

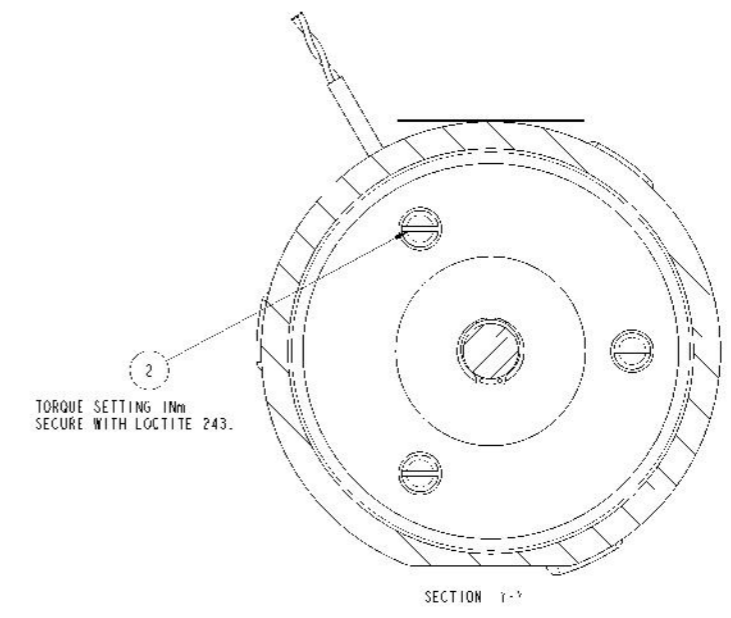
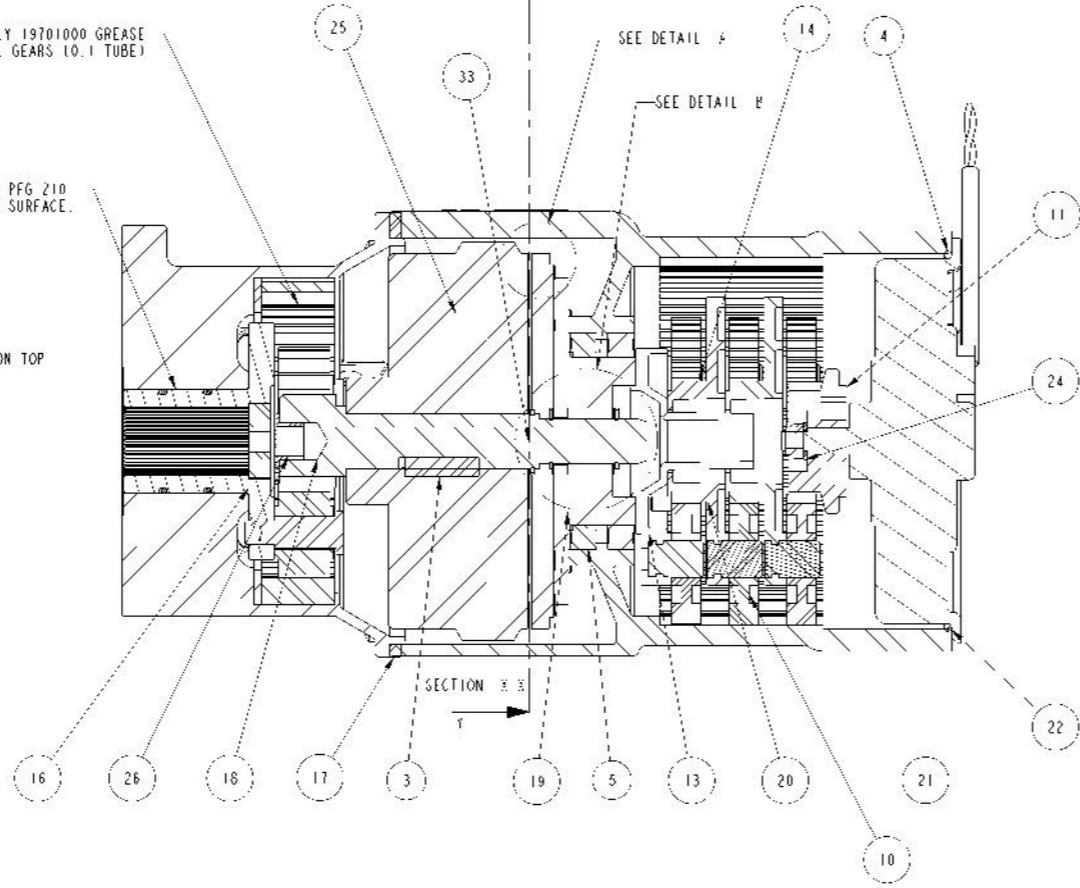
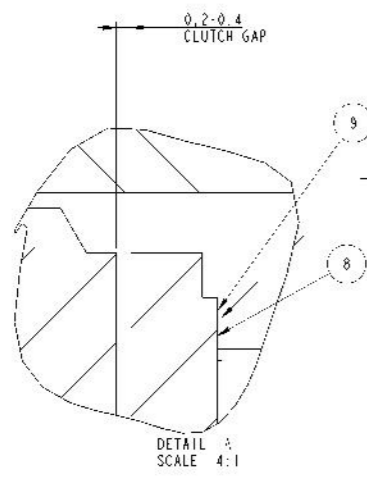
FIRST ANGLE PROJECTION

ISSUE	REVISION	MOD No.	DATE
G	SEE MOD SHT	14177	25-OCT-12

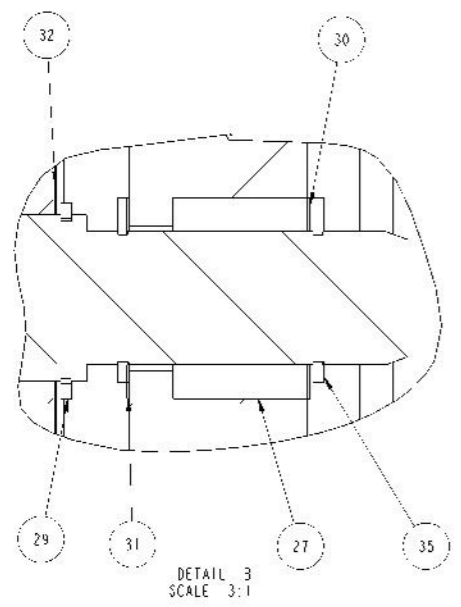
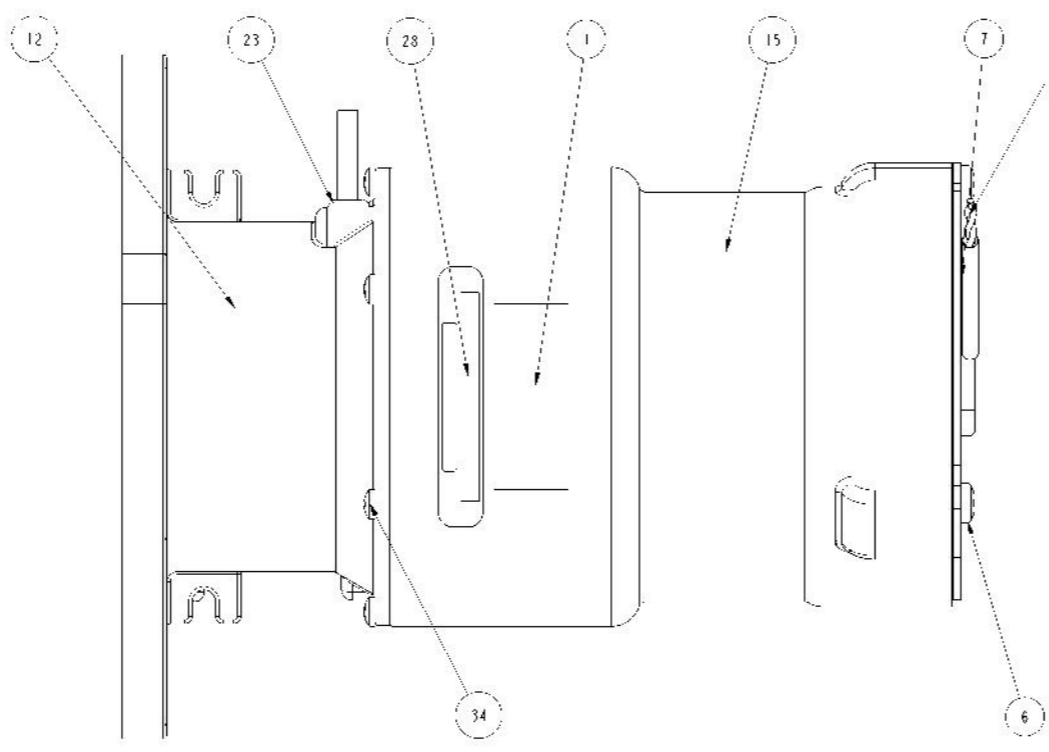
APPLY 19701000 GREASE TO STEEL GEARS (0.1 TUBE)

REMOVE ALL BURRS AND SHARP EDGES

APPLY GREASE PFG 210 TO BEARING SURFACE.

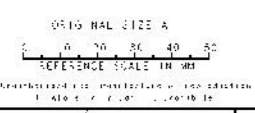


- SHIMMING INSTRUCTIONS
1. SHIM CLUTCH GAP TO 1MM WITH STEEL SHIMS.
  2. ADD PLASTIC SHIMS (ITEM 8 AND 9) BETWEEN ADAPTOR PLATE AND CLUTCH PLATE TO REACH FINAL CLUTCH GAP.



35	B9956	D1400.0120_ CIRCLIP	STAINLESS STEEL	2
34	B4114	POSI PAN HD SCREW	St. Steel	6
33	B2458	STEEL SHIM 25X15 X 0.1	STEEL	1
32	B2457	STEEL SHIM 25X15 X 0.2	STEEL	1
31	B2456	STEEL SHIM 18X12 X 0.2	STEEL	2
30	B2455	STEEL SHIM 18X12 X 0.1	STEEL	1
29	B2343	CIRCLIP	STAINLESS	1
28	B2196-4	LABEL	N/A	1
27	B13650	NEEDLE ROLLER BEARING K 12X18X12 TN	TBD	1
26	B12926	IGUS BEARING	TBD	1
25	B12767	S&G S210 CLUTCH	N/A	1
24	B1210	WASHER	S/S	1
23	B12044	CABLE GROMMET	TBD	1
22	B12043	O RING	TBD	1
21	B1078-A4	M5 NYLOC NUT A4	TBD	1
20	B0744	SOCKET HD CAP SCREW	A2	4
19	85008924	CLUTCH ADAPTOR PLATE	6082 T6	1
18	85008923	INTEGRA SUN GEAR	304 S15	1
17	85008922	HOUSING GASKIT	SEE NOTE	1
16	85008920	OUTPUT SHAFT ASSY	AS STATED	1
15	85008916	INTEGRA MAIN BODY	PA6035+MB015A	1
14	85008914	CARRIER	NYLON 6 30% G/F - NATURAL	2
13	85008913	CARRIER	NYLON 6 30% G/F - NATURAL	1
12	85008912	LOWER HOUSING ASSY	20XGF P'PRO GB205U	1
11	85005253	OUTPUT GEAR	NYLON 6	1
10	85005252	PLANET GEAR	ACETAL	9
9	85000507	1/4 & 1/2 HP CLUTCH 0.010" SHIM	TBD	1
8	85000505	1/4 & 1/2 HP CLUTCH 0.002" SHIM	TBD	1
7	82100029	HEAT SHRINK TUBING	TBD	1
6	82001406	PAN HD POSI No 12 x 1"	A2	3
5	82001372	BRG 61809 2RS	TBD	2
4	82001333	MOTOR 12V DC	TBD	1
3	82000573	5x5x20 KEY	TBD	1
2	82000224	M5x6 SLOTTED PAN HD	A2	3
1	66300044	LABEL	POLYESTER	1
ITEM	PART No.	DESCRIPTION	MATERIAL	QTY

PART No. 89300137



TORQUE SETTING 1Nm APPLY GREASE PFG 210 TO ALL PLANET GEARS AND BEARING SURFACES.

ADDITIONAL REQUIREMENTS  
B12596 INSTRUCTION MANUAL (1 OFF)  
B12441 BOX (1 OFF)

MATERIAL AS STATED	ALL DIMENSIONS IN mm TOLERANCES (UNLESS STATED) LINEAR ± N/A ANGULAR ± N/A	DRN JO DATE 14-Mar-08 SCALE 1:1	TITLE INTEGRA BASE DRIVE UNIT PART No. 89300137
FINISH CLEAN	MOBIL NAME: 89300137		THE PAPER