screws lock the Tension Screws in place and provide fine adjustment of the Carrier Bearings (22).
  - a. Fully loosen all Tension (25) and Lock Screws (24) about 1/2 of a turn so that they are not engaged with the Bearing (22).
  - b. Tighten Tension Screws (25) on both sides of the Carrier (23) roughly 1/8 to 1/4 turn clockwise past where the Screw starts to feel snug. The Carrier should be very difficult or impossible to move by hand. If not, turn another 1/8 turn until it is difficult to move.



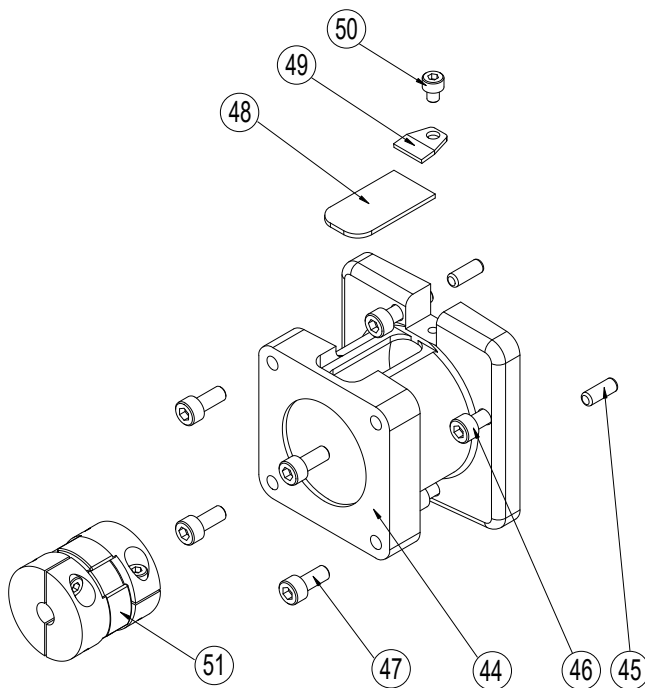
- c. Next, adjust the Lock Screws (24) on both sides of the Carrier (23) roughly 1/8 to 1/4 turn clockwise past where the Screw starts to engage. The Carrier will be loose but should not rock sideways. To correct this, loosen the Lock Screws about 1/16 of a turn. If the Carrier becomes too snug, adjust the Lock Screws another 1/8 of a turn.

- d. Ideal carrier tension is achieved when the Carrier (23) feels snug in relation to the Tube (10), yet can be moved by hand. No rocking motion should be present. The Carrier should also be loose enough to be moved by hand over the entire length of the actuator. If after this process the Carrier has become too loose, equally adjust all of the Lock Screws (24) with a slight 1/32 turn counter-clockwise. **During the service life of the application this process may need to be repeated. Keeping the Carrier in a properly adjusted tension will prolong the life of the MX bearing system and the actuator itself.**
- e. When the proper carrier tension has been achieved, finish tightening the four Screws (20) to the Bearing End Caps (21).
- f. Position the Carrier (23) over the Belt Clamps (16, 19) and install Fasteners (26), leaving looser at this time.
6. TENSION THE BELT: To measure belt tension, position the edge of the Carrier (23) that is nearest the Head 6" from the inside edge of the Head (4) (either end of the actuator). Locate a force gage on the Belt (11) 2" from the inside edge of the Head. Support the tube side of the Carrier so that it is rigid to the Tube (10). Deflect the Belt 1/4" [6 mm] in either direction. The force gage should read between 12 and 16 lbs. [53 - 62 N]
7. Adjust the Turnbuckle (18) to achieve this tension, then tighten the Fasteners (26) to secure the Belt Clamps (16, 19) to the Carrier (23).

**ALLEN WRENCH SIZES FOR CARRIER ADJUSTMENT,  
SOLID BEARING ACTUATORS**

	TENSION SCREW		LOCK SCREW	
	MM	IN	MM	IN
25	4	5/32	3	1/8

## In-Line (LMI) Mounting Option



ITEM	PART NO.	DESCRIPTION	QTY
44.	CONFIGURED	MOTOR SPACER	1
45.	CONFIGURED	DOWEL PIN	2
46.	CONFIGURED	SCREW	4
47.	CONFIGURED	SCREW	4
48.	CONFIGURED	COVER	1
49.	CONFIGURED	CLAMP	1
50.	CONFIGURED	SCREW	1
51.	CONFIGURED	COUPLER	1

♦ Part number varies depending on YMH (Your Motor Here).  
Contact [help@tolomatic.com](mailto:help@tolomatic.com) for replacement part number.

A replacement Motor Mount Kit contains all parts listed above.

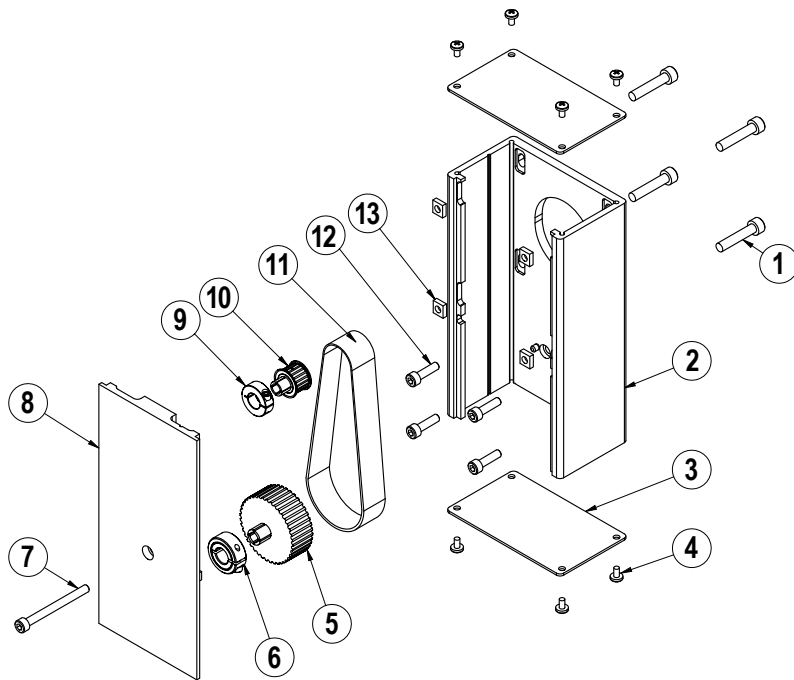
Replacement Motor Mount Kits ordering method: **MMK MXB25S** ☐ ☐ ☐ **YM** ☐ ☐ ☐ ☐

**EXAMPLE: MMK MXB25S S S D L YM O T B D 0**

Motor Mount Kit — Model & Size — Bearing Style — Mounting Style — Motor Code

## Reverse Parallel Reduction Drive Option

3:1 Reduction Drive



ITEM	PART NO.	DESCRIPTION	QTY.
1.	CONFIGURED	MOTOR FASTENER	4
2.	CONFIGURED	RP HOUSING	1
3.	CONFIGURED	RP HOUSING END CAP	2
4.	CONFIGURED	END CAP SCREW	8
5.	CONFIGURED	DRIVE SHAFT PULLEY	1
6.	CONFIGURED	COLLAR CLAMP, DRIVE SHAFT	1
7.	CONFIGURED	RP COVER FASTENER	1
8.	CONFIGURED	RP COVER	1
9.	CONFIGURED	COLLAR CLAMP, MOTOR	1
10.	CONFIGURED	MOTOR PULLEY	1
11.	CONFIGURED	BELT	1
12.	CONFIGURED	RP PLATE FASTENER	4
13.	CONFIGURED	SQUARE NUT	4

♦ Part numbers varies depending on YMH (Your Motor Here).  
Contact [help@tolomatic.com](mailto:help@tolomatic.com) for replacement part numbers.

### Disassembly Instructions

1. Remove End Caps (3), and release the tension on the Belt (11) by breaking loose the motor fasteners (1).
2. Remove the RP Cover (8).
3. The Belt (11) can now be removed along with the Motor.
4. Remove both Pulleys (10) and (5) from their respective shafts.
5. Remove the RP Housing (2) from the actuator head by removing the Fasteners (12).

### Assembly Instructions

Note: Apply Loctite #242 to all fasteners upon installation

1. Install RP Housing (2) onto the actuator Head with Fasteners (12).  
**Note:** If the RP housing has a bearing in it do not fully tighten the fasteners at this time. Instead temporarily install the RP cover (8) onto the RP case, positioning the bearing over the leadscrew shaft. Hold the cover in place while tightening all the Fasteners (12) so that the case is snug. Then remove the RP cover and finish tightening the fasteners
2. Install the Motor to the RP Housing with Fasteners (1) and Square Nuts (13). Do not tighten the fasteners at this time.
3. Locate the Belt (11) over the Pulleys (10) and (5) and slide both pulleys over their respective shafts. Tighten each pulley to its shaft with the Collar Clamps (9) and (6).

4. Tension the Belt (11) by pulling the motor away from the drive shaft with the appropriate tension force shown in the chart below. While tensioning, the actuator should be positioned so the weight of the motor does not affect the belt tension. Tighten the Motor Fasteners (1) while the tensioning force is applied to the motor.

SMALLEST SHAFT DIAMETER (Motor or Actuator)		TOTAL WEIGHT TO APPLY	
Inches	mm	lbs	kgs
0.18 to 0.259	4.572 to 6.579	13	5.902
0.260 to 0.499	6.604 to 12.675	22	9.988
0.500 to 0.625	12.7 to 15.875	31	14.074
0.625 and larger	15.875 and larger	40	18.160

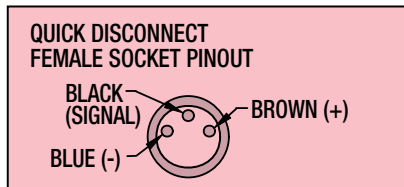
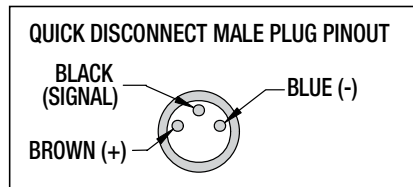
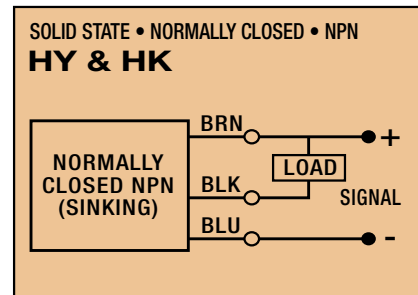
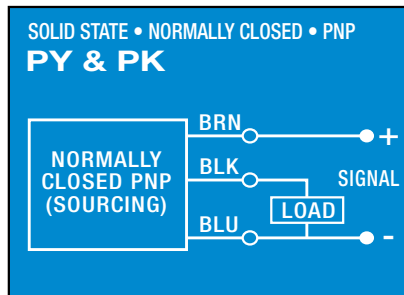
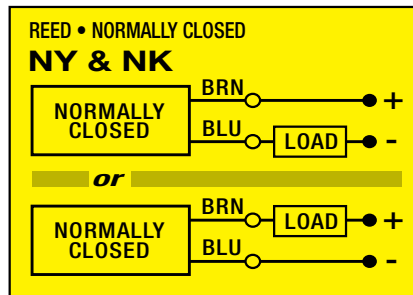
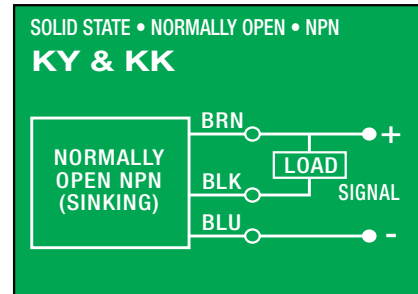
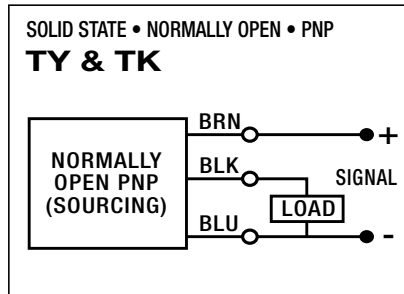
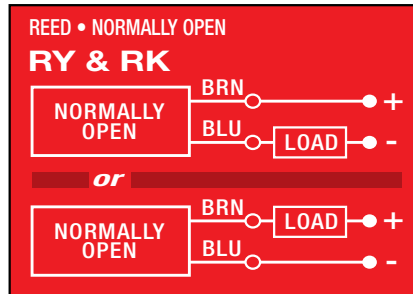
Additional tips are found in Tolomatic [Electric Actuator Motor Mounts Technical Note # 3600-4203](#).

5. Verify that there is clearance between the inside of the RP case and each pulley. Verify the pulleys are aligned to each other.
6. Position the Cover (8) in the mating slot of the RP case and install the Fasteners (7) to hold it in place. Take care not to overtighten. If the cover is deflected, it can interfere with the leadscrew.
7. Install both End Caps (3) with the Screws (4) to finalize the assembly.





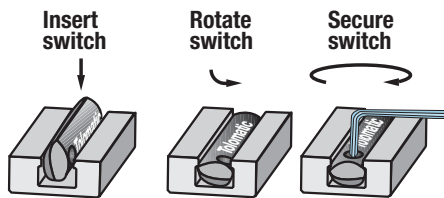
## Switch Wiring Diagrams and Label Color Coding (Ce and Rohs Compliant)



Switches for MX:

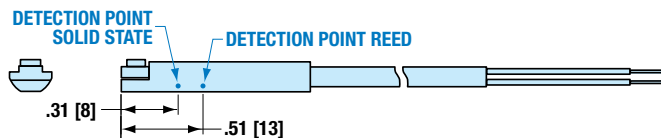
- Include retained mounting hardware
- In slot, sit below extrusion profile
- Same for all sizes and bearing styles

### Switch installation and replacement



Place switch in side groove on tube at desired location with "Tolomatic" facing outward. While applying light pressure to the switch, rotate it such that the switch is halfway in the groove. Maintaining light pressure, rotate the switch in the opposite direction until the switch is fully inside the groove with "Tolomatic" visible. Re-position the switch to the exact location and lock the switch securely into place by tightening the screw on the switch.

### Switch Detection point



Dimensions in inches [brackets indicate dimensions in millimeters]

**Tolomatic**<sup>TM</sup>  
EXCELLENCE IN MOTION

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