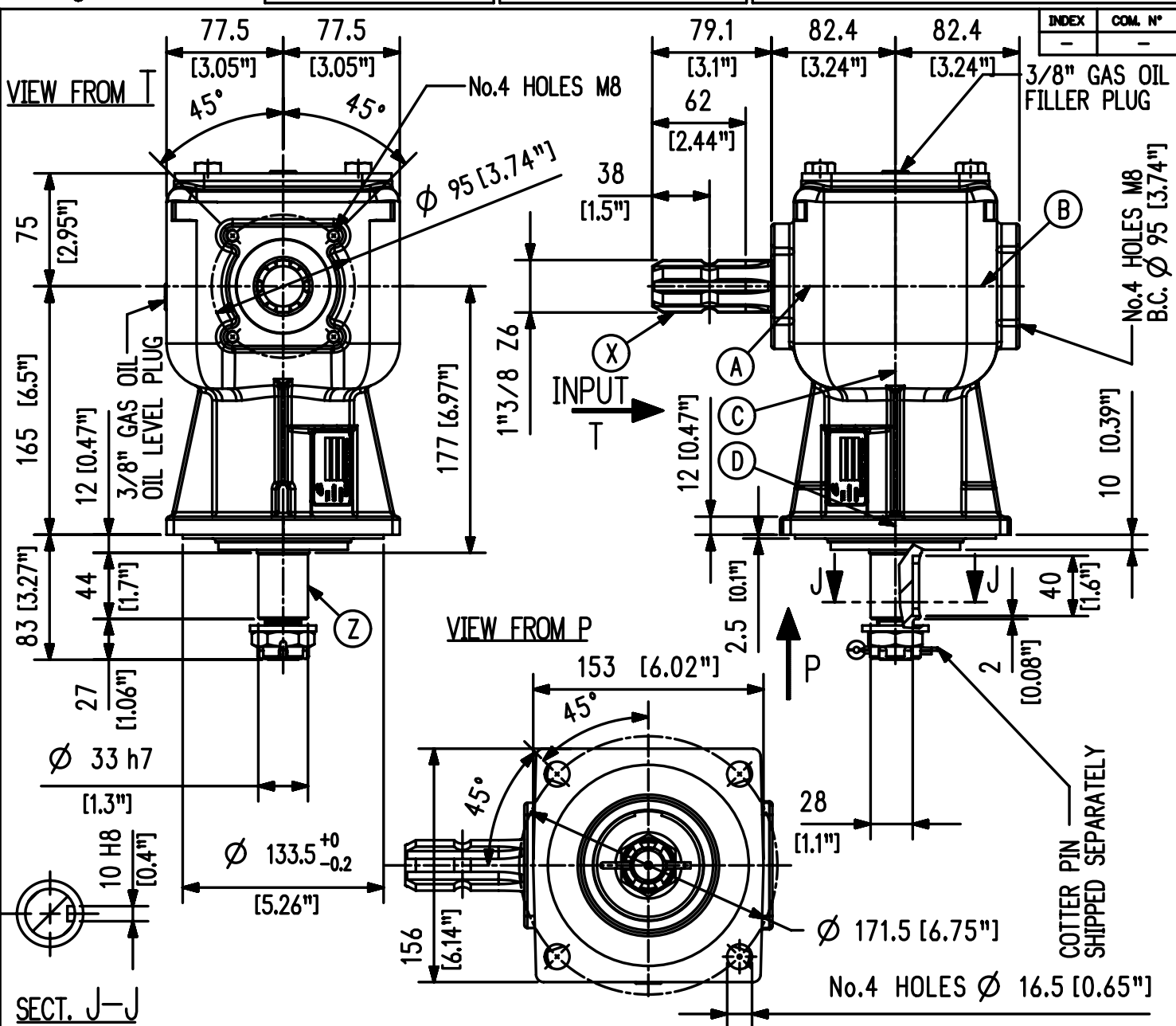
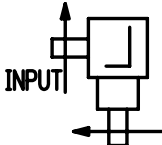




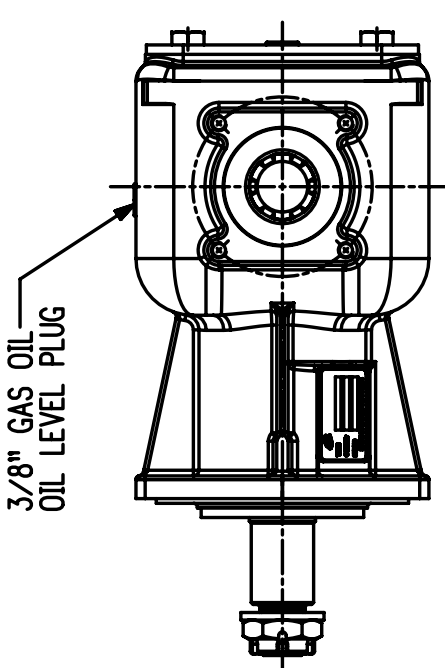
SPEED INCREASING UNIT	Ratio i		Rated input r.p.m.		Rated input power HP kW		Rated output torque da Nm		Weight Kg		Oil ☒ Grease ☐ Type Quantity Lt.								
	1 : 2.83		540		20 14.7		8.9		—		SAE 90 EP 0.5								
	Gear Arrangement		Bevel couplings						Cylindrical couplings						Bearings				
			Helicoid	Straight	Teeth number			Module	Helicoid	Straight	Teeth number			Module	A	6007			
					Z 1	Z 2	Z 3	Z 4	M.			Z 1	Z 2	Z 3	Z 4	M.	B	6207	
				*	12	34			3.36									C	6207
																		D	6207
																	E		
Components material																F			
Casing		Shaft X		Shaft Z		Bevel gear		Spur gear				G							
ASTM 60-40-18		AISI 1040		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

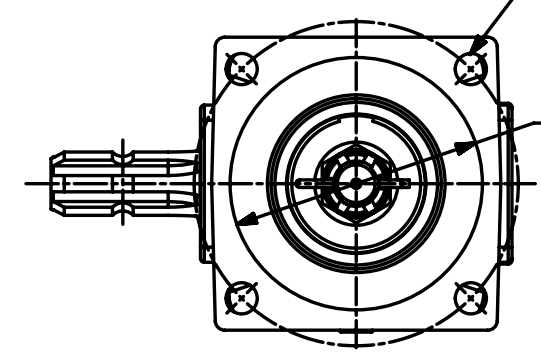
 comer industries gearboxes	RIF. OFF.		COMPANY:		INDEX	COM. N°
	RATIO	FIG. MONT.	COD.LETT.	LF - 211J	CODE	
	1 : 2.83	23 - 24	COD.NUM.	211	9.211.899.00	

VIEW FROM T

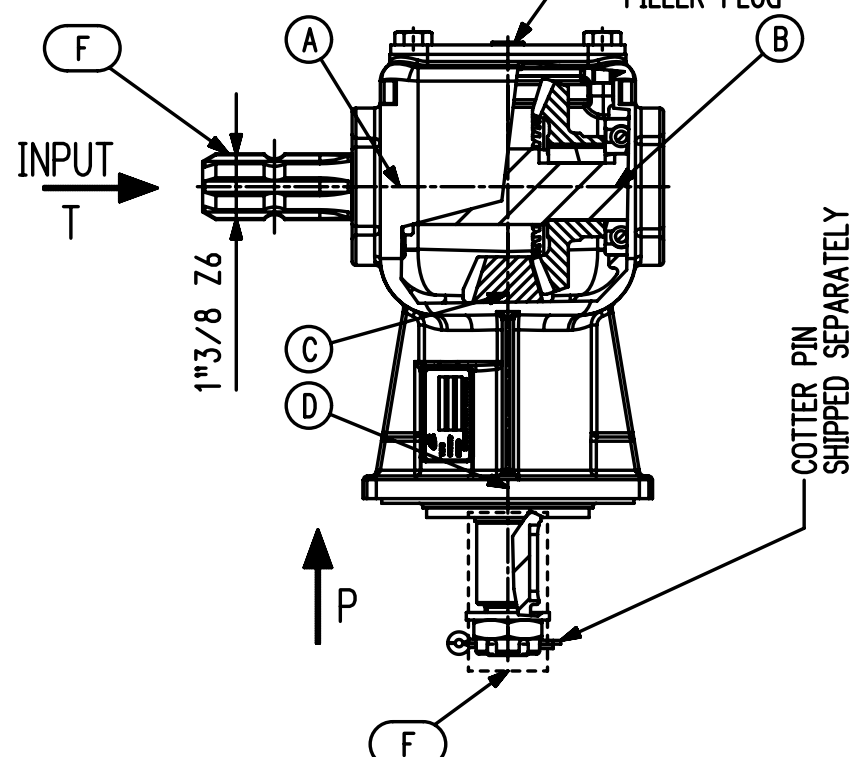


3/8" GAS OIL OIL LEVEL PLUG

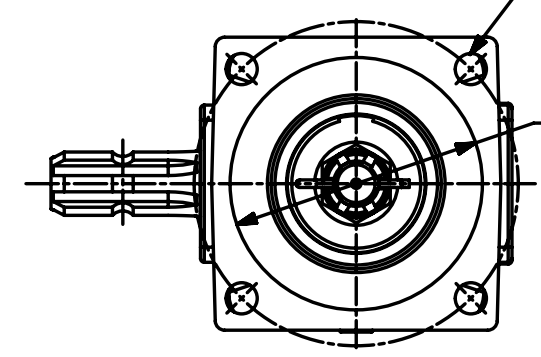
VIEW FROM P



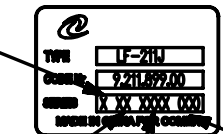
3/8" GAS OIL OIL LEVEL PLUG



3/8" GAS OIL OIL LEVEL PLUG



3/8" GAS OIL OIL LEVEL PLUG



DETAIL M

SPECIFICA CIS.1.01 PRODOTTO-PROCESSO PRODUCT-PROCESS SPECIFICATION CIS.1.01	CLASSE FUNZIONALE FUNCTIONAL CLASS
CARATTERISTICA REPORT REPORT CHARACTERISTIC	0
CARATTERISTICA IMPORTANTE CRITICA CRITICAL CHARACTERISTIC	0
CARATTERISTICA DI ATTENZIONE WARNING CHARACTERISTIC	0
CARATTERISTICA DI FISSAGGIO CLIENTE FIT CHARACTERISTIC	4

 comer industries gearboxes	RIF. OFF.		COMPANY:		INDEX	COM. N°
	RATIO	FIG. MONT.	COD.LETT.	LF - 211J	CODE	
	1 : 2.83	23 - 24	COD.NUM.	211	9.211.899.00	

NOTE DI MONTAGGIO

- GIOCO D'INGRANAMENTO : 0.10 - 0.27 mm.
- GIOCO ASSIALE DI ENTRATA : 0 - 0.2 mm. (SENZA ANELLI DI TENUTA) .
- PRECARICO ASSE DI USCITA : 0 - 3 kgcm. (SENZA ANELLO DI TENUTA) .
- SERRAGGIO VITI COPERCHIO : 5 - 6.4 kgm.
- GRASSO AL BISOLFURO DI MOLIBDENO TRA CUSCINETTO E PARAOLIO IN POS. - D - .
- IL CAPPELLOTTO IN POS. - B - DEVE ESSERE MONTATO PARI AL PIANO SCATOLA.
- IN POS. - C - MONTARE UN SOLO SPESSORE (SPESSORE UNICO) .
- NEBULIZZARE ALL'INTERNO DELLA SCATOLA CON "NUCLEOIL 10" COME ULTIMA OPERAZIONE .
- PARTICOLARI SMONTATI COD. A.108.012 .
- PARTICOLARI COMMERCIALI SECONDO CIS 1.02.001.
- PARAOLIO IN POS. - D - : APPLICARE GRASSO AL BISOLFURO DI MOLIBDENO TRA I DUE LABBRI.
- SERRAGGIO TAPPI OLIO 3 kgm. MAX.: INGRASSARE CON GRASSO IL FORO PRIMA DI MONTARE IL TAPPO.
- DETTAGLIO "M": STAMPIGLIARE LA TARGHETTA COME INDICATO NEL DISEGNO (EX.G 13 0034).
- APPLICARE SILICONE TRA SCATOLA E COPERCHIO.

ASSEMBLY NOTES

- GEARS BACKLASH : 0.10 - 0.27 mm.
- INPUT SHAFT AXIAL CLEARANCE : 0 - 0.2 mm. (WITHOUT OIL SEAL) .
- OUTPUT SHAFT BEARINGS PRELOAD : 0 - 3 kgcm. (WITHOUT OIL SEAL) .
- TIGHTENING COVER BOLTS : 5 - 6.4 kgm.
- BISULPHIDE MOLYBDENUM GREASE BETWEEN BEARING AND DUST LIP IN POS. - D - .
- THE OIL CAP IN POS. - B - MUST BE ASSEMBLED ON THE SAME LEVEL WITH THE PLANE CASING.
- IN POS. - C - ASSEMBLY ONLY ONE SHIM (UNIQUE SHIM) .
- SPRAY "NUCLEOIL 10" INSIDE THE HOUSING AS LAST OPERATION .
- NOT ASSEMBLED PARTS P/No. A.108.012 .
- COMMERCIAL COMPONENTS ACCORDING CIS 1.02.001.
- OIL SEAL IN POS. - D - : APPLY BISULPHIDE MOLYBDENUM GREASE BETWEEN PRINCIPAL LIP AND DUST LIP.
- TIGHTEN OIL PLUG AT 3 kgm. MAX.: GREASE WITH GREASE THE HOLE BEFORE ASSEMBLING THE PLUG.
- DETAIL "M": PRINT THE NAME PLATE AS INDICATED INTO DRAWING (EXAMPLE G 13 0034).
- APPLY SILICONE SEALANT BETWEEN COVER AND HOUSING.

SPESS. TEORICA IN:
THEORETICAL SHIMS:

0.9 mm.
 0.9 mm.
 0.8 mm.
 0.8 mm.

VERSIONE COME 9.211.803.00 MA CON INGRANAGGI IN PRECISION FORGING

 comer industries gearboxes	RIF.OFF.			COMPANY:		INDEX	COM. N°
						-	-
	RATIO	FIG. MONT.	COD.LETT.	LF - 211J	CODE		
1 : 2.83	23 - 24	COD.NUM.	211	9.211.899.00			

POS.	DRG. No.	PCS.	DESCRIPTION
1	0.141.2100.00	1	1"3/8 Z6 INPUT SHAFT
2	8.7.0.00744	1	OIL CAP (72x10)
3	8.0.1.00870	3	BALL BEARING 6207 (35x72x17)
4	0.259.7500.00	2	SHIM KIT (35.3x48.0)
5	8.4.1.00993	1	PARALLEL KEY B (10x8x30) HARDENED AND TEMPERED
6	0.211.5000.00	1	GEAR CROWN Z34 M3.36 (PRECISION FORGING)
7	8.6.6.00201	2	3/8" GAS OIL PLUG WITH EMBEDDED HEXAGON
8	8.5.2.00648	1	SNAP RING (62x65x3 , FOR HOLES)
9	0.113.7500.00	1	SHIM KIT (55.3x61.7)
10	8.1.1.00054	4	BOLT M10x20 HHB (8.8)
11	0.205.1300.00	1	COVER
12	8.0.1.00000	1	BALL BEARING 6007 (35x62x14)
13	0.211.6001.00	1	PINION SHAFT Z12 M3.36 (PRECISION FORGING)
14	0.141.7100.00	1	SPACER (64x70x59.7)
15	8.7.1.00152	1	DUST LIP (35x72x10)
16	8.5.3.00915	1	SNAP RING SB 72
17	8.2.2.01144	1	CASTLE NUT M24x2 PR80B
18	8.3.2.00409	1	FLAT WASHER (25x44x4)
19	8.5.1.00005	1	SNAP RING (33x35x1.5 , FOR SHAFT)
20	8.5.2.00131	2	SNAP RING (72x75x2.5 , FOR HOLES)
21	0.211.0300.00	1	CASTING & MACHINING
22	0.124.7135.00	1	NAME PLATE
23	0.248.7500.00	1	SHIM KIT (60.3x71.7)
24	8.7.3.01259	1	OIL SEAL (35x62x7)
25	0.211.7100.00	1	SPACER (35.1x51x5.5)

A.108.012 (SHIPPED SEPARATELY)			
POS.	DRG. No.	PCS.	DESCRIPTION
251	8.4.7.00516	1	COTTER PIN B5x50

DISTINTA PRODOTTO										VS1:								
Fig. Mont.										VS2:								
DESCRIZIONE										Data		Cod.Std		Pag				
SCATOLA INGRANAGGI LF-211J										13.01.2014		9.211.803.00		1				
														9.211.899.00				
Liv.	SV	Codice Part.	Posiz	UM	NP	Desc. Particolare				SD	Qualita'	Cod.Grezzo	Peso	Tp.Stato	mat pad	Stato	mat comp	Tipo pos
1		0.113.7500.00	9	NR	1	SPES.REG. 55.3x61.7				01017503	C 72 UNI 3545			9 S		S		L
1		0.124.7135.00	22	NR	1	TARGHETTA (made in China)					ALLUMINIO	1.124.7135.00		22 S		S		L
1		0.141.2100.00	1	NR	1	ALBERO CALETTATO 1"3/8 Z6					C 40 UNI 5332	4.10.202.0218	2,35	1 S		S		L
1		0.141.7100.00	14	NR	1	DISTANZIALE 64x70x59.7					FE360UNI-FE37	4.20.130.0265	0,33	14 S		S		L
1		0.205.1300.00	11	NR	1	COPERCHIO PIATTO LF-205J					FE360UNI-FE37			11 S		S		L
1		0.211.0300.00	21	NR	1	SCATOLA LF-211J					GGG40 DIN 1693			21 S		S		L
1		0.211.5000.00	6	NR	1	COR.CON.Z34 M3,36 PREC.FORG.					20 CRMNTI	1.211.5000.00		6 S		S		L
1		0.211.6001.00	13	NR	1	ALB.PIGN.P.FORG.CON.Z12 M3,36					20 CRMNTI	1.211.6001.00		13 S		S		L
1		0.211.7100.00	25	NR	1	DISTANZIALE 35.1x51x5.5					FE510UNI-FE52			25 S		S		L
1		0.248.7500.00	23	NR	1	SPES.REG. 60.3x71.7				01017503	C 72 UNI 3545			23 S		S		L
1		0.259.7500.00	4	NR	2	SPES.REG. 35.3x48.0				01017503	C 72 UNI 3545			4 S		S		L
1		8.0.1.00000	12	NR	1	CUSC. SFERE CLB 6007					*		0,16	12 S		S		L
1		8.0.1.00870	3	NR	3	CUSC. SFERE CLB 6207					*		0,30	3 S		S		L
1		8.1.1.00054	10	NR	4	VITE TE M10x20 UNI5739 8.8					*			10 S		S		L
1		8.2.2.01144	17	NR	1	DADO ES.INT. M24x2 UNI5594 PR80B								17 S		S		L
1		8.3.2.00409	18	NR	1	ROS. x VITI 25x44x4					*			18 S		S		L
1		8.4.1.00993	5	NR	1	LINGUETTA TEMPRATA B 10x8x30					*			5 S		S		L
1		8.5.1.00005	19	NR	1	ANELLO EL.SIC. x ALB 35 UNI7435					*			19 S		S		L
1		8.5.2.00131	20	NR	2	ANELLO EL.SIC. x FORO 72 UNI7437					*			20 S		S		L
1		8.5.2.00648	8	NR	1	ANELLO EL.SIC. x FORO 62 H=3 UNI7438					*			8 S		S		L
1		8.5.3.00915	16	NR	1	ANELLO DI SPAL. x ALLOG. SB72					*			16 S		S		L
1		8.6.6.00201	7	NR	2	TAPPO CON.ESAG.INC. 3/8"Gas					*			7 S		S		L
1		8.7.0.00744	2	NR	1	CAPPELLOTTO DI CHI. 72x10					*			2 S		S		L
1		8.7.1.00152	15	NR	1	AN.TEN.LAB.PAR.BAUD 35x72x10					*		0,05	15 S		S		L
1		8.7.3.01259	24	NR	1	AN.TEN.NORM. BA 35x62x7								24 S		S		L
1		A.108.012	.	NR	1	PARTICOLARI SMONTATI								. S		S		L
.2		8.4.7.00516	.	NR	1	COPIGLIA B5x50 UNI1336								251S		S		L