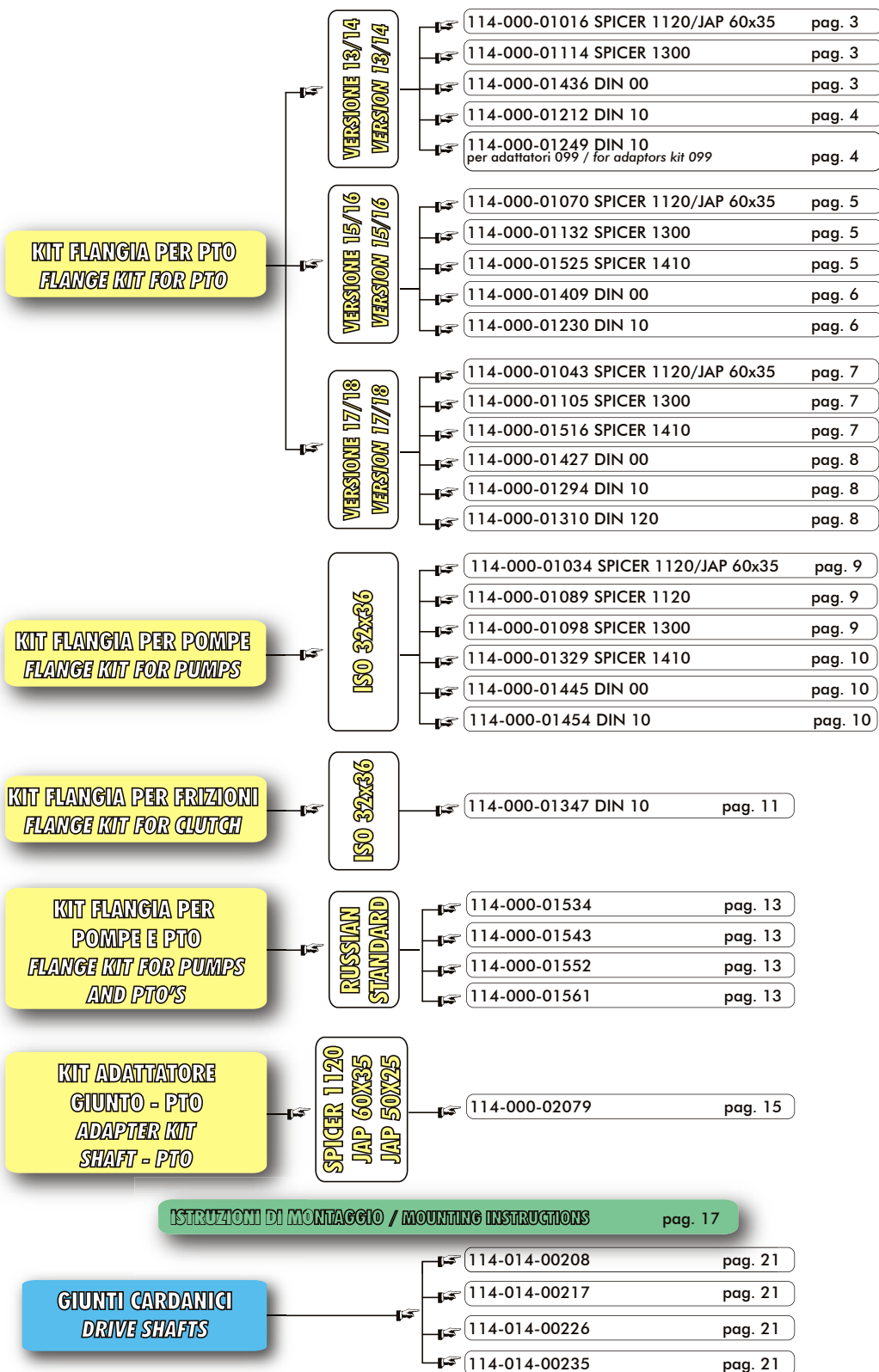


KIT FLANGIA

FLANGE KIT



Алматы (7273)495-231
Ангарск (3955)60-70-56
Архангельск (8182)63-90-72
Астрахань (8512)99-46-04
Барнаул (3852)73-04-60
Белгород (4722)40-23-64
Благовещенск (4162)22-76-07
Брянск (4832)59-03-52
Владивосток (423)249-28-31
Владикавказ (8672)28-90-48
Владимир (4922)49-43-18
Волгоград (844)278-03-48
Вологда (8172)26-41-59
Воронеж (473)204-51-73
Екатеринбург (343)384-55-89

Иваново (4932)77-34-06
Ижевск (3412)26-03-58
Иркутск (395)279-98-46
Казань (843)206-01-48
Калининград (4012)72-03-81
Калуга (4842)92-23-67
Кемерово (3842)65-04-62
Киров (8332)68-02-04
Коломна (4966)23-41-49
Кострома (4942)77-07-48
Краснодар (861)203-40-90
Красноярск (391)204-63-61
Курск (4712)77-13-04
Курган (3522)50-90-47
Липецк (4742)52-20-81

Магнитогорск (3519)55-03-13
Москва (495)268-04-70
Мурманск (8152)59-64-93
Набережные Челны (8552)20-53-41
Нижний Новгород (831)429-08-12
Новокузнецк (3843)20-46-81
Ноябрьск (3496)41-32-12
Новосибирск (383)227-86-73
Омск (3812)21-46-40
Орел (4862)44-53-42
Оренбург (3532)37-68-04
Пенза (8412)22-31-16
Петрозаводск (8142)55-98-37
Псков (8112)59-10-37
Пермь (342)205-81-47

Ростов-на-Дону (863)308-18-15
Рязань (4912)46-61-64
Самара (846)206-03-16
Санкт-Петербург (812)309-46-40
Саратов (845)249-38-78
Севастополь (8692)22-31-93
Саранск (8342)22-96-24
Симферополь (3652)67-13-56
Смоленск (4812)29-41-54
Сочи (862)225-72-31
Ставрополь (8652)20-65-13
Сургут (3462)77-98-35
Сыктывкар (8212)25-95-17
Тамбов (4752)50-40-97
Тверь (4822)63-31-35

Тольятти (8482)63-91-07
Томск (3822)98-41-53
Тула (4872)33-79-87
Тюмень (3452)66-21-18
Ульяновск (8422)24-23-59
Улан-Удэ (3012)59-97-51
Уфа (347)229-48-12
Хабаровск (4212)92-98-04
Чебоксары (8352)28-53-07
Челябинск (351)202-03-61
Череповец (8202)49-02-64
Чита (3022)38-34-83
Якутск (4112)23-90-97
Ярославль (4852)69-52-93

Россия +7(495)268-04-70

Казахстан +7(7172)727-132

Киргизия +996(312)96-26-47

**KIT FLANGIA PER PTO VERSIONE
13/14 (UNI-ALBERO 21x25)
FLANGE KIT FOR PTO VERSION
13/14 (UNI-SHAFT 21x25)**

CODICE FAMIGLIA
FAMILY CODE

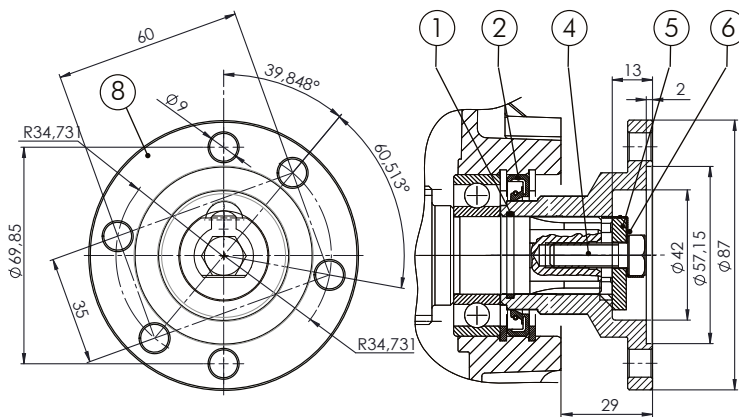
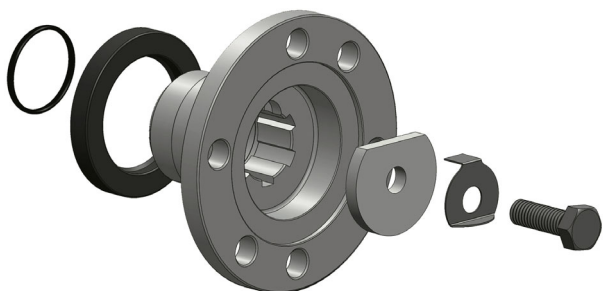
114000

v. 13/14

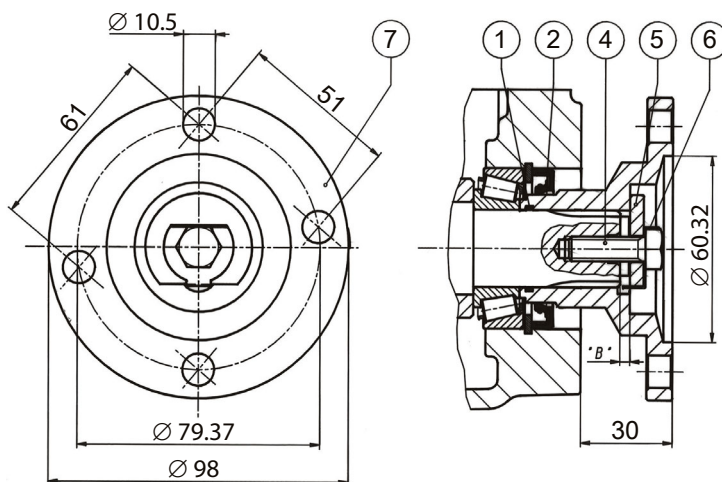
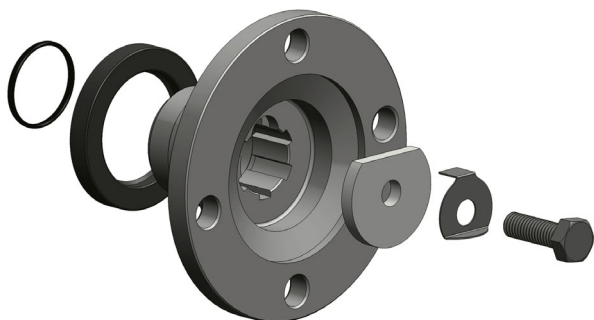
KIT FLANGIA / FLANGE KIT

INGOMBRO / DIMENSIONS

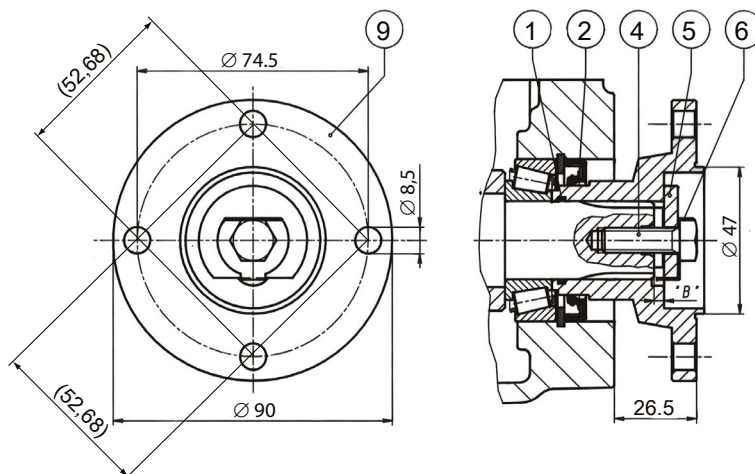
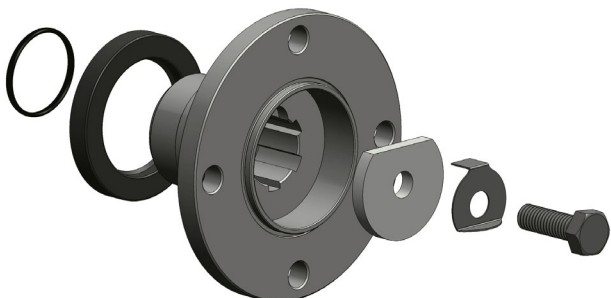
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SPICER 1120 / JAP 60x35**



**11400001114
SPICER 1300**

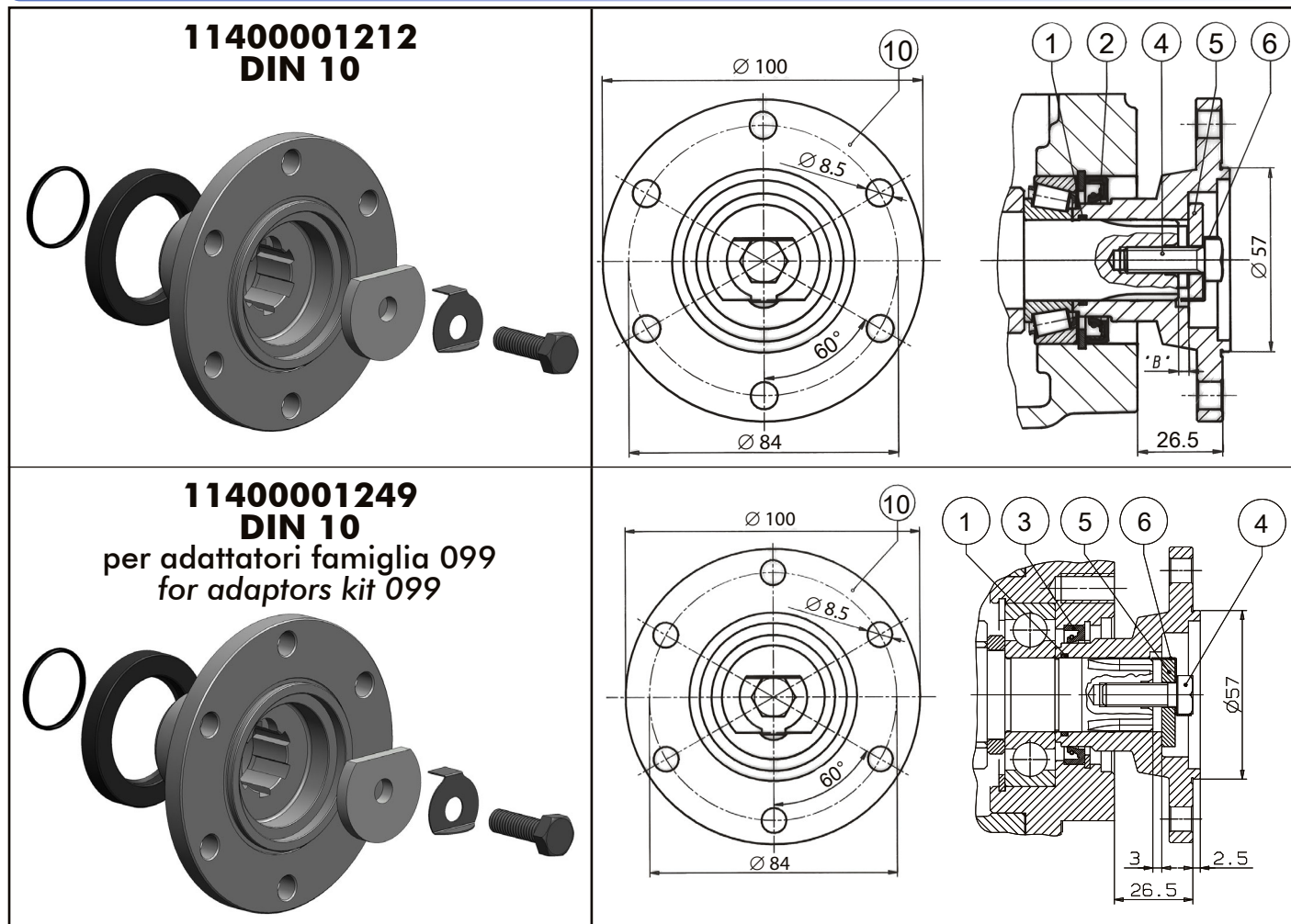


**11400001436
DIN 00**



99740011410

99711401016 Rev: AD



Pos.	Codice Code	Pezzi Pieces	Denominazione Denomination
1	50600100220	1	Guarnizione OR 2100 Gasket OR 2100
2	50600700608	1	Paraolio Ø 35x52 H=7 Oil-seal Ø 35x52 H=7
3	50600700573	1	Paraolio Ø 35x47 H=7 Oil-seal Ø 35x47 H=7
4	50200300066	1	Vite TE M8x25 UNI 5739 Hex Bolt M8x25 UNI 5739
5	50101200174	1	Rondella ferma flangia Stop flange washer
6	50101700106	1	Rosetta di sicurezza Ø 9 UNI 1746 Safety washer Ø 9 UNI 1746
7	11400800153	1	Flangia tipo SPICER 1300 Flange type SPICER 1300
8	11400700154	1	Flangia tipo SPICER 1120 Flange type SPICER 1120
9	11400800297	1	Flangia tipo DIN 00 Flange type DIN 00
10	11400800108	1	Flangia tipo DIN 10 Flange type DIN 10

**KIT FLANGIA PER PTO VERSIONE
15/16 (ISO-ALBERO 32x36)
FLANGE KIT FOR PTO VERSION
15/16 (ISO-SHAFT 32x36)**

CODICE FAMIGLIA
FAMILY CODE

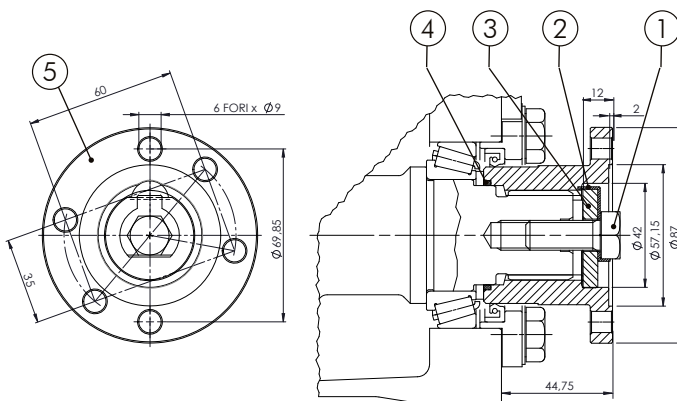
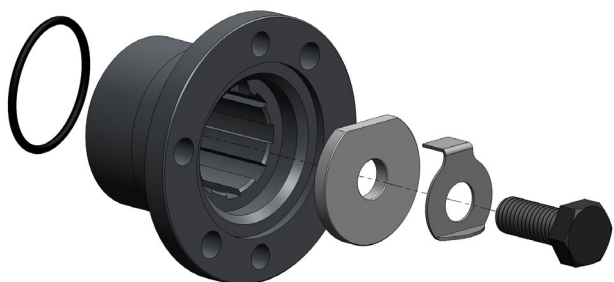
114000

v. 15/16

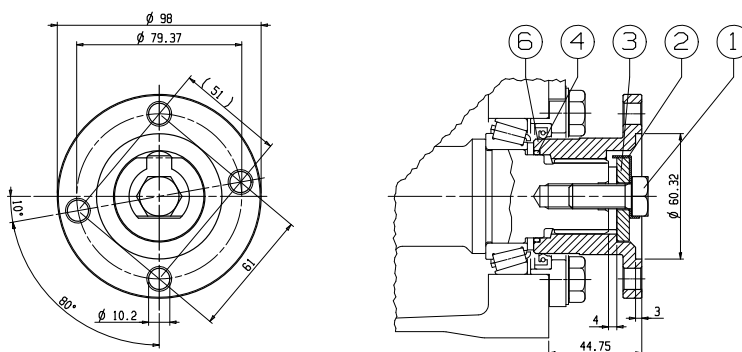
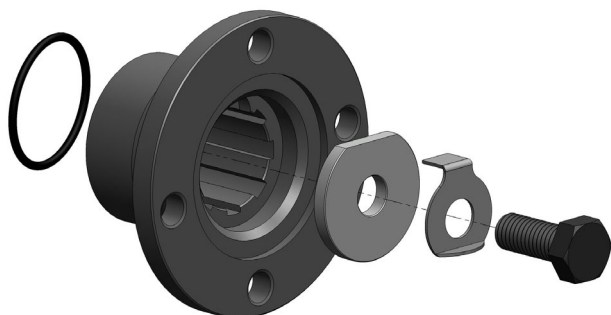
KIT FLANGIA / FLANGE KIT

INGOMBRO / DIMENSIONS

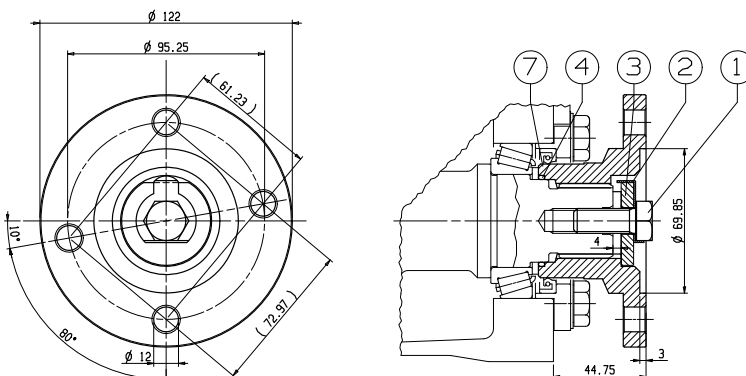
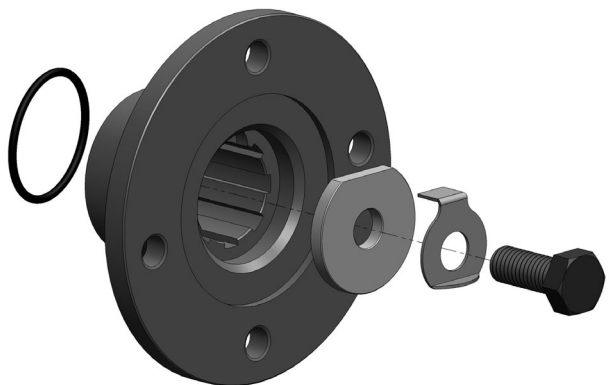
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SPICER 1120 / JAP 60x35**



**11400001132
SPICER 1300**

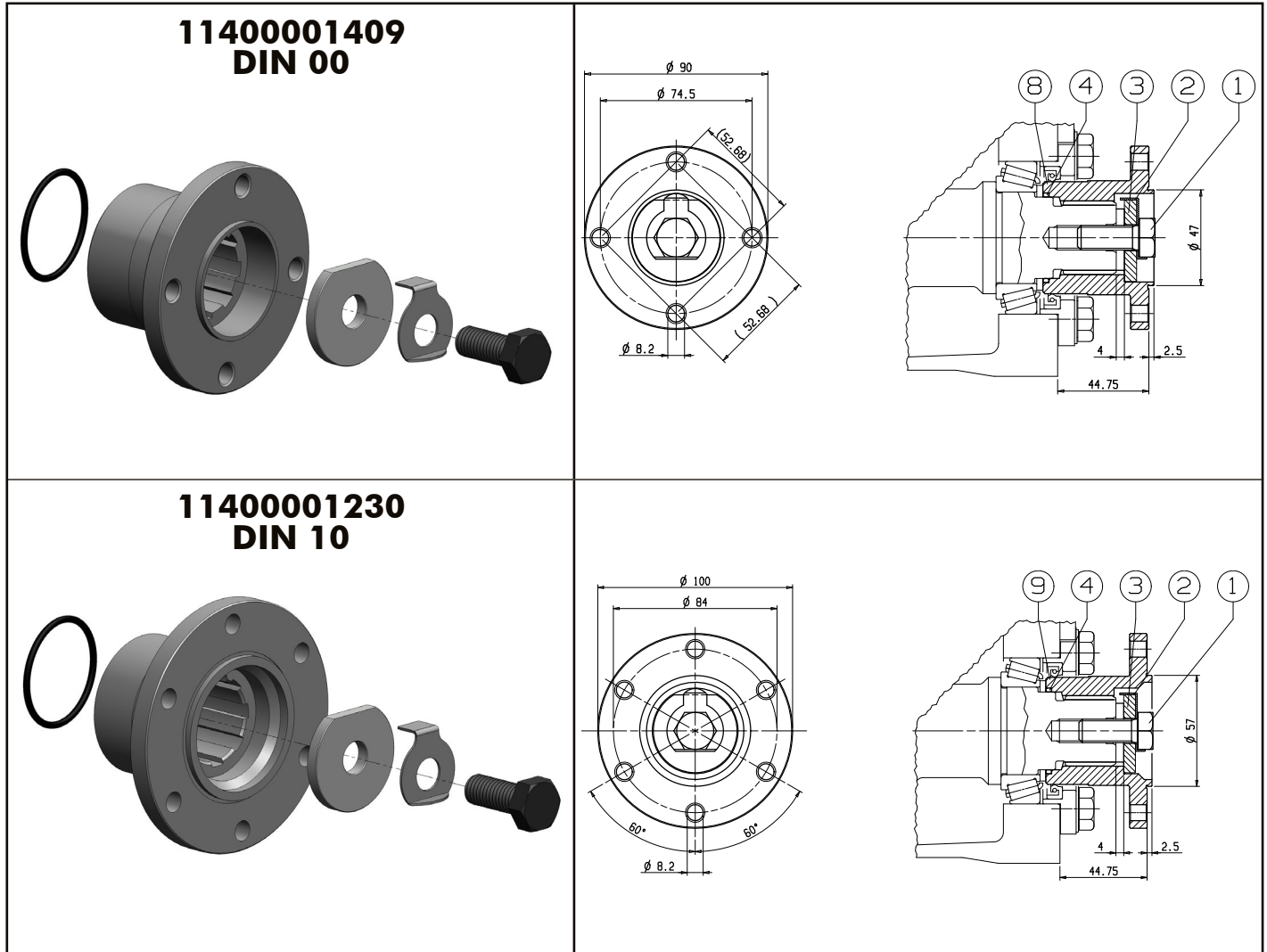


**11400001525
SPICER 1410**



99740011410

99711401070 Rev: AC



Pos.	Codice Code	Pezzi Pieces	Denominazione Denomination
1	50200500055	1	Vite TE M 12x30 UNI 5739 Screw TE M 12x30 UNI 5739
2	50101700142	1	Rondella di sicurezza con linguetta x M12 Back-up washer M12
3	50101200156	1	Rondella bloccaggio flangia Flange locking washer
4	50600603156	1	Guarnizione O-R 3156 FKM/FPM Gasket O-R 3156 FKM/FPM
5	11400700289	1	Flangia femmina 32x36 SPICER 1120 Female flange 32x36 SPICER 1120
6	11400800171	1	Flangia femmina 32x36 SPICER 1300 Female flange 32x36 SPICER 1300
7	11400800386	1	Flangia femmina 32x36 SPICER 1410 Female flange 32x36 SPICER 1410
8	11400800206	1	Flangia femmina 32x36 DIN 00 Female flange 32x36 DIN 00
9	11400800180	1	Flangia femmina 32x36 DIN 10 Female flange 32x36 DIN 10

**KIT FLANGIA PER PTO VERSIONE
17/18 (ISO-MOZZO 32x36)
FLANGE KIT FOR PTO VERSION
17/18 (ISO-HUB 32x36)**

CODICE FAMIGLIA
FAMILY CODE

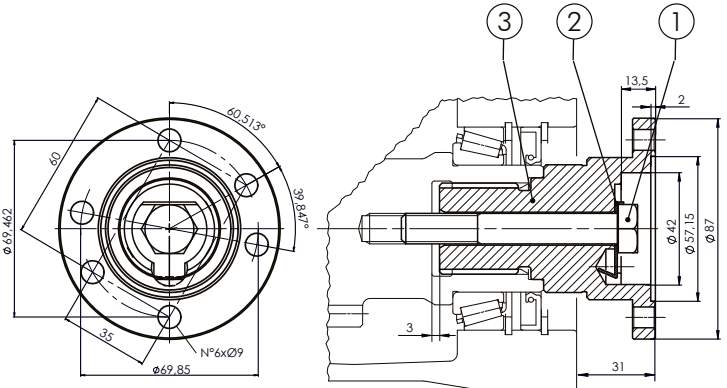
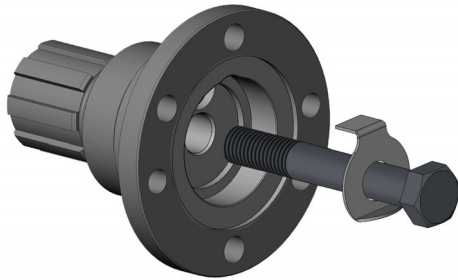
114000

v. 17/18

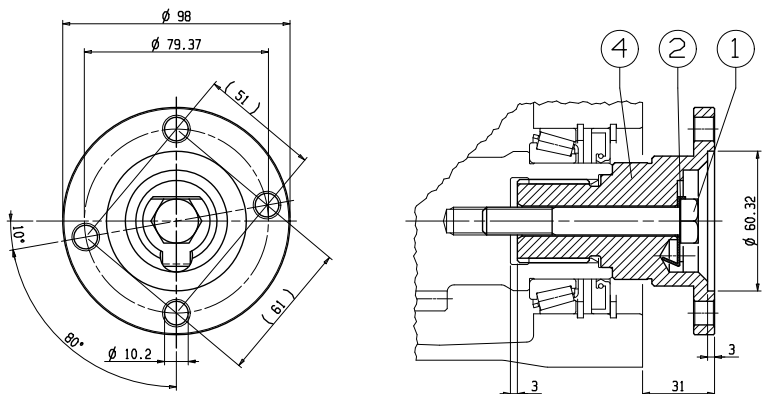
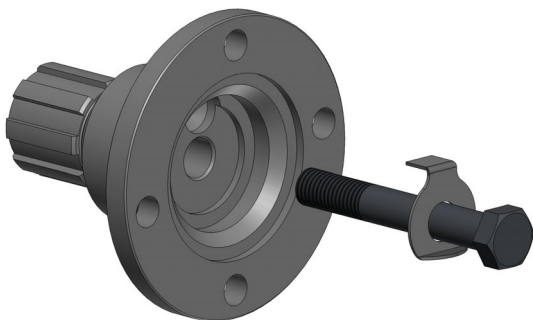
KIT FLANGIA / FLANGE KIT

INGOMBRO / DIMENSIONS

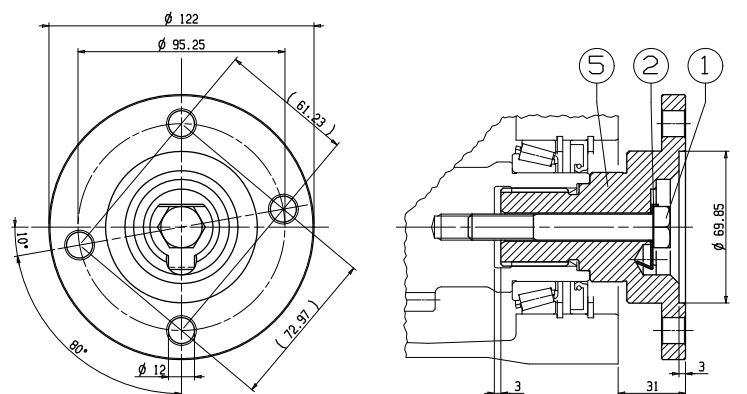
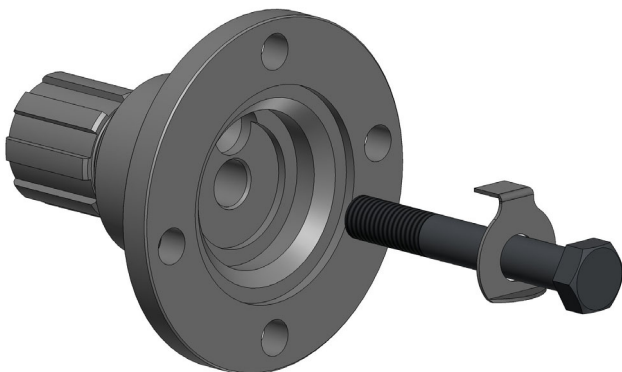
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SPICER 1120 / JAP 60x35**



**11400001105
SPICER 1300**



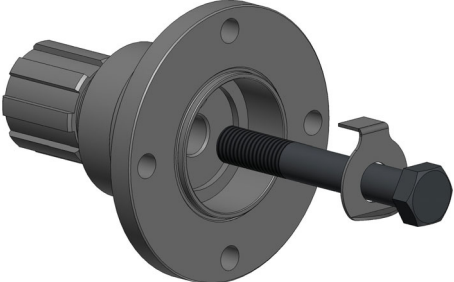
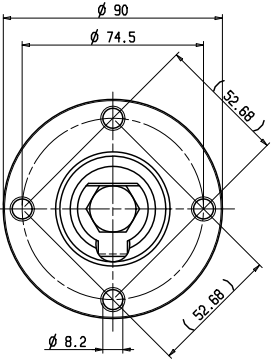
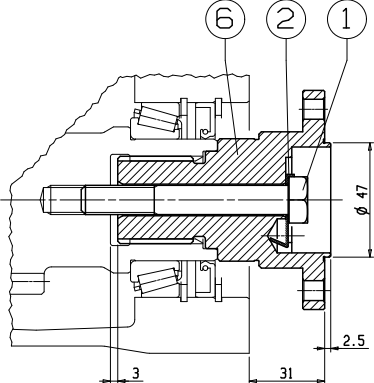
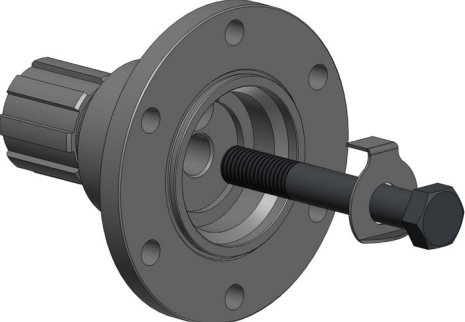
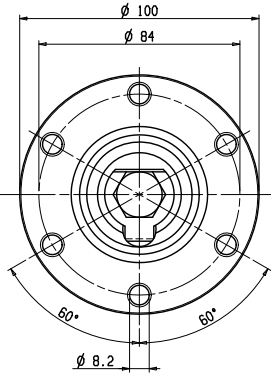
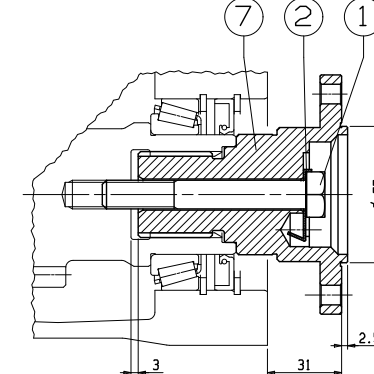
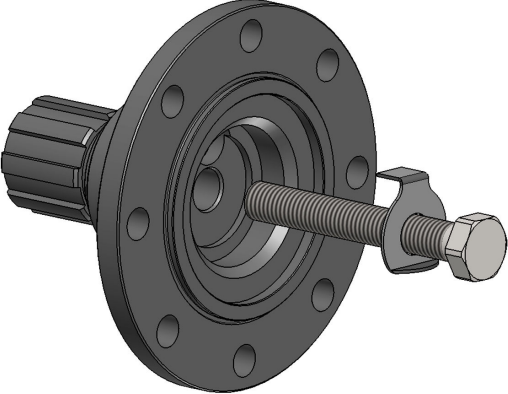
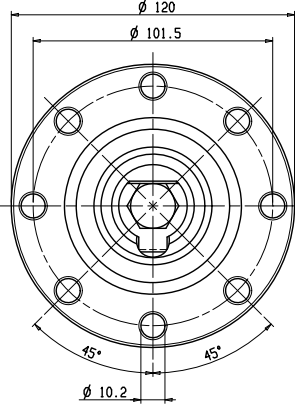
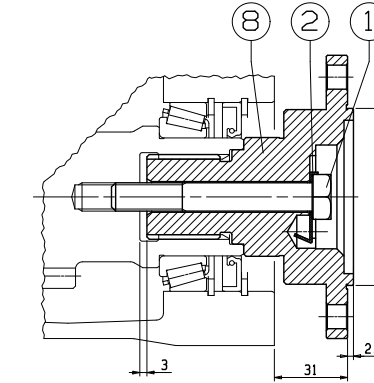
**11400001516
SPICER 1410**



99740011410

21/12/2021

99711401043 Rev:AD

<p>11400001427 DIN 00</p> 		
<p>11400001294 DIN 10</p> 		
<p>11400001310 DIN 120</p> 		

99740011410

Pos.	Codice / Code	Q.tà / Q.ty	Denominazione / Denomination
1	50200500402	1	Vite TE M 12x85 UNI 5737 CL. 10.9 Screw TE M 12x85 UNI 5737 CL. 10.9
2	50101700142	1	Rondella di sicurezza con linguetta x M12 Back-up washer M12
3	11400800279	1	Flangia 32x36 SPICER 1120 / Flange 32x36 SPICER 1120
4	11400800251	1	Flangia 32x36 SPICER 1300 / Flange 32x36 SPICER 1300
5	11400800377	1	Flangia 32x36 SPICER 1410 / Flange 32x36 SPICER 1410
6	11400800304	1	Flangia 32x36 DIN 00 / Flange 32x36 DIN 00
7	11400800313	1	Flangia 32x36 DIN 10 / Flange 32x36 DIN 10
8	11400800457	1	Flangia 32x36 DIN 120 / Flange 32x36 DIN 120

9971401043 Rev: AD

KIT FLANGIA PER POMPE
FLANGIA ISO 32x36
FLANGE KIT FOR ISO FLANGE
PUMPS 32x36

CODICE FAMIGLIA
FAMILY CODE

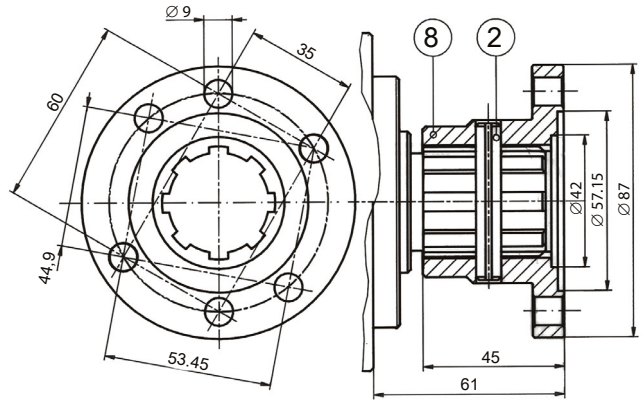
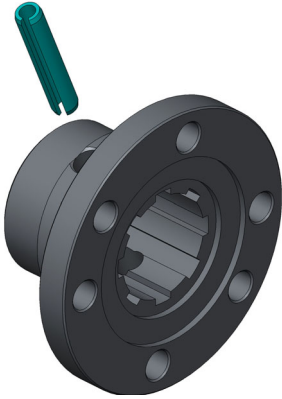
114000

ISO 32x36

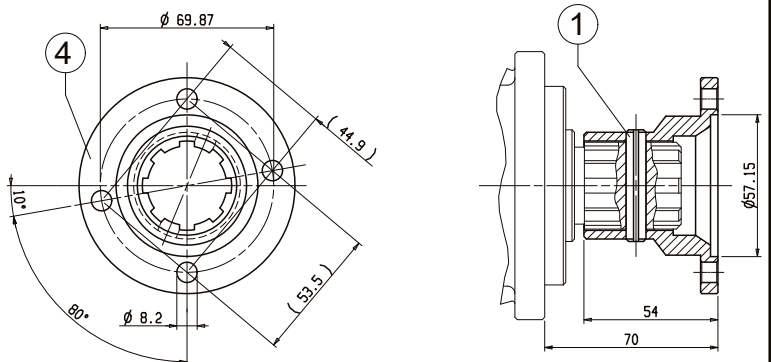
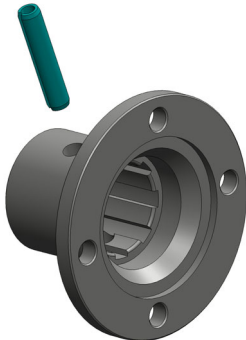
KIT FLANGIA / FLANGE KIT

INGOMBRO / DIMENSIONS

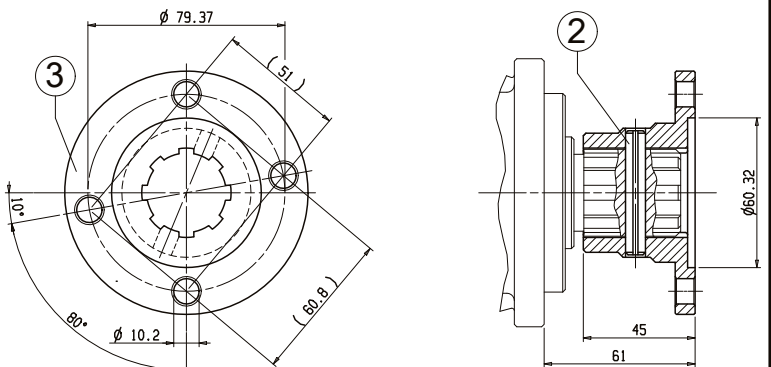
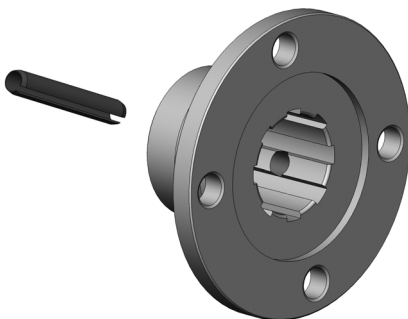
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SPICER 1120 / JAP 60x35



11400001089
SPICER 1120

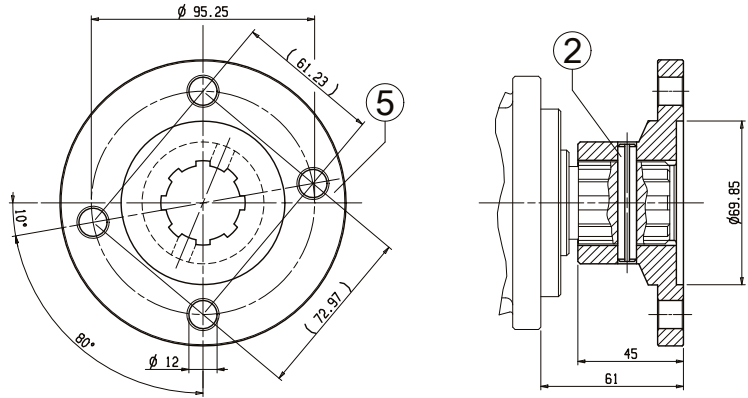
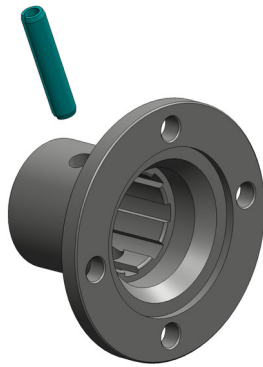
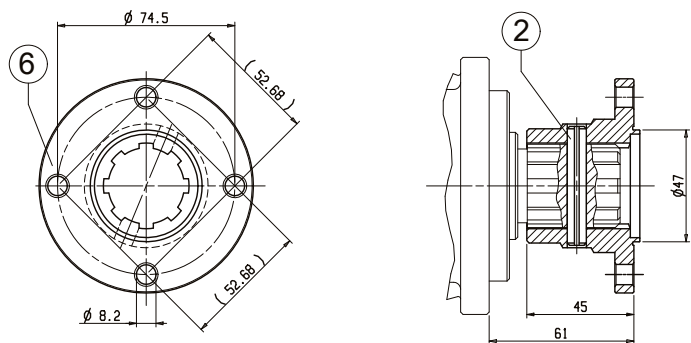
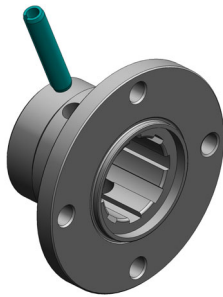
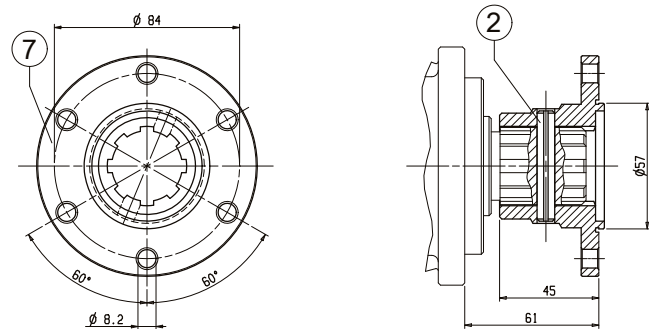


11400001098
SPICER 1300



99740011410

99711401089 Rev:AD

**11400001329
SPICER 1410****11400001445
DIN 00****11400001454
DIN 10**

Pos.	Codice/Code	N°	Denominazione / Denomination
1	50100400156	1	Spina elastica $\varnothing 8 \times 45$ / $\varnothing 8 \times 45$ spring pin
2	50100400183	1	Spina elastica $\varnothing 8 \times 50$ / $\varnothing 8 \times 50$ spring pin
3	11400800199	1	Flangia tipo SPICER 1300 / Flange type SPICER 1300
4	11400700207	1	Flangia tipo SPICER 1120 / Flange type SPICER 1120
5	11400800439	1	Flangia tipo SPICER 1410 / Flange type SPICER 1410
6	11400800322	1	Flangia tipo DIN 00 / Flange type DIN 00
7	11400800224	1	Flangia tipo DIN 10 / Flange type DIN 10
8	11400700298	1	Flangia tipo G speciale / Flange type G special

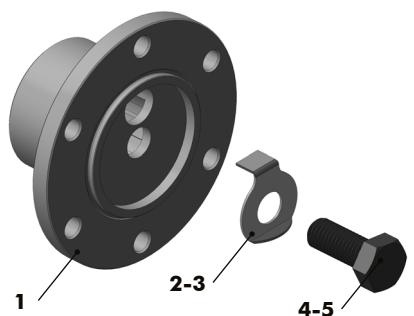
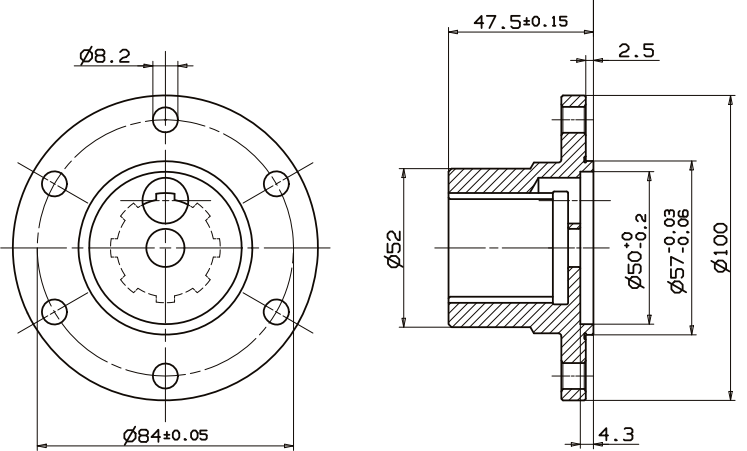
KIT FLANGIA DIN 10 PER FRIZIONE ISO DIN 10 FLANGE KIT FOR ISO CLUTCH

CODICE FAMIGLIA
FAMILY CODE

114000

ISO 32x36

99740011410

KIT FLANGIA / FLANGE KIT	INGOMBRO / DIMENSIONS
<p>1140001347 DIN 10</p> <p>Mozzo/Hub 8x32x36 (ISO 14)</p> 	

Pos.	Codice/Code	N°	Denominazione / Denomination
1	11400800340	1	Flangia Di 32x36 DIN 10 / Flange Di 32x36 DIN 10
2	50101700106	1	Rosetta di sicurezza / Back-up washer
3	50101700142	1	Rosetta di sicurezza / Back-up washer
4	50200300057	1	Vite TE M8x22 UNI 5739 / Hex Bolt M8x22 UNI 5739
5	50200500055	1	Vite TE M12x30 UNI 5739 / Hex Bolt M12x30 UNI 5739

99711401347 Rev: //

KIT FLANGIA RUSSIAN STANDARD RUSSIAN STANDARD FLANGE KIT

CODICE FAMIGLIA
FAMILY CODE

114000

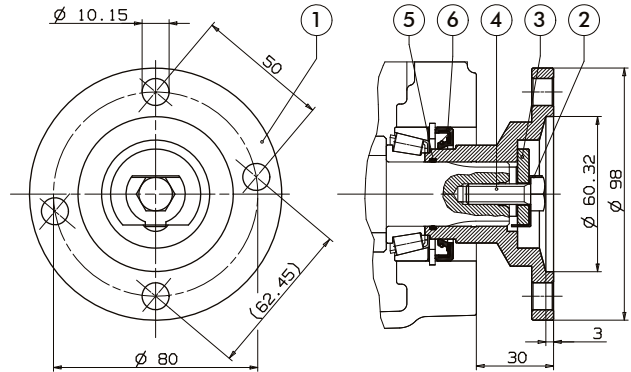
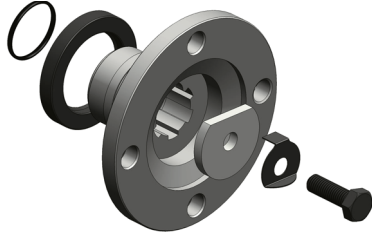
**RUSSIAN
STANDARD**

KIT FLANGIA / FLANGE KIT

INGOMBRO / DIMENSIONS

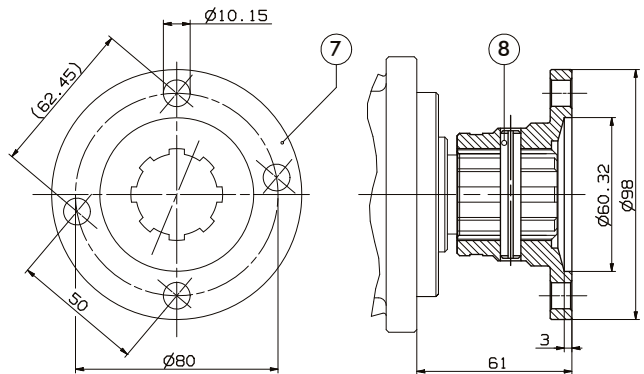
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PTO vers. 13/14
(UNI-Albero/
Shaft 21x25)



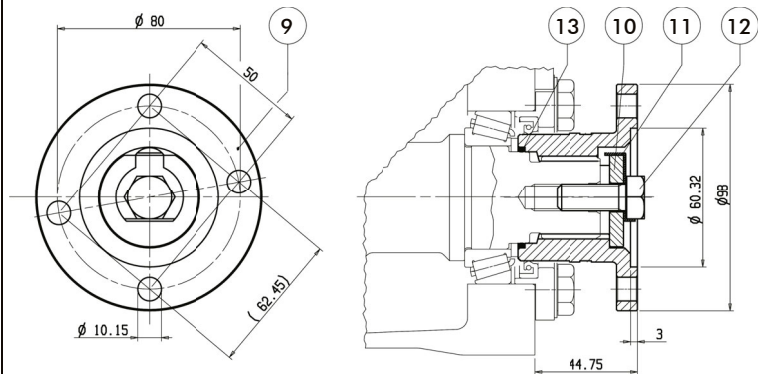
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POMPE
PUMP
ISO 32x36



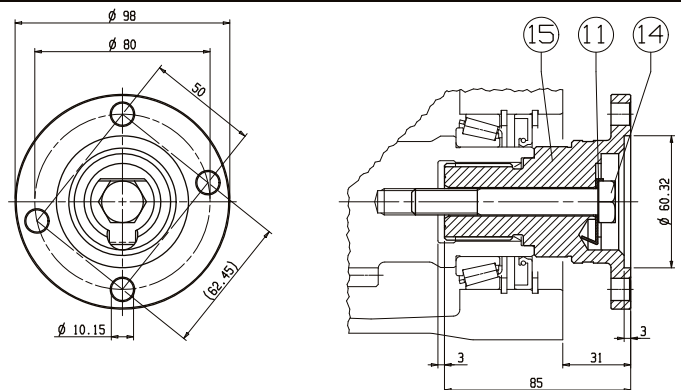
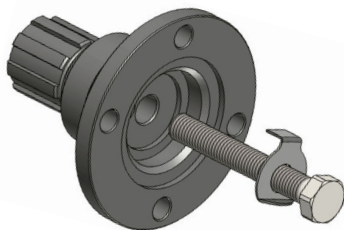
11400001552

PTO vers. 15/16
(ISO-Albero/
Shaft 32X36)



11400001561

PTO vers. 17/18
(ISO-Mozzo/
Hub 32X36)



99740011410

99711401534 Rev:AA

KIT FLANGIA RUSSIAN STANDARD
RUSSIAN STANDARD FLANGE KIT

Pos.	Codice/Code	N°	Denominazione / Denomination
1	11400800402	1	Flangia G 21X25 Russian standard / Flange Russian standard
2	50101200174	1	Rondella ferma flangia / Stop flange washer
3	50101700106	1	Rosetta di sicurezza Ø 9 UNI 1746 / Safety washer
4	50200300066	1	Vite TE M8x25 UNI 5739 / Hex Bolt M8x25 UNI 5739
5	50600100220	1	Guarnizione OR 2100 / Gasket OR 2100
6	50600700608	1	Paraolio Ø 35x52 H=7 / Oil-seal Ø 35x52 H=7
7	11400800411	1	Flangia D.I. 32x36 Russian standard / Flange Russian standard
8	50100400183	1	Spina elastica 8x50 / Spring pin
9	11400800448	1	Flangia D.I. 32x36 Russian standard / Flange Russian standard
10	50101200156	1	Rondella ferma flangia / Stop flange washer
11	50101700142	1	Rosetta di sicurezza / Safety washer
12	50200500055	1	Vite TE M12x30 UNI 5739 / Hex Bolt M12x30 UNI 5739
13	50600603156	1	Guarnizione OR 3156 / Gasket OR 3156
14	50200500402	1	Vite TE M12x85 UNI 5737 / Hex Bolt M12x85 UNI 5737
15	11400800475	1	Flangia 32x36 Russian standard / Flange Russian standard 32x36

99740011410

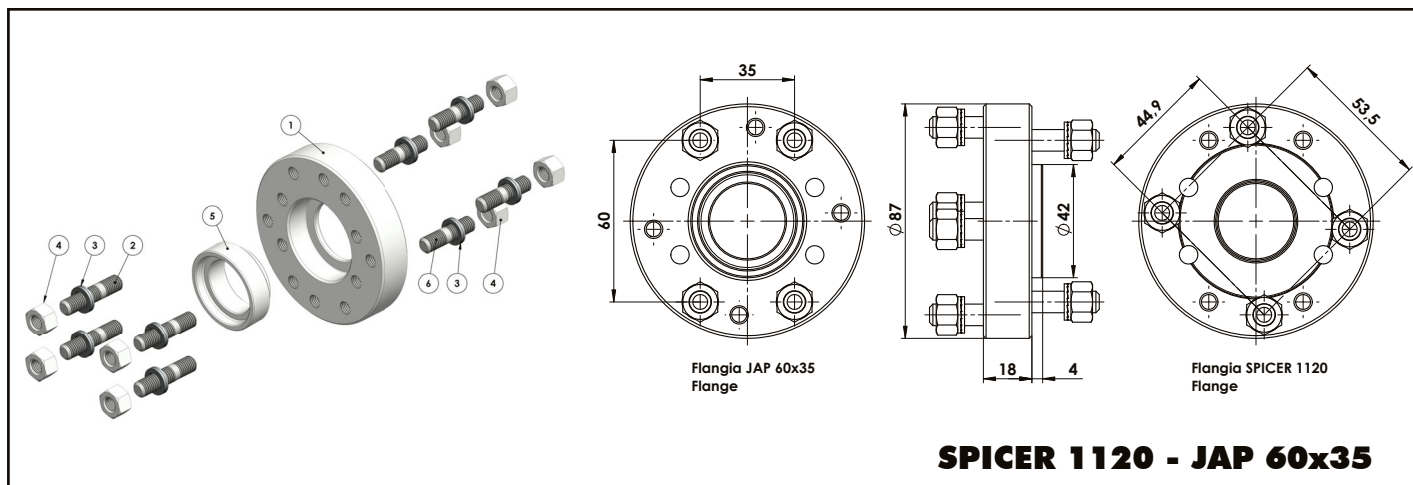
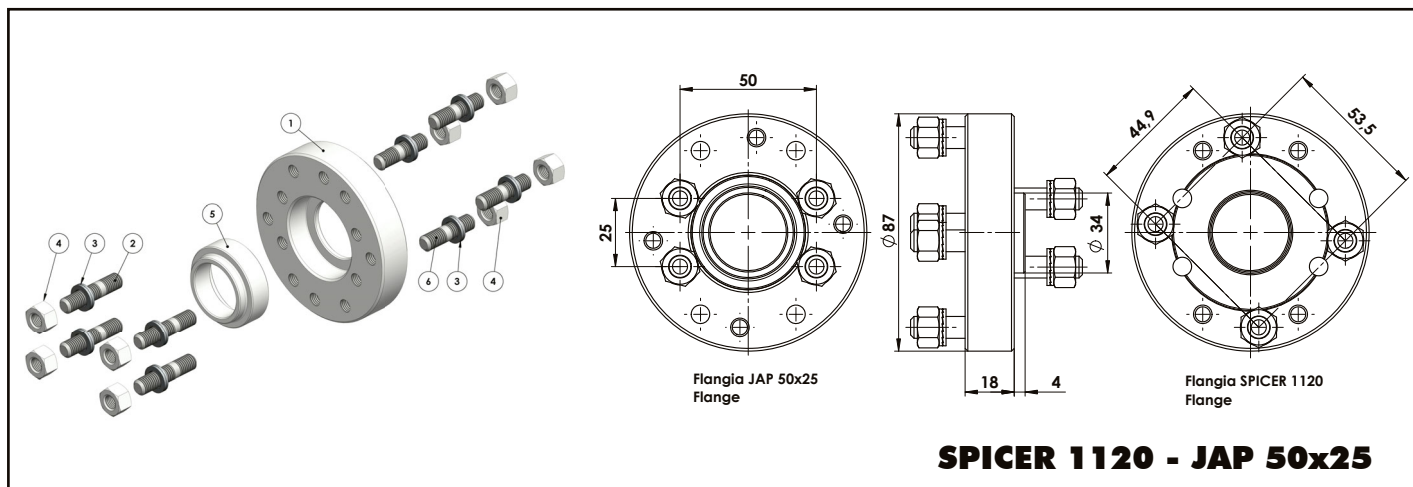
Kit adattatore giunto spicer 1120-PTO JAP 60x35/50x25

Adapter kit spicer 1120 shaft - PTO JAP 60x35/50x25

CODICE
CODE

11400002079

99740011410



Pos.	Codice/Code	Denominazione	Description	Q.
1	11400900714	Flangia JAP / SPICER 1120	JAP / SPICER 1120 flange	1
2	50300300019	Prigioniero M8x25 UNI 5909	Stud M8x25 UNI 5909	4
3	50100750082	Rondella NORD-LOCK x M8	NORD-LOCK washer x M8	8
4	50500300015	Dado M8 CH13 H8 UNI 5587	Nut M8 CH13 H8 UNI 5587	8
5	51100000122	Bussola centraggio flangia JAP	Centre ring for JAP flange	1
6	50300300180	Prigioniero M8x20 UNI 5909	Stud M8x20 UNI 5909	4



**Al montaggio porre attenzione all'orientamento della bussola particolare 5.
Pay attention to the positioning of centre ring pos.5 during fitment.**

99711402079 Rev: //

ISTRUZIONI DI MONTAGGIO KIT FLANGIA PER PTO FITTING INSTRUCTIONS OF THE FLANGE KIT FOR PTO

CODICE FAMIGLIA
FAMILY CODE

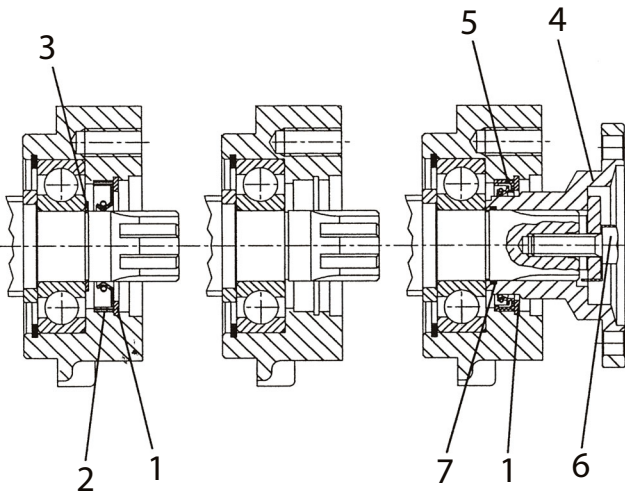
114000

v. 13/14

**KIT FLANGIA:
FLANGE KIT:**

11400001016 / 11400001114 / 11400001212 / 11400001249 / 11400001436 / 11400001534

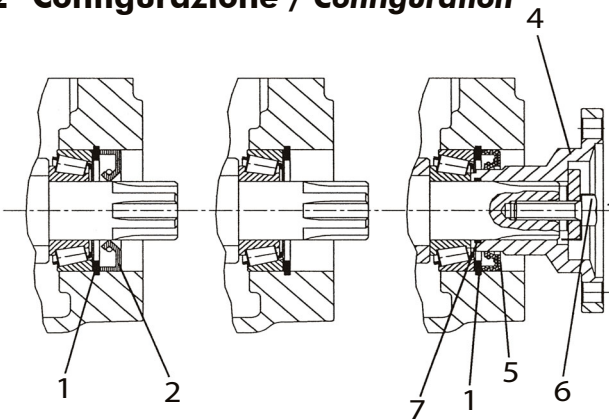
1ª Configurazione / Configuration



- 1) Smontare l'anello Seeger di Bloccaggio del paraolio "1"
- 2) Smontare il paraolio "2"
- 3) Smontare l'anello Seeger sull'albero "3" (IMPORTANTE)
- 4) Montare il paraolio "5"
- 5) Montare il Seeger "1"
- 6) Verificare che l'anello di tenuta "OR" "7" sia in posizione corretta nella sede della flangia "4"
- 7) Montare la flangia "4"
- 8) Montare la rondella, la rosetta di sicurezza e la vite di chiusura "6"
- 9) Chiudere a coppia (21-27 Nm) con chiave dinamometrica
- 10) Bloccare la vite rivoltando la rosetta di sicurezza
- 11) Controllare dopo qualche ora di funzionamento che non vi siano perdite di olio o allentamenti degli organi di bloccaggio.

- 1) Dismantle the locking seeger of the oil-seal "1"
- 2) Dismantle the oil-seal "2"
- 3) Dismantle the seeger on the shaft "3" (IMPORTANT)
- 4) Fit the oil seal "5"
- 5) Fit the seeger "1"
- 6) Check the correct position of the o-ring "7" in the flange seat "4"
- 7) Fit the flange "4"
- 8) Fit the washer and the screw "6"
- 9) Screw at a torque of 21-27 Nm using a torque wrench
- 10) Lock the screw turning over the safety washer
- 11) Check after a few working hours that there is no oil leak or slackening of the locking bolts

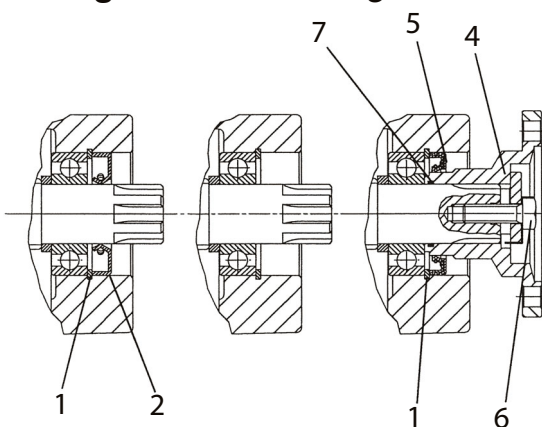
2ª Configurazione / Configuration



- 1) Smontare il paraolio "2"
- 2) Montare il paraolio "5"
- 3) Verificare che l'anello di tenuta "OR" "7" sia in posizione corretta nella sede della flangia "4"
- 4) Montare la flangia "4"
- 5) Montare la rondella, la rosetta di sicurezza e la vite di chiusura "6"
- 6) Chiudere a coppia (21-27 Nm) con chiave dinamometrica
- 7) Bloccare la vite rivoltando la rosetta di sicurezza
- 8) Controllare dopo qualche ora di funzionamento che non vi siano perdite di olio o allentamenti degli organi di bloccaggio.

- 1) Dismantle the oil-seal "2"
- 2) Fit the oil seal "5"
- 3) Check the correct position of the o-ring "7" in the flange seat "4"
- 4) Fit the flange "4"
- 5) Fit the washers and the screw "6"
- 6) Screw at a torque of 21-27 Nm using a torque wrench
- 7) Lock the screw turning over the safety washer
- 8) Check after a few working hours that there is no oil leak or slackening of the locking bolts.

3ª Configurazione / Configuration

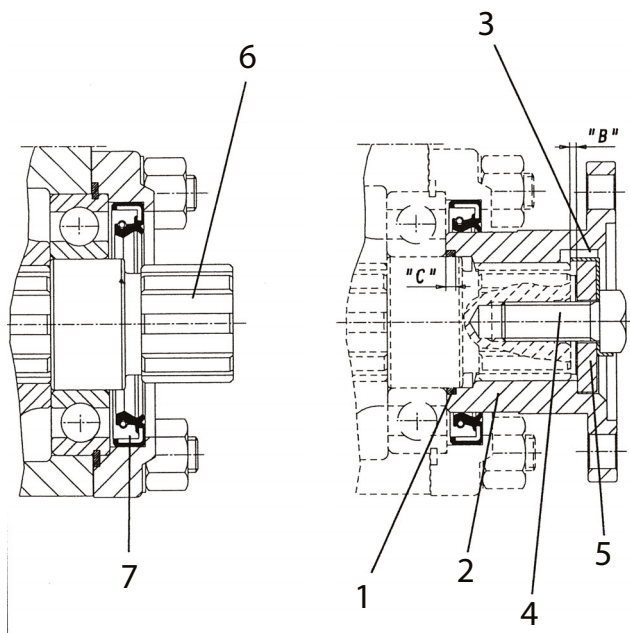


- 1) Smontare il paraolio "2"
- 2) Montare il paraolio "5"
- 3) Verificare che l'anello di tenuta "OR" "7" sia in posizione corretta nella sede della flangia "4"
- 4) Montare la flangia "4"
- 5) Montare la rondella, la rosetta di sicurezza e la vite di chiusura "6"
- 6) Chiudere a coppia (21-27 Nm) con chiave dinamometrica
- 7) Bloccare la vite rivoltando la rosetta di sicurezza
- 8) Controllare dopo qualche ora di funzionamento che non vi siano perdite di olio o allentamenti degli organi di bloccaggio.

- 1) Dismantle the oil-seal "2"
- 2) Fit the oil seal "2"
- 3) Check the correct position of the o-ring "7" in the flange seat "4"
- 4) Fit the flange "4"
- 5) Fit the washers and the screw "6"
- 6) Screw at a torque of 21-27 Nm using a torque wrench
- 7) Lock the screw turning over the safety washer
- 8) Check after a few working hours that there is no oil leak or slackening of the locking bolts

114000**CODICE FAMIGLIA**
FAMILY CODE**ISTRUZIONI DI MONTAGGIO**
KIT FLANGIA PER PTO
FITTING INSTRUCTIONS OF THE
FLANGE KIT FOR PTO**v. 15/16 - 17/18****KIT FLANGIA:**
FLANGE KIT:

11400001070 / 11400001132 / 11400001409 / 11400001230/ 1140001525 / 11400001552

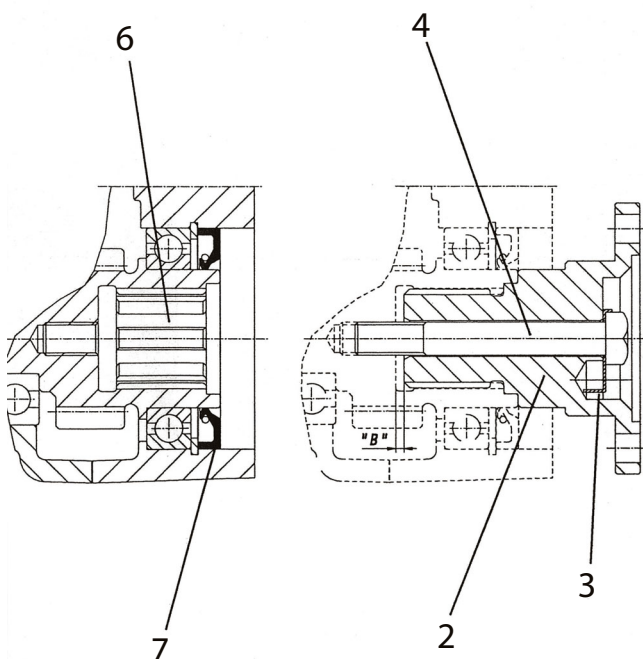


- 1) Verificare l'integrità del paraolio "7" e che sia nella corretta posizione
- 2) Verificare che l'anello di tenuta "OR" "1" sia montato correttamente nella sede della flangia "2"
- 3) Montare la flangia "2"
- 4) Verificare che l'albero "6" e la rondella "5" esista un gioco "B"
- 5) Montare la rosetta di sicurezza "3" e la vite "4"
- 6) Chiudere la vite "4" usando frenafili tipo forte. Coppia di serraggio 65-70 Nm. Usare chiave dinamometrica.
- 7) Bloccare la vite rivoltando la rosetta di sicurezza
- 8) Controllare dopo qualche ora di funzionamento che non vi siano perdite di olio o allentamenti degli organi di bloccaggio.

- 1) Check the integrity of the oil-seal "7" and its correct position
- 2) Check the correct position of the o-ring "1" in the flange "2" seat
- 3) Fit the flange "2"
- 4) Check that there is backlash "B" between the shaft "6" and the washer "5"
- 5) Fit the safety washer "3" and the screw "4"
- 6) Lock the screw "4" with strength threadlocker at 65-70 Nm torque using a torque wrench.
- 7) Lock the screw turning over the safety washer
- 8) Check after a few working hours that there is no oil leak or slackening of the locking bolts

KIT FLANGIA:
FLANGE KIT:

1140001043 / 11400001105 / 11400001427 / 11400001294/11400001516



- 1) Montare la flangia "2"
- 2) Montare la rosetta di sicurezza "3" e la vite "4"
- 3) Chiudere la vite "4" usando frenafili tipo forte. Coppia di serraggio 65-70 Nm. Usare chiave dinamometrica.
- 4) Bloccare la vite rivoltando la rosetta di sicurezza
- 5) Controllare dopo qualche ora di funzionamento che non vi siano perdite di olio o allentamenti degli organi di bloccaggio.

- 1) Fit the flange "2"
- 2) Fit the safety washer "3" and the screw "4"
- 3) Lock the screw "4" with strength threadlocker at 65-70 Nm torque using a torque wrench.
- 4) Lock the screw turning over the safety washer
- 5) Check after a few working hours that there is no oil leak or slackening of the locking bolts

ISTRUZIONI DI MONTAGGIO KIT FLANGIA PER POMPE FITTING INSTRUCTIONS OF THE FLANGE KIT FOR PUMPS

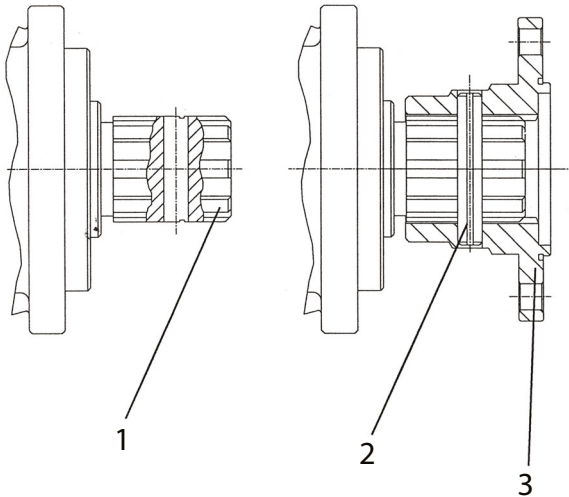
CODICE FAMIGLIA
FAMILY CODE

114000

ISO 32x36

**KIT FLANGIA:
FLANGE KIT:**

11400001089 / 11400001098 / 11400001329
11400001445 / 11400001454 / 11400001034 / 11400001543



- 1) Montare sull'albero "1" la flangia "3"
- 2) Deposare sulla spina elastica "2" alcune gocce di Loctite 270
- 3) Infilare la spina nell'apposita sede dell'albero "1"
- 4) Controllare che la posizione della spina sia correttamente centrata.

- 1) Fit the flange "3" on the shaft "1"
- 2) Put some Loctite 270 on the spring pin "2"
- 3) Put the pin in its housing in the shaft "1"
- 4) Check the correct position of the pin

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99711401015 Rev: AB

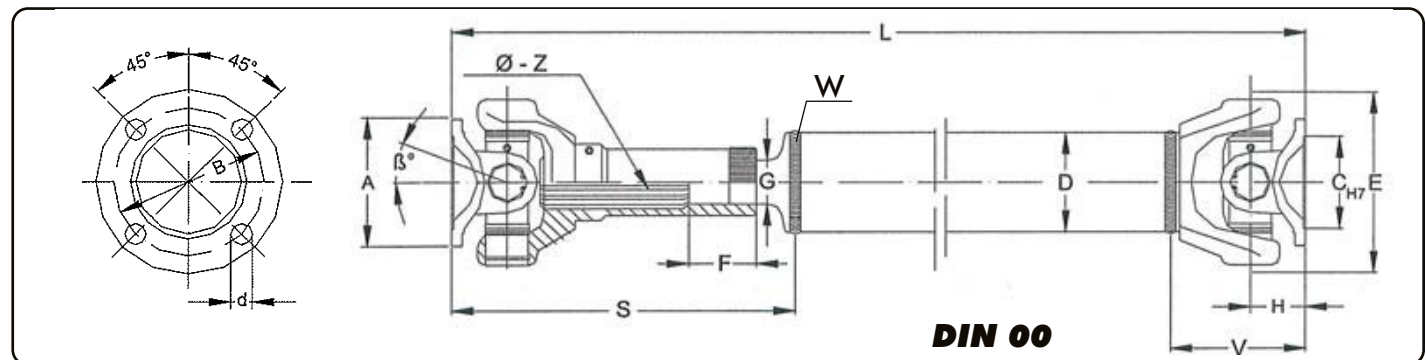
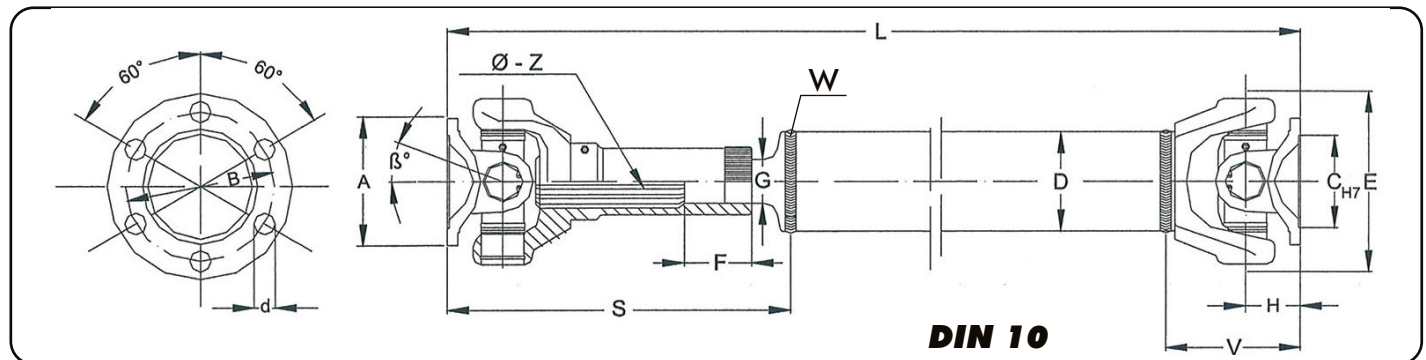
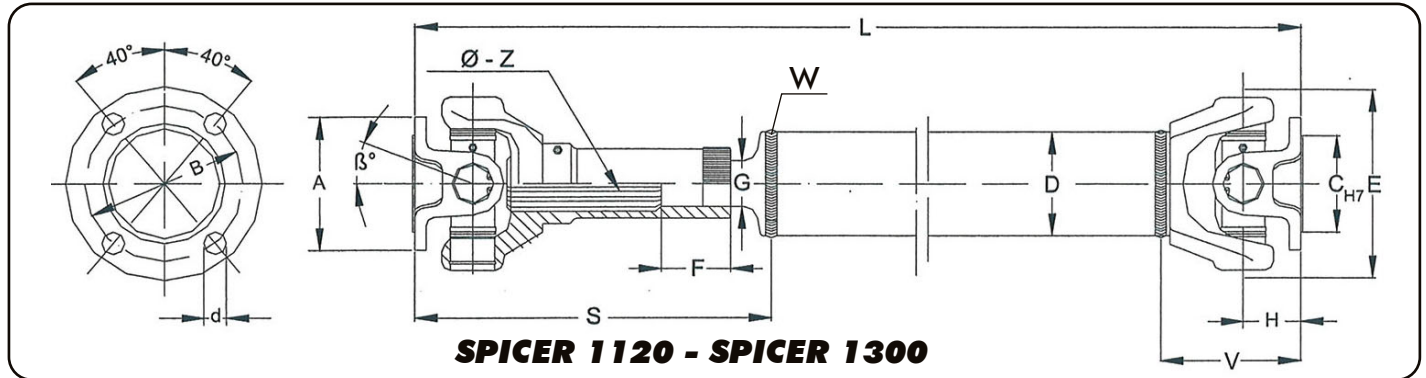
GIUNTI CARDANICI DRIVE SHAFTS

CODICE
CODE

114014

I giunti sono forniti smontati e possono essere saldati alla misura desiderata (compresa tra L min e L max - vedi tabella) nel punto "W". Sono provvisti inoltre di ingrassatore sia sulle crociere che sullo scanalato.
The drive shafts are supplied loose and should be welded at the "W" point according to the required length (included between L min and L max - see table). Grease cups are available both on the joint and on the splined shaft.

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Dati tecnici - Technical data

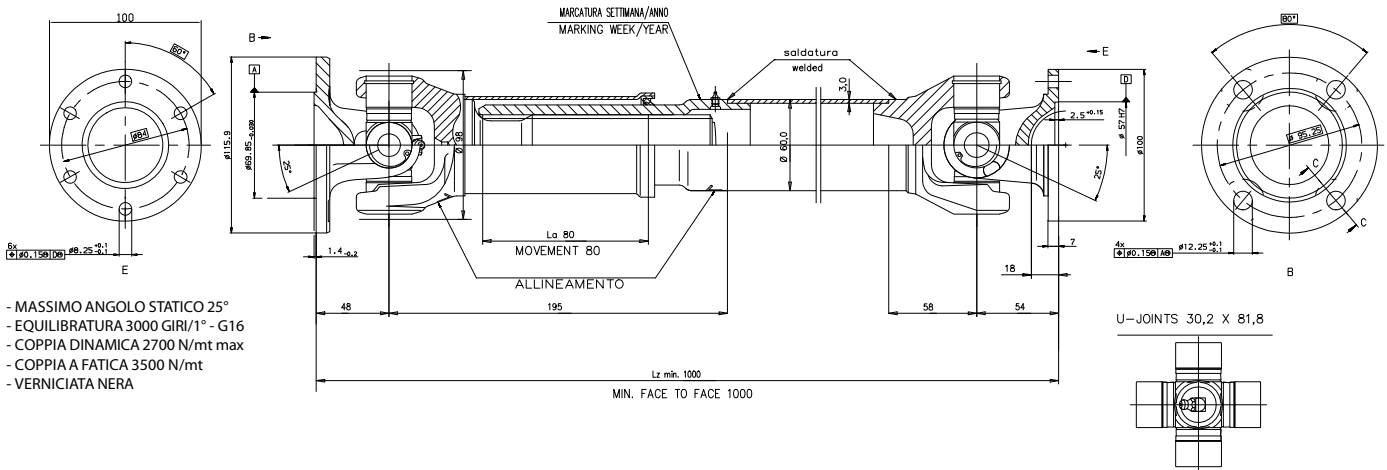
Tipo Type	D	Coppia max.* Max torque	V	S	L min.	L max.	F	H	β°	E	B	C	Fori Holes	d	A	G	Ø	Z
					mm													
SPICER 1120 11401400208	51x2.5	900 Nm	84	192	310	1000	÷40	33	20°	80	69.85	57.15	4	8	88	22.5	27-23	16
SPICER 1300 11401400217	60x2.5	1800 Nm	85	197	310		÷40	37	20°	100	79.40	60.32	4	10	97	29	35-30	
DIN 00 11401400226	51x2.5	900 Nm	96	218	349		÷40	47	22°	100	74.5	47	4	6	90	22.5	27-23	
DIN 10 11401400235	60x2.5	1800 Nm	96	232	354		÷40	50	28°	96	84	57	6	8	100	29	35-31	

* Valore nominale influenzato da diversi fattori. Per un corretto dimensionamento contattare il nostro servizio tecnico commerciale.

* Nominal value only that can be affected by different factors. Please consult our sales dept, for a proper dimensioning.

99711401430 Rev:AG

11401470008



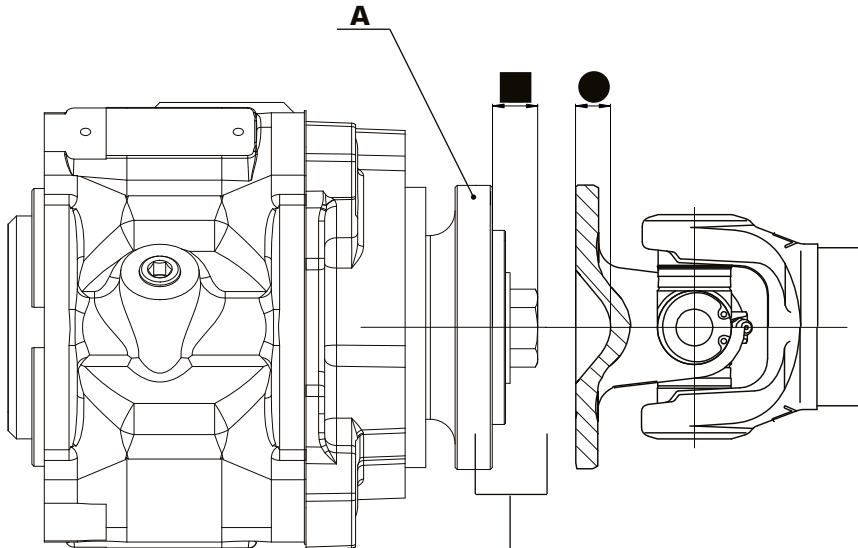
SPICER 1410 - DIN00

ATTENZIONE:

LE FLANGE DI CONTROPARTE "A" NON DEVONO AVERE SPORGENZE ■ CON SPessori MAGGIORI DEI CENTRAGGI ●. QUALORA CI SIANO SPORGENZE MAGGIORI, É NECESSARIO COMUNICARLO, PER POTER FORNIRE GIUNTI DEDICATI AGLI INGOMBRI RISCONTRATI.

ATTENTION !

COUNTERPART FLANGE MUST NOT HAVE PROJECTION ■ WITH THICKNESS HIGHER THAN THE CENTERING ●. IN CASE FLANGE PROJECTION IS HIGHER THAN CENTERING GET IN TOUCH WITH OMFb IN ORDER TO SELECT AN APPROPRIATE DRIVE SHAFT.



**SPORGENZA NON NORMATA
PROJECTION NOT ACCORDING TO ANY NORM**

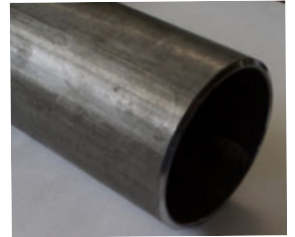
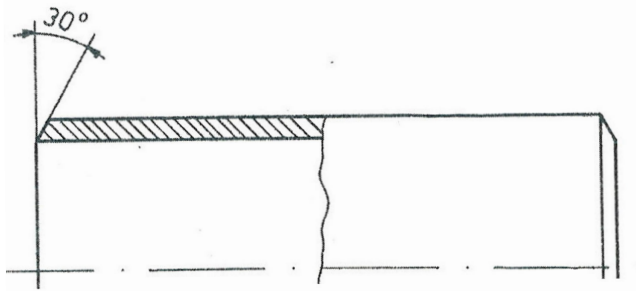
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OPERAZIONI DI SALDATURA / WELDING OPERATION

Preparazione del tubo:
Intestare il tubo

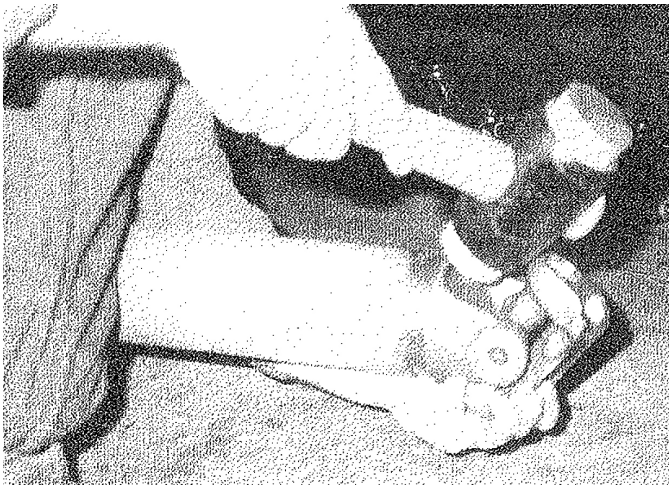
Pipe preparation:
lining the pipe



Preparazione della trasmissione prima della saldatura:

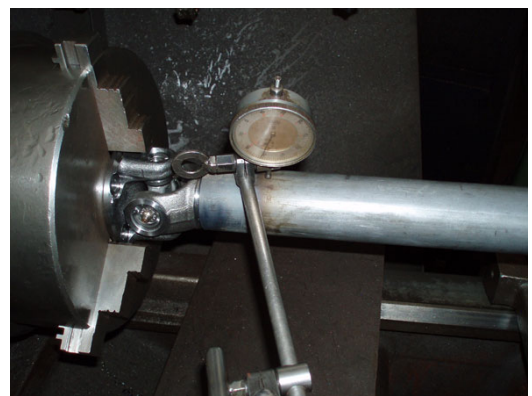
Innestare i due giunti con la pressa orizzontale. In mancanza della stessa, per tubi fino ad uno spessore di mm 2,4 innestare i giunti a colpi di mazzuolo.

Transmission preparation before welding: join the two couplings with a horizontal press. If you don't have one, you can join the pipes until a thickness of 2,4 mm with mallet strokes.



Per tubi con spessore superiore a mm2,4 scaldare con il cannello (non oltre i 300°C). Rispettare sempre l'allineamento delle forcelle (tolleranza max +/- 1°). Per il controllo allineare due punzoni appoggiati sui cuscinetti. Per saldare, montare la trasmissione su due controflange corrispondenti all'attacco delle flange.

For pipes thicker than 2,4 mm, heat up with a welding torch (not more that 300°C). Always maintain the brackets alignment (max tolerance +/- 1°). To check, put two punches on the bearings and line them up. To weld, mount the transmission on two counter-flanges corresponding to the flange junction.

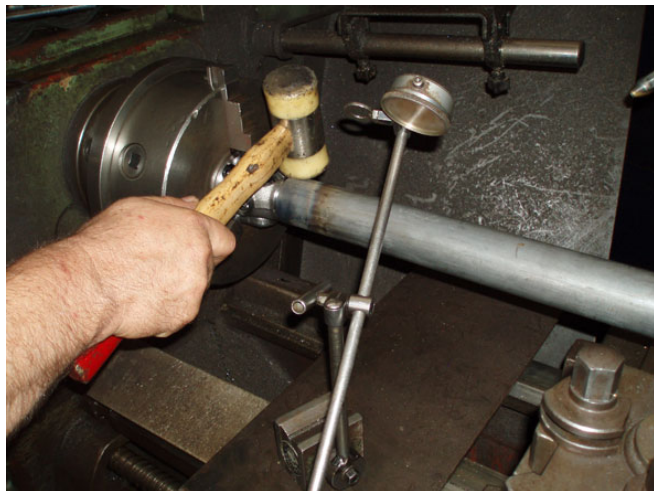


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99711401430 Rev:AG

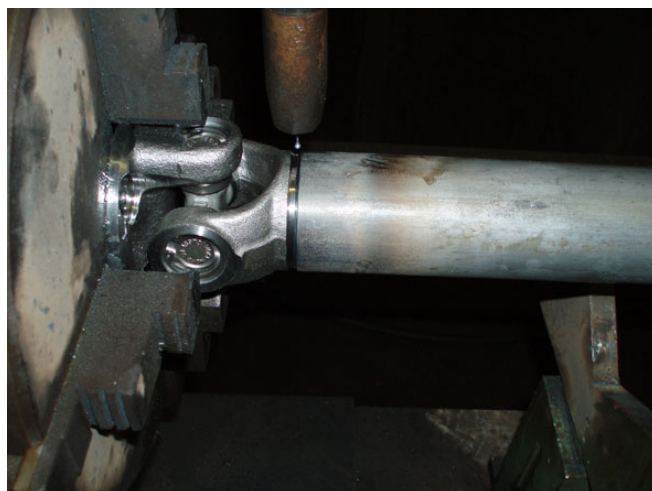
Controllare l'eccentricità della trasmissione con il comparatore, assestando con tolleranza da mm 0 a +0,2

Check the transmission eccentricity with a dial gauge, adjusting with a tolerance from 0 to +0,2 mm



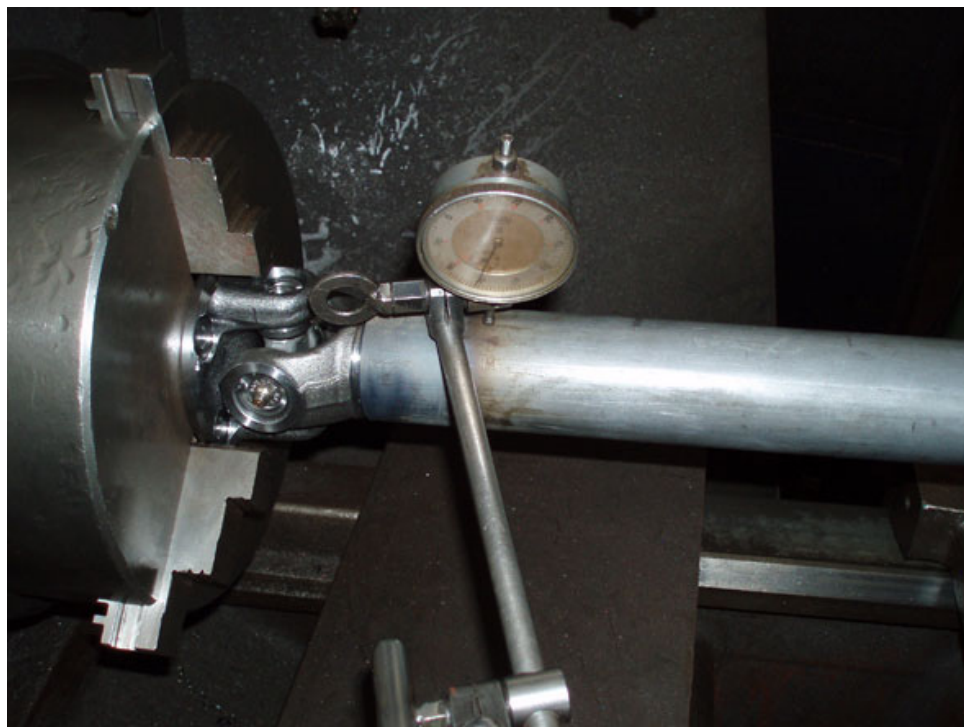
Rilevare il punto massimo di eccentricità per effettuare in tale posizione l'inizio della saldatura.

Detect the maximum point of eccentricity to start the welding in this position.



Dopo la saldatura ricontrollare l'eccentricità, con il comparatore e, se necessario, raddrizzare la trasmissione con la pressa.

After welding, double check the eccentricity with the dial gauge and, if necessary, straighten the transmission with the press.



Chi non fosse munito di pressa deve seguire la seguente procedura:

- fare quattro punti di saldatura disposti a 90° senza variare l'eccentricità.
- saldare.
- controllare nuovamente l'eccentricità ammessa dai valori in tabella nella pagina successiva.

If you don't have a press, you have to follow the below described procedure:

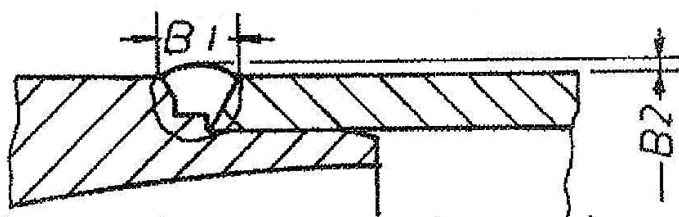
- make 4 welding holes disposed at 90° without varying the eccentricity
- weld
- double check the eccentricity allowed by the values as per table reported in the next page

Tolleranza massima (mm) Maximum tolerance (mm)	Posizione sulla trasmissione Position on the transmission
0 ÷ 0,15	Sul collo dello scorrevole On sliding pipe neck
0 ÷ 0,25	A ciascuna estremità del tubo e a 40mm dalle saldature At each pipe ending and at 40mm from welding points
0 ÷ 0,25	A metà del tubo per trasmissioni fino ad un metro At half pipe for transmission until 1 mt
0 ÷ 0,45	Come sopra per lunghezze oltre un metro Same as above for transmissions longer than 1 mt
0 ÷ 0,05	Sull'alloggiamento cuscinetto, per semitrasmiss. On the bearing housing, for semi-transmissions.

Saldatura / Saldatura

La saldatura viene effettuata con filo diametro 1,2mm secondo le norme previste. Parametri per la saldatura stessa: vedi tabella successiva. (Tabella indicativa perchè può variare secondo caratteristiche della saldatrice).

The welding is carried out with a wire of diameter of 1,2 mm in compliance with regulations. Parameters for the welding itself: see next table (Indicative table which can vary according to the welder features)



Tubo (mm) Tube (mm)	Volts	Amp.	Velocità rotaz. Rotation speed	Passate Welding passes	Filo fuori il guardafilo Wire out of wireman	Miscela L/min. Mixture L/min	Largh. sald. (B1) Welding width	Sporg.sald. (B2) Welding protrusion
120x6	30-31	260-270	*	1	15-18	18-20	18	2.8
110x6	30-31	260-270	*	1	15-18	18-20	18	2.8
100x6	30-31	260-270	*	1	15-18	18-20	18	2.8
90x5.5	30-31	260-270	*	1	15-18	18-20	15	2.5
90x4.5	30-31	260-270	*	1	15-18	18-20	15	2.5
85x5	30-31	260-270	*	1	15-18	18-20	15	2.5
80x4	27-28	240-250	*	1	15-18	18-20	12	2.2
80x2	21	180	*	1	8-10	12-15	10	1.9
76.2x2.25	22	190	*	1	8-10	12-15	10	1.9
70x3	24	220	*	1	15-18	18-20	10	2.0
70x2.5	23	200	*	1	8-10	12-15	8	1.8
70x2	21	180	*	1	8-10	12-15	8	1.8
60x2	21	180	*	1	8-10	12-15	8	1.8
50x3	24	220	*	1	8-10	12-15	10	2.0
50x2	22	180	*	1	8-10	12-15	8	1.8
40x2	21	180	*	1	8-10	12-15	8	1.8
32x1.5	20	160	*	1	8-10	12-15	6	1.6
28x1.5	20	160	*	1	8-10	12-15	6	1.6

* Velocità rotazione secondo variatore montato Rotation speed according to mounted dimmer

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Архангельск (8182)63-90-72
Астрахань (8512)99-46-04
Барнаул (3852)73-04-60
Белгород (4722)40-23-64
Благовещенск (4162)22-76-07
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Симферополь (3652)67-13-56
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Киргизия +996(312)96-26-47

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