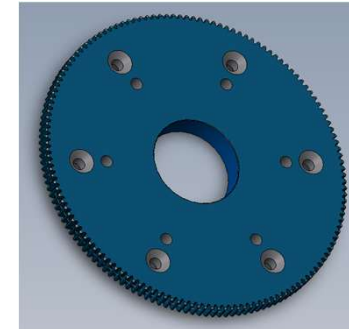


glass technology



Edge removal

Replacement spur gear Z=140



Replacement spur gear Z=140

Required material:



- Spur gear Z=140
31-4026-2030



- Spur gear Z=20
31-4026-2020



- Plugs / pins
31-4084-3100



- soldering iron



- 6-point angle
screwdriver 1/16"



- Spanner
60mm



- Locksmith

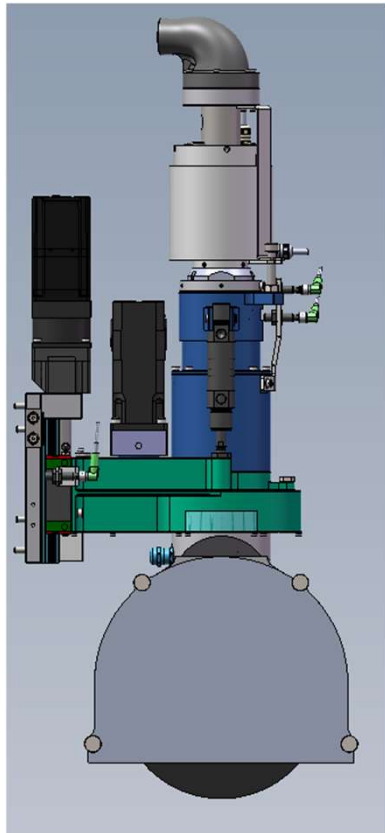


- Hammer

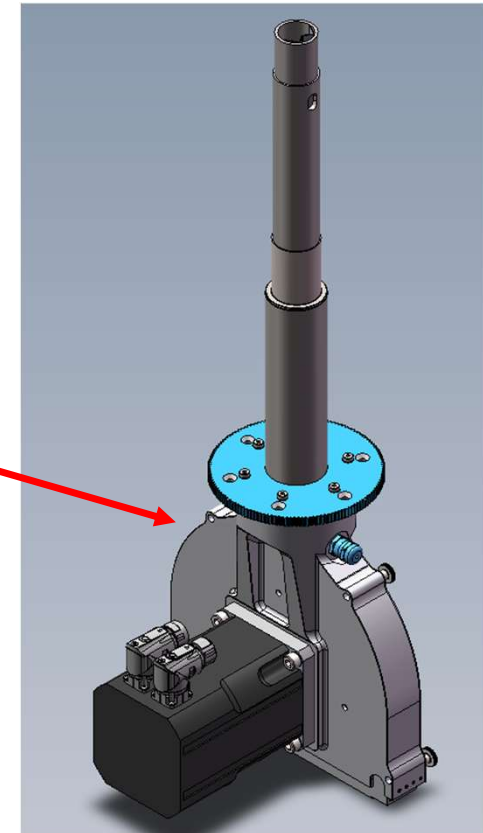


- Loctite screw
locking

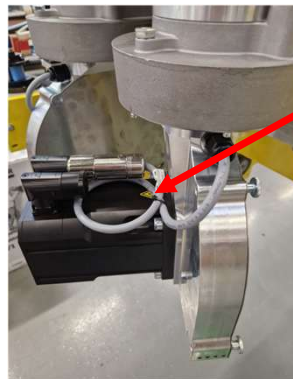
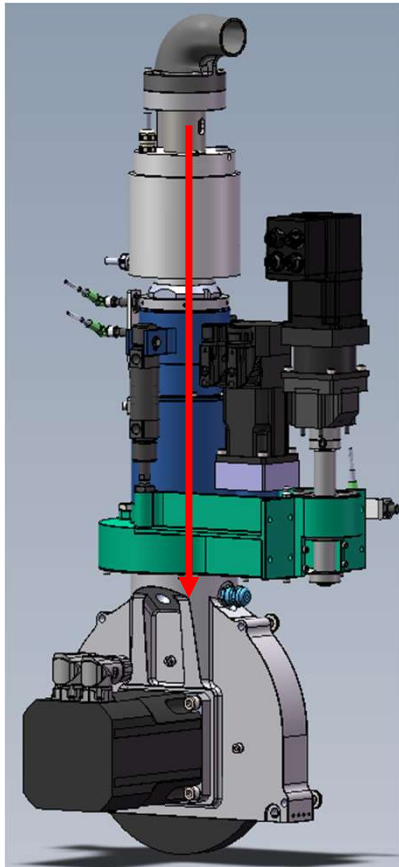
Replacement spur gear Z=140



- In order to replace the spur gear, the rotor unit must be removed.
- In addition:

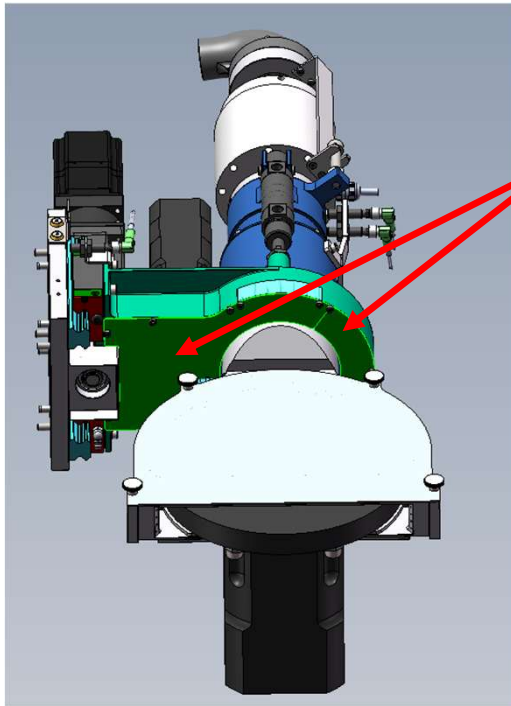


Replacement spur gear Z=140

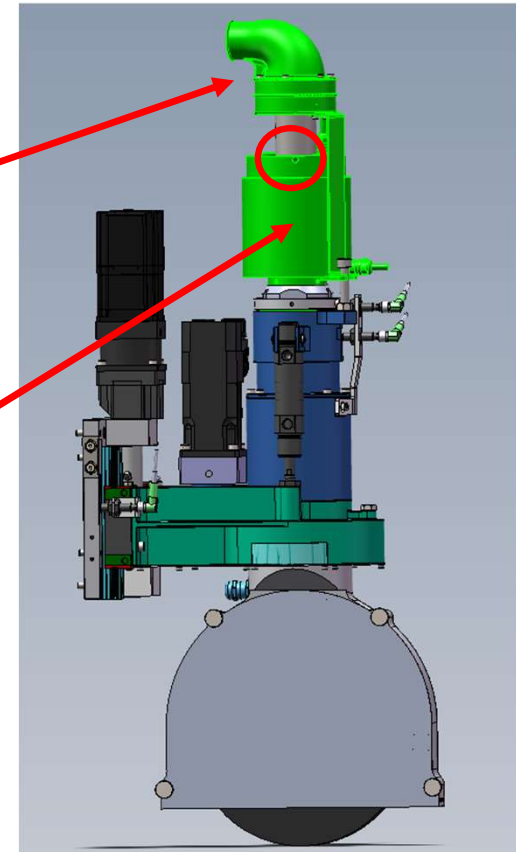


- The cable from the slip ring transmitter is guided through the guide shaft.
- To disassemble, the cable must be removed.
- To do this: Disconnect the plug from the cable. If new pins and crimping pliers are available, cut off the pins. Otherwise, cut the cable so that it can be soldered afterwards.
- Then pull the cable upwards out of the guide shaft.

Replacement spur gear Z=140

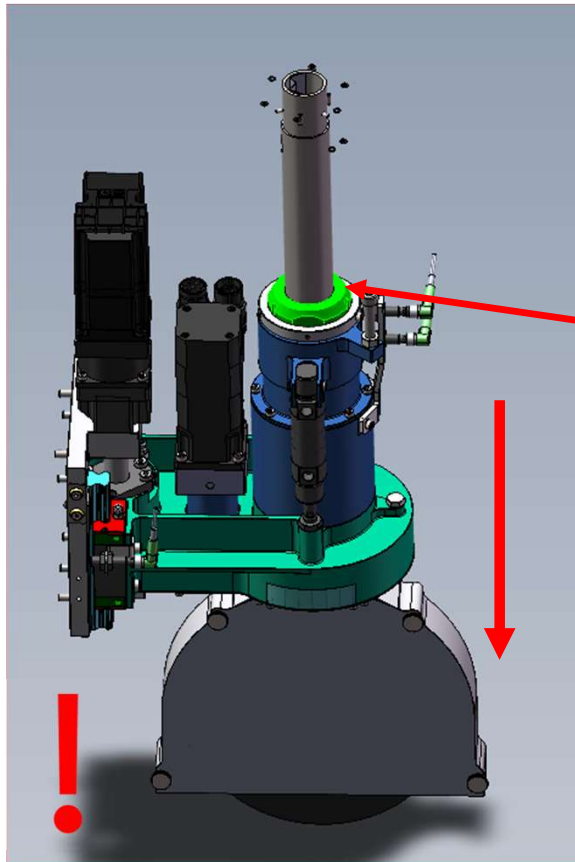


- Remove the bottom covers.
- Remove:
 - Suction rotor
 - and
 - Slip ring transmitter

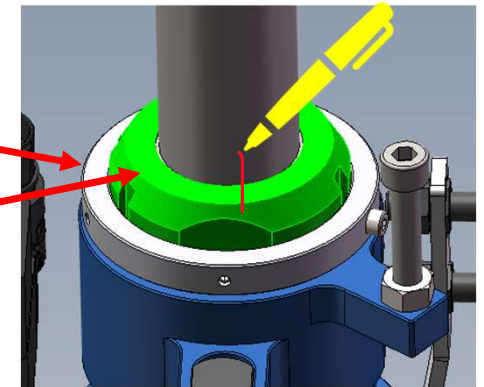


6-point key wrench 1/16 inch

Replacement spur gear Z=140

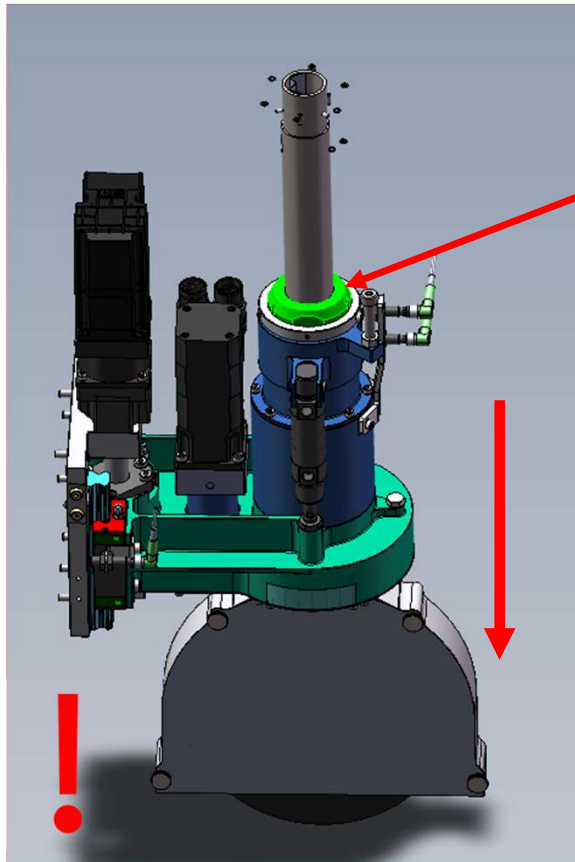


- First mark the position of the adjusting ring cam, then remove it.
- Loosen the shaft nut.
- **Danger!**
- The rotor unit sinks downwards.
- Secure against falling out.

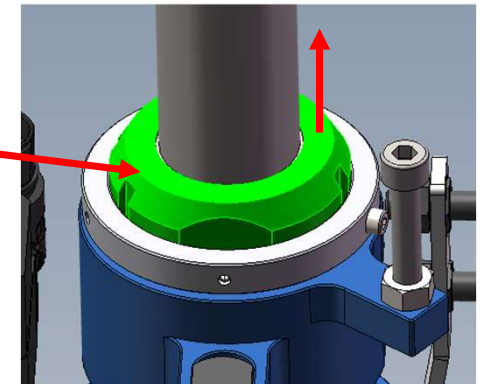


- Spanner 60mm

Replacement spur gear Z=140

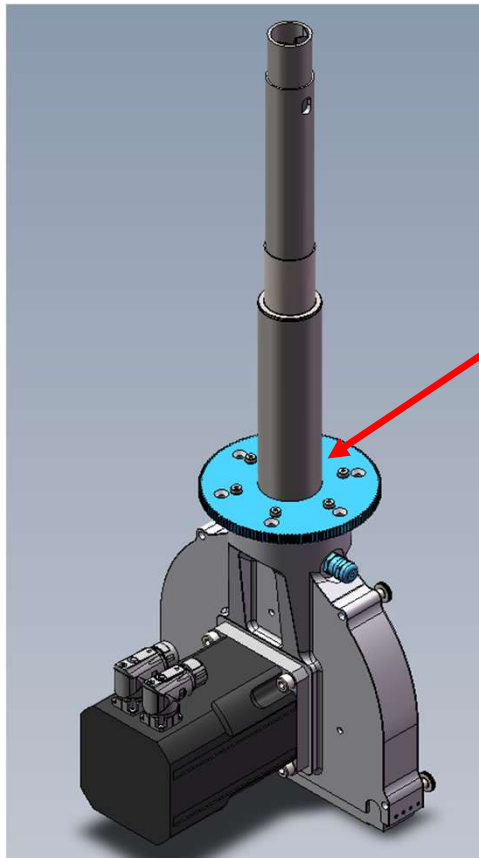


- The shaft nut upwards and remove the rotor unit.

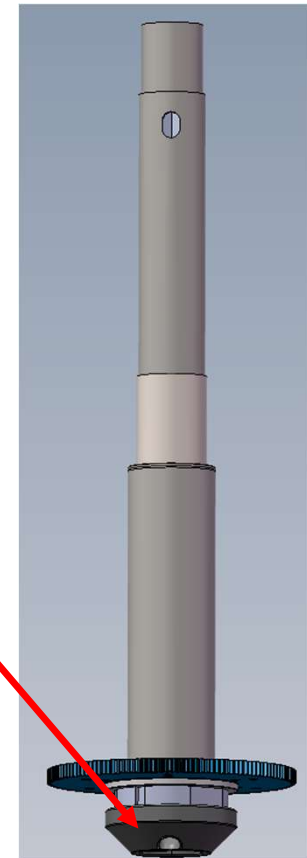


- Spanner 60mm

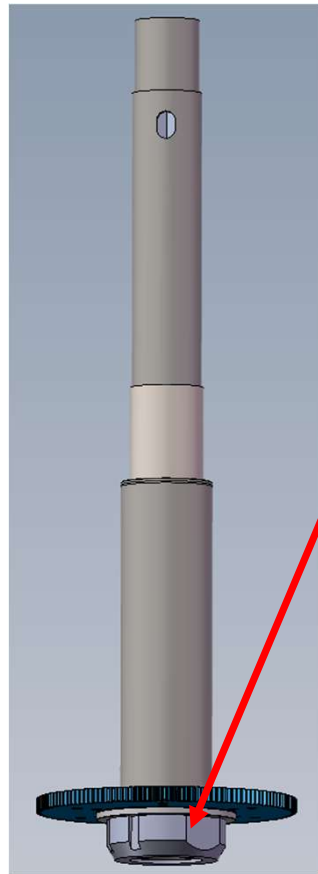
Replacement spur gear Z=140



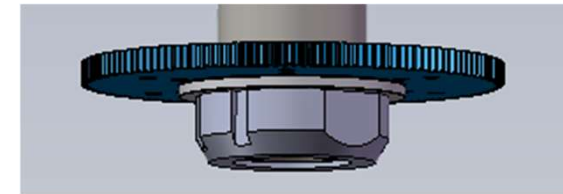
- After removing the guide shaft, dismantle the spur gear and remove the suction duct.



Replacement spur gear Z=140



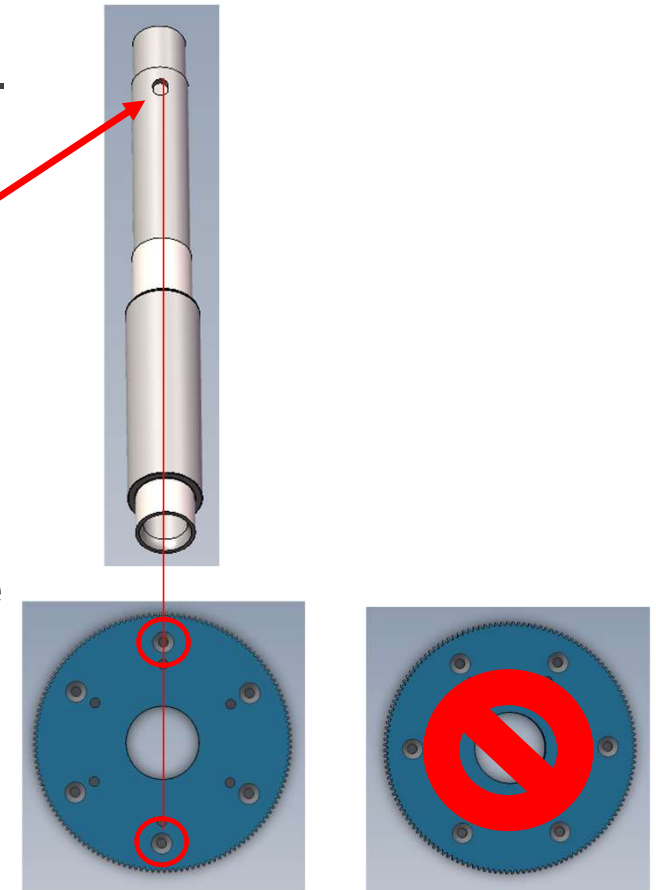
- Loosen the lower shaft nut.
- It is possible that a punch with a hammer must be used for this.



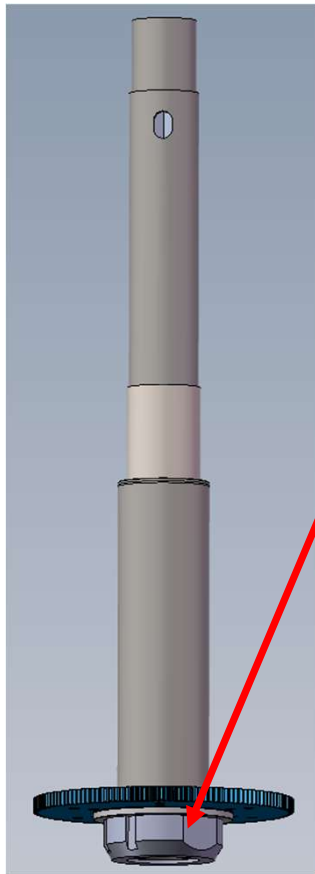
Replacement spur gear Z=140



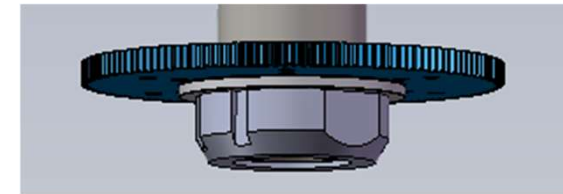
- The spur gear can now be replaced.
- When fitting the new spur gear, the cable feedthrough and the arrangement of the drilling pattern must be observed. The holes at the top should be aligned with the cable feedthrough.



Replacement spur gear Z=140



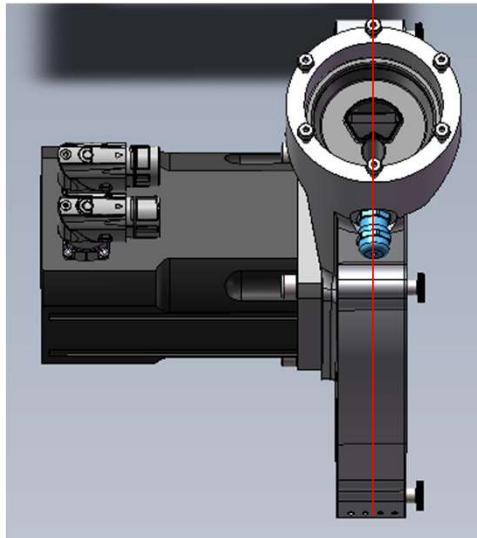
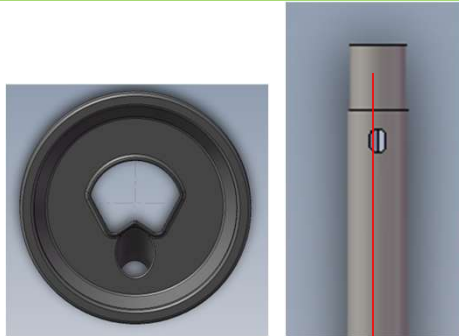
- Put on the lower shaft nut and fix it.
- Danger!
- The shaft nut must also be secured with a punch. Simply securing it with a 60mm open-end wrench is not enough!



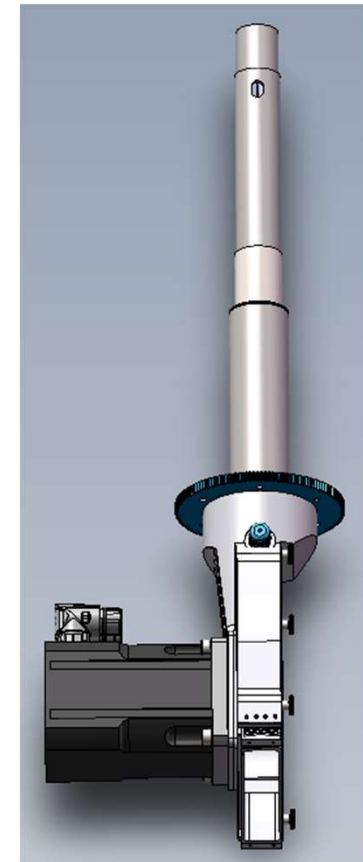
- The grub screws must be additionally secured with Loctite.



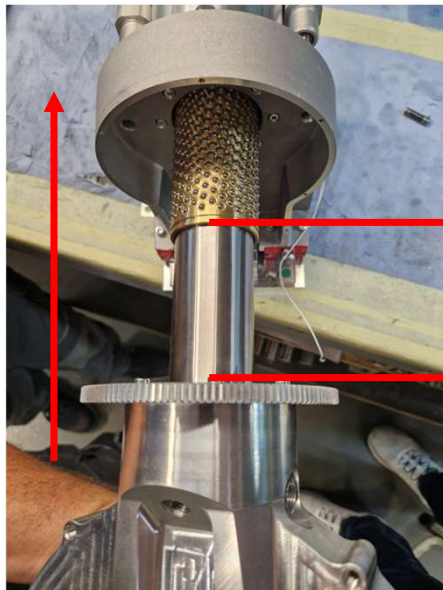
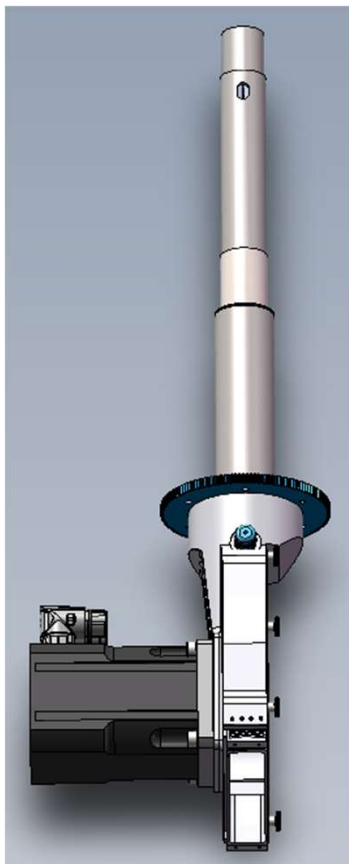
Replacement spur gear Z=140



- The suction duct, the suction apron and the guide shaft must be aligned for cable routing.
- Insert the guide shaft including the spur gear and screw it in place.



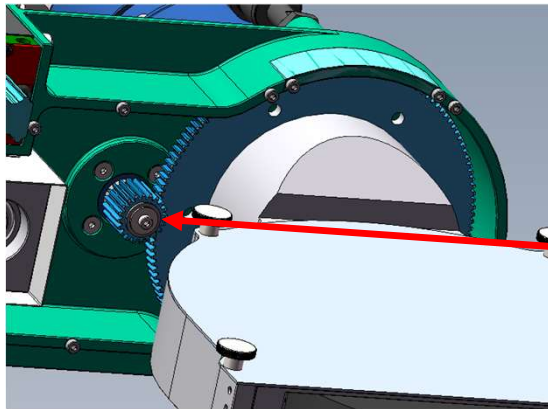
Replacement spur gear Z=140



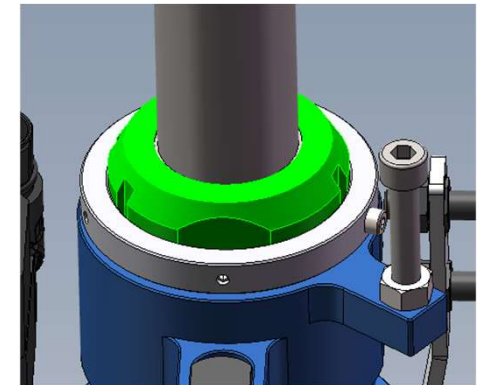
90mm

- Grease the roller guide with multi purpose grease I (32-0001-1200) onto the guide shaft with the recess facing downwards.
- When inserting the guide shaft, the distance between the spur gear and the roller guide must be 90 mm.

Replacement spur gear Z=140



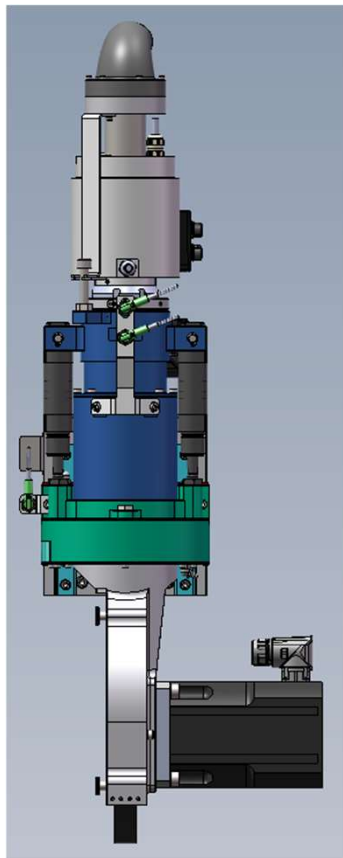
- When installing the rotor unit must be checked that the teeth with the small Spur gear mesh. Then return everything back to its original state.



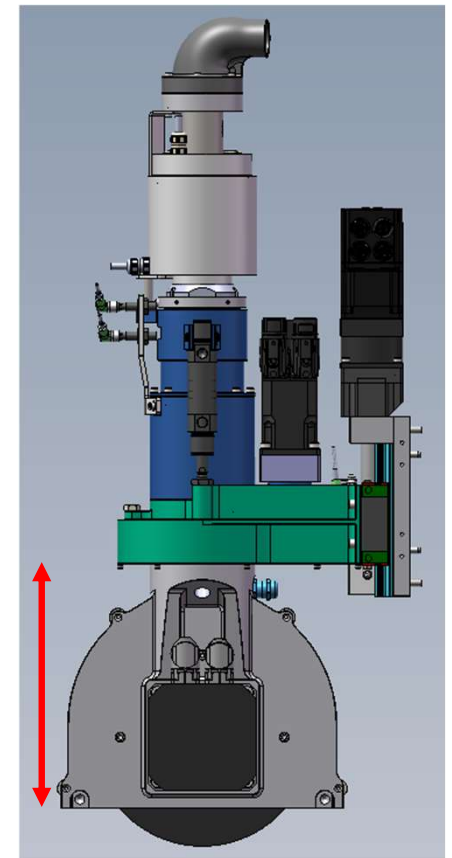
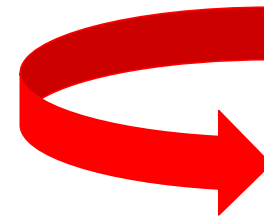
- The grub screws must be additionally secured with Loctite.



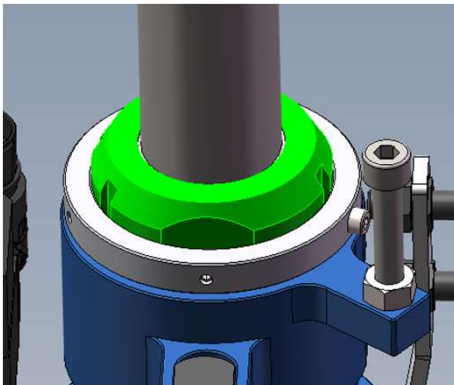
Replacement spur gear Z=140



- The grub screws on the slip ring transmitter must be additionally secured with Loctite.
- Rotate the grinding head into all positions and move it up and down against the pressure of the two cylinders.



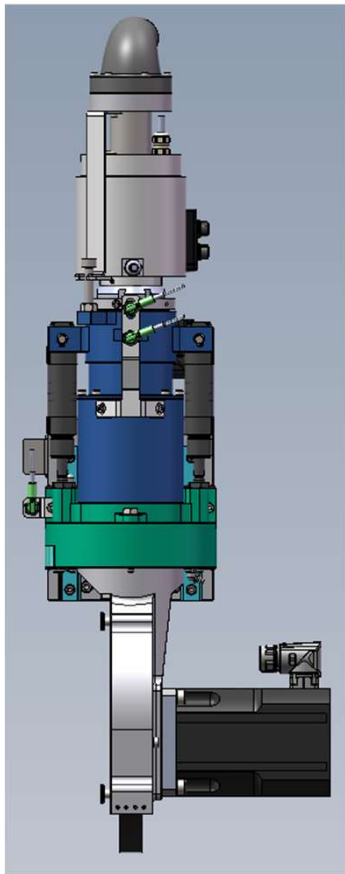
Replacement spur gear Z=140



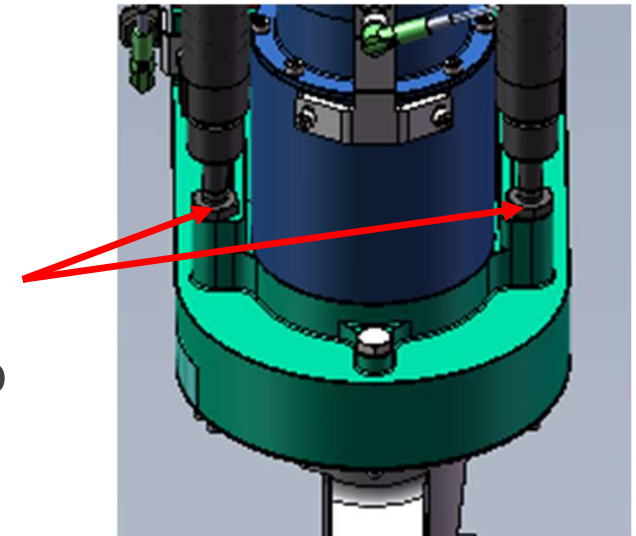
- The adjusting ring cam used for referencing must be aligned with the rotor unit. If necessary, turn the cam before fixing it.
- Glue the screws on the adjusting ring cam with Loctite.



Replacement spur gear Z=140



- If the grinding head is difficult to move up and down in one position, loosen the lock nuts on the piston rods of the cylinders, move them up and down again and fix them again.



Vielen Dank für Ihre Aufmerksamkeit!

Many thanks for your attention!



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