

VIV - CELHEM.



# Instruction book

## Separator

### MRPX 314TGV-74C

In letters, telegrams, telex messages and calls state type and manufacturing No. of the machine.

Unless the manufacturing No. has been filled in on this page, the book serves purposes of general information only and neither part Nos. nor operating instructions are unreservedly applicable.

**Manufacturing number:**

Spec: 4271-15  
Fig: 33436  
Orig: 1/7911

**Book No.:** S4271-15:01 E

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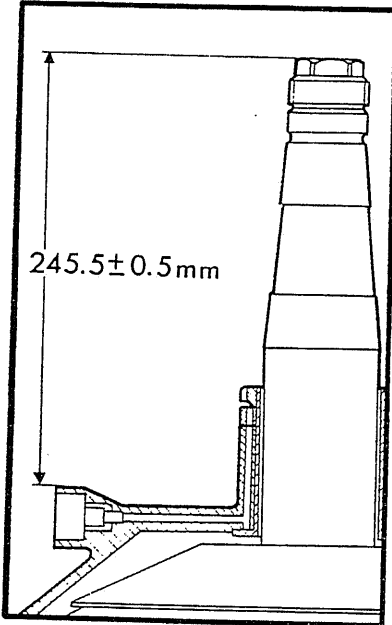
○

## HEIGHT ADJUSTMENT

Checking should be done both in connection with the yearly overhaul and after exchange or mounting of parts which can affect the height position.

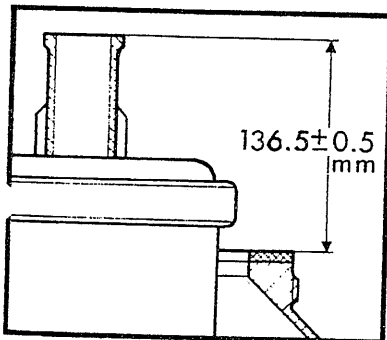
The tolerances are narrow and it is essential, therefore, that all parts are clean and free from burrs.

## Distributing cover



The distance between the distributing cover and the spindle top should be as indicated in the figure. The height position is adjusted by means of height adjusting rings under the distributing cover. See also chapter S "Operating liquid distributor".

## Paring discs of bowl



Assemble the bowl. Put on the frame hood and clamp it with the hinged bolts. Remove the guide ring.

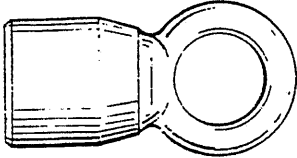
The distance between the height adjusting ring and the upper edge of the upper paring disc should be as indicated in the figure. If this is not the case, replace the inserted height adjusting ring by a ring with more suitable thickness. For height adjusting rings see chapter I "Inlet. Outlet".

## Check

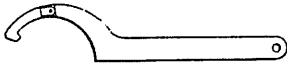
After every height adjustment of the distributing cover the bowl spindle should be revolved by hand (with bowl body put on the spindle). If scraping noise is audible, the adjustment is probably wrong – readjust.

If a scraping noise is audible in the inlet and outlet after the machine has been started, stop the machine at once and recheck the adjustment. The listening for scraping noise must be done as near the inlet and outlet as possible and in immediate connection with the start.

SPECIAL TOOLS for BOWL SPINDLE



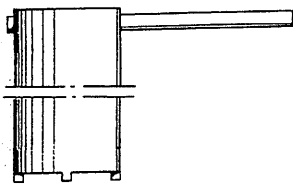
Eye nut for bowl spindle -- 70844



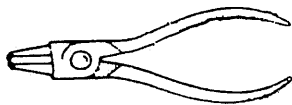
Hook spanner (articulated) for lock ring of ball bearing housing -- 535555-01



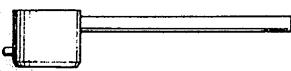
Sleeve, width 8, for screw in worm wheel -- 260164-03



Pin spanner for round nut of worm -- 535477-80

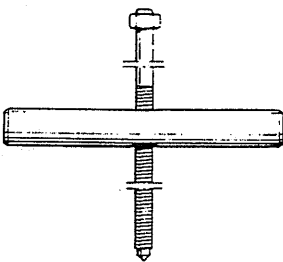


Snap ring tongs -- 527393-05



Retaining tool for worm -- 535478-80

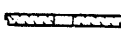
Dismounting/mounting tool for worm and for bearings in spring casing



Yoke and spindle -- 535450-80



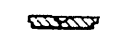
Discs: 535455-02



535455-01



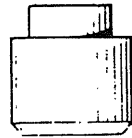
535454-01



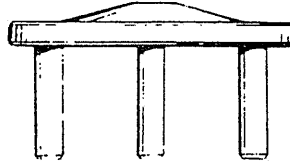
535453-01

Sleeve

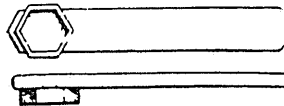
-- 535479-01



Drive-off tool for ball bearing of top bearing -- 528280-01



Drive-off tool for ball bearing of worm -- 72205

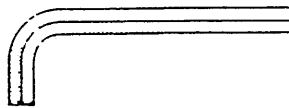


Spanner for bowl spindle -- 70846

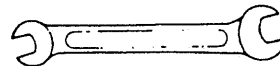


Pin spanner for stop ring of top bearing -- 537707-80

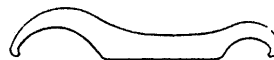
VARIOUS SPECIAL TOOLS



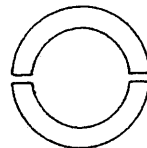
Offset hexagon key wrench -- 42348



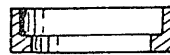
Screw spanner (3/4", 15/16") -- 42354



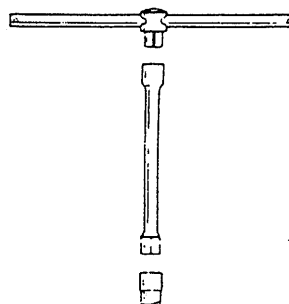
Hook spanner -- 69696



Segment for puller ring (2) -- 539318-02



Puller ring for worm -- 539317-01



T-handle -- 72243

Extension rod -- 72244

Sockets:

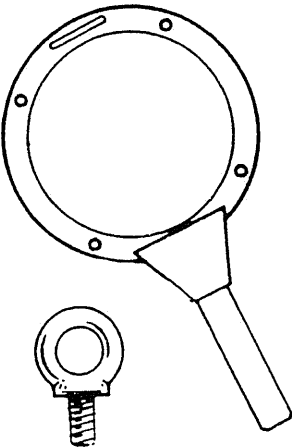
9/16" -- 73376

3/4" -- 73377

15/16" -- 42384

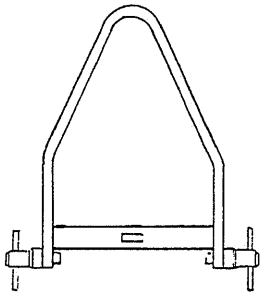
1 1/8" -- 527354-06

SPECIAL TOOLS for BOWL

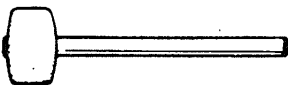


Spanner for large lock ring  
-- 74783

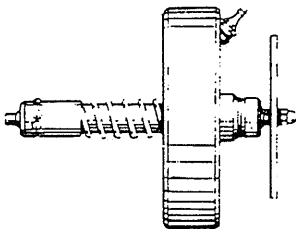
Eye bolt for large lock ring (2)  
-- 225304-05



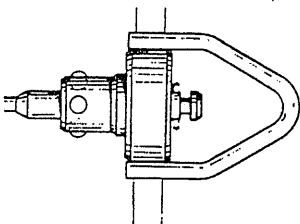
Spanner for small lock ring.  
Lifting tool for bowl hood  
-- 524312-81



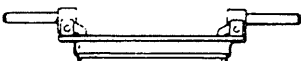
Tin mallet  
-- 64324



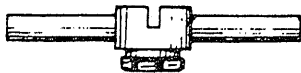
Compression tool for disc set  
-- 532292-80  
(comp. special page)



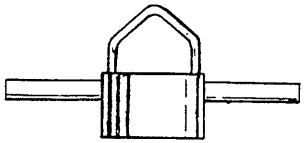
Lifting tool for distributor  
-- 74387



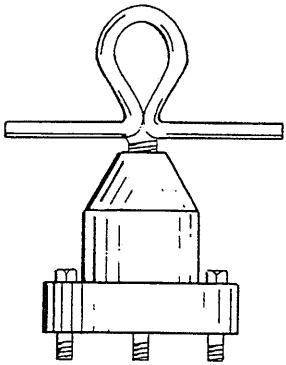
Lifting tool for bowl disc  
-- 528380-82



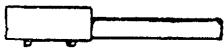
Lifting tool for distributing cone  
-- 524303-80



Lifting tool for sliding bowl bottom  
-- 524317-80

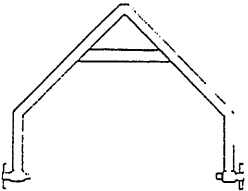


Lifting tool for bowl body  
-- 524301-80



537707-80

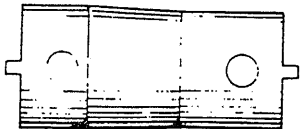
Pin spanner for the stop ring of the top bearing.



528350-81

Tilting tool for bowl body.

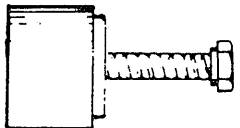
SPECIAL TOOLS for WORM WHEEL SHAFT



Pin spanner for round nuts  
-- 72719

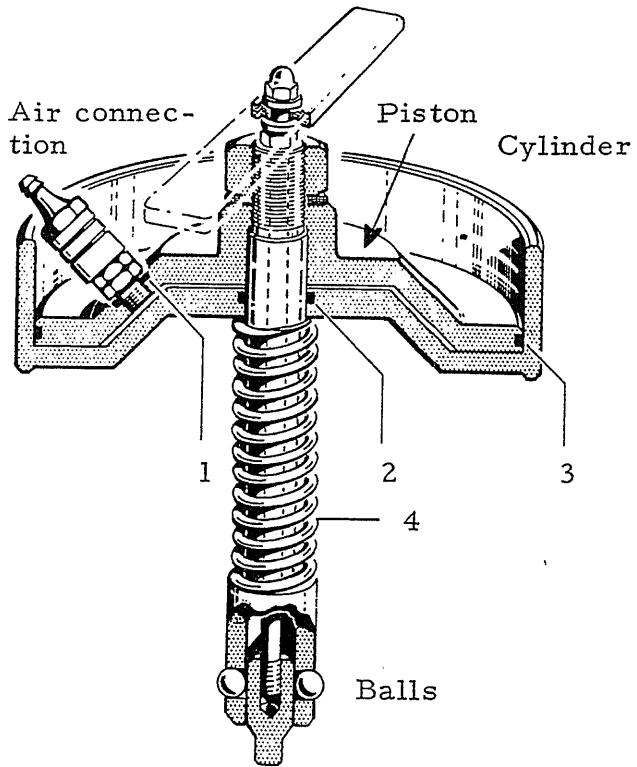


Extracting screw for sealing washer (2)  
-- 2210935-16



Puller for spacing sleeve of worm wheel shaft  
-- 534223-80

## COMPRESSING TOOL for DISC SET -- 532292-80



- 1 Seal ring  
-- 32697
- 2 Seal ring  
-- 223406-20
- 3 Seal ring  
-- 223412-43
- 4 Spring  
-- 226214-96

Take good care of the tool. If it is not to be used for a time, oil it.

For further information - see Bowl, chapter I.

## BOWL (comp. chapter I)

523188-03 Nozzle (3)  
 515133-03 Nozzle  
 528162-01 Valve plug (3)  
 226214-27 Spring (5)  
 536594-04 Bowl disc (5) — see Bowl

Seal rings for:  
 223408-14 operating slide (2)  
 223412-12 bowl body (2)  
 74722 sliding bowl bottom (2)  
 74355 bowl hood (2)  
 74736 bowl hood

Packings for:  
 524262-01 spring support  
 223436-11 paring chamber cover (2)  
 516281-08 cyclone nut (2)  
 516281-21 lower paring disc  
 516281-07 upper paring disc

## INLET. OUTLET (comp. chapter I)

522808-02 Sealing strip for frame hood  
 - Spare parts for re-  
 gulating valve and flow  
 meter — see chapter X

Packings :  
 71066 --  
 130603 --  
 223318-01 --

COUPLING. WORM WHEEL SHAFT  
(comp. chapter P)

223408-09 Seal ring for seal washer  
 43626 Packing for bearing shield

## OTHER PARTS

537086-02 Molybdenum  
 disulphide paste

## BOWL SPINDLE (compare chapter P)

72473 Washer for screw plug (12)

70340 Springs for:  
 65197 axial buffer (20)  
 top bearing (12)

Seal rings for:  
 223412-42 cover for spring casing  
 223412-17 throw-off collar  
 223412-51 protecting cap

## FRAME PARTS (comp. chapter S)

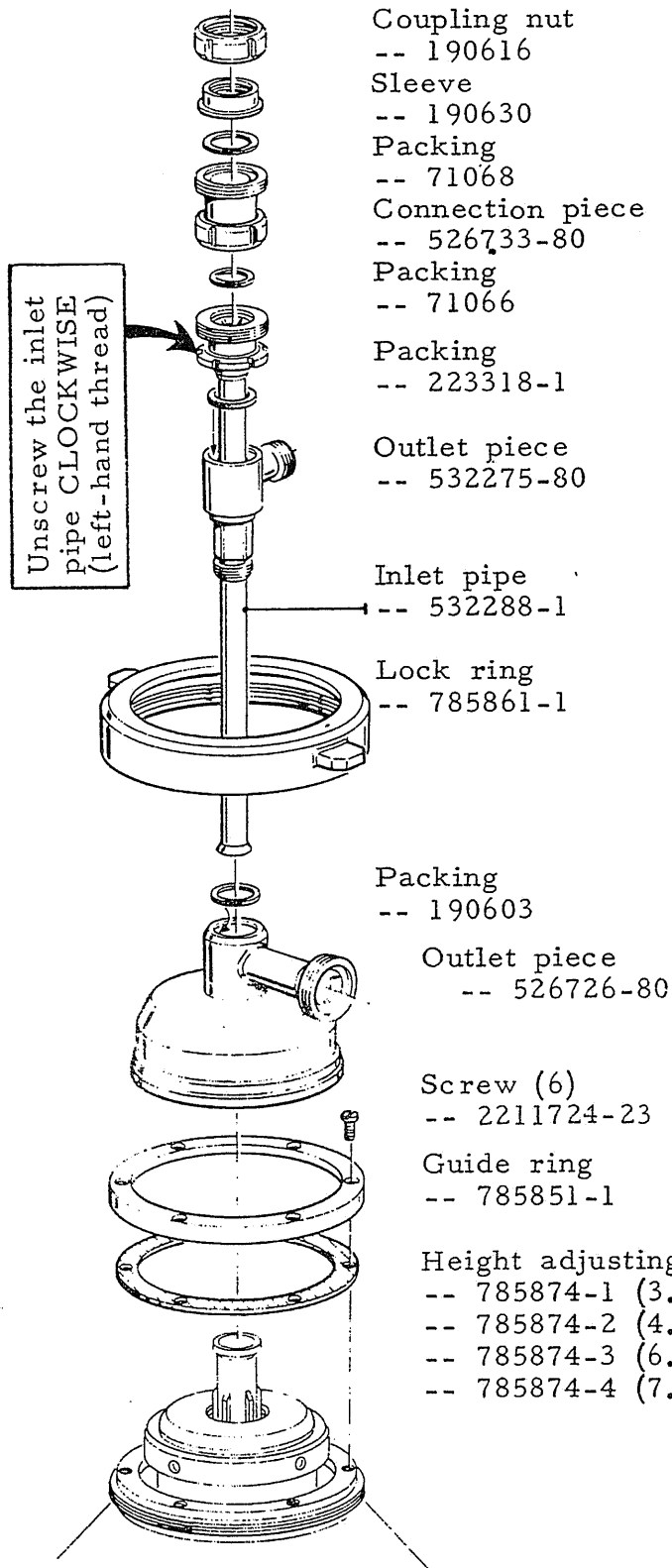
65227 Brake lining with 3 screws  
 38685 Oil gauge glass  
 223521-08 Lipseal ring for revolution  
 counter and tachometer (2)  
 528746-01\* Protecting glass for  
 tachometer

Seal rings for:  
 64708 control valve  
 70936 control valve  
 223404-06 control valve  
 38411 bottom bearing housing  
 223406-27\*\* pneumatic brake (2)

Packings for:  
 516281-11 cyclone (or outlet bend)  
 71066 drain tube  
 516281-10 flushing nozzle  
 68937 flushing nozzle and  
 control valve (5)  
 223316-05 oil drain screw  
 528723-01 oil gauge glass  
 37167 oil gauge glass  
 71068 ventilation bend  
 524323-01 distributing cover —  
 operating liquid distributor  
 sleeve —  
 71320 operating liquid distributor  
 71322 sprayer —  
 operating liquid distributor  
 223434-02 revolution counter  
 223316-05 oil filling screw — see  
 Revolution counter  
 528732-01 protecting cap (2) — see  
 Brake and Revolution  
 counter

\* Not for machine equipped for  
 remote speed indication.

\*\* Only for remotely controlled  
 machine.



DISMANTLING

Note that the bowl must be at rest before starting the dismantling — check by means of the revolution counter.

Dismantle the parts in the sequence appearing from the illustration. Use a hook spanner for unscrewing the inlet pipe from the lower paring disc (see also vertical section).

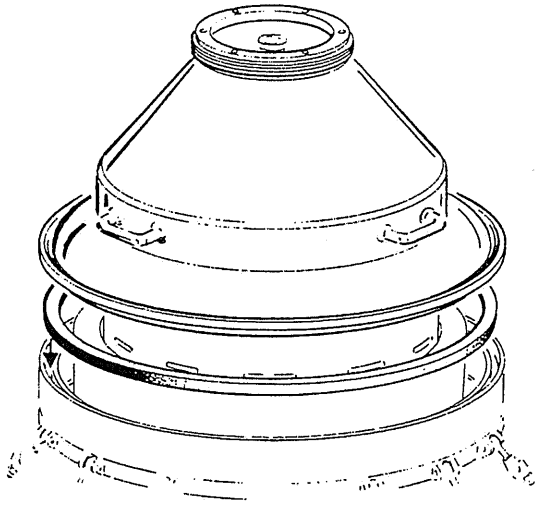
ASSEMBLY.

Clean all parts. Carefully lubricate threads and contact surfaces, and particularly the thread of the inlet pipe. Screw in the pipe firmly.

Check the height position of the paring discs before the first start and after exchange of parts that could affect the height position — see also chapter L "Height adjustment".

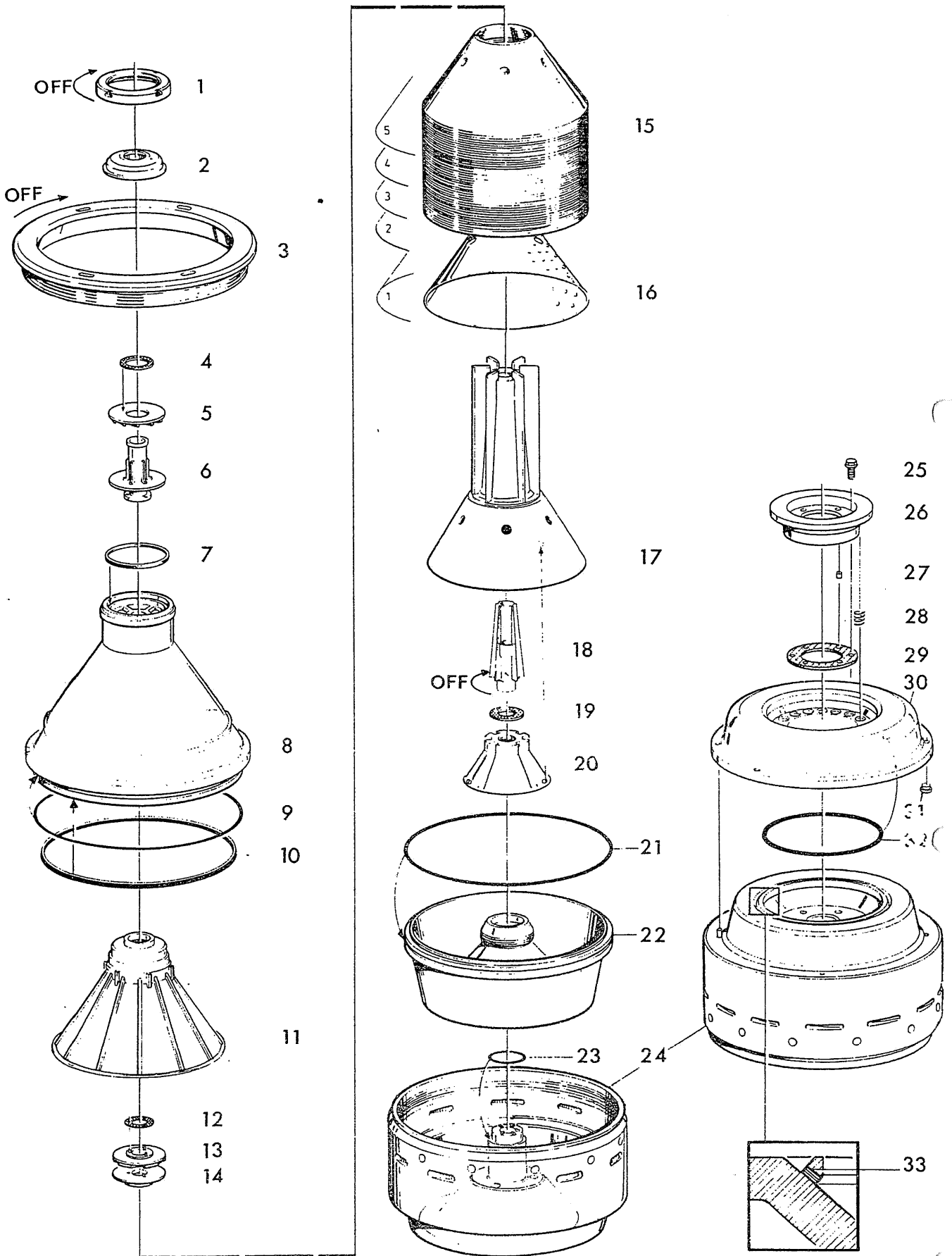
\* One height adjusting ring is mounted before delivery, another one of the next smaller thickness is supplied unmounted. For 3mm, one of the same thickness.

(Inlet. Outlet, page 2)



Frame hood  
-- 785830-80

Sealing strip  
-- 522808-2



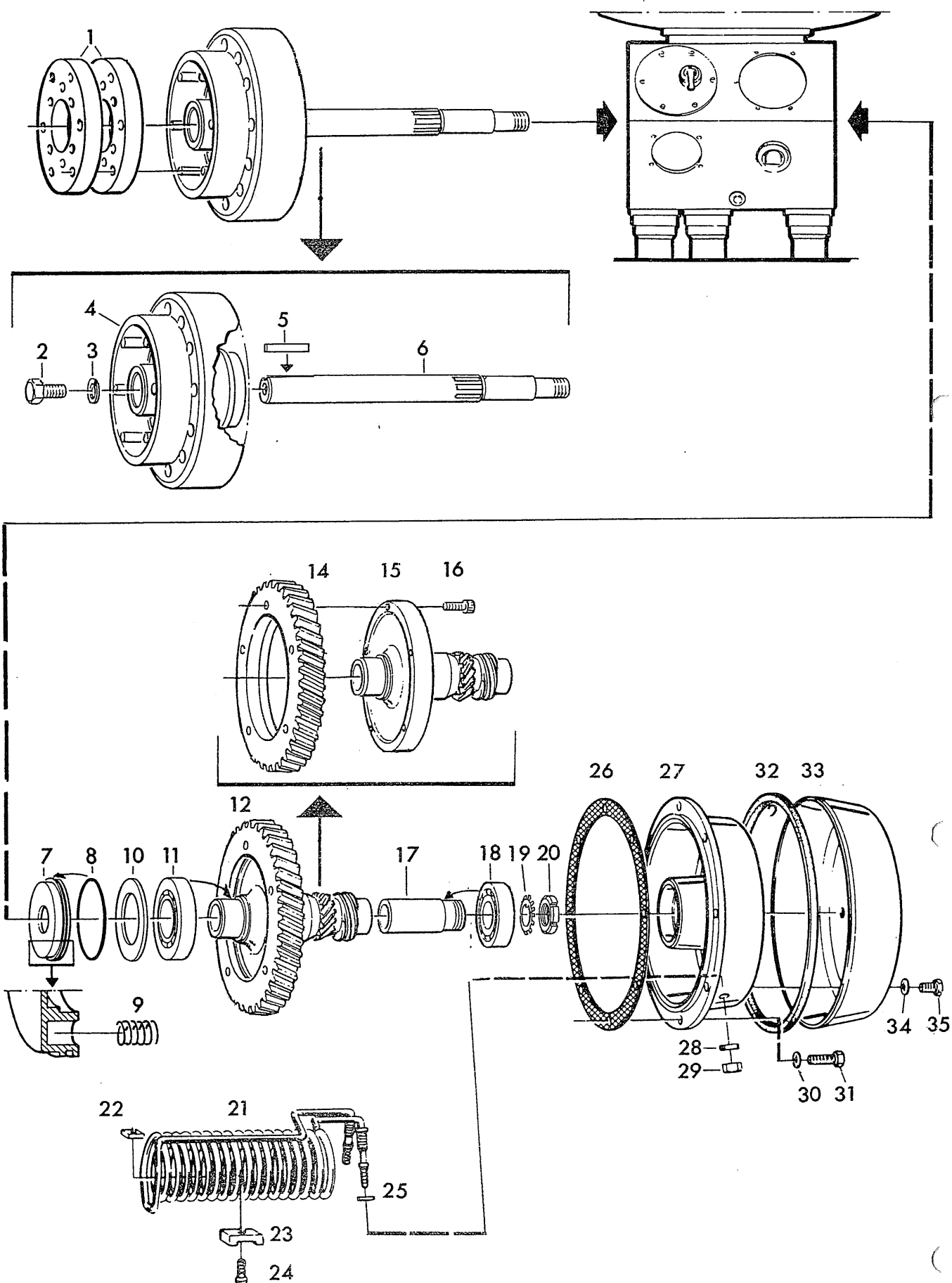
Ref.	Part No. Delnr.	Qty. Ant.	Part name	Benämning
1	516917-01	1	Lock ring, small (left-hand thread)	Låsring, liten (vänstergänga)
2	526486-01	1	Paring chamber cover	Skalkammarlock
3	536721-01*	1	Lock ring, large (left-hand thread)	Låsring, stor (vänstergänga)
4	516281-07	1	Packing	Packning
5	785846-01**	1	Paring disc, top part	Skalskiva, överdel
6	532296-01**	1	Paring disc, bottom part	Skalskiva, underdel
7	223436-11	1	Packing	Packning
8	536975-01*	1	Bowl hood	Kulhuv
9	74355	1	Seal ring	Tättningsring
10	74736	1	Seal ring	Tättningsring
11	536597-02*	1	Top disc	Överplåt
12	516281-21	1	Packing	Packning
13	532294-80**	1	Paring disc, top part	Skalskiva, överdel
14	532293-01**	1	Paring disc, bottom part	Skalskiva, underdel
15	536594-04	190	Bowl disc	Insatsplåt
16	536594-05	1	Bottom disc	Underplåt
17	536599-80*	1	Distributor	Fördelare
18	540420-01**	1	Cyclone nut (left-hand thread)	Cyklonmutter (vänster- gänga)
19	516281-08	1	Packing	Packning
20	532278-80*	1	Distributing cone	Fördelningskona
21	74722	1	Seal ring	Tättningsring
22	524264-01	1	Sliding bowl bottom	Slidallrik
23	223412-12	1	Seal ring	Tättningsring
24	536719-01*	1	Bowl body	Kulkropp
25	520401-03	3	Screw	Skruv
26	531457-80	1	Spring support	Fjäderhållare
27	523188-03	3	Nozzle	Munstycke
28	226214-27	18	Spring	Fjäder
29	524262-01	1	Packing	Packning
30	532305-01	1	Operating slide	Manöverslid
31	528162-01	3	Valve plug	Ventilpropp
32	223408-14	1	Seal ring	Tättningsring
33	515133-03	1	Nozzle	Munstycke

\* Exchange necessitates  
rebalancing — send the  
COMPLETE bowl to an  
authorized ALFA-LAVAL  
representative.

\*\* Not included in the  
complete-unit number of  
the bowl.

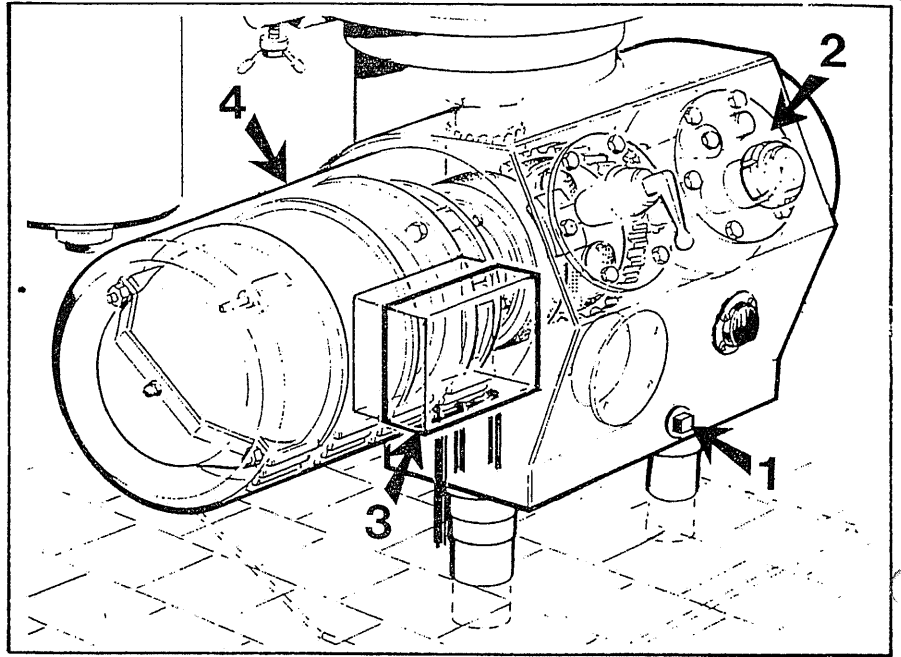
\* Utbyte nödvändiggör om-  
balansering — skicka in  
HELA kulan till en aukto-  
riserad ALFA-LAVAL  
representant.

\*\* Ingår ej i kulans  
komplettnummer.



ALFA-LAVAL

Ref.	Part No. Delnr.	Qty. Ant.	Part name	Benämning
1	60571	2	Elastic plate	Ledskiva
2	2210947-16	1	Screw	Skruv
3	62094	1	Spring washer	Fjäderbricka
4	534181-80	1	Conveyor pulley	Medbringarskiva
5	223610-19	1	Key	Kil
6	534180-01	1	Worm wheel shaft	Skruvhjulsaxel
7	534191-01	1	Seal washer	Tätningbricka
8	223408-09	1	O-ring	O-ring
9	74467	12	Spring	Fjäder
10	536666-01	1	Thrust disk	Spännbricka
11	233215-07	1	Angular contact ball bearing (SKF 7213B)*	Vinkelkontaktkullager (SKF 7213 B)*
12	50 Hz: 538049-82 60 Hz: 538049-83	1	Worm wheel, complete	Skruvhjul, komplett
13	537089-01	1	Clamping ring	Klämring
14	50 Hz: 538051-05 60 Hz: 538051-04	1	Gear rim	Kuggkrans
15	--	1	Worm wheel nave	Skruvhjulsnav
16	2217759-07	5	Screw	Skruv
17	534193-01	1	Spacing sleeve	Distanshylsa
18	233215-08	1	Angular contact ball bearing (SKF 7308B)*	Vinkelkontaktkullager (SKF 7308B)*
19	37992	1	Lock washer (SKF MB 6)	Låsbricka (SKF MB 6)
20	67473	1	Round nut (SKF KM6)	Rundmutter (SKF KM6)
21- 24	534126-81	1	Cooling coil, complete	Kylslinga, komplett
22	534128-01	1	Washer	Bricka
23	534127-01	1	Magnet	Magnet
24	221226-43	1	Screw	Skruv
25	73665	2	Packing	Packning
26	43626	1	Packing	Packning
27	534111-01	1	Bearing shield	Lagersköld
28	223101-37	2	Washer	Bricka
29	2218043-18	2	Nut	Mutter
30	223101-34	8	Washer	Bricka
31	2210942-15	8	Screw	Skruv
32	43630	1	Sealing strip	Tätningstlist
33	528709-01	1	Protecting cap	Skyddskåpa
34	223101-34	3	Washer	Bricka
35	2210942-35	3	Screw	Skruv
			* or equivalent bearing of other make	* eller likvärdigt lager av annat fabrikat

DISMANTLING.  
ASSEMBLYExchange of  
worm wheel only

1. Drain off the oil.
2. Remove the tachometer cap.

Remove the protecting cap (if any), bearing shield etc. according to illustration on foregoing page. Observe any directions in the following text.

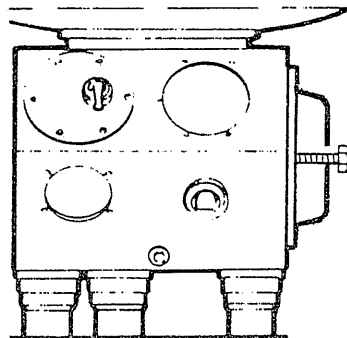
Note. The motor need not be removed.

Complete  
dismantling

1. Drain off the oil.
2. Remove the tachometer cap.
3. Disconnect the electric wires from the terminal block on the motor.
4. Remove the motor (together with the motor adapter).

Remove the protecting cap (if any), bearing shield etc. according to illustration on foregoing page. Observe any directions in the following text.

## Bearing shield



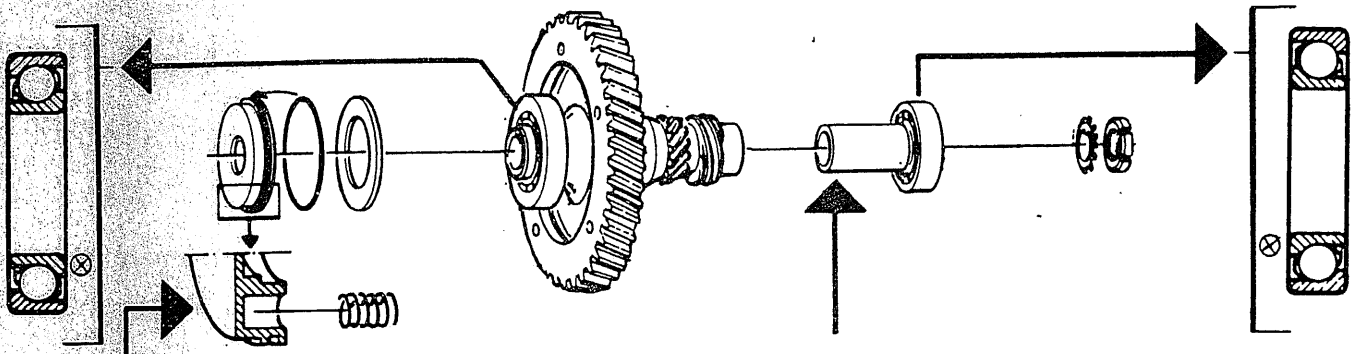
To detach the bearing shield from the frame use two of its screws, screwing them into the two threaded holes of the shield.

(Dismantling. Assembly)

Angular contact ball bearings



The bearings for worm wheel and spacing sleeve are single-row angular-contact ball bearings. When mounting them it is essential that they should be turned in the direction shown in the illustration below. The symbol ⊗ indicates the stamped side of the inner ring. Heat the bearings in oil before fitting them on the worm wheel, and on the spacing sleeve respectively.



Seal washer

The seal washer is pulled out by means of two special screws included in the set of tools.

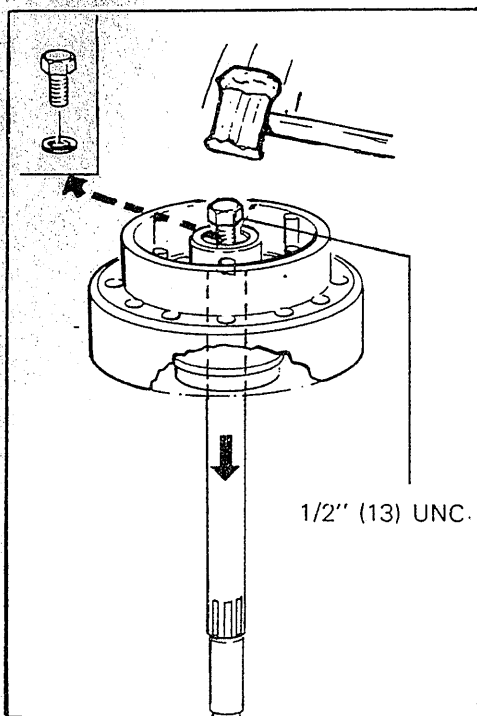
To retain the springs of the washer during mounting apply a little consistent grease to them.

Exchange of conveyor pulley or worm wheel shaft

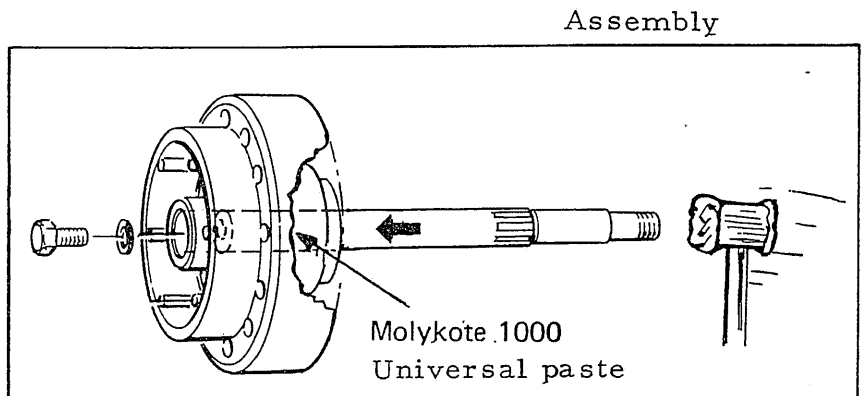
Spacing sleeve

The spacing sleeve (with the bearing) is pulled off from the worm wheel shaft by means of a special screw included in the set of tools.

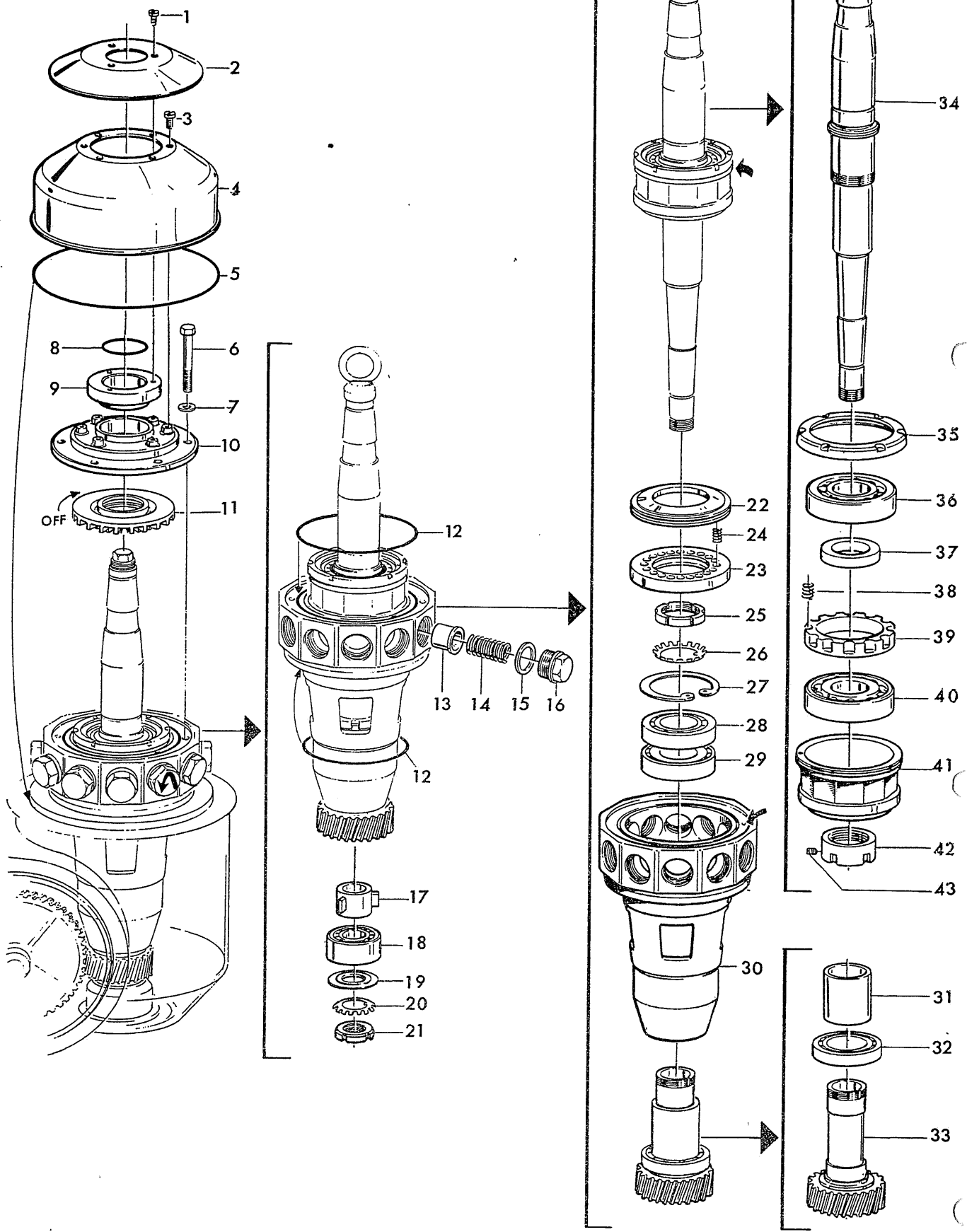
Note. Before mounting the worm wheel, apply some Molykote on the place of the shaft where the worm wheel is going to be mounted.



Dismantling



Assembly



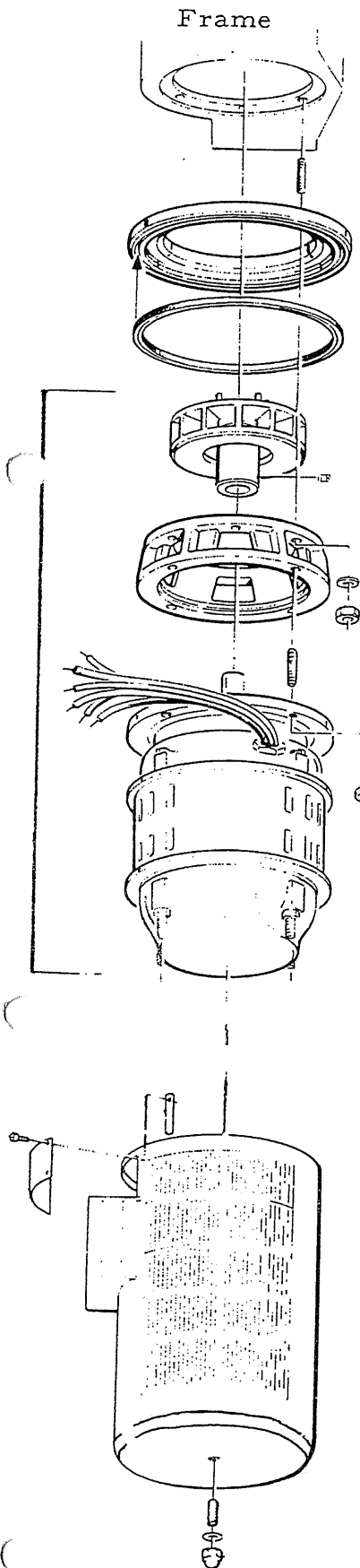
Ref.	Part No. Delnr.	Qty. Ant.	Part name	Benämning
1	2211722-24	3	Screw	Skruv
2	526198-03	1	Top shield	Skyddsplåt
3	2211724-22	6	Screw	Skruv
4	526196-02	1	Protecting cap	Skyddskåpa
5	223412-51	1	Seal ring	Tätningring
6	2210947-08	6	Screw	Skruv
7	223101-50	6	Washer	Bricka
8	223412-17	1	Seal ring	Tätningring
9	526197-03	1	Throw-off collar	Skyddskrage
10	533512-02	1	Cover	Lock
11	533414-02	1	Oil deflector (left-h. thr.)	Oljefläkt (vänstergånga)
12	223412-42	2	Seal ring	Tätningring
13	70346	12	Buffer	Buffert
14	65197	12	Spring	Fjäder
15	72473	12	Washer	Bricka
16	528776-01	12	Plug	Propp
17	71973	1	Conveyor	Medbringare
18	69843	1	Self-aligning ball bearing (SKF 2309M)*	Sfäriskt kullager (SKF 2309M)*
19	73988	1	Intermediate washer	Mellanläggsbricka
20	66076	1	Lock washer (SKF MB9)	Låsbricka (SKF MB9)
21	67476	1	Round nut (SKF KM9)	Rundmutter (SKF KM9)
22	533417-01	1	Wear ring	Slitring
23	533418-01	1	Spring support	Fjäderhållare
24	70340	20	Spring	Fjäder
25	66312	1	Round nut (SKF KM14)	Rundmutter (SKF KM14)
26	66313	1	Lock washer (SKF MB 14)	Låsbricka (SKF MB 14)
27	223642-45	1	Snap ring	Spårring
28	69850	2	Angular contact ball bearing (SKF 7214BM)*	Vinkelkontaktkullager (SKF 7214BM)*
29				
30	534143-01	1	Spring casing	Fjäderhus
31	534276-01	1	Spacing sleeve	Distanshylsa
32	65187	1	Rigid ball bearing (SKF 6014M)*	Spårkullager (SKF 6014M)*
33	50 Hz: 534275-17 60 Hz: 534275-16	1	Worm	Snäcka
34	540372-01	1	Spindle	Spindel

\* or equivalent bearing of other make.

\* eller likvärdigt lager av annat fabrikat.

Ref.	Part No. Delnr.	Qty. Ant.	Part name	Benämning
35	533413-01	1	Lock ring	Låsring
36	233211-49	1	Rigid ball bearing (SKF 6315M)*	Spårkullager (SKF 6315M)*
37	533415-01	1	Spacing sleeve	Distanshylsa
38	62763	12	Spring	Fjäder
39	533412-01	1	Spring support	Fjäderhållare
40	233215-03	1	Angular contact ball bearing (SKF 7315BM)*	Vinkelkontaktkullager (SKF 7315 BM)*
41	533411-01	1	Ball bearing housing	Kullagerhus
42	533416-01	1	Stop ring	Stoppring
43	221545-02	2	Set screw	Stoppskruv
			* or equivalent bearing of other make.	* eller likvärdigt lager av annat fabrikat.

(Mounting the motor)



Stud bolt (6)  
-- 2216261-02

Guide ring  
-- 529531-02

Sealing strip  
-- 532072-01

Coupling pulley\*  
-- 534184-80  
/534183-01 \*

Set screw  
-- 221585-18

Motor adapter  
-- 537560-80

Washer (6)  
-- 223101-50

Nut (6)  
-- 72946

Stud bolt (8)  
-- 70489

Nut (8)  
-- 2216043-04

Motor (make Brook, type UC 200L three-phase motor)\*\*

Protecting cover  
-- 540760-80

Top cover  
-- 540763-80

Support  
-- 540764-80

Screw  
-- 221136-01 (4)

Cap nut  
-- 221851-11

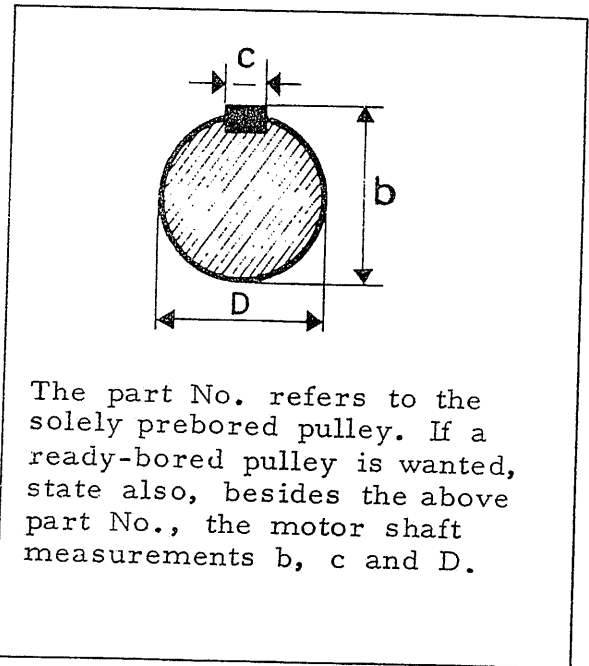
Stud bolt  
-- 260202-02

Washer  
-- 223101-61 (5)

Dismantling. Assembly  
When dismantling first disconnect the electric cables from the terminal block in the frame, then dismantle the parts according to the figure. If the coupling pulley should be loosened — see "Coupling pulley" in this chapter.

After assembly remove the brake cap and check that there is a play at the elastic plate.

\*



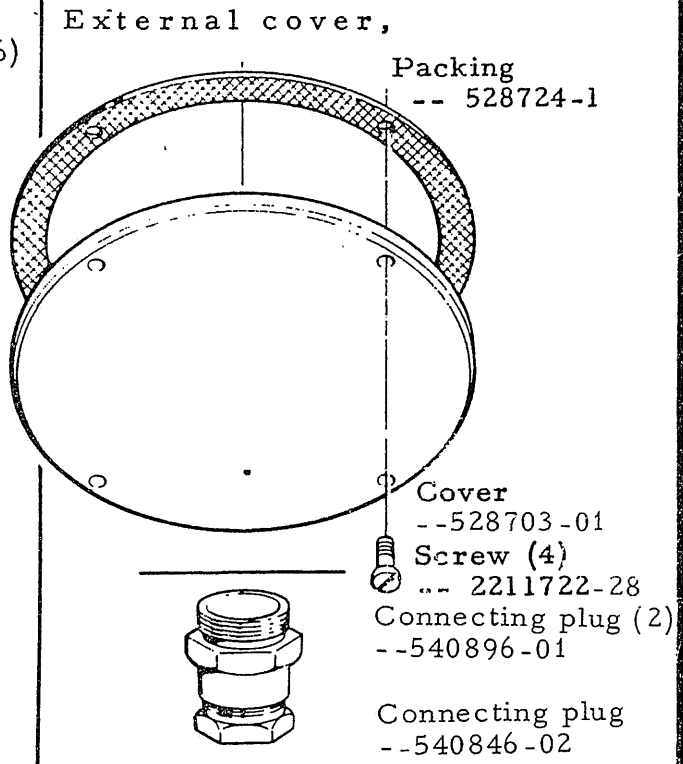
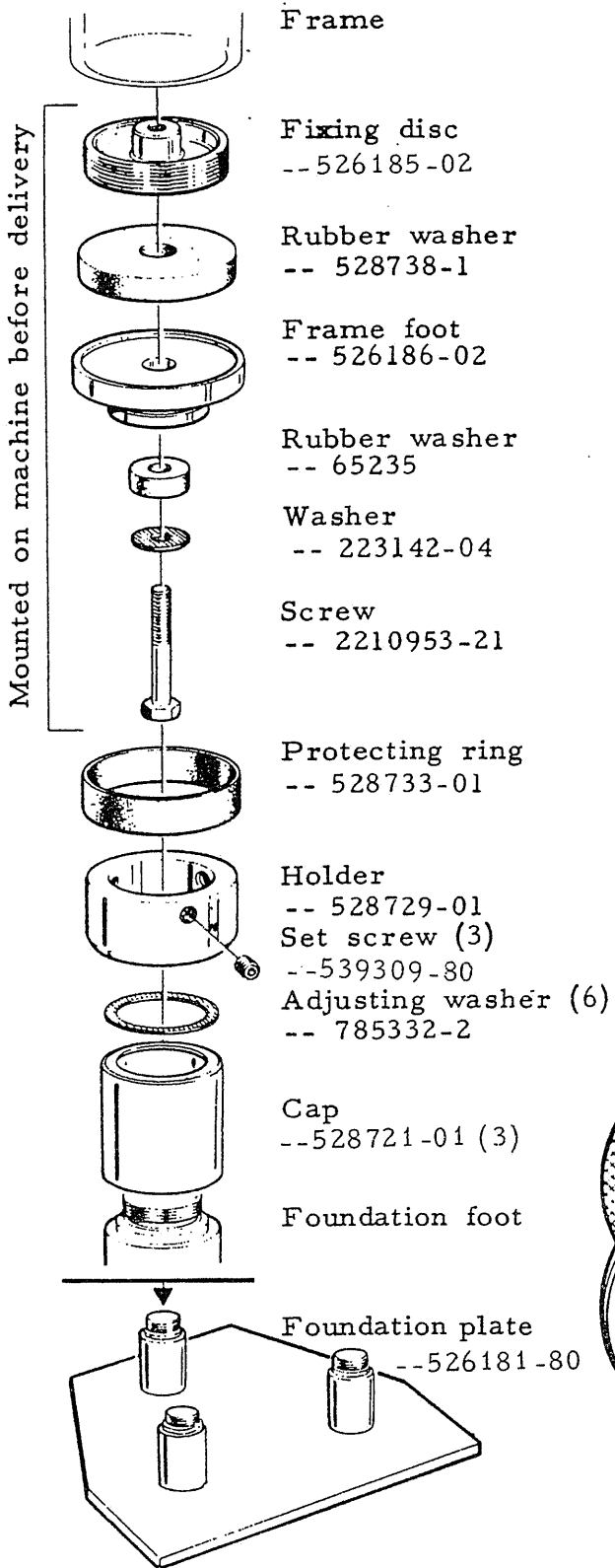
The part No. refers to the solely prebored pulley. If a ready-bored pulley is wanted, state also, besides the above part No., the motor shaft measurements b, c and D.

\*\*

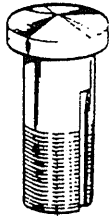
When ordering state also the output, frequency and voltage.

\* For MRPX 418TGV

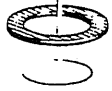
VIBRATION DAMPER (3) and FOUNDATION PLATE



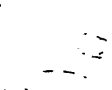
FLUSHING DEVICE for SOLIDS COVER



Nozzle  
-- 785868-01



Packing  
-- 516281-10



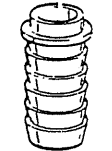
Frame ring



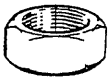
Nut  
-- 785877-01



Packing  
-- 68937

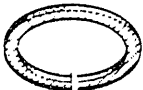


Hose nipple  
-- 252613-12

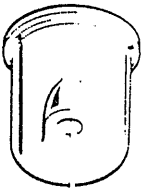


Nut  
-- 521136-01

VENTILATION BEND



Packing  
-- 71068



Bend  
528710-02



Stud bolt  
-- 2216241-17

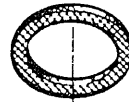


Washer  
-- 223101-34

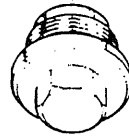


Cap nut  
-- 72947

OIL DRAIN

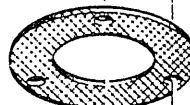


Packing  
-- 223316-05



Screw  
-- 526189-01

OIL GAUGE GLASS



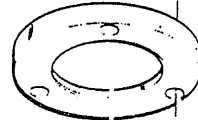
Packing  
-- 528723-01



Glass  
-- 38685



Packing  
-- 37167



Fixing ring  
-- 523215-02



Screw (3)  
-- 2211722-28

HINGED BOLT (12)



Cap nut  
-- 221854-19



Clamping shoe  
-- 785865-02



Hinged bolt  
-- 225444-18

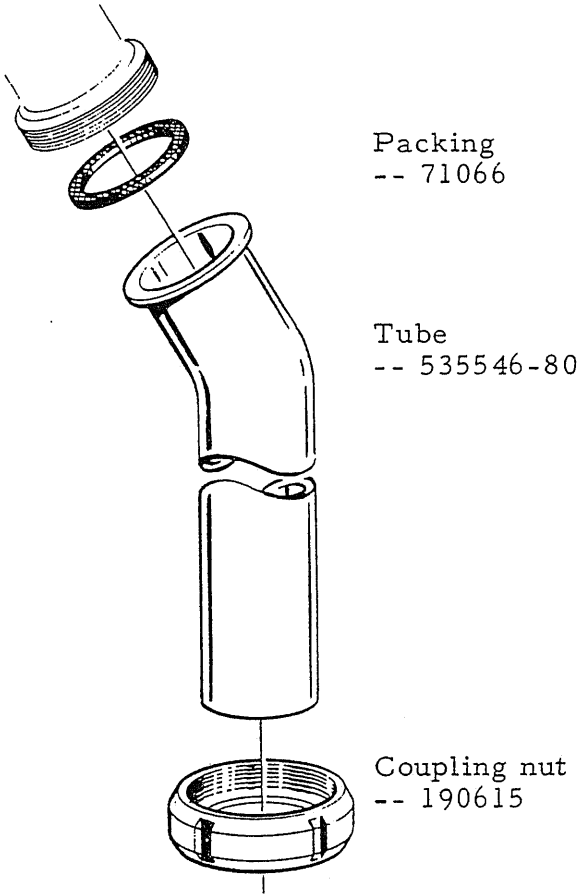


Slotted pin  
-- 67783

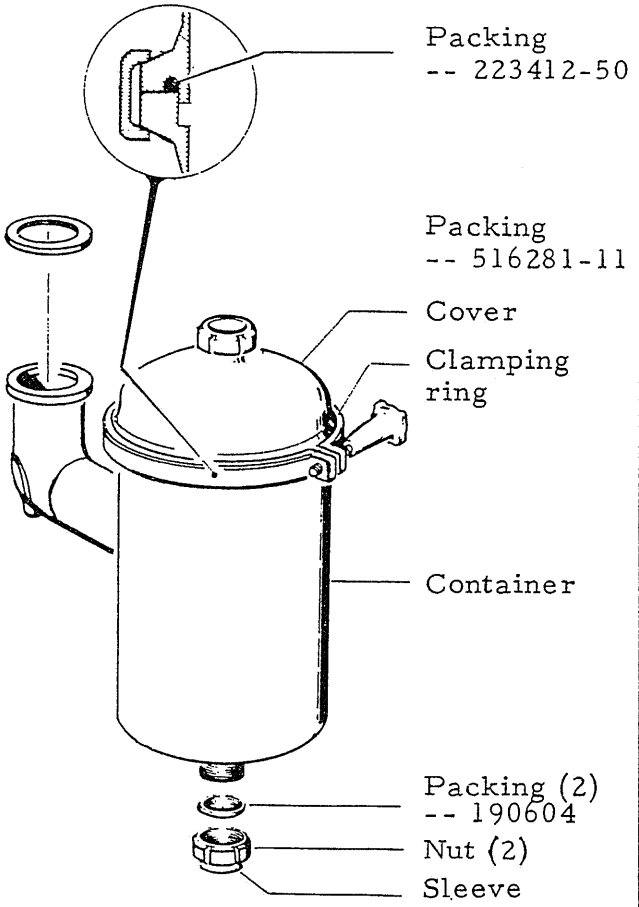


Hinged pin  
-- 71456

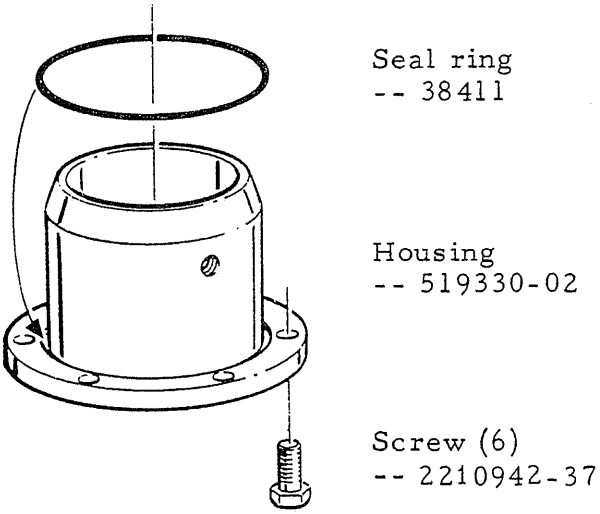
DRAIN TUBE



CYCLONE  
Cyclone, complete 32302-0001-2

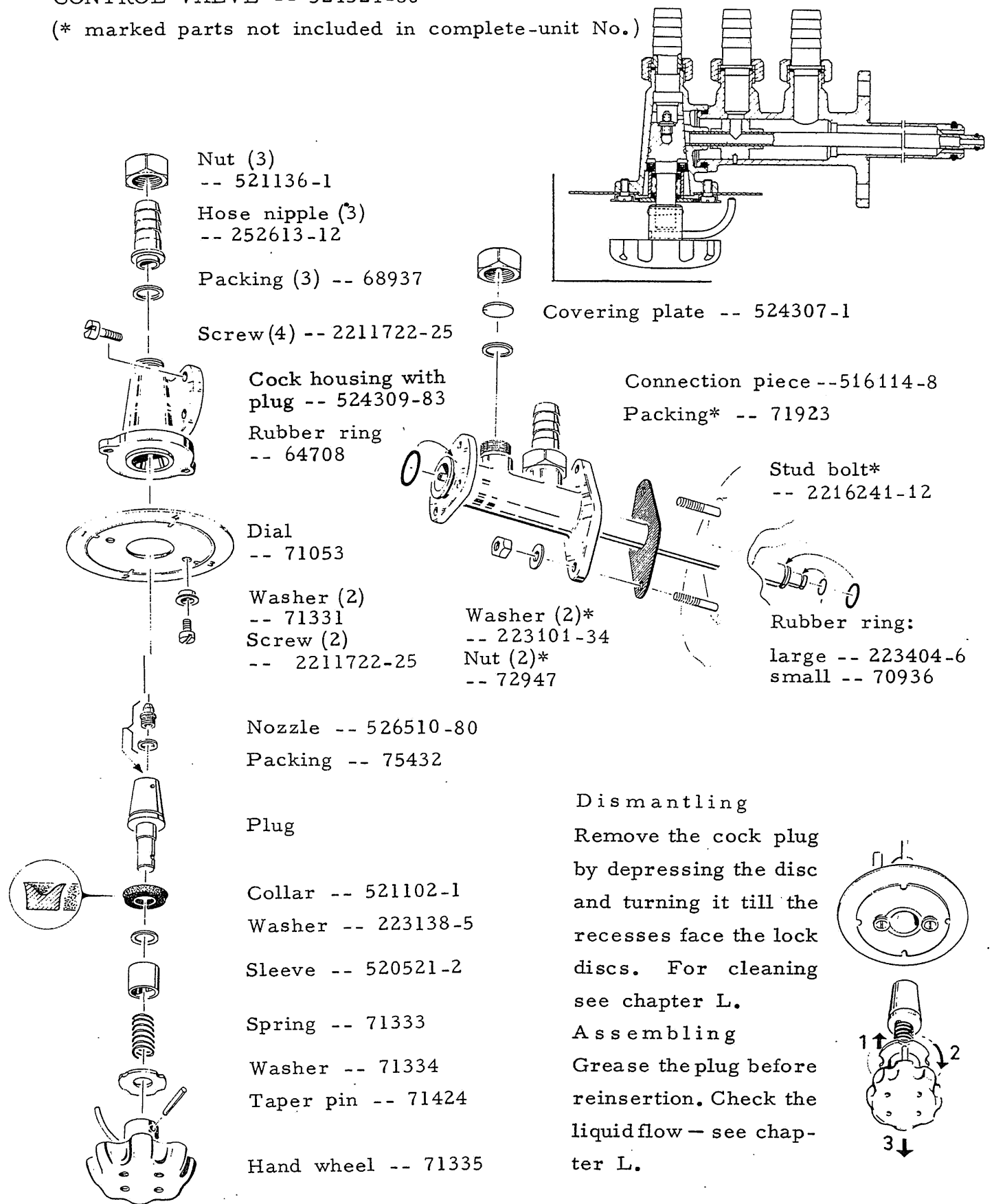


BOTTOM BEARING HOUSING



CONTROL VALVE -- 524324-80

(\* marked parts not included in complete-unit No.)



- Nut (3) -- 521136-1
- Hose nipple (3) -- 252613-12
- Packing (3) -- 68937
- Screw (4) -- 2211722-25

- Cock housing with plug -- 524309-83
- Rubber ring -- 64708

- Dial -- 71053
- Washer (2) -- 71331
- Screw (2) -- 2211722-25

- Nozzle -- 526510-80
- Packing -- 75432

- Plug
- Collar -- 521102-1
- Washer -- 223138-5
- Sleeve -- 520521-2
- Spring -- 71333
- Washer -- 71334
- Taper pin -- 71424
- Hand wheel -- 71335

- Covering plate -- 524307-1
- Connection piece -- 516114-8
- Packing\* -- 71923

- Stud bolt\* -- 2216241-12
- Rubber ring:  
large -- 223404-6  
small -- 70936

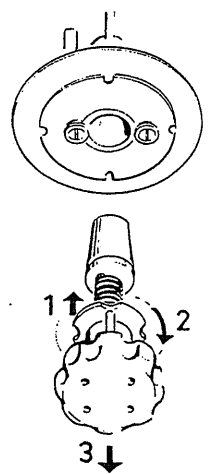
- Washer (2)\* -- 223101-34
- Nut (2)\* -- 72947

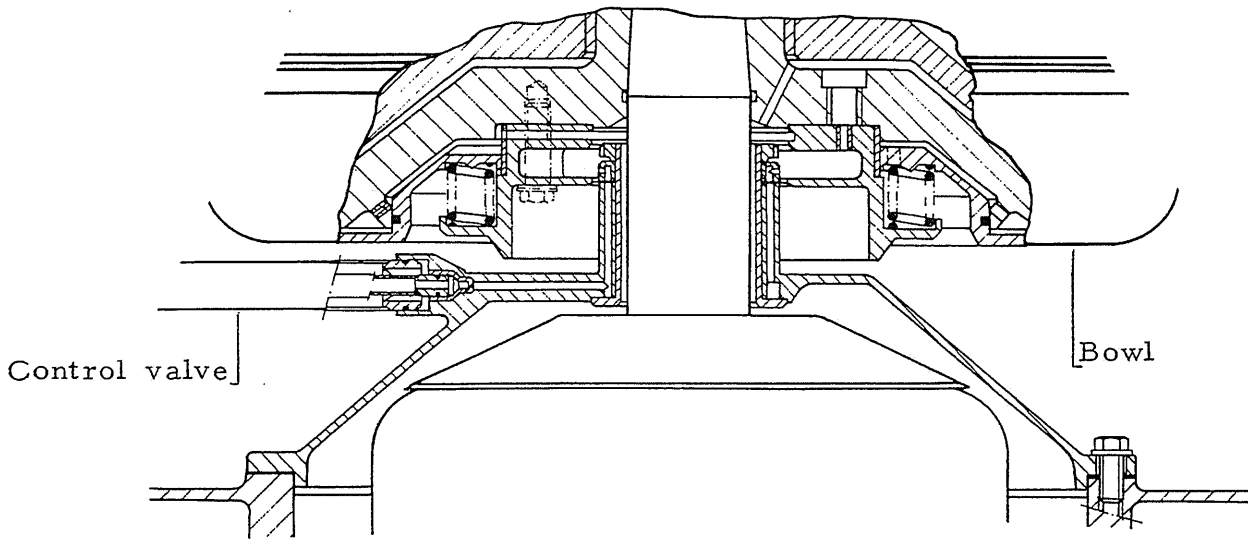
**Dismantling**

Remove the cock plug by depressing the disc and turning it till the recesses face the lock discs. For cleaning see chapter L.

**Assembling**

Grease the plug before reinsertion. Check the liquid flow — see chapter L.





Dismantling

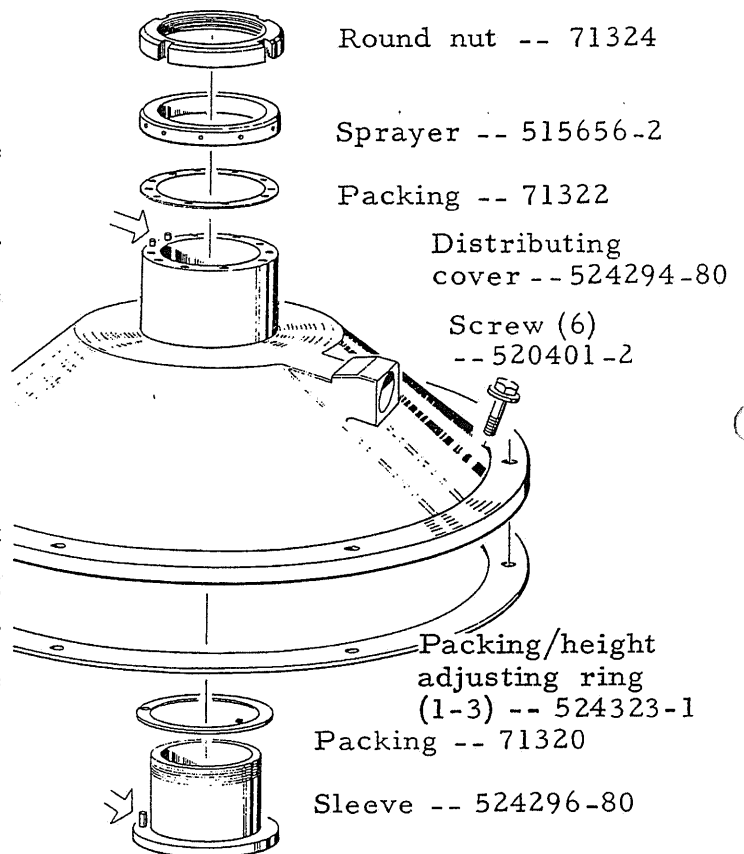
For dismantling of bowl see chapter L. Loosen the control valve and pull the pipes out of the frame.

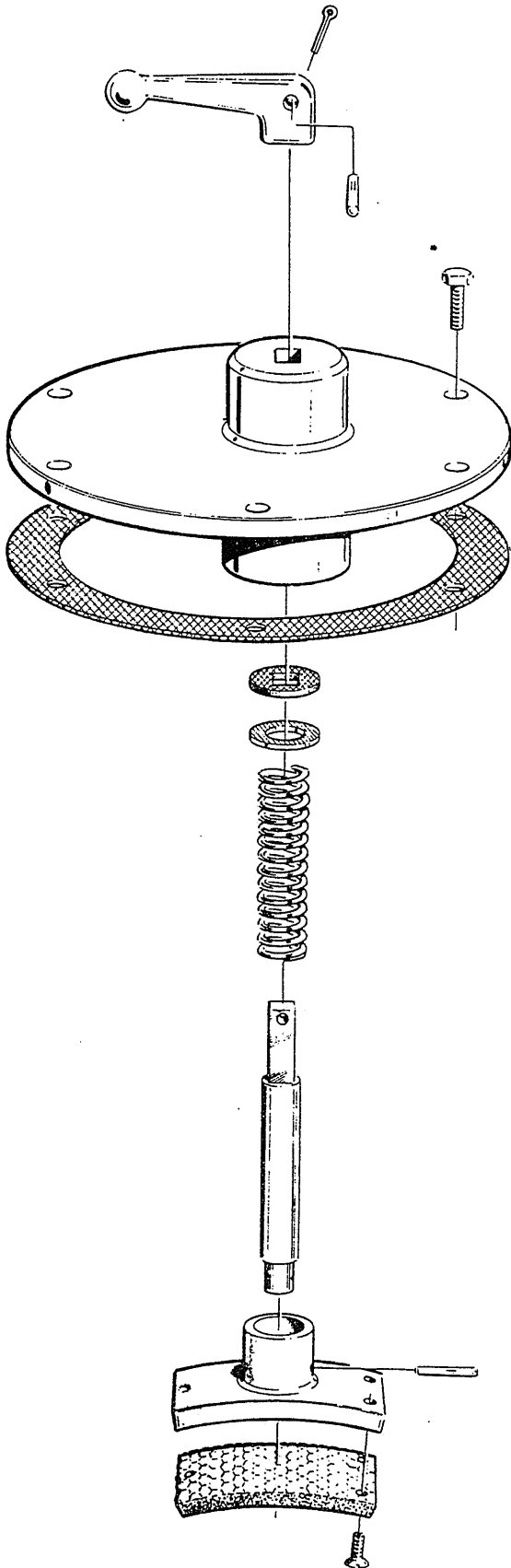
Loosen screws in distributing cover and lift out the latter. Dismantle the parts. Check packings and seal rings. For cleaning see chapter L.

Assembling

Fit the sleeve with packing in distributing cover so that the guide pin - at the arrow - enters the corresponding hole. Fit in the packing and sprayer by the aid of the guide pins - see arrow. Tighten the round nut firmly. Fasten the distributing cover.

Check the height position of the distributing cover - see chapter L.





Split pin  
-- 222210-19

Handle  
-- 533513-01

Pivot  
-- 222137-10

Screw (6)  
-- 2210942-37

Cap  
-- 528715-01

Packing  
-- 528732-01

Packing  
-- 528720-1

Washer  
-- 223101-37

Spring  
-- 39096

Spindle  
-- 65461

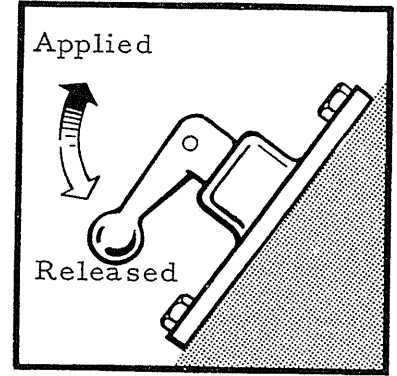
Brake shoe, compl.  
-- 537602-80

Slotted pin  
-- 67960

Brake shoe  
-- 65226

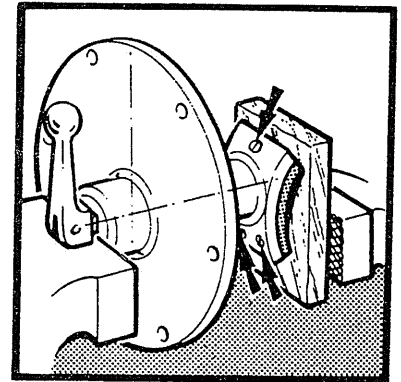
Lining  
-- 65227

Screw  
(3)  
-- 8341



Exchange of lining  
Release the brake and re-  
move the cap. Note that  
the screws are slotted at  
both ends (use an angle  
driver). Fasten the cap to  
the machine with the handle  
pointing downward.

Dismantling. Assemb-  
ling



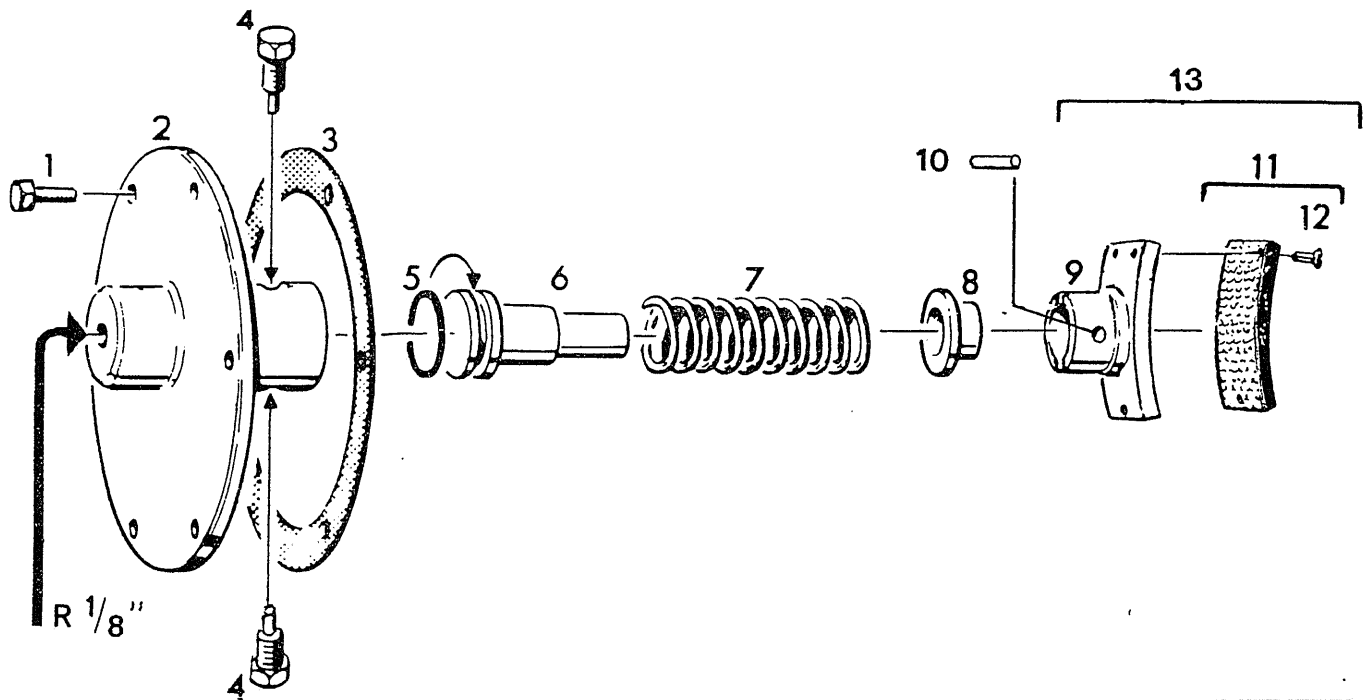
Clamp the cap in a screw  
vice, apply the brake, and  
remove the handle. See that  
cap, handle, and brake shoe  
are turned as shown by the  
arrows in the figure. Fasten  
the cap to the machine with  
the handle pointing downward.

PNEUMATIC BRAKE (for machine designed for remote control).

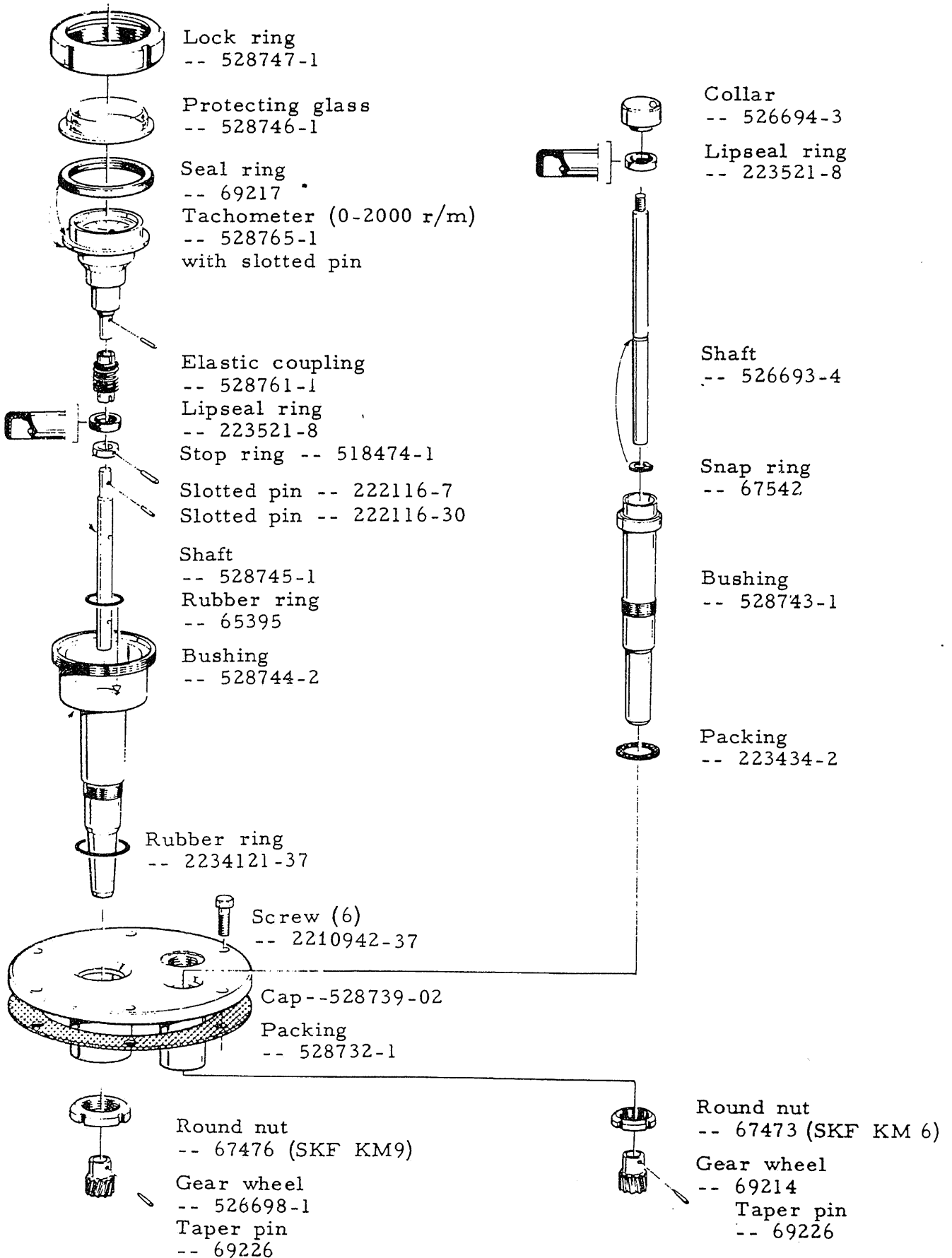
The piston 6 presses the brake shoe lining 11 against the coupling pulley when compressed air is fed to the cylinder 2. Suitable air pressure is 5-6 bar (72-87 psi).

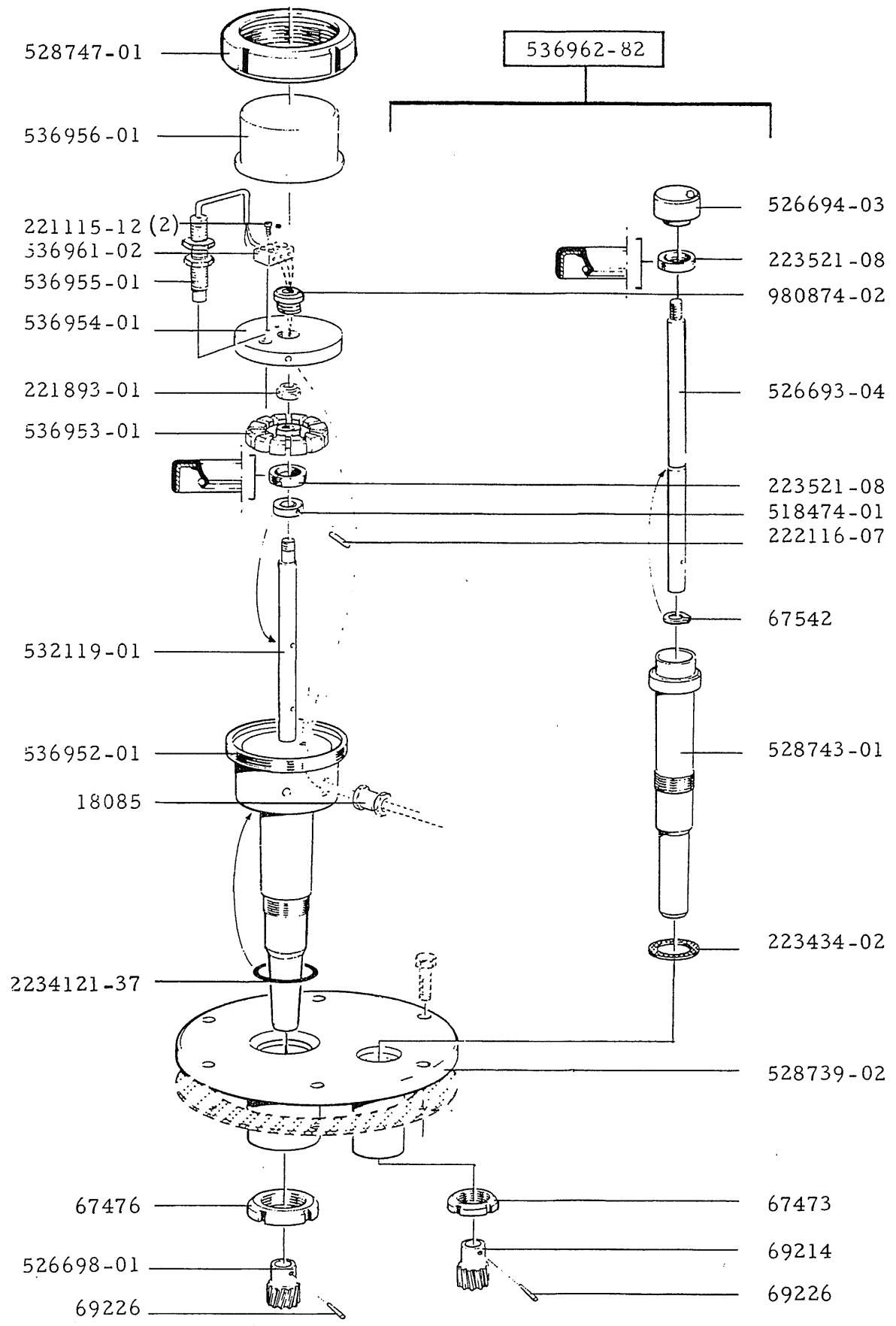
PNEUMATISK BROMS (för maskin avsedd för fjärrstyrning).

Då tryckluft tillföres cylindern 2 pressar kolven 6 skoningen 11 mot medbringarskivan. Lämpligt lufttryck 5-6 bar.



Ref.	Part No. Delnr.	Qty. Ant.	Part name	Benämning
1	2210942-37	6	Screw	Skruv
2	535449-80	1	Cap/cylinder	Kåpa/cylinder
3	528732-01	1	Packing	Packning
4	535207-01	2	Set screw	Stoppsskruv
5	223406-27	1	O-ring	O-ring
6	535202-01	1	Piston	Kolv
7	226214-83	1	Spring	Fjäder
8	535206-01	1	Gland	Gland
9	535204-01	1	Brake shoe	Bromsplatta
10	67960	1	Slotted pin	Räffelpinne
11	65227	1	Lining (with screws)	Skoning (med skruvar)
12	8341	3	Screw	Skruv
13	537602-81		Brake shoe	Bromsback

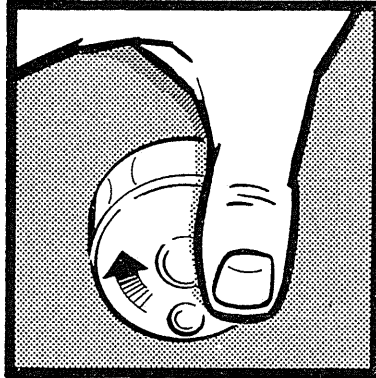




(Revolution counter and speed sensor, page 2)

## REVOLUTION COUNTER

### Speed checking



Speed particulars — see chapter C. Count the number of revolutions during one minute.

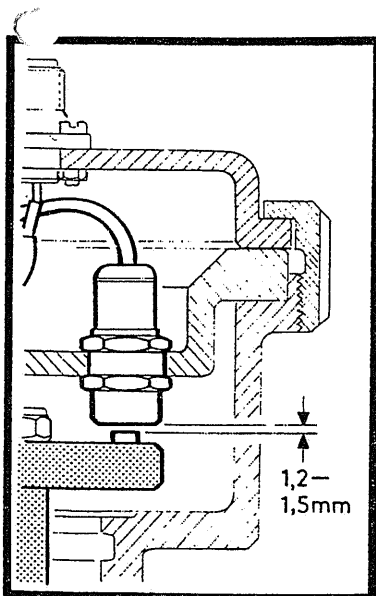
### Assembling

When mounting lubricate shaft and gear wheel with oil of the type used in the gear housing. Direct the gear wheel correctly — pin and hole are tapered. In case of play ream the hole (conicity 0.02).

Make sure the lipseal ring is directed according to the illustration and knock it carefully into its seat.

## SPEED SENSOR

### Assembling



Lubricate shaft and gear wheel with oil of the same type as used in the gear housing. Push home the shaft and secure the gear wheel with the taper pin. Direct the gear wheel correctly — pin and hole are tapered. In case of play ream the hole (conicity 0.02).

Direct the lipseal ring according to the illustration, slip it onto the shaft and knock it carefully into its seat.

After any dismantling which can affect the play indicated in the figure, the play must be readjusted. An impression of the play can be made in modelling clay.

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