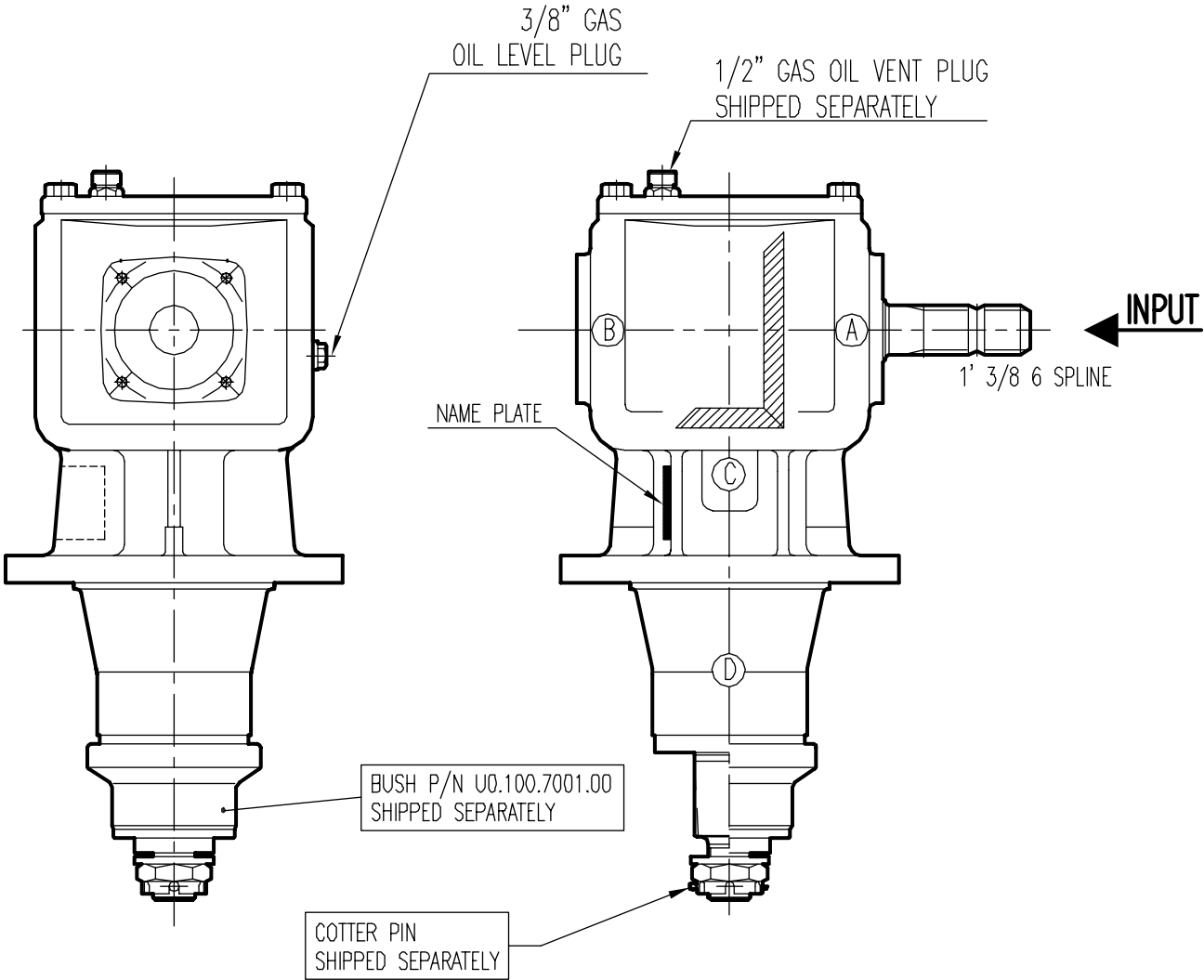




COMER INDUSTRIES S.p.A. 42046 Villanova di Reggio (R.E.) Italia Tel. 0522\974111 (9 Linee) Telefax 0522\973249

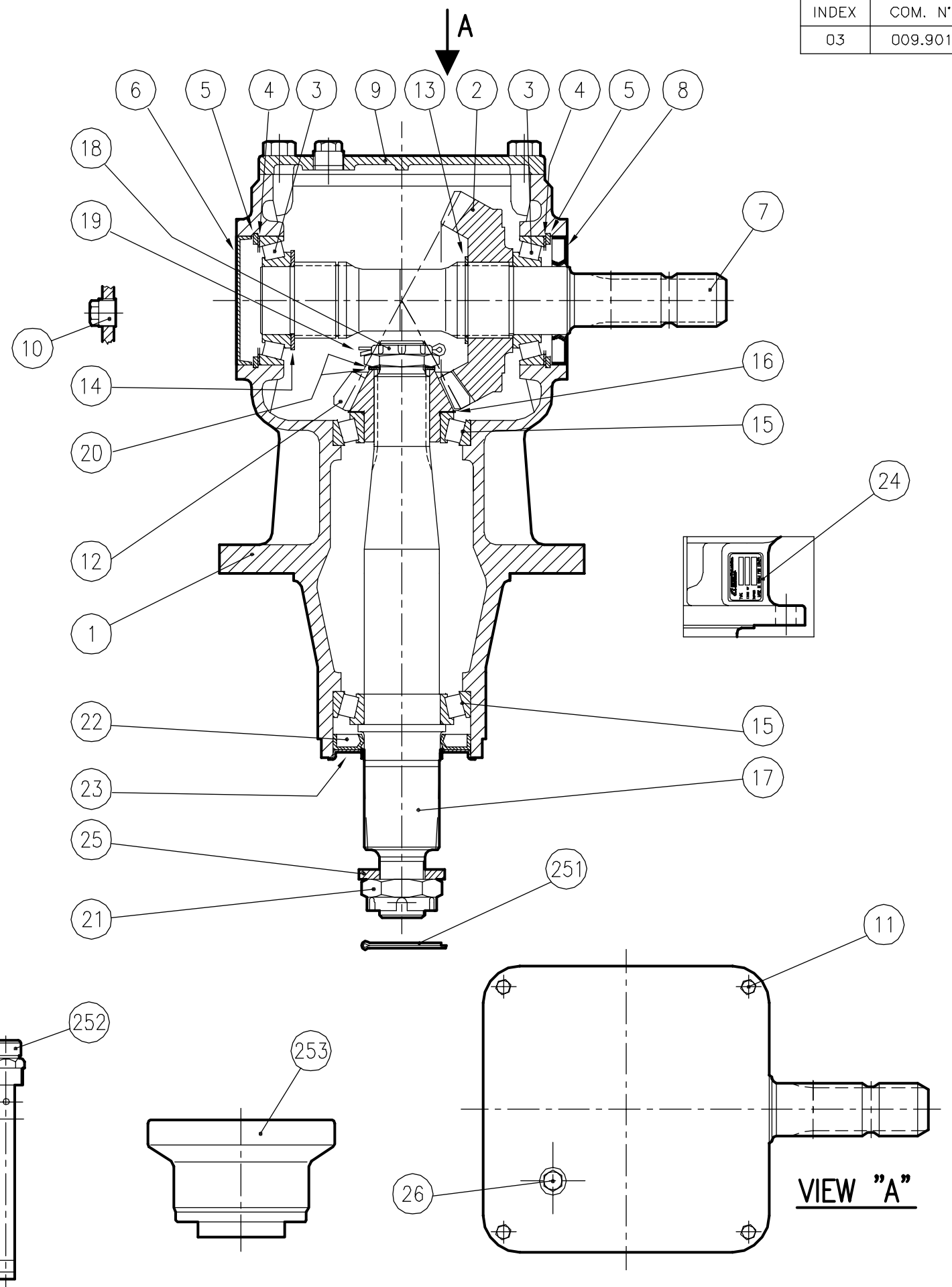
 comer industries gearboxes	RIF. OFF.9318				COMPANY: COMMERCIAL		INDEX	COM. N°
							03	009.901
	RATIO	FIG. MONT.	COD.LETT.	LF-227J		CODE		
	1 : 1.83	21 – 22	COD.NUM.	227		9.227.004.00		



NOTE DI MONTAGGIO	ASSEMBLY NOTES	
- GIOCO DI INGRANAMENTO - PRECARICO ASSE DI U. (senza anello di tenuta) . - PRECARICO ASSE DI E. (senza anello di tenuta) . - MONTARE IL PARAOLIO IN POS. "A" PARI AL PIANO SCATOLA . - APPLICARE SILICONE TRA COPERCHIO E SCATOLA . - SERRAGGIO VITI COPERCHIO . - APPLICARE GRASSO AL BISOLFURO DI MOLIBDENO IN POS. "D" TRA PARAOLIO E CUSCINETTO . - Nr.2 SPESSORI COD.0.102.7510.00 IN POS. - 20 - VANNO INSERITI TRA INGRANAGGIO E GHIERA . - NEBULIZZARE ALL'INTERNO DELLA SCATOLA CON "NUCLEOIL 10" COME ULTIMA OPERAZIONE . - PARTICOLARI SMONTATI . - GRUPPI SPEDITI IN COMER ITALIA : I PARTICOLARI SMONTATI A.227.000 VANNO INSERITI CASSA PER CASSA , UGUALE AL NUMERO DEI GRUPPI PRESENTI NELLA CASSA .	- GEARS BACKLASH - OUTPUT SHAFT BEARINGS PRELOAD (WITHOUT OIL SEAL) . - INPUT SHAFT BEARINGS PRELOAD (WITHOUT OIL SEAL) . - MOUNT THE DUST LIP IN POS. "A" ON THE SAME LEVEL OF PLANE HOUSING . - APPLY SILICONE SEALANT BETWEEN COVER AND HOUSING . - TIGHTENING COVER BOLTS . - APPLY BISULPHIDE MOLYBDENUM GREASE IN POS. "D" BETWEEN OIL SEAL AND BEARING . - No.2 SHIMS COD.0.102.7510.00 IN POS. - 20 - ARE LOCATED BETWEEN THE GEAR AND NUT . - SPRAY "NUCLEOIL 10" INSIDE THE HOUSING AS LAST OPERATION . - NOT ASSEMBLED PARTS . - ONLY FOR DELIVERY TO COMER ITALY , THE A.227.000 MUST BE INSERTED IN THE CASE TOGETHER WITH THE COMPLETE GEARBOXES , IN THE SAME QUANTITIES .	0.20 ÷ 0.52 mm 8 ÷ 15 Kgcm. 1 ÷ 5 Kgcm. 2.6 ÷ 3.3 Kgm. P/N A.227.000

SPESS. TEORICA IN: THEORETICAL SHIMS:	(A) 0.95 mm	(B) 0.95 mm	(C) 0.95 mm
--	-------------	-------------	-------------

COMPANY COMMERCIAL	REF. OFF. 9318	DESIGNATION LF-227J
	DATE 27/MAY/04	CODE 9.227.004.00



 comer industries gearboxes		RIF. OFF. 9318				COMPANY: COMMERCIAL		INDEX	COM. N°
								03	009.901
		RATIO		FIG. MONT.	COD.LETT.		LF-227J	CODE	
1 : 1.83		21 - 22		COD.NUM.		227		9.227.004.00	
POS.	DRG. Nr.		PCS.	DESCRIPTION					
1	0.227.0300.00		1	CASTING & MACHINING					
2	0.227.6001.00		1	GEAR CROWN Z22 M6.5					
3	8.0.9.00143		2	ROLLER BEARING 30209 (45x85x20.75)					
4	0.709.7500.00		2	SHIM KIT (70.3x84.7)					
5	8.5.2.00332		2	SNAP RING (85x88.5x3 , FOR HOLES)					
6	0.121.7101.00		1	OIL CAP (ø85x10)					
7	0.210.2000.00		1	INPUT SHAFT 1" 3/8 Z6					
8	8.7.1.02348		1	DUST LIP (45x85x10)					
9	0.227.1300.00		1	COVER					
10	8.6.5.00006		1	3/8" GAS SOLID PLUG					
11	8.1.1.00031		4	BOLTS M8x25 HHB (8.8)					
12	0.227.5001.00		1	PINION Z12 M6.5					
13	8.5.1.00533		1	SNAP RING (50x47x2 , FOR SHAFTS)					
14	0.252.7525.00		1	SHIM (45.3x65.3x2.5)					
15	8.0.9.00469		2	ROLLER BEARING 30210 (50x90x21.75)					
16	0.712.7500.00		1	SHIM KIT (50.3x70.3)					
17	0.227.3001.00		1	OUTPUT SHAFT					
18	0.132.7106.00		1	CASTLE NUT M30x1.5					
19	8.4.7.02265		1	COTTER PIN B5x60					
20	0.102.7510.00		2	SHIM (30.3x44x1)					
21	8.2.2.00555		1	CASTLE NUT M30x2					
22	8.7.1.01107		1	DUST LIP (50x90x10)					
23	0.139.7100.00		1	PROTECTIVE WASHER					
24	0.124.7135.00		1	NAME PLATE					
25	0.139.7101.00		1	BOLT WASHER (31x56x6)					
26	8.6.5.00203		1	1/2" GAS SOLID PLUG					

A.227.000 (SHIPPED SEPARATELY)			
POS.	DRG. Nr.	PCS.	DESCRIPTION
251	8.4.7.00146	1	COTTER PIN B6x60
252	0.286.7100.00	1	1/2" GAS OIL FILLER LEVEL VENT PLUG
253	U0.100.7001.00	1	BUSHING GROOVED