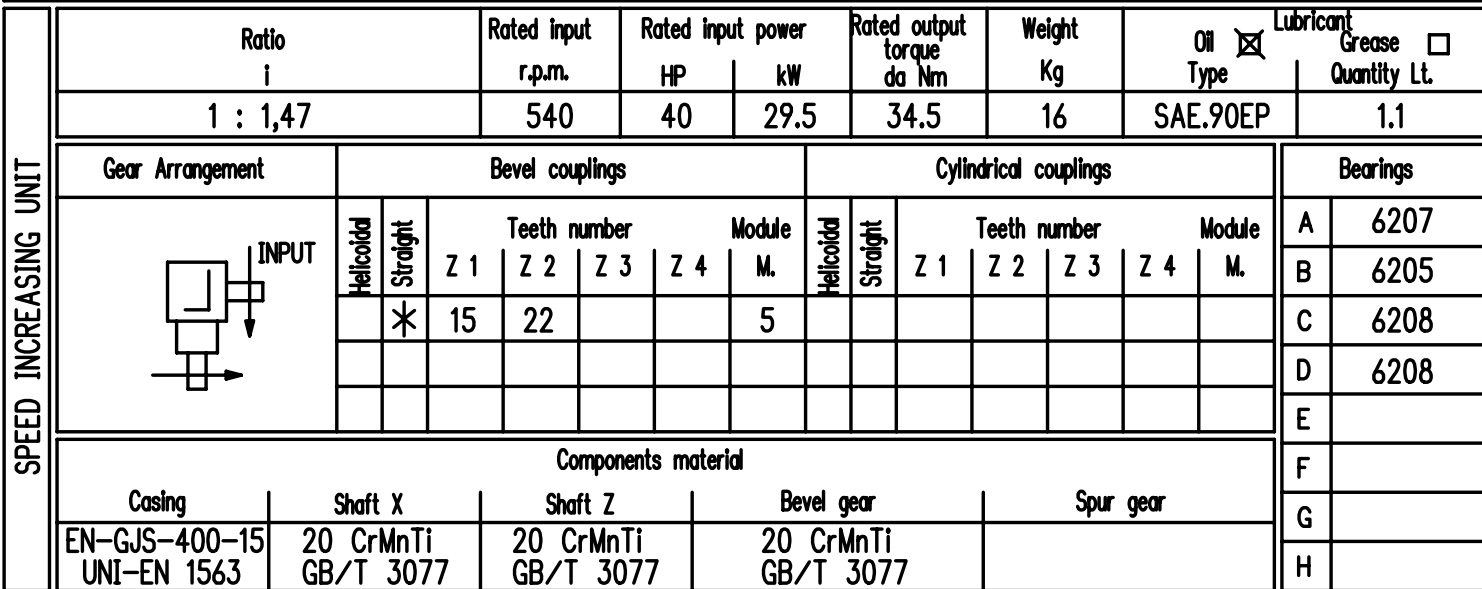
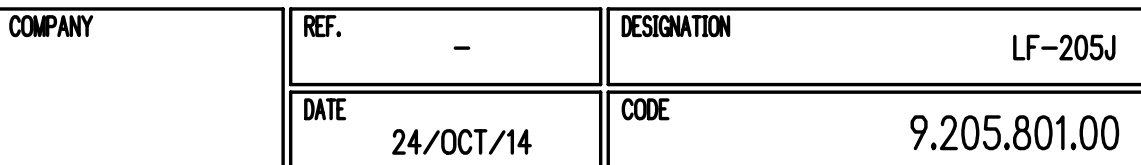
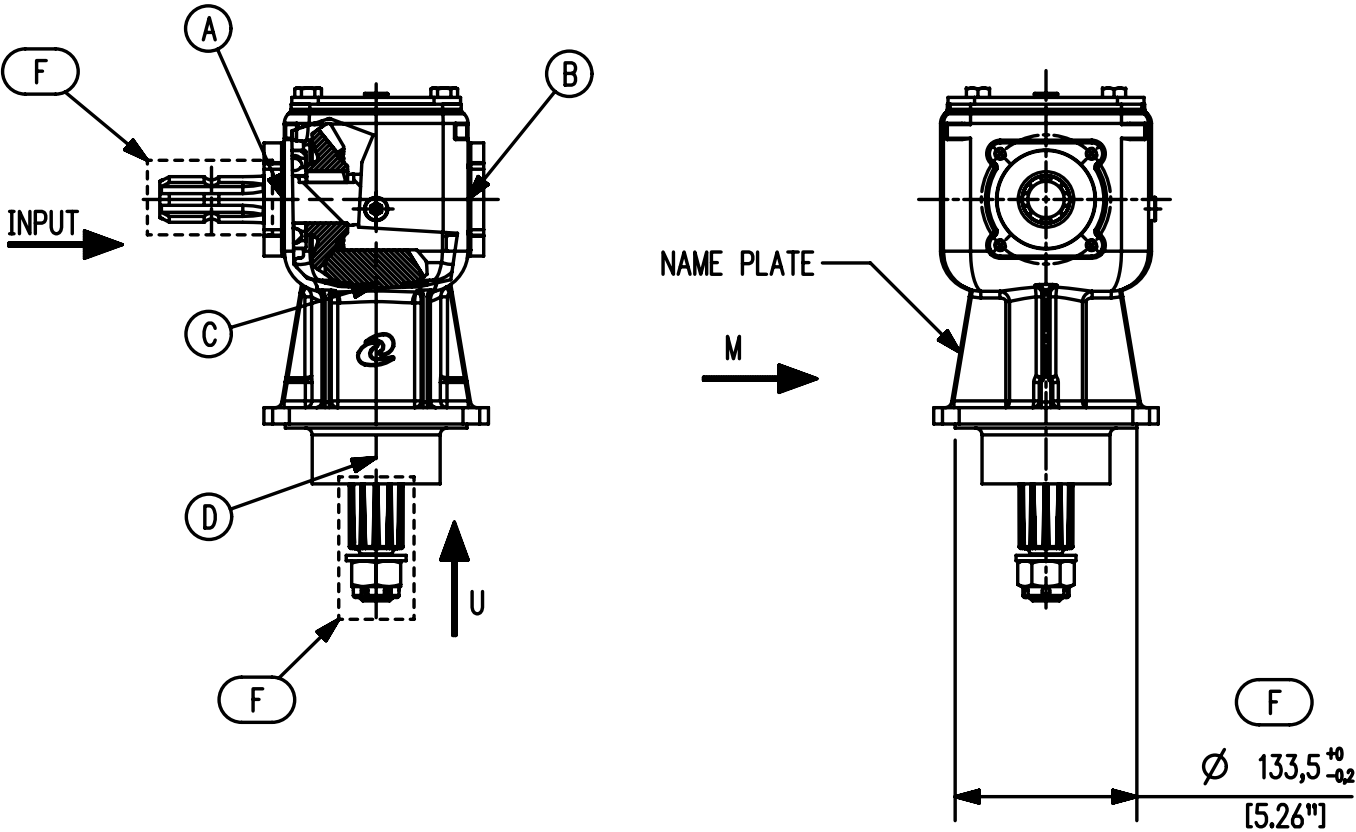




COMER INDUSTRIES S.p.A. 42046 Villanova di Reggiolo (R.E.) Italia Tel. 0522\974111 (9 Linee) Telefax 0522\973249

 comer industries gearboxes	RIF. OFF.		COMPANY:		INDEX	COM. N°
					04	016.243
	RATIO	FIG. MONT.	COD.LETT.	LF-205J	CODE	
	1 : 1.47	21 - 22	COD.NUM.	205	9.205.801.00	



VIEW FROM M



TYPE	LF-205J
CODE N°	9.205.801.00
SERIES	X XX XXXX (XX)
MADE IN CHINA FOR COMER	

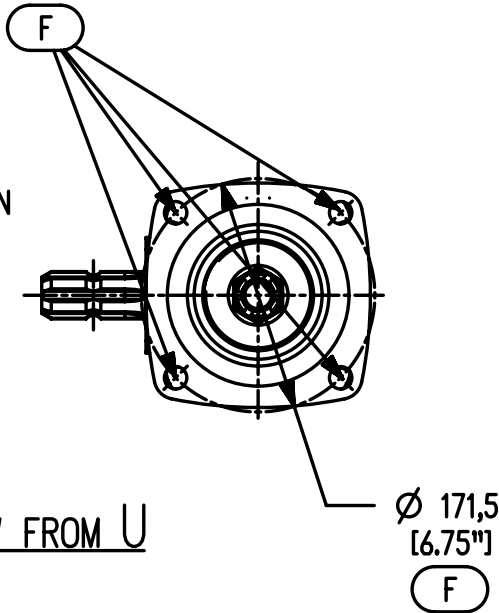
PRODUCTION MONTH (BY LETTER A-L) ———

PRODUCTION YEAR (LAST 2 DIGIT) ———

SUPPLIER IDENTIFICATION (PREVIOUSLY PRINTED) ———

SERIAL NUMBER ———

SPECIFICA CIS.1.01 PRODOTTO-PROCESSO PRODUCT-PROCESS SPECIFICATION CIS.1.01		CLASSE FUNZIONALE FUNCTIONAL CLASS
 CARATTERISTICA REPORT REPORT CHARACTERISTIC	0	CF 3
 CARATTERISTICA IMPORTANTE CRITICA CRITICAL CHARACTERISTIC	0	
 CARATTERISTICA DI ATTENZIONE WARNING CHARACTERISTIC	0	
 CARATTERISTICA DI FISSAGGIO CLIENTE FIT CHARACTERISTIC	5	



VIEW FROM U

 comer industries gearboxes	RIF. OFF.		COMPANY:		INDEX	COM. N°
					04	016.243
	RATIO	FIG. MONT.	COD.LETT.	LF-205J	CODE	
	1 : 1.47	21 - 22	COD.NUM.	205	9.205.801.00	

NOTE DI MONTAGGIO

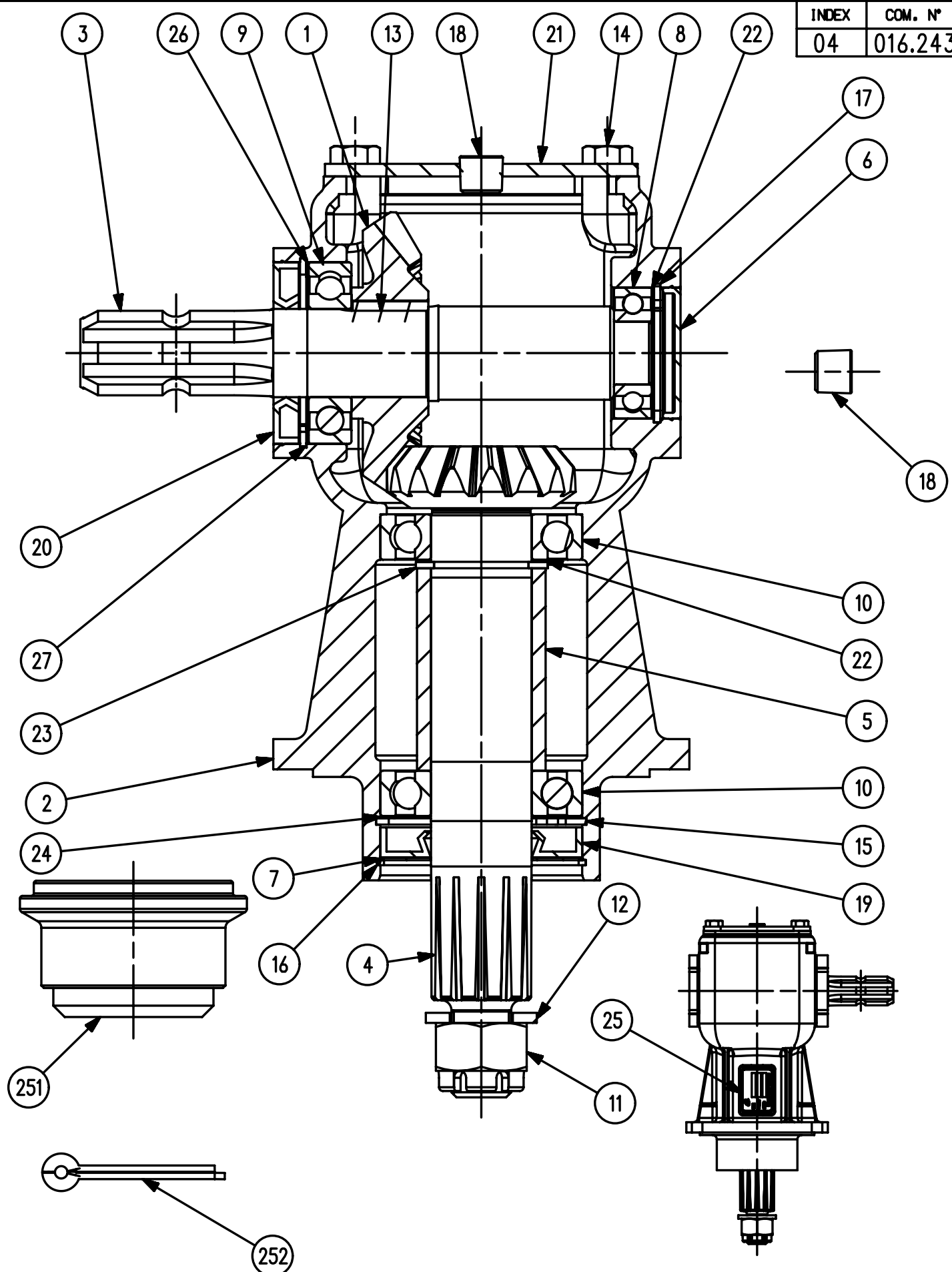
- GIOCO DI INGRANAMENTO: 0.15 - 0.4 mm.
- GIOCO ASSIALE DI USCITA: 0 - 0.2 mm.
- GIOCO ASSIALE DI ENTRATA: 0 - 0.2 mm.
- APPLICARE SILICONE TRA COPERCHIO E SCATOLA.
- SERRAGGIO VITI COPERCHIO : 5 - 6.4 kgm.
- NEBULIZZARE ALL'INTERNO DELLA SCATOLA CON "NUCLEOIL 10" COME ULTIMA OPERAZIONE.
- SERRAGGIO TAPPI OLIO 3 kgm. MAX.: INGRASSARE CON GRASSO IL FORO PRIMA DI MONTARE IL TAPPO .
- PARAOLIO IN POS. - D - : APPLICARE GRASSO AL BISOLFURO DI MOLIBDENO TRA I DUE LABBRI.
- PARTICOLARI SMONTATI A COD. A.119.003 .
- GRUPPI SPEDITI IN COMER ITALIA : I PARTICOLARI SMONTATI A.119.003 VANNO INSERITI CASSA PER CASSA , UGUALE AL NUMERO DEI GRUPPI PRESENTI NELLA CASSA.
- APPLICARE GRASSO AL BISOLFURO DI MOLIBDENO TRA CUSCINETTO E ANELLO DI TENUTA IN POS. - D - .
- VISTA "M": STAMPIGLIARE LA TARGHETTA COME INDICATO NEL DISEGNO (EX.G 13 00034).
- IL PARAOLIO IN POS. - A - DEVE ESSERE MONTATO PARI AL PIANO DELLA SCATOLA.
- IL CAPPELOTTO IN POS. - B - DEVE ESSERE MONTATO PARI AL PIANO DELLA SCATOLA.

ASSEMBLY NOTES

- GEARS BACKLASH: 0.15 - 0.4 mm.
- OUTPUT SHAFT AXIAL CLEARANCE: 0 - 0.2 mm.
- INPUT SHAFT AXIAL CLEARANCE: 0 - 0.2 mm.
- APPLY SILICONE SEALANT BETWEEN COVER AND HOUSING.
- TIGHTENING COVER BOLTS: 5 - 6.4 kgm.
- SPRAY "NUCLEOIL 10" INSIDE THE HOUSING AS LAST OPERATION.
- TIGHTEN OIL PLUG AT 3 kgm. MAX.:GREASE WITH GREASE THE HOLE BEFORE ASSEMBLING THE PLUG .
- OIL SEAL IN POS.- D - : APPLY BISULPHIDE MOLYBDENUM GREASE BETWEEN PRINCIPAL LIP AND DUST LIP.
- NOT ASSEMBLED PARTS : P/No. A.119.003 .
- ONLY FOR DELIVERY TO COMER ITALY , THE A.119.003 MUST BE INSERTED IN THE CASE TOGETHER WITH THE COMPLETE GEARBOXES, IN THE SAME QUANTITIES.
- APPLY BISULPHIDE MOLYBDENUM GREASE BETWEEN BEARING AND DUST LIP IN POS. - D - .
- VIEW "M": PRINT THE NAME PLATE AS INDICATED IN THE DRAWING (EXAMPLE G 13 0034).
- THE OIL SEAL IN POS. - A - MUST BE ASSEMBLED ON THE SAME LEVEL WITH THE PLANE CASING.
- THE OIL CAP IN POS. - B - MUST BE ASSEMBLED ON THE SAME LEVEL WITH THE PLANE CASING.

SPEC. TEORICA IN: THEORETICAL SHIMS: (A) 0.9 mm. (B) 0.9 mm. (C) 0.9 mm. (D) 0.9 mm.

COMPANY	REF. —	DESIGNATION LF-205J
	DATE 24/OCT/14	CODE 9.205.801.00



INDEX	COM. N°
04	016.243

REF.OFF.	COMPANY:	INDEX	COM. No.
		04	016.243

RATIO	FIG. MONT.	COD. LETT.	LF-205J	CODE
1 : 1.47	21 - 22	COD. NUM.	205	9.205.801.00

A.119.003 (SHIPPED SEPARATELY)			
POS.	DRG. No.	PCS.	DESCRIPTION
251	0.135.7000.00	1	BUSHING GROOVED
252	8.4.7.00516	1	COTTER PIN B5x50

REF. 135.001

DESIGNATION	GEAR BOX	LF-205J	CODE Nr.	9.205.801.00
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POS.	DRG. N.	PIEC	DESCRIPTION
1	0.131.5000.00	1	CROWN WHEEL Z22 M5
2	0.205.0300.00	1	CASING LF-205J
3	0.135.2001.00	1	SHAFT 1 3/8"Z6
4	0.135.6201.00	1	PINION Z15 M5
5	0.135.7105.00	1	SPACER
6	8.7.0.00693	1	CAP 52X7
7	1.135.7100.00	1	PROTECTIVE WASHER
8	8.0.1.00034	1	BEARING 6205
9	8.0.1.00870	1	BALL BEARING 6207
10	8.0.1.00871	2	BEARING 6208
11	8.2.2.00515	1	CASTLE NUT M24X2 PR80B
12	8.3.2.00409	1	BOLT WASHER 25X44X4
13	8.4.1.00993	1	PARALLEL KEY B 10X8X30
14	8.1.1.00054	4	BOLT M10X20 8,8
15	8.5.2.00030	1	SNAP RING FOR HOLES D 80 UNI7437
16	8.5.3.00955	1	SNAP RING SB 81
17	8.5.2.01358	1	SNAP RING FOR HOLE D52 UNI7438
18	8.6.6.00201	2	PLUG 3/8"GAS
19	8.7.1.00748	1	DOUBLE LIP SEAL 40X80X12
20	8.7.3.00055	1	OIL SEAL 35X72X10
21	0.205.1300.00	1	COVER
22	0.244.7500.00	2	SHIM KIT 40.3x51.5
23	8.5.1.00680	1	SNAP RING 40 UNI7436
24	0.267.7500.00	1	SHIM 69.0x79.9
25	0.124.7135.00	1	NAME PLATE
26	0.248.7500.00	1	SHIM 60.3x71.7
27	8.5.2.00131	1	SNAP RING FOR HOLES D72 UNI7437
	A.119.003	1	NOT ASSEMBLED PARTS
251	0.135.7000.00	1	HUB
252	8.4.7.00516	1	COTTER PIN B5X50