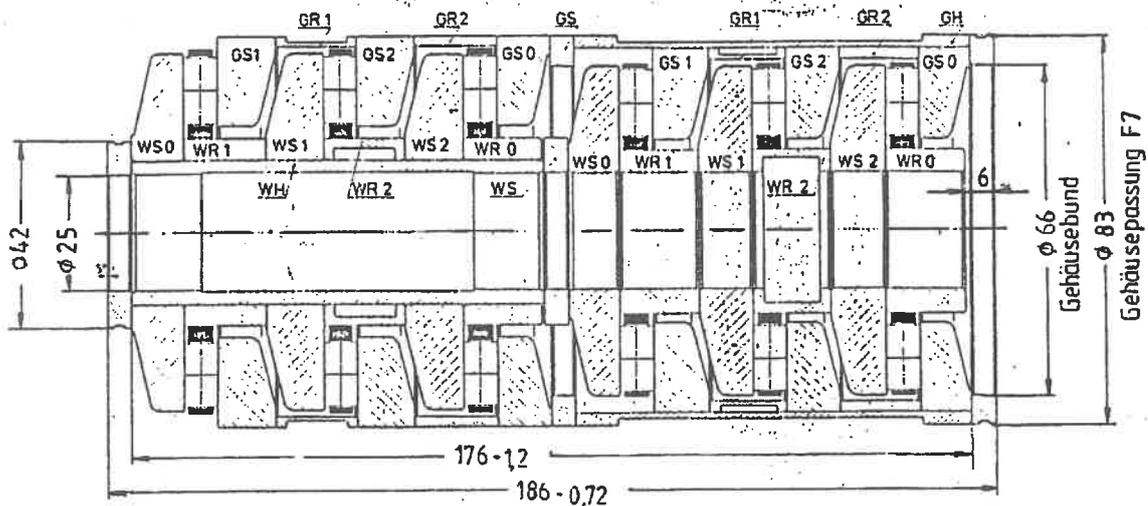




5.2 Assembly shaft (part no. 200)

Mount heated roller bearings (part no. 251 resp. 252) on shaft (part no. 200), paying attention to correct installation, - axial bearing clearance 1 mm (see drawing) and assemble ring (part no. 214).
Mount bearings T6 AR (part no. 250) on shaft according to number markings on housing, and discs, (see drg. below) mount circlip (part no. 261).



- 1) Each bearing is furnished with instructions regarding assembly of individual bearing parts.
- 2) Each disc and ring are, as shown, marked by letters numbers and all bearing parts (including cages) are identified by consecutive bearing nos.

Push guide sleeve (part no. 225) across T6 bearing - thrust bearing (part no. 253) pre-tension springs (part no. 270) and thrust plate (part no. 240) with the aid of screw M 12 (part no. 241) see reference in assembly-drawing - assemble steady-sleeve bush (part no. 216) and place the complete assembly into housing parting line - press against shaft on front face until it is located against bearing surface.

5.3. Assembly shaft (part no. 100)

Attention!

Shaft (part no. 100) with shrunk-on thrust piece (part no. 145) must only be transport hanging vertically.

Heat cylindrical roller bearings (part nos. 153, 152) and mount them on shaft (part no. 100) being careful to instal correctly - heat thrust piece