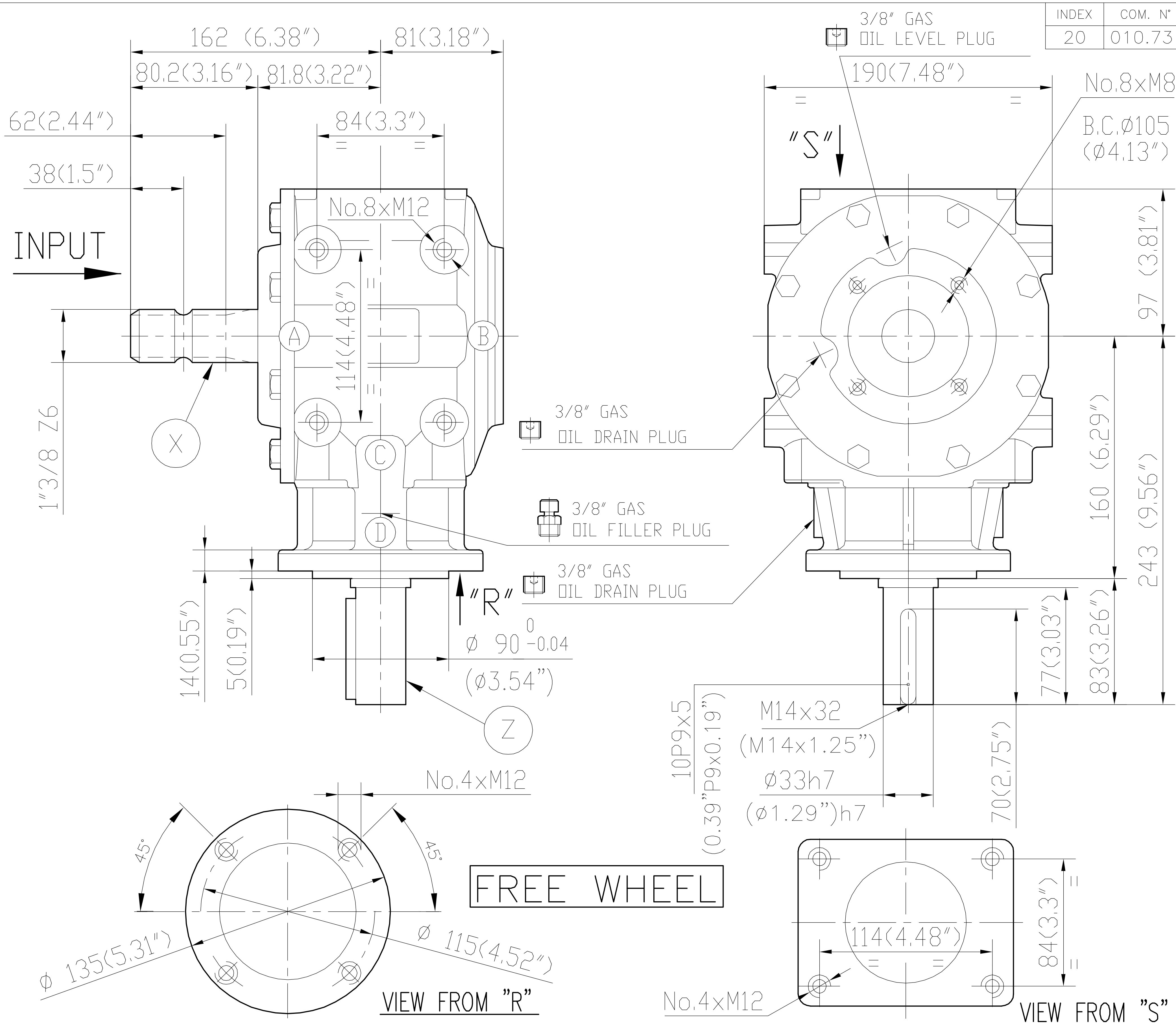
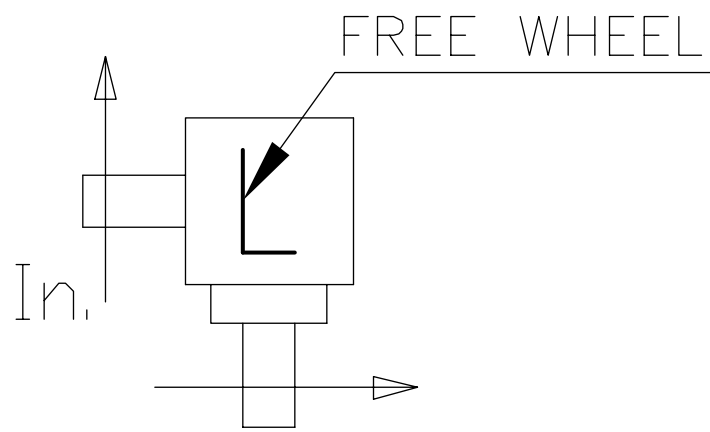


INDEX	COM. N°
20	010.731

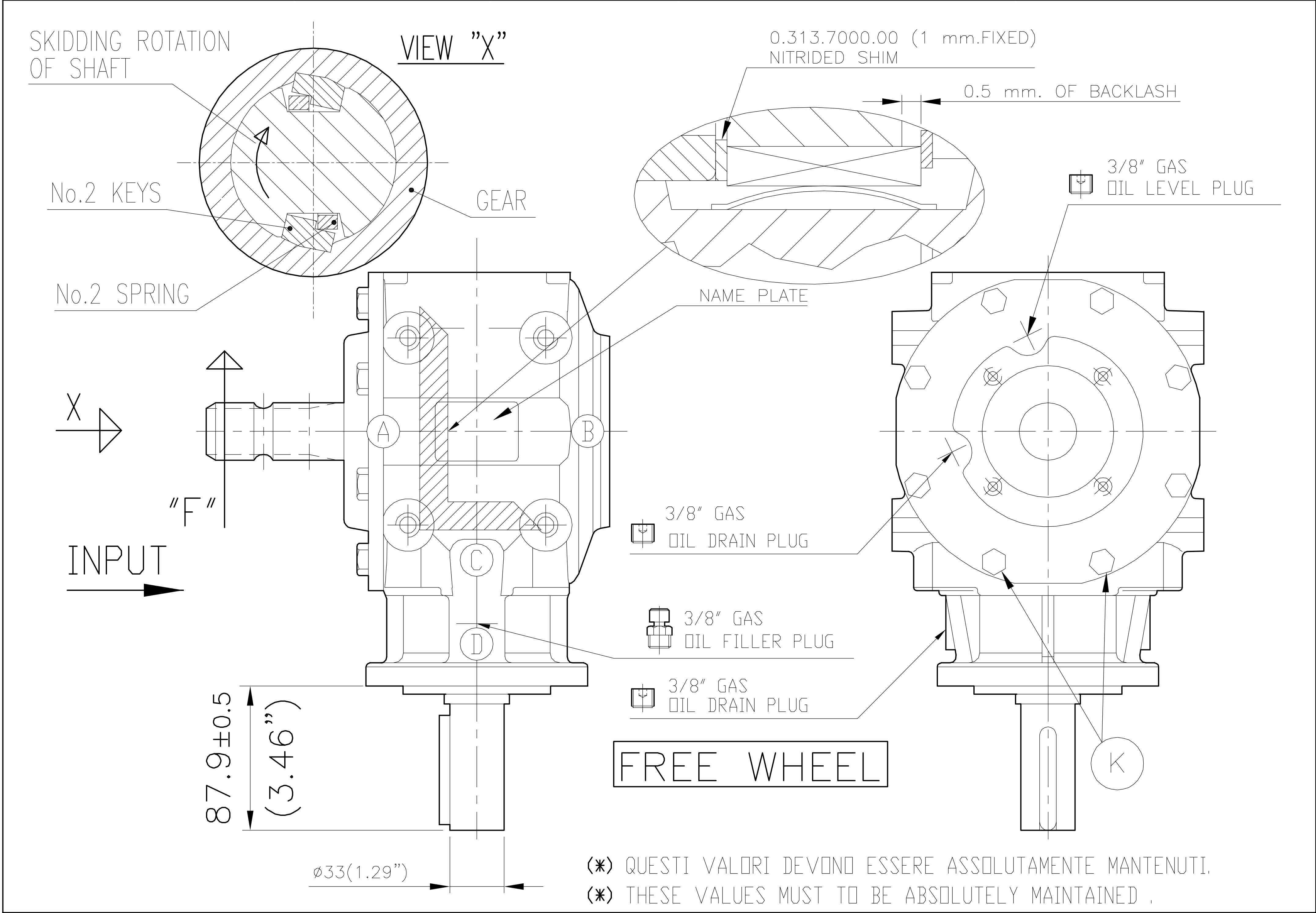


SPEED INCREASING UNIT	Ratio i					Rated input r.p.m.		Rated input power HP kW		Rated output torque da Nm		Weight Kg		Oil ☒ Grease ☐ Type Quantity Kg.					
	1 : 3					540		50		36.8		21		20.2		SAE.90EP		Lt. 1.2	
	Gear Arrangement		Bevel couplings							Cylindrical couplings							Bearings		
			Helicoidal	Straight	Teeth number				Module	Helicoidal	Straight	Teeth number				Module	A	6307	
				*	Z 1	Z 2	Z 3	Z 4	M.			Z 1	Z 2	Z 3	Z 4	M.	B	6307	
					12	36			4.35									C	32207
																		D	30207
																		E	
	Components material																	F	
	Casing		Shaft X			Shaft Z			Bevel gear				Spur gear				G		
ASTM 60-40-18		AISI 3120			AISI 3120			AISI 3120								H			

COMER INDUSTRIES reserves the right to make any change to this product without prior public acknowledgement

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

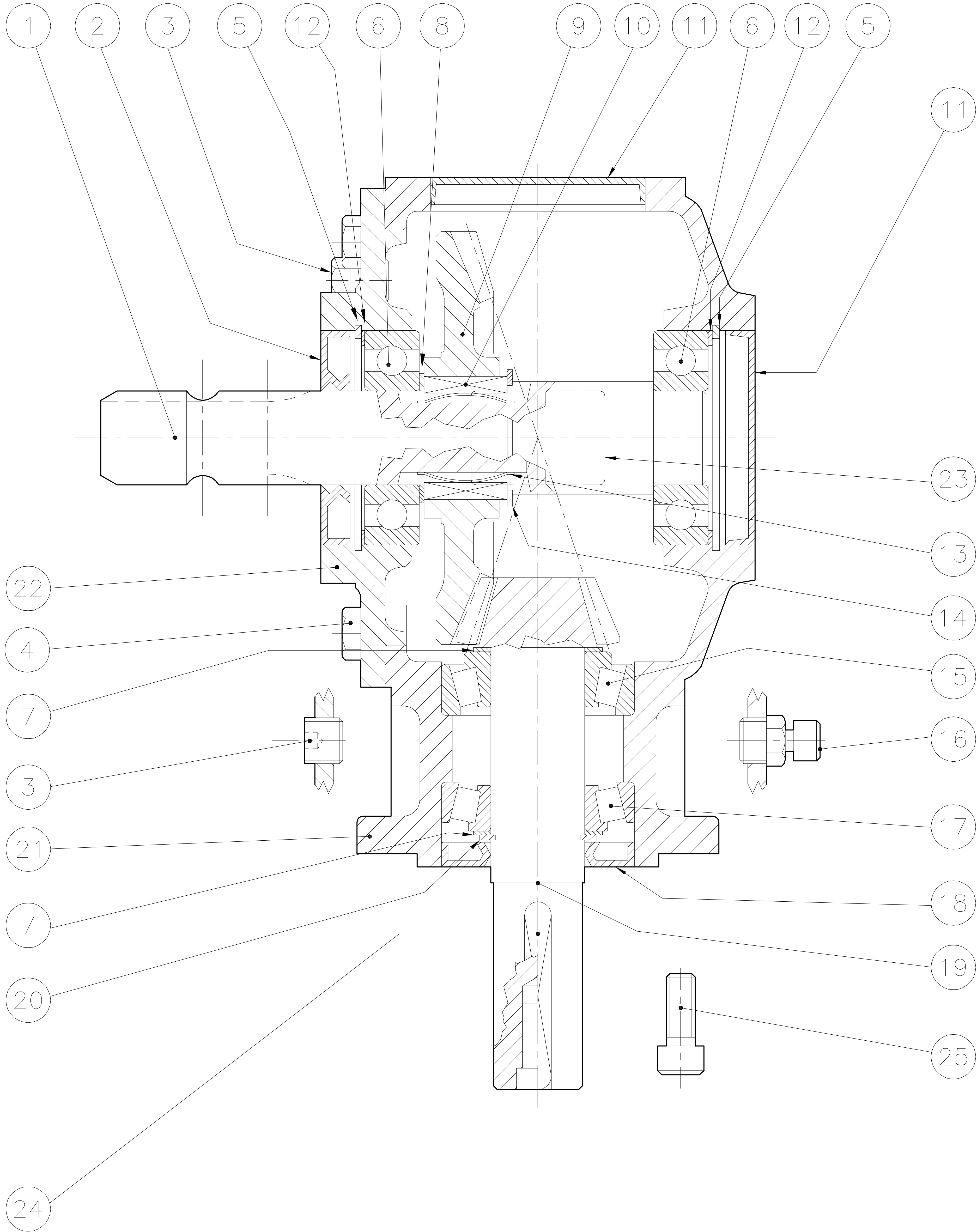
 comer industries gearboxes	REF. —		COMPANY : COMMERCIAL		INDEX	COM. N°
					20	010.731
	RATIO	FIG. MONT.	COD.LETT.	T-311J	CODE	
	1 : 3	21 – 22	COD.NUM.	311	9.311.874.20	



NOTE DI MONTAGGIO	ASSEMBLY NOTES
- GIOCO DI INGRANAMENTO 0,13 ÷ 0,35 mm. - PRECARICARE L'ASSE DI USCITA A 4÷10 kgcm (*) (SENZA PARAOILIO) , - GIOCO ASSE DI ENTRATA 0÷0,2 mm (SENZA PARAOILIO) , - SERRARE LE VITI COPERCHIO IN POS."A" A 5÷6,4 Kgcm. - AVVITARE LE VITI COD.8.1.2.00311 SULLA FLANGIA IN POS."D" SENZA PRECARICHI - APPLICARE SILICONE TRA COP. E SCATOLA IN POS."A". - NEBULIZZARE ALL'INTERNO DELLA SCATOLA CON "NUCLEOIL 10" COME ULTIMA OPERAZIONE - LE VITI IN POS."K" VANNO MONTATE CON SILICONE , - LA FRECCIA "F" INDICA LA ROTAZIONE DI LAVORO DELL'ALBERO (SI HA QUINDI LO LITTAMENTO CON ROTAZIONE OPPOSTA) , - IN POS. "A" TRA CUSC. E CORONA METTERE SOLAMENTE LO SPESS. COD. 0.313.7000.00. - AGGIUNGERE CON PENNELLO UN SOTTILE STRATO DI MOLYKOTE TIPO GN/PLUS COD. 8.8.9.02185 SUL ø INTERNO DELL'INGRANAGGIO E SUL ø ESTERNO DELL'ALBERO, TRALASCIANDO LE 2 CAVE PER LINGUETTA. - CONTROLLARE 100% QUOTA DELLA SPORGENZA DEL PIGNONE IN USCITA (87,9±0,5). - LA LINGUETTA COD. 0.267.7109.00 E LA MOLLA COD.0.267.7110.00 DEVONO ESSERE DI PRODUZIONE ITALIANA .	- GEARS BACKLASH 0,13 ÷ 0,35 mm. - PRELOAD THE BEARINGS OF OUTPUT SHAFT AT 4÷10 Kgcm (*) (WHITOUT OIL SEAL). - CLEARANCE INPUT SHAFT 0÷0,2 mm (WHITOUT OIL SEAL). - TIGHTEN THE COVER BOLTS IN POS."A" AT 5÷6,4 Kgcm. - ASSEMBLE THE BOLTS COD.8.1.2.00311 ON THE FLANGE POS."D" WITHOUT PRELOAD , - APPLY SILICONE SEALANT BETWEEN COVER AND HOUSING IN POS."A". - SPRAY "NUCLEOIL 10" INSIDE THE HOUSING AS LAST OPERATION - APPLY SILICONE SEALANT ON BOLTS IN POS."K" , - THE ARROW "F" INDICATES THE WORK ROTATION OF SHAFT (SU THE SKIDDING IS WITH OPPOSED ROTATION) , - IN POS. "A", INSERT THE SHIM COD. 0.313.7000.00 ONLY BETWEEN BEARING AND GEAR CROWN. - APPLY A SMALL LAYER OF MOLYKOTE TYPE "GN/PLUS" CODE 8.8.9.02185 WITH BRUSH ON INSIDE DIA. OF GEAR AND ON OUTSIDE DIA. OF SHAFT. - DON'T APPLY MOLYKOTE ON TWO KEYS SEAT. - CHECK 100% THE DIMENSION OF OUTPUT SHAFT OUTRIGGEN (87,9±0,5) , - THE KEY SEAT P/N. 0.267.7109.00 AND SPRING P/N. 0.267.7110.00 MUST BE OF ITALIAN PRODUCTION .
THEORETICAL SHIMS: (A) 1.8mm (B) 1.7 mm (C) 2.15 mm (D) 0.85 mm	

COMPANY	REF.	DESIGNATION
COMMERCIAL		T-311J
DATE	CODE	
15/FEB/07	9.311.874.20	

INDEX	COM. N°
20	010.731



 comer industries gearboxes	REF. . COMPANY : COMMERCIAL			INDEX	COM. N°
				20	010.731
	RATIO	FIG. MONT.	COD.LETT.	CODE	
1 : 3	21 - 22	COD.NUM.	T-311J 311	9.311.874.20	

POS.	DRG. Nr.	PCS.	DESCRIPTION
1	0.311.3201.00	1	1" 3/8 Z6 INPUT SHAFT
2	8.7.1.00315	1	DUST LIP (35x80x10)
3	8.6.6.00201	3	3/8" GAS OIL PLUG WITH EMBEDDED HEXAGON
4	8.1.1.00061	8	BOLT M10X25 HHB (8.8)
5	8.5.2.00030	2	SNAP RING (80x83.5x2.5 , FOR HOLES)
6	8.0.1.00049	2	BALL BEARING 6307 (35x80x21)
7	0.259.7500.00	2	SHIM KIT (35.3x48)
8	0.313.7000.00	1	NITRIDED SHIM (35.3x48x1)
9	0.311.6214.00	1	CROWN WHEEL Z36 M4.35
10	0.267.7109.00	2	KEY FOR FREE WHEEL
11	8.7.0.00790	2	OIL CAP 80X10
12	0.267.7500.00	2	SHIM KIT (69x79.7)
13	0.267.7110.00	2	RUBBER BAND
14	8.5.1.00712	1	SNAP RING (42x39.5x1.75 , FOR SHAFTS)
15	8.0.9.00127	1	ROLLER BEARING 32207 (35x72x24.25)
16	8.6.7.00161	1	3/8" GAS OIL VENT PLUG
17	8.0.9.00026	1	ROLLER BEARING 30207 (35x72x18.25)
18	8.7.3.00055	1	OIL SEAL (35x72x10)
19	0.304.5011.00	1	PINION SHAFT Z12 M4.35
20	8.5.1.00583	1	SNAP RING (35x33x2.5 , FOR SHAFTS)
21	0.311.0303.00	1	HOUSING
22	0.311.1310.00	1	COVER
23	0.124.7135.00	1	NAME PLATE
24	8.4.1.01689	1	HARDENED PARALLEL KEY A (10x8x65)
25	8.1.2.00311	4	M12x30 HEX SOCKET HEAD CAP SCREWS (8.8) UNI5931

SHIPPED SEPARATELY			
POS.	DRG. Nr.	PCS.	DESCRIPTION