



57	Clearance: -0.01 ... -0.03 mm Adjust key POS 4016 accordingly
56	Distance during assembly Pitch tube POS 7532 positioned completely to rotor side
35	Axial clearance: -0.050 ... -0.100 mm Adjust cover POS 5722 accordingly
54	Axial clearance: -0.050 ... -0.100 mm Adjust cover POS 5721 accordingly
53	Axial clearance: +0.190 ... +0.150 mm Adjust cover POS 4021 accordingly
52	Axial clearance: Adjust spacer POS 5311 in combination with pressure embedding to obtain zero clearance (contact) between POS 2612 & circlips
50	No Mobilux EP3 on seals
27	To be mounted with Loctite 603
26	Degrease mating surfaces before assembly
25	Plugs to be mounted with Loctite 577
24	Mating surfaces to be mounted with Dow Corning 7091 sealant according to WFM77.2.21
23	O-rings: seal sliding surfaces or other components to be mounted with grease Mobilux EP3
22	Mating surfaces to be mounted with Gleitmo 805 paste
21	Bolts to be mounted with Loctite 243
18	Minimum wet sump oil level at 24°C oil temperature
15	Tightening torque lock nut: 4300 Nm +/- 10% Tightening torque lock screw M10: 35 Nm +/- 10%
14	Tightening torque: 2583 ... 2045 Nm Before assembly apply grease Mobilux EP3 on the nut thread and contact face
13	Required orientation of serial numbers on gears
12	Heating-up of bearings and gears according to WFM77.2.18, unless indicated otherwise
11	Bolt tightening according to WFM77.1.5 Unless indicated otherwise
8	Axial bearing clearance: -0.080 ... -0.180 mm Adjust cover POS 6934 accordingly
6	Axial bearing clearance: +0.000 ... -0.100 mm Adjust cover POS 6933 accordingly
5	Axial bearing clearance: preadjusted by bearing manufacturer Range: +0.100 ... -0.100 See bearing drawings POS 6022
4	Axial bearing clearance: preadjusted by bearing manufacturer Range: -0.135 ... -0.385 See bearing drawings POS 6012
2	Axial bearing clearance: +0.055 ... -0.245 mm Deformations during assembly are taken into account Adjust spacer pack POS 5711 + POS 4016 accordingly
1	Axial clearance (after assembly) +...xxx = preload +...xxx = clearance clearance values at 20°C

MASS - MASSA 80789 Kg SCALE - SCHALE 1/6 mm ISO 13800 - BF	GENERAL DIMENSIONS ISO 2768-01 ISO 13800 - BF	MATERIAL MATERIAL BEHAVIOUR REF. ON POSITION UNLESS OTHERWISE SPECIFIED	MACHINED SURF BEWERKTE OPG. ✓ ISO 1300 TOLERANCE PRINCIPLE TOEGANGSPRINCIP DIN 7187 DIMENSIONAL SYSTEM ISO 13800 - BF	DRAWN 2016-08-08 RELEASED 2016-08-12 DWG. NUMBER PO	USE GEERLUX TITLE ASSEMBLY DRAWING BEHAVIOUR CRED
--	---	--	--	--	--