



comer industries
gearboxes

COMPANY COMMERCIAL

INDEX	COM. N°
01	008.317

RATIO

7.75 : 1

FIG. MONT.

1-2

COD.LETT.

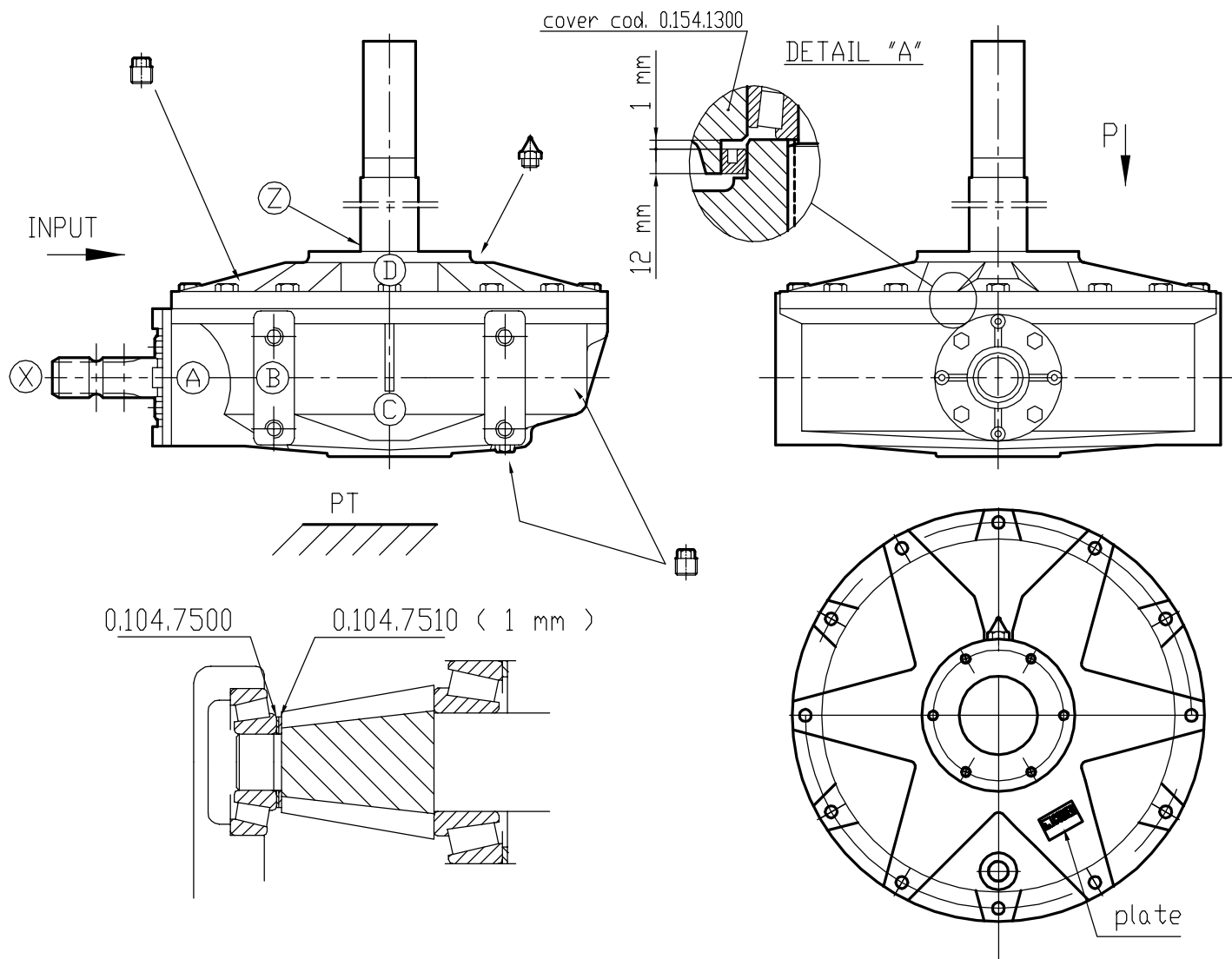
L-154J

COD.NUM.

154

CODE

154.802



NOTE DI MONTAGGIO

- GIOCO DI INGRANAMENTO
- PRECARICO ASSE DI U.
- PRECARICO ASSE DI E.
- SERRAGGIO VITI COP. DI U.
- SERRAGGIO VITI COP. DI E.
- IL PARAOLIO COD. 8.7.3.01331 IN POS. -17- DEVE ESSERE MONTATO PARI AL COPERCHIO (PARTICOLARE "A")
- MONTARE L'ALBERO E LA CORONA AD INTERFERENZA
- AL MONTAGGIO IL CUSCINETTO IN 5 DEVE ESSERE SCALDATO.
- MEDIANTE INGRASSATORE RIEMPIRE CON GRASSO NLGI 2 TRA CUSCINETTO E PARAOLIO FINO ALLA FUORIUSCITA DEL GRASSO DAL FORD OPPOSTO ALL'INGRESSATORE.
- PARTICOLARI SMONTATI

ASSEMBLY NOTES

- GEARS BACKLASH
- OUTPUT SHAFT BEARINGS PRELOAD
- INPUT SHAFT BEARINGS PRELOAD
- TIGHTENING OUTPUT COVER BOLTS
- TIGHTENING INPUT COVER BOLTS
- THE OIL SEAL COD.8.7.3.01331 (POS.-17-) MUST BE ASSEMBLED ON THE SAME LEVEL WITH THE COVER (DETAIL "A")
- ASSEMBLE THE OUTPUT SHAFT AND THE CROWN TO INTERFERENCE
- FOR THE ASSEMBLAGE THE BEARING 5 MUST BE HEATED
- USE LUBRICATOR TO FILL WITH NLGI2 GREASE BETWEEN BEARING AND OIL SEAL UNTIL THE GREASE EXIT FROM OPPOSITE HOLE
- NOT ASSEMBLED PARTS

0.15-0.25 mm
1-5 KGcm
1-5 KGcm
5.5-6.5 Kgm
5.5-6.5 Kgm

P/N A.154.000

SPESS. TEORICA IN:
THEORETICAL SHIM

A= 1.75 mm - B= 0.75+1 mm C= 1 mm - D= 1 mm

 comer industries gearboxes		COMPANY				INDEX	COM. N°
						01	008.317
		RATIO		FIG. MONT.	COD.LETT. L-154J		CODE
7.75 : 1		1-2		COD.NUM. 154		9.154.802	
POS.	DRG. Nr.		PCS.	DESCRIPTION			
1	0.154.0300		1	CASTING & MACHINING			
2	0.104.7510		1	SHIM 20.3 X 1			
3	8.0.9.01330		1	BEARING 30304			
4	0.712.7500		1	SHIM 50.3x70.3			
5	8.0.9.00469		2	ROLLER BEARING 30210			
6	0.154.7100		1	SPACE			
7	8.6.5.00006		3	3/8" GAS SOLID PLUG			
8	8.1.1.00073		12	BOLT M10x30 8.8			
9	0.154.6102		1	CROWN Z62 M5.1			
10	0.154.1300		1	COVER			
11	8.8.1.01332		1	1/8" GAS LUBRICATOR			
12	0.702.7500		1	SHIM KIT (80.3 X 89.7)			
13	8.7.1.01097		1	DUST LIP 50x72x8			
14	0.154.3004		1	OUTPUT SHAFT			
15	0.248.7500		1	SHIM KIT (60.3 X 71.7)			
16	0.154.1301		1	COVER			
17	8.7.3.01331		1	OIL SEAL 90x110x12			
18	0.104.7500		1	SHIM KIT (20.3 X 32)			
19	8.6.5.00203		1	1/2" GAS SOLID PLUG			
20	8.0.9.00127		1	ROLLER BEARING 32207			
21	8.1.1.00501		4	BOLT M10 x 22 8.8			
22	8.7.3.00028		1	OIL SEAL 35x52x7			
23	0.154.5100		1	PINION Z8 M5.1			
24	0.124.7135		1	NAME PLATE			
25	0.278.7925		1	TUBOLAR NET			

A.154.000 — SHIPPED SEPARATELY			
POS.	DRG. Nr.	PCS.	DESCRIPTION
251	0.154.7001	1	HUB


comer industries
gearboxes

COMPANY

REF.

DESIGNATION

L-154J

DATE

14/dec/00

CODE

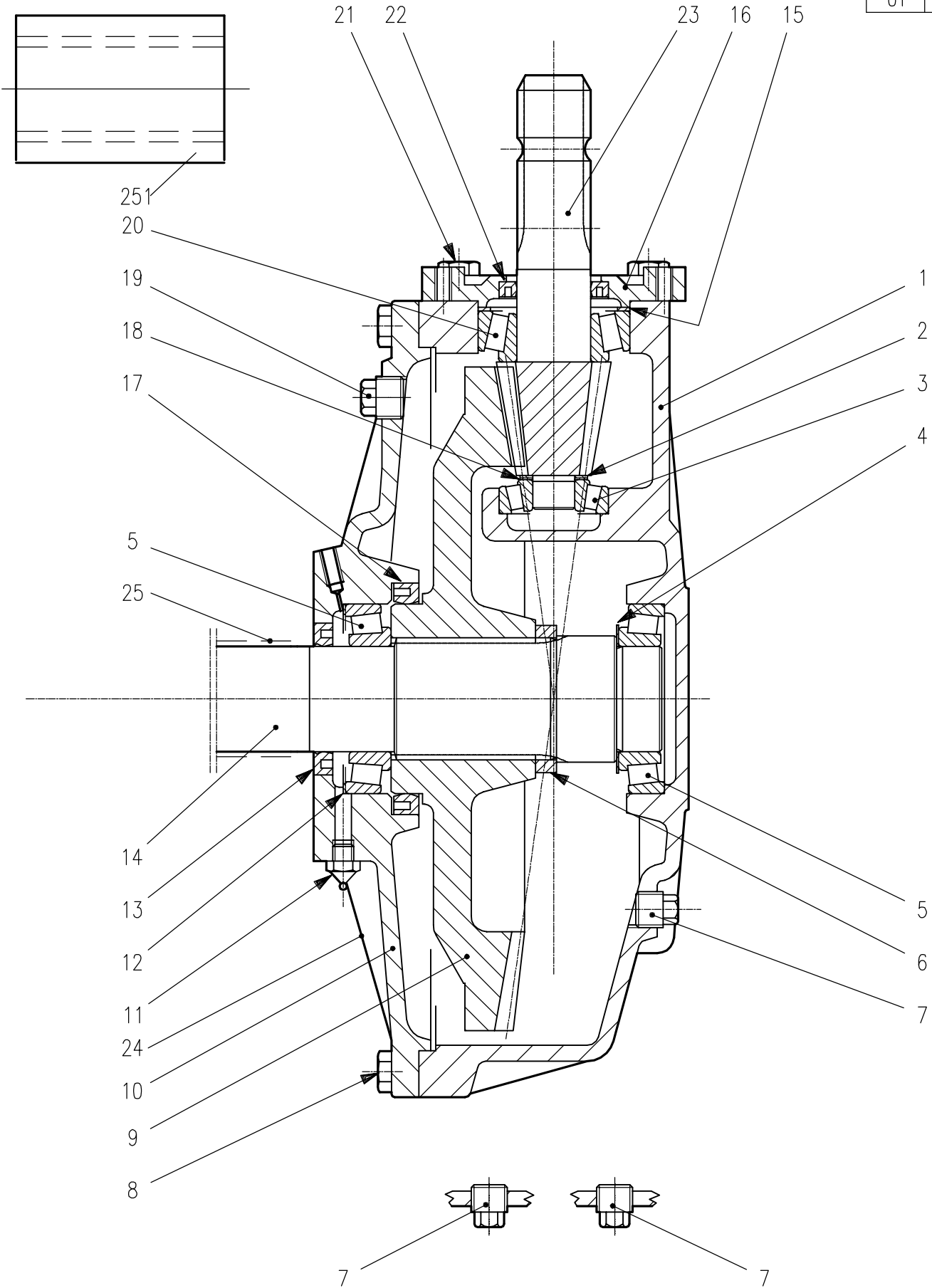
9.154.802

INDEX

COM. N°

01

008.317



Technical drawing of a gearbox assembly, showing internal components and parts numbered 1 through 25, and 251. The drawing includes a cross-section view of the gearbox housing and internal assembly, with a detail view of the hub (251) shown separately. The drawing is labeled with 'COMER INDUSTRIES S.p.A' and '42046 Villanova di Reggiolo (RE) Italia'.

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