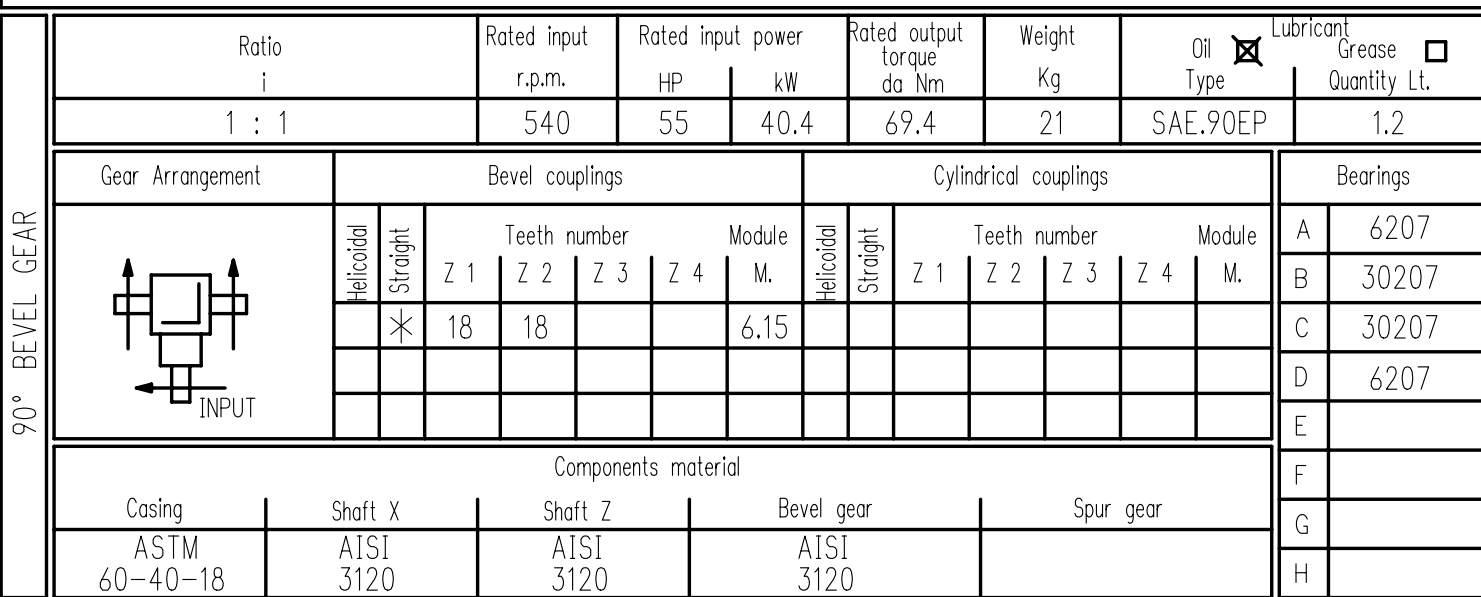
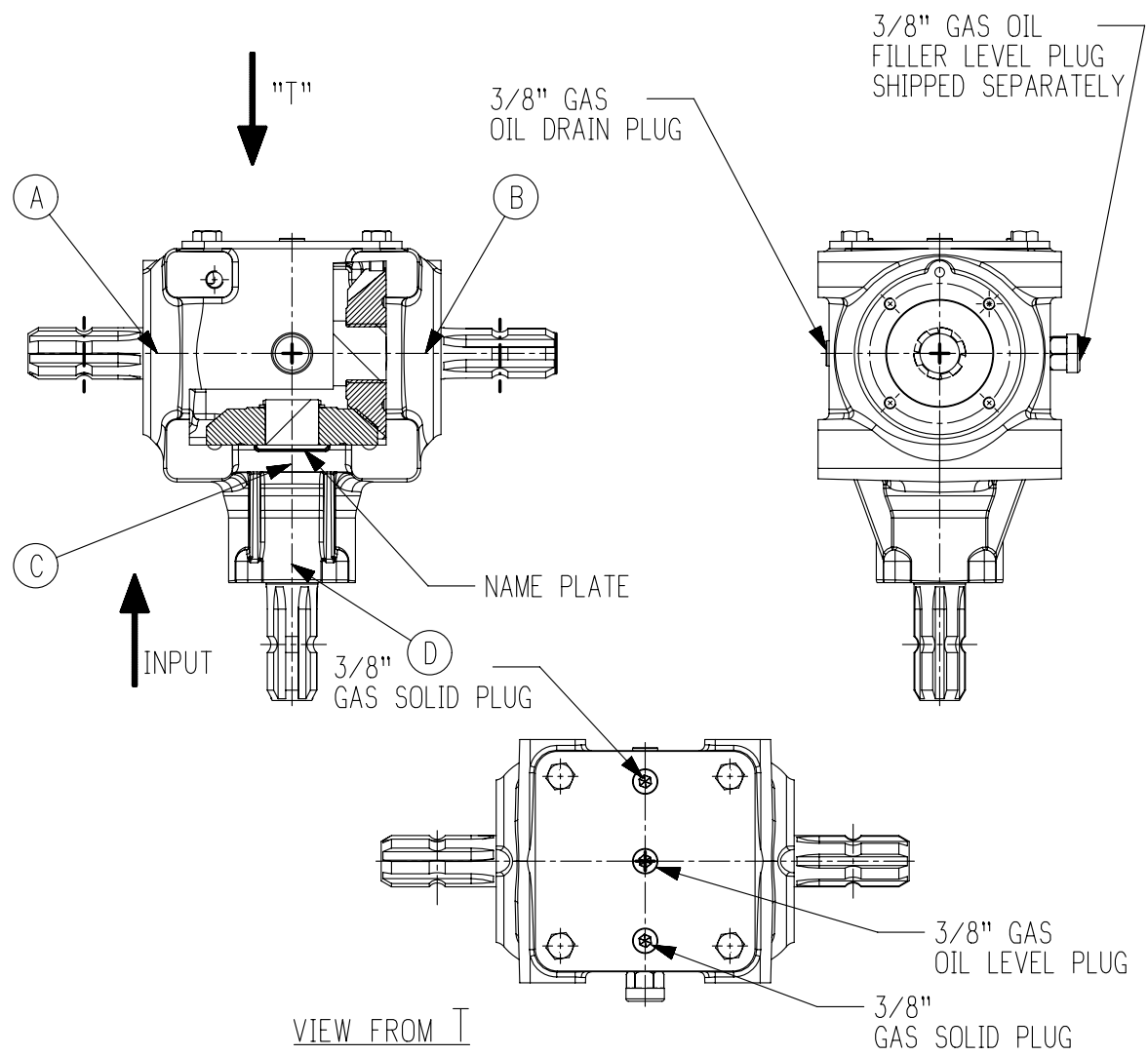




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 comer industries gearboxes	RIF. OFF.				COMPANY:		INDEX	COM. N°
							13	012.017
	RATIO	FIG. MONT.	COD.LETT.	T-27J		CODE		
	1 : 1	5 - 6	COD.NUM.	267		9.267.806.10		



NOTE DI MONTAGGIO	ASSEMBLY NOTES
- GIOCO DI INGRANAMENTO : 0.18 - 0.49 mm. - PRECARICO ASSE ENTRATA (SENZA PARAOLIO): 2.5 - 5 Kgcm. - PRECARICO ASSE USCITA (SENZA PARAOLIO): 1 - 5 Kgcm. - APPLICARE SILICONE TRA COPERCHIO E SCATOLA. - SERRAGGIO VITI COPERCHIO : 5 - 6.4 Kgcm. - NEBULIZZARE ALL'INTERNO DELLA SCATOLA CON "NUCLEOIL 10" COME ULTIMA OPERAZIONE. - SERRAGGIO TAPPI OLIO 3 Kgcm. : INGRASSARE CON GRASSO IL FORO PRIMA DI MONTARE IL TAPPO . - PARAOLIO IN POS.-A-,-B- E-D-: APPLICARE GRASSO AL BISOLFURO DI MOLIBDENO TRA I DUE LABBRI. - PARTICOLARI SMONTATI A COD. A.253.001. - PARTICOLARI COMMERCIALI SECONDO CIS 1.02.001 .	- GEARS BACKLASH : 0.18 - 0.49 mm. - INPUT SHAFT BEARINGS PRELOAD (WITHOUT OIL SEAL) : 2.5 - 5 Kgcm. - OUTPUT SHAFT BEARINGS PRELOAD (WITHOUT OIL SEAL) : 1 - 5 Kgcm. - APPLY SILICONE SEALANT BETWEEN COVER AND HOUSING. - TIGHTENING COVER BOLTS : 5 - 6.4 Kgcm. - SPRAY "NUCLEOIL 10" INSIDE THE HOUSING AS LAST OPERATION. - TIGHTENOIL PLUG AT 3 Kgcm. : GREASE WITH GREASE THE HOLE BEFORE ASSEMBLING THE PLUG. - OIL SEAL IN POS.-A-,-B-,AND -D- : APPLY BISULPHIDE MOLYBDENUM GREASE BETWEEN PRINCIPAL LIP AND DUST LIP. - NOT ASSEMBLED PARTS CODE A.253.001 . - COMMERCIAL COMPONENTS ACCORDING CIS 1.02.001 .

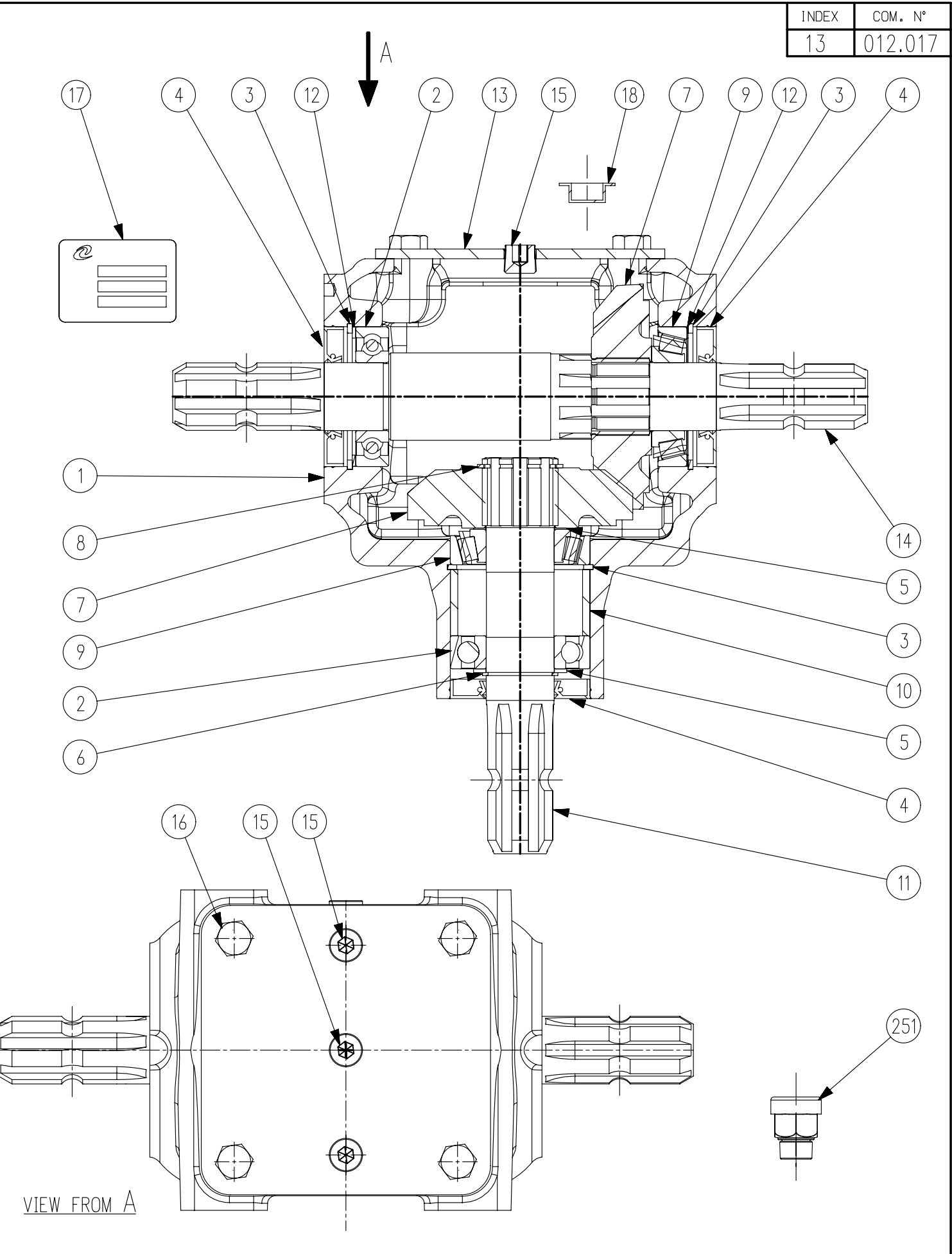
SPESS. TEORICA IN:

(A) 1.8 mm.
 (C) 0.65 mm.

 THEORETICAL SHIMS:

(B) 0.55 mm.
 (D) 1.95 mm.

COMPANY	REF. —	DESIGNATION T-27J
	DATE 03/MAY/12	CODE 9.267.806.10



REF.OFF.	COMPANY:	INDEX 13	COM. No. 012.017

RATIO	FIG. MONT.	COD. LETT.	T-27J	CODE
1 : 1	5 - 6	COD. NUM.	267	9.267.806.10

POS.	DRG. No.	PCS.	DESCRIPTION
1	0.267.0304.00	1	CASTING & MACHINING
2	8.0.1.00870	2	BALL BEARING 6207 (35x72x17)
3	8.5.2.00131	3	SNAP RING (72x75x2.5 , FOR HOLES)
4	8.7.1.02545	3	DUST LIP (35x72x10)
5	0.259.7500.00	2	SHIM KIT (35.3x48)
6	8.5.1.00005	1	SNAP RING (35x33x1.5 , FOR SHAFTS)
7	0.267.5007.00	2	GEAR Z18 M6.15
8	8.5.1.00029	1	SNAP RING (40x37.5x1.75 , FOR SHAFTS)
9	8.0.9.00026	2	ROLLER BEARING 30207 (35x72x18.25)
10	0.267.7100.00	1	SPACER (64.3x71.8x34.1)
11	0.267.2001.00	1	1"3/8 Z6 INPUT SHAFT
12	0.248.7500.00	2	SHIM KIT (60.3x71.7)
13	0.267.1300.00	1	COVER
14	0.267.3005.00	1	1"3/8 Z6 THROUGH OUTPUT SHAFT
15	8.6.6.00201	4	3/8" GAS CONICAL PLUG WITH EMBEDDED HEX
16	8.1.1.00054	4	BOLT M10x20 HHB (8.8)
17	0.124.7135.00	1	NAME PLATE
18	8.6.0.01684	1	3/8" GAS UNDERCAP

A.253.001 (SHIPPED SEPARATELY)			
POS.	DRG. No.	PCS.	DESCRIPTION
251	8.6.7.00161	1	3/8" GAS OIL VENT PLUG

DISTINTA PRODOTTO					VS1:					
Fig. Mont.					VS2:					
DESCRIZIONE					Data					
SCATOLA INGRANAGGI T-27J					21.07.2011					
					Cod.Std					
					9.267.006.10					
					Pag					
					1					
					9.267.806.10					
Liv. SV	Codice Part.	Posiz	UM	NP	Desc. Particolare	SD	Qualita'	Cod.Grezzo	Peso	Tp.
1	0.124.7135.00	17	NR	1	TARGHETTA (made in China)					
1	0.248.7500.00	12	NR	2	SPES.REG. 60.3x71.7	01017503	C 72 UNI 3545			
1	0.259.7500.00	5	NR	2	SPES.REG. 35.3x48.0	01017503	C 72 UNI 3545			
1	0.267.0304.00	1	NR	1	SCATOLA					
1	0.267.1300.00	13	NR	1	COPERCHIO PIATTO T3		FE360UNI-FE37			
1	0.267.2001.00	11	NR	1	ALBERO CALETTATO 1"3/8 Z6				1,47	
1	0.267.3005.00	14	NR	1	ALBERO PASSANTE 1"3/8 Z6				2,97	
1	0.267.5007.00	7	NR	2	IN.CON.FORG. Z18 M6,15 AP=20° C		20 CRMNTI			
1	0.267.7100.00	10	NR	1	DISTANZIALE 64.3x71.8x34.1					
1	8.0.1.00870	2	NR	2	CUSC. SFERE CLB 6207		*		0,01	
1	8.0.9.00026	9	NR	2	CUSC.RULLI CON.CLB 30207		*		0,32	
1	8.1.1.00054	16	NR	4	VITE TE M10x20 UNI5739 8.8		*			
1	8.5.1.00005	6	NR	1	ANELLO EL.SIC. x ALB 35 UNI7435		*			
1	8.5.1.00029	8	NR	1	ANELLO EL.SIC. x ALB 40 UNI7435		*			
1	8.5.2.00131	3	NR	3	ANELLO EL.SIC. x FORO 72 UNI7437		*			
1	8.6.0.01684	18	NR	1	SOTTOTAPPO 3/8"GAS					
1	8.6.6.00201	15	NR	4	TAPPO CON.ESAG.INC. 3/8"Gas		*			
1	8.7.1.02545	4	NR	3	AN.TEN.LAB.PAR.BASL 35X72 X10CFW-CP)					
1	A.253.001		NR	1	PARTICOLARI SMONTATI		ASS. VARI PART			

Distinta base alternativa 1 e 3 in COME
3 in D600