

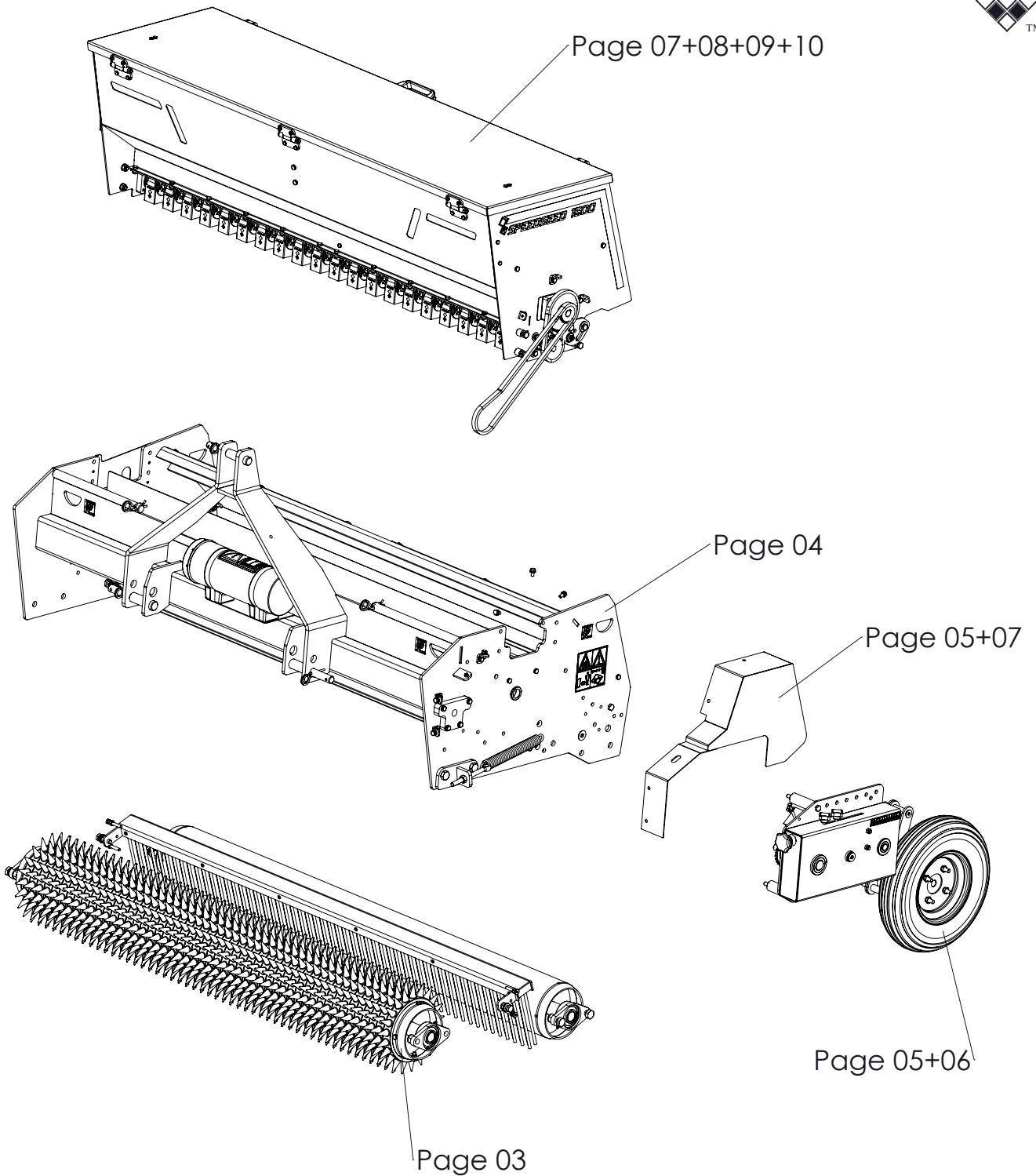
# ***SPEEDSEED 1100-1500***



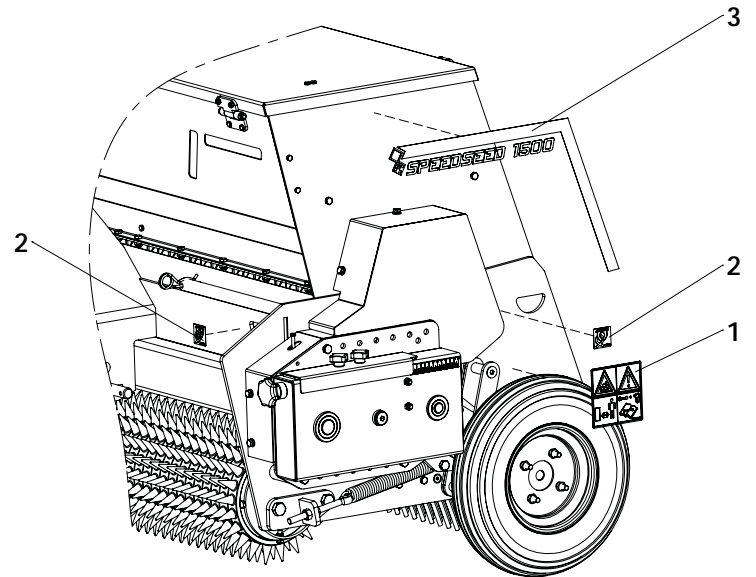
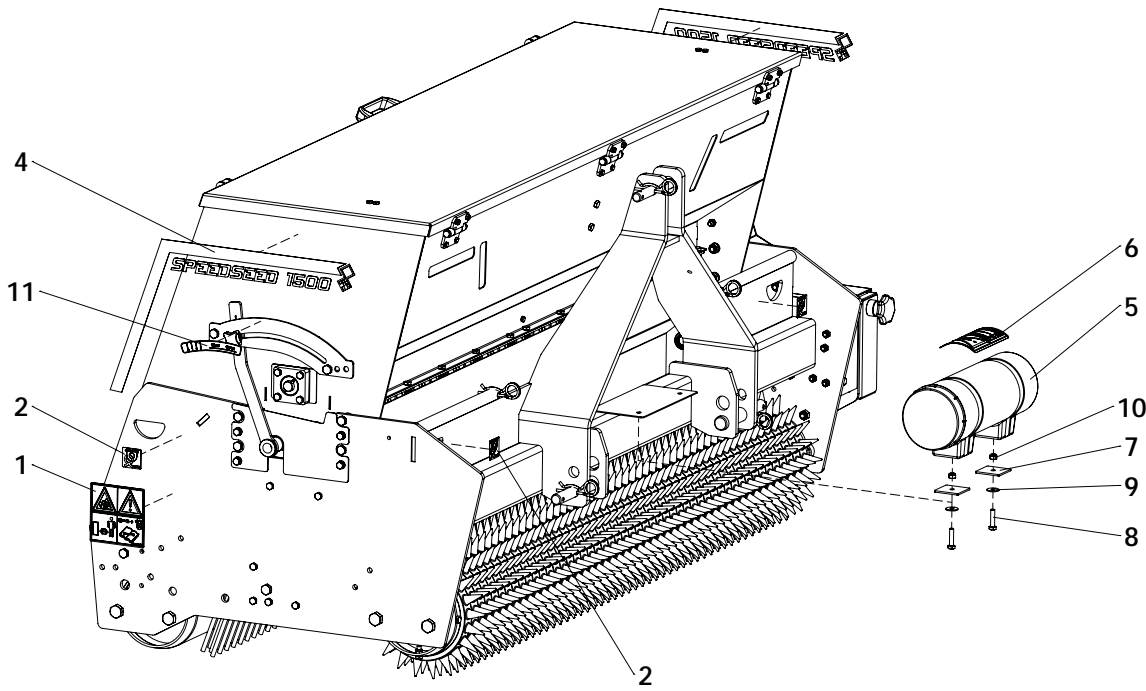
Version: 2242



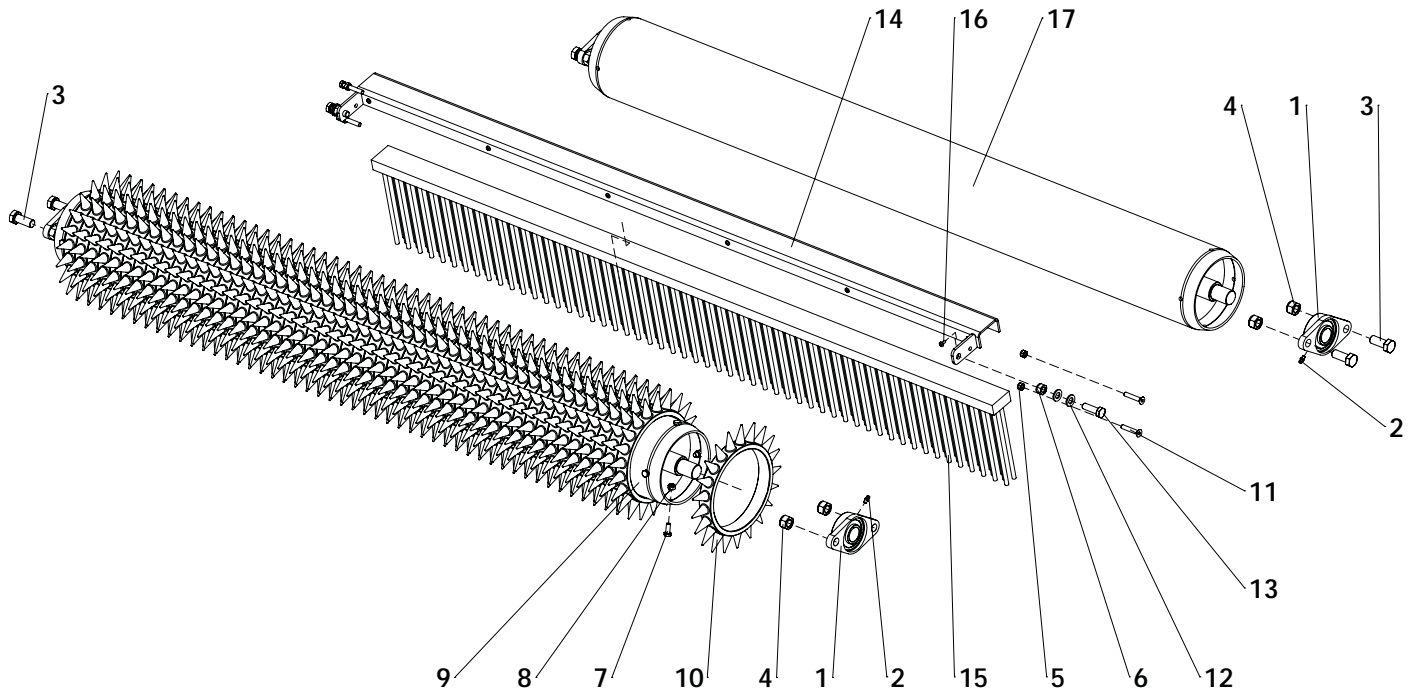
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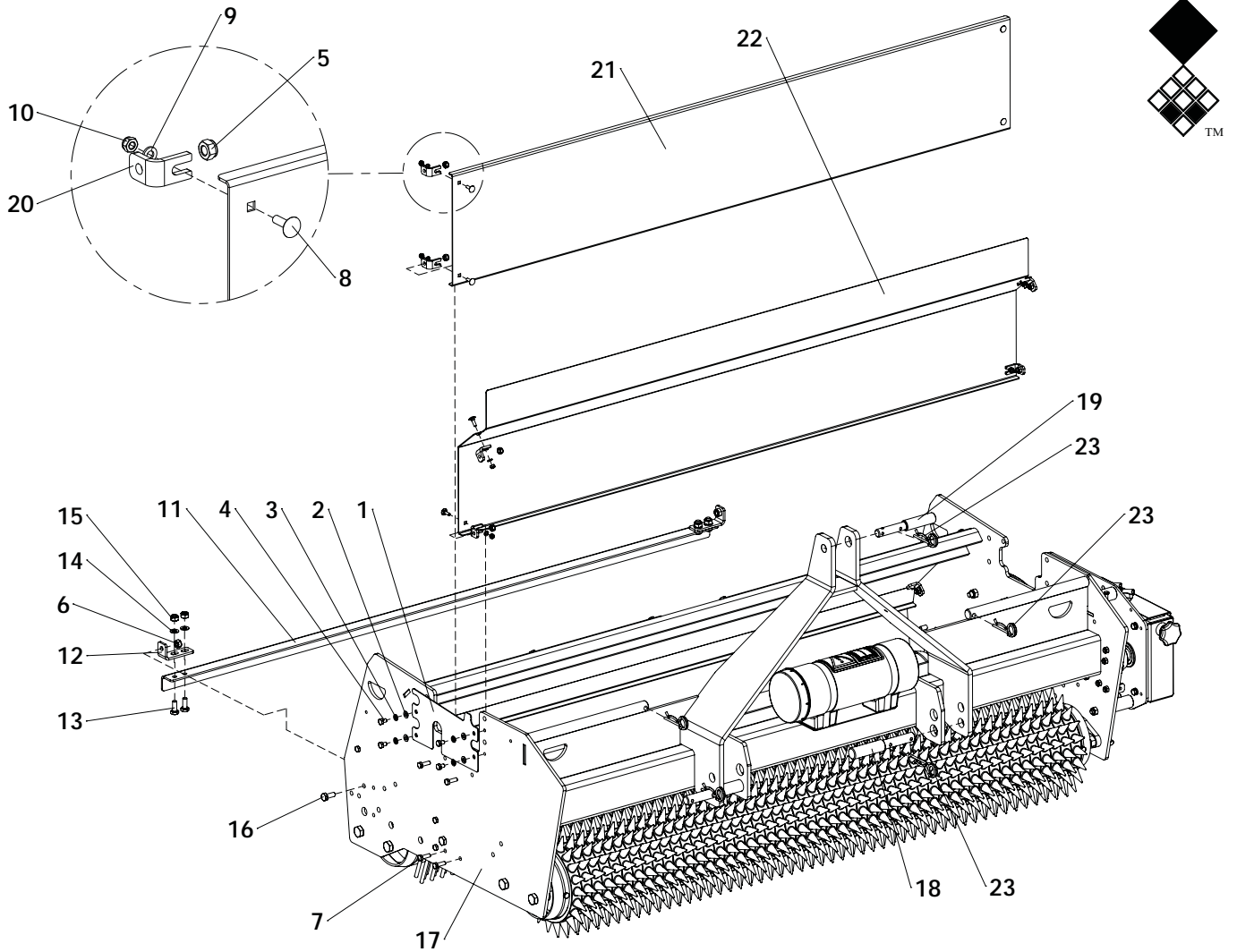
Page 11 - Option: Rear roller with spikes  
Page 12 - Option: Brush scraper complete  
Page 13 - Option: Crushing rear roller  
Page G1: Gearbox



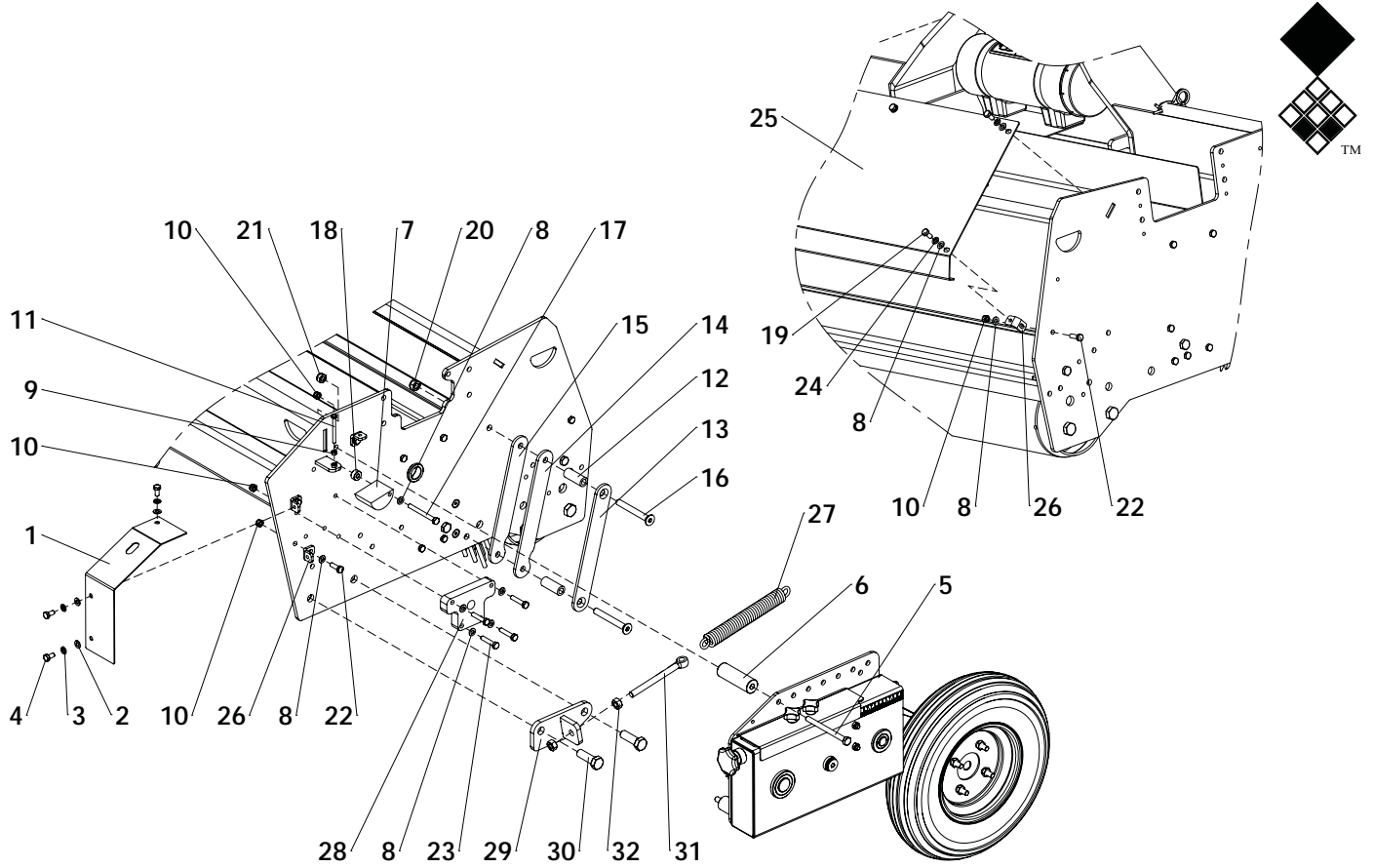
ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA 1100	QUA 1500
1	921.280.402	Safety decall VS		2	2
2	922.340.008	Decall fixation point		4	4
3	900.260.002	Label speedseed 2000 left		0	1
	900.260.000	Label speedseed 2300 left		1	0
4	900.260.003	Label speedseed2000 right		0	1
	900.260.001	Label speedseed 2300 right		1	0
5	444.803.100	Toolbox Complete		1	1
6	900.280.402	Safety decall manual		1	1
7	468.030.530	Toolbox contraplate		2	2
8	804.080.350	Bolt M8 x 35 - ISO 4017		2	2
9	864.080.024	Large washer M8 - DIN 9021		2	2
10	830.080.080	Self Lock Nut M8 - ISO 10511		2	2
11	924.340.001	Decall adjustment valve		1	1



ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA 1100	QUA 1500
1	742.300.400	Bearing UCFL206		4	4
2	880.060.100	Grease nipple M6 DIN 71412A		4	4
3	804.160.400	Bolt M16 x 40 - ISO 4017		6	6
4	830.160.160	Self Lock Nut M16 10.9 - ISO 10511		8	8
5	830.080.080	Self Lock Nut M8 - ISO 10511		8	4
6	830.120.120	Self Lock Nut M12 - ISO 10511		2	2
7	804.080.200	Bolt M8 x 20 - ISO 4017		8	8
8	830.080.080	Self Lock Nut M8 - ISO 10511		8	8
9	478.059.162	Back roller		0	1
	478.059.120	Back roller		1	0
10	316.272.029	Spiked Segment		37	50
11	816.080.450	Bolt M8 x 45 DIN 7991		2	2
12	864.120.030	Washer M12 - ISO 7089		4	4
13	804.120.400	Bolt M12 x 40 - ISO 4017		2	2
14	494.162.134	Weld assy U-channel brush		0	1
	494.123.130	Weld assy U-channel brush		1	0
15	486.539.150	Rear lag brush		0	1
	486.219.912	Rear lag brush		1	0
16	860.050.130	Tapping screw 4.8 x 13 - DIN 7049		10	12
17	478.059.162	Back roller		0	1
	478.059.120	Back roller		1	0

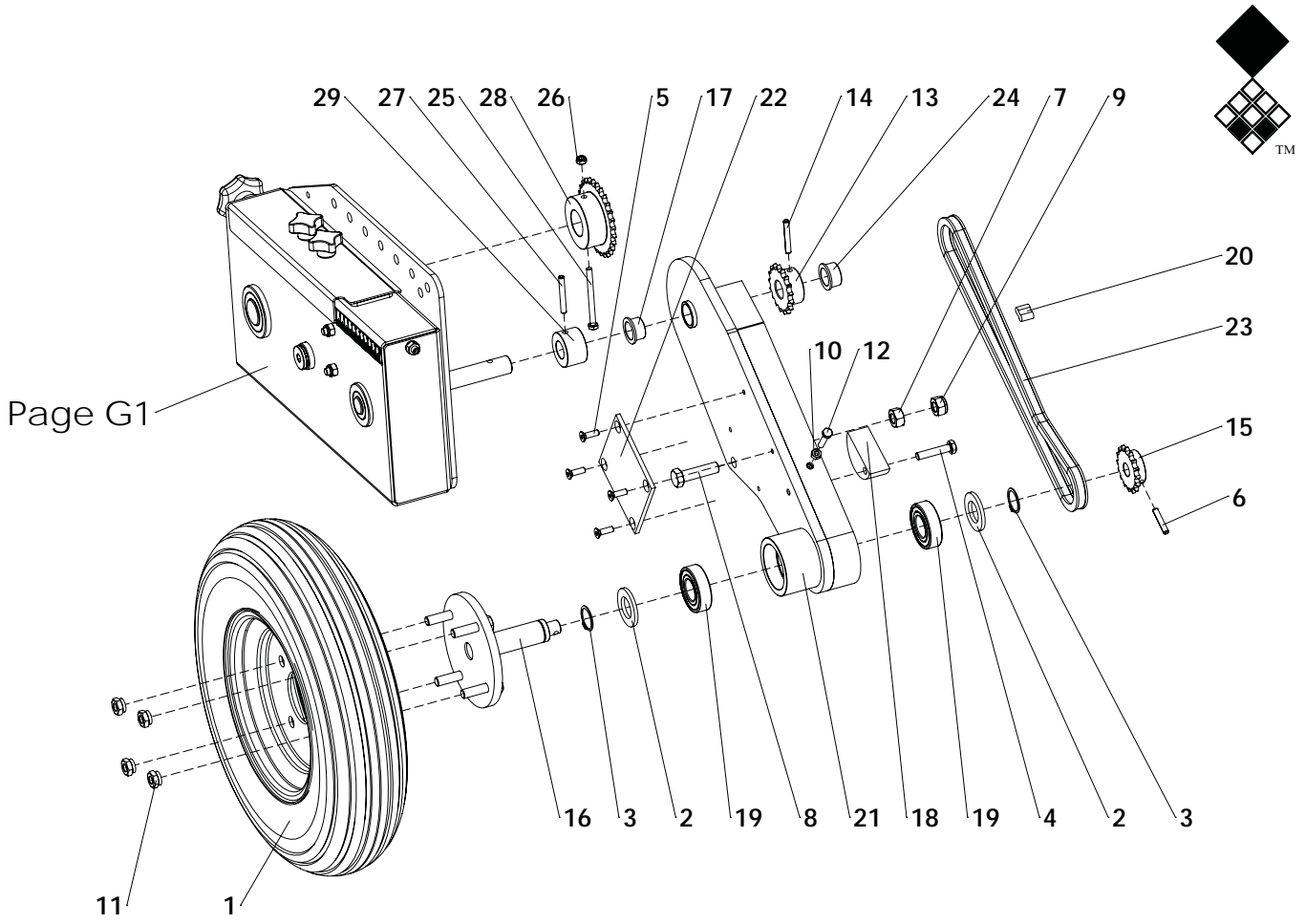


ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA 1100	QUA 1500
1	456.022.600	Side cover plate		1	1
2	864.080.030	Washer M8 - ISO 7089		4	4
3	866.080.020	Spring Washer M8 - DIN 127		4	4
4	804.080.120	Bolt M8 x 12 - ISO 4017		4	4
5	830.080.080	Self Lock Nut M8 - ISO 10511		8	8
6	830.100.100	Self Lock Nut M10 - ISO 10511		2	2
7	804.080.250	Bolt M8 x 25 - ISO 4017		8	8
8	820.060.200	MH Bolt M6 x 20 ISO 8677		8	8
9	864.060.030	Washer M6 - ISO 7089		8	8
10	830.060.060	Self Lock Nut M6 - ISO 10511		8	8
11	468.049.164	Scraper		0	1
	462.409.120	Scraper		1	0
12	464.050.850	Bracket scraper		2	2
13	804.100.250	Bolt M10 x 25 - ISO 4017		4	4
14	864.100.030	Washer M10 - ISO 7089		4	4
15	830.100.100	Self Lock Nut M10 - ISO 10511		4	4
16	804.100.250	Bolt M10 x 25 - ISO 4017		2	2
17	494.166.087	Frame Speedseed 1500		0	1
	494.127.087	Frame Speedseed 1100		1	0
18	521.221.600	3-point pin		2	2
19	521.191.600	Top link pin OS		1	1
20	464.053.500	Cover mounting bracket		8	8
21	468.029.166	Seed Guide Plate Front		0	1
	468.029.130	Seed Guide Plate Front		1	0
22	469.029.163	Seed guide plate front		0	1
	469.029.125	Seed guide plate front		1	0
23	523.051.000	R-clip Round 5, DIN 11024		5	5

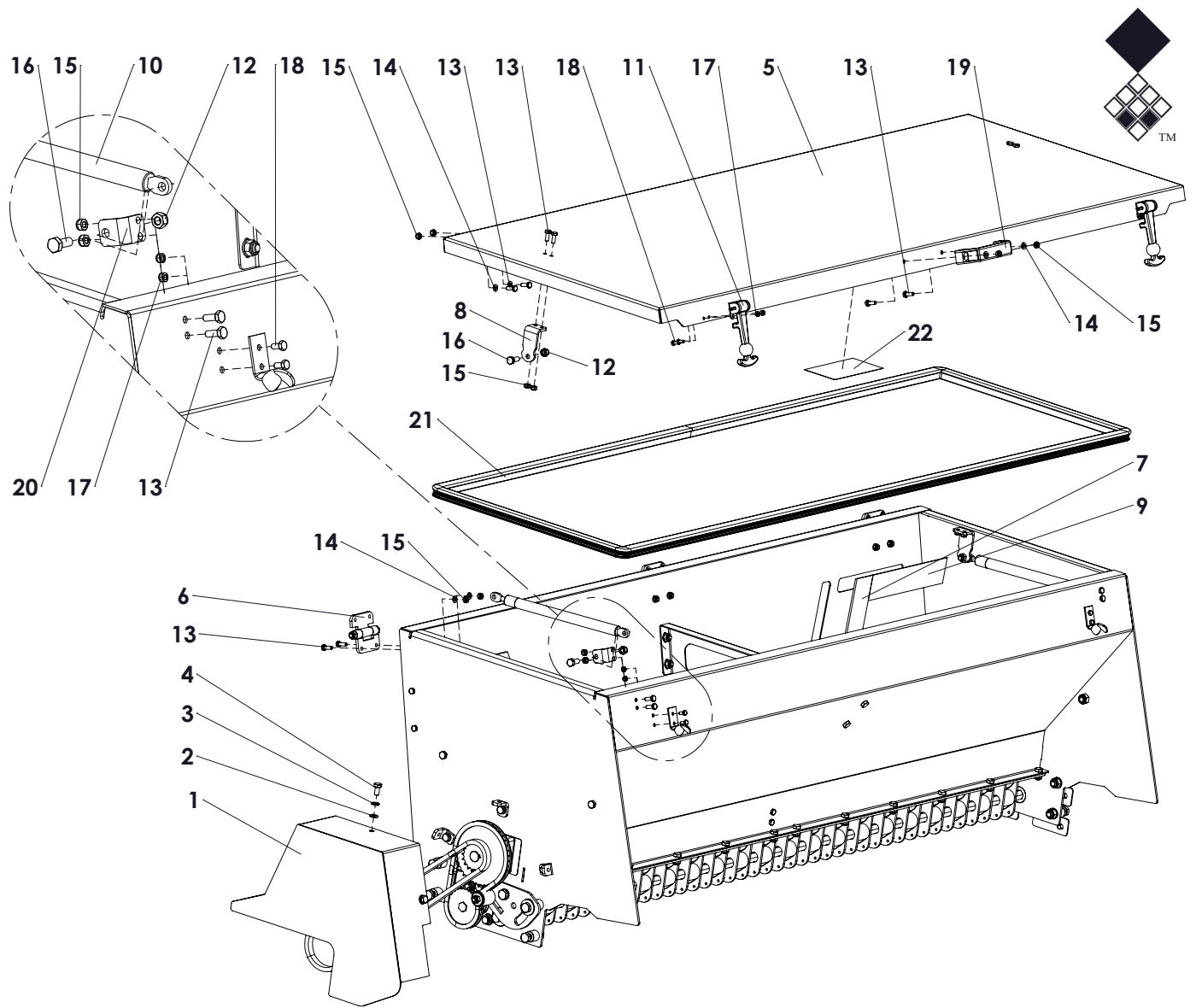


ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA 1100	QUA 1500
1	456.196.088	Cover		1	1
2	864.080.030	Washer M8 - ISO 7089		3	3
3	866.080.020	Spring Washer M8 - DIN 127		3	3
4	804.080.160	Bolt M8 x 16 - ISO 4017		3	3
5	802.101.200	Bolt M10 x 120 - ISO 4014		3	3
6	402.110.920	Spacer		3	3
7	444.500.600	Chain Tensioner		1	1
8	864.080.030	Washer M8 - ISO 7089		16	16
9	826.060.060	Nut M6 - DIN 934		1	1
10	830.080.080	Self Lock Nut M8 - ISO 10511		13	13
11	804.060.600	ISO 4017 - M6 x 60-C		1	1
12	406.200.510	Block bush Swing arm		2	2
13	468.062.804	Guide swing arm		1	1
14	444.062.800	Guide swing arm		1	1
15	468.062.800	Spacer		1	1
16	816.121.000	CSK Screw M12 x 100 - DIN 7991		2	2
17	802.080.800	Bolt M8 x 80 - ISO 4014		1	1
18	402.080.100	Distance bush		1	1
19	804.080.162	Bolt M8 x 16 - ISO 4017		4	4
20	830.120.120	Self Lock Nut M12 - ISO 10511 Class 10.9		2	2
21	830.100.100	Self Lock Nut M10 - ISO 10511		3	3
22	804.080.250	Bolt M8 x 25 - ISO 4017		5	5
23	804.080.400	Bolt M8 x 40 - ISO 4017		4	4
24	866.080.020	Spring Washer M8 - DIN 127		4	4
25	468.029.168	Cover plate		0	1
	468.029.134	Cover		1	0
26	464.050.300	Cover mounting bracket		7	7
27	575.302.250	Spring wheelaxle		1	1
28	444.201.300	Bearing plate		1	1
29	470.101.570	Bracket spring tensioner		1	1
30	804.160.500	Bolt M16 x 50 - ISO 4017		2	2
31	822.121.400	Eye Bolt M12x140 DIN 444LB (full thread)		1	1
32	826.120.120	Nut M12 - DIN 934		2	2



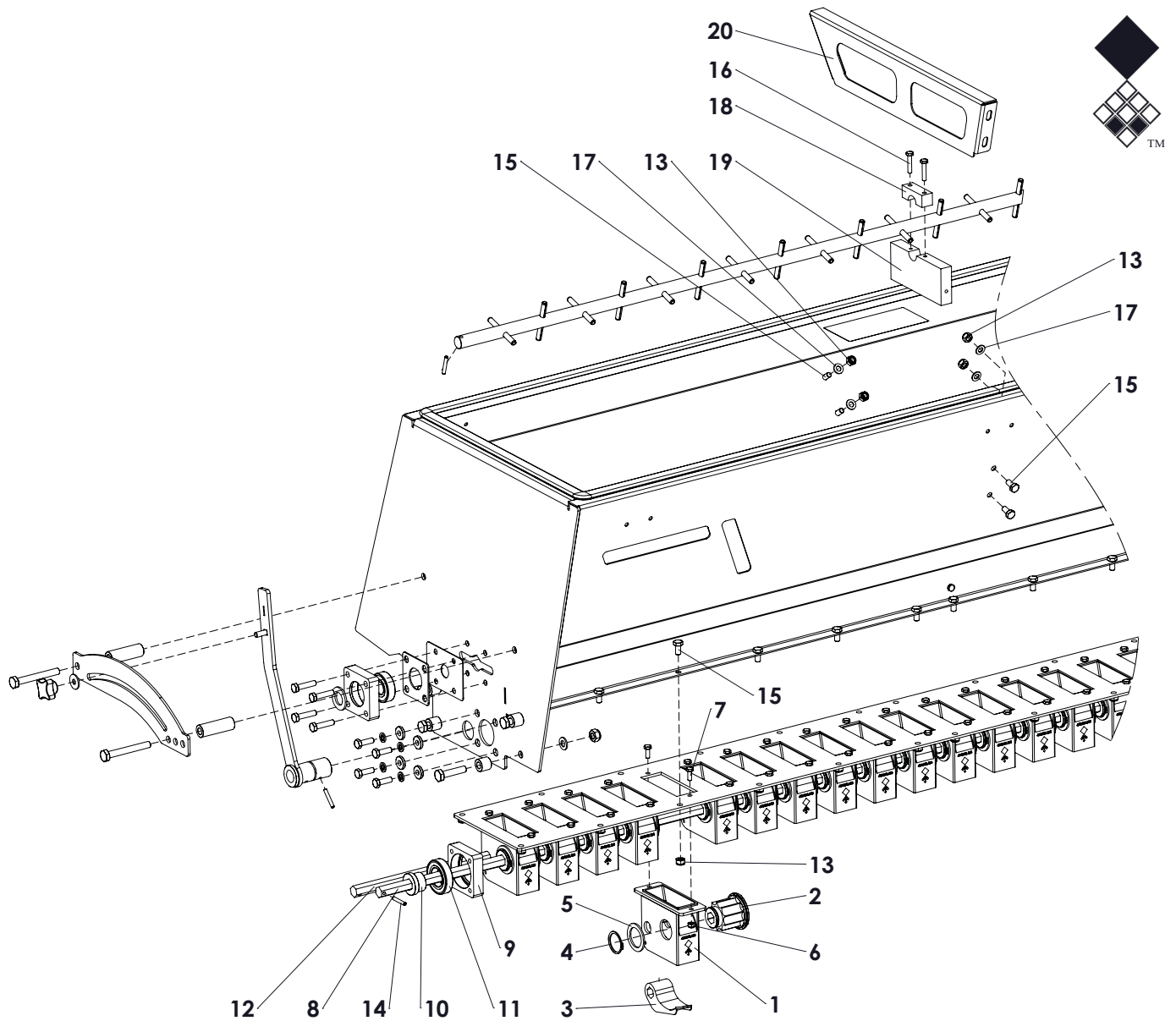


ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA 1100	QUA 1500
1	511.400.106	Tire 4.00-8/4PR		1	1
2	864.240.044	Washer M24 - ISO 7089		2	2
3	870.025.120	Circlip d=25 - DIN 471		2	2
4	802.080.400	Bolt M8 x 40 - ISO 4014		1	1
5	816.060.200	Bolt M6 x 20 - DIN 7991		4	4
6	878.060.320	Roll Pin 6 x 32 - ISO 8752		1	1
7	826.120.120	Nut M12 - DIN 934		1	1
8	802.120.450	Bolt M12 x 45 ISO 4014		1	1
9	830.120.120	Self Lock Nut M12 - ISO 10511 Class 10.9		1	1
10	826.060.060	Nut M6 - DIN 934		1	1
11	844.100.100	Wheel nut M10x1.25		4	4
12	804.060.300	Bolt M6 x 30 - ISO 4017		1	1
13	635.000.572	Sprocket 3/8" (06B) simplex 17Z		1	1
14	878.060.400	Roll Pin 6 x 40 - ISO 8752		1	1
15	635.000.540	Sprocket 3/8" (06B) simplex 16Z		1	1
16	474.251.400	Wheel hub		1	1
17	442.200.152	Bearing bush swingarm		1	1
18	444.250.600	Chain tensioner		1	1
19	713.250.150	Bearing 6205-LLU		2	2
20	638.090.090	Chain connector 3_8 inch 6B Simplex		1	1
21	466.160.000	Frame swingarm		1	1
22	444.051.000	Guide plate swingarm		1	1
23	631.000.817	Chain 3/8" Simplex L=817		1	1
24	442.200.150	Bearing bush gearaxle		1	1
25	802.060.700	Bolt M6 x 70 - ISO 4014		1	1
26	830.060.060	Self Lock Nut M6 - ISO 10511		1	1
27	878.060.450	Roll Pin 6 x 45 - ISO 8752		1	1
28	635.000.902	Sprocket 3/8" (06B) simplex 28Z Ø30		1	1
29	402.200.240	Distance bush		1	1

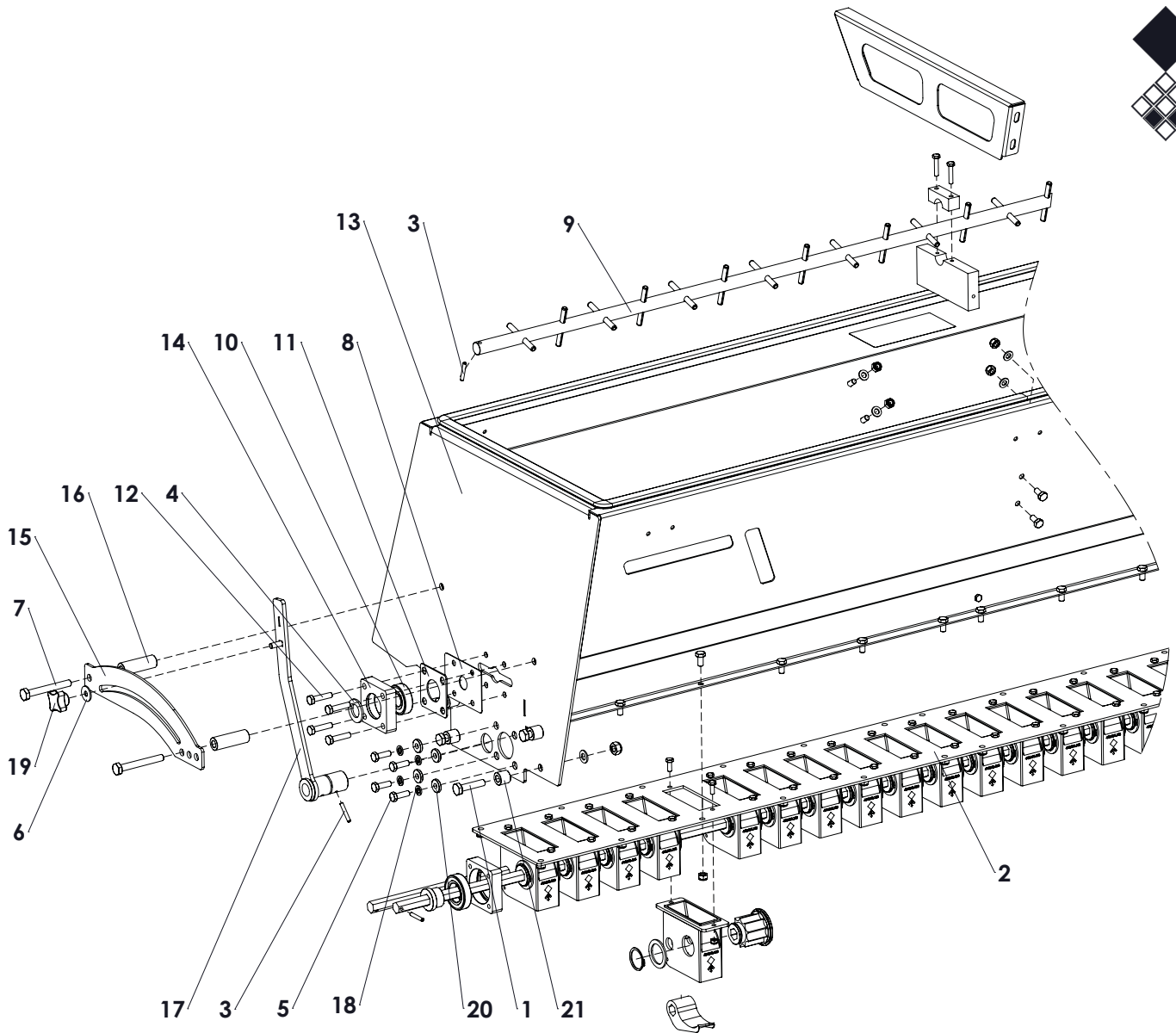


ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA 1100	QUA 1500
1	456.407.116	Cover		1	1
2	864.080.030	Washer M8 - ISO 7089		3	3
3	866.080.020	Spring Washer M8 - DIN 127		3	3
4	804.080.160	Bolt M8 x 16 - ISO 4017		3	4
5	456.162.052	Top cover		0	1
	456.123.052	Top cover		1	0
6	899.100.634	Hinge		3	3
7	444.041.300	Window		2	2
8	468.040.654	Support L=65mm		2	2
9	444.042.100	Window angle		2	2
10	571.224.854	Gas strut L=485/stroke=200, F=150N		2	2
11	590.650.000	Rubber lock assy		2	2
12	830.080.080	Self Lock Nut M8 - ISO 10511		6	6
13	804.060.160	Bolt M6 x 16 - ISO 4017		18	18
14	864.060.030	Washer M6 - ISO 7089		18	18
15	830.060.060	Self Lock Nut M6 - ISO 10511		18	18
16	804.080.200	Bolt M8 x 20 - ISO 4017		4	4
17	830.050.050	Self Lock Nut M5 - ISO 10511		8	8
18	804.050.100	Bolt M5 x 10 - ISO 4017		8	8
19	444.151.250	Handle		1	1
20	468.040.302	Support L=30mm		2	2
21	592.130.002	Glass Rubber		0	1
	592.130.004	Glass Rubber		1	0
22	924.280.000	Decal seed hopper		1	1

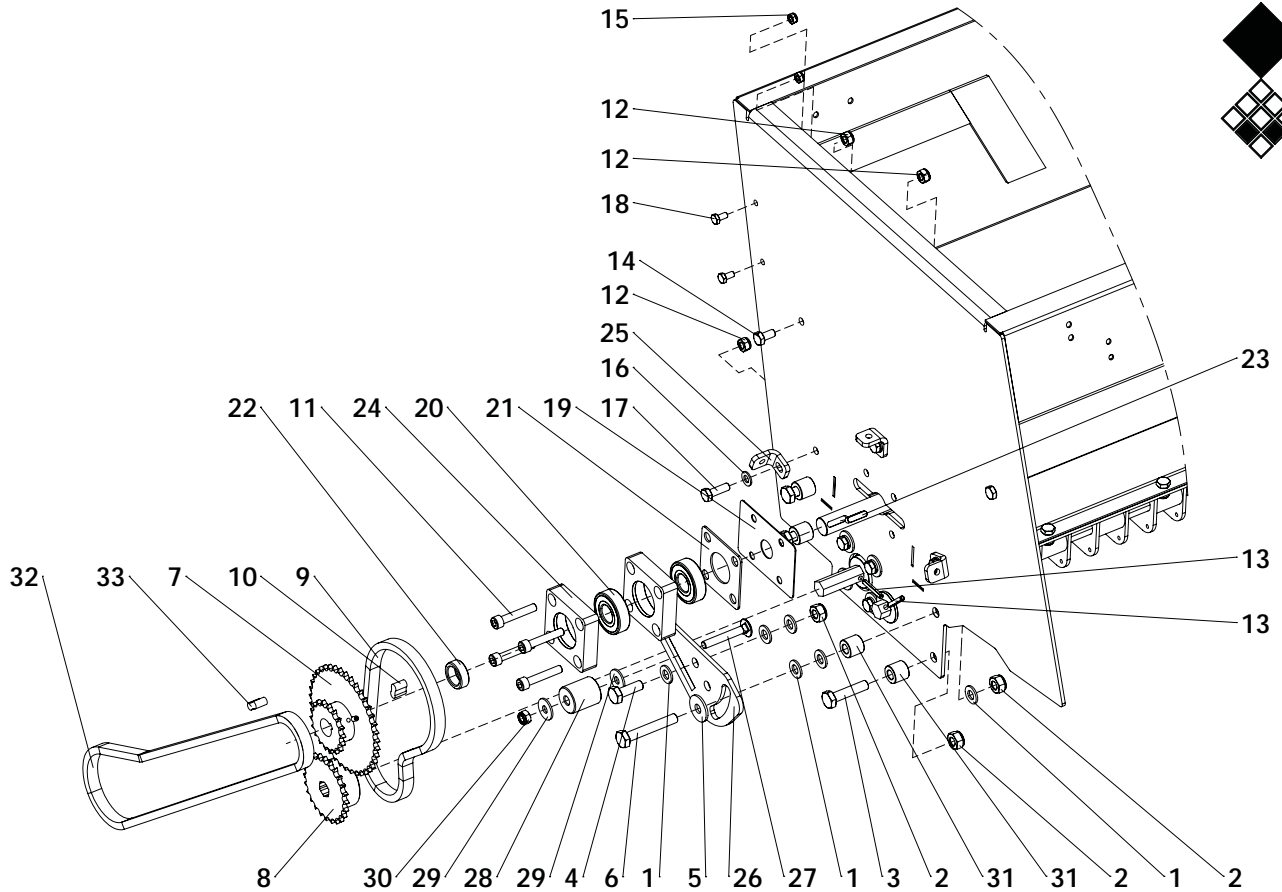




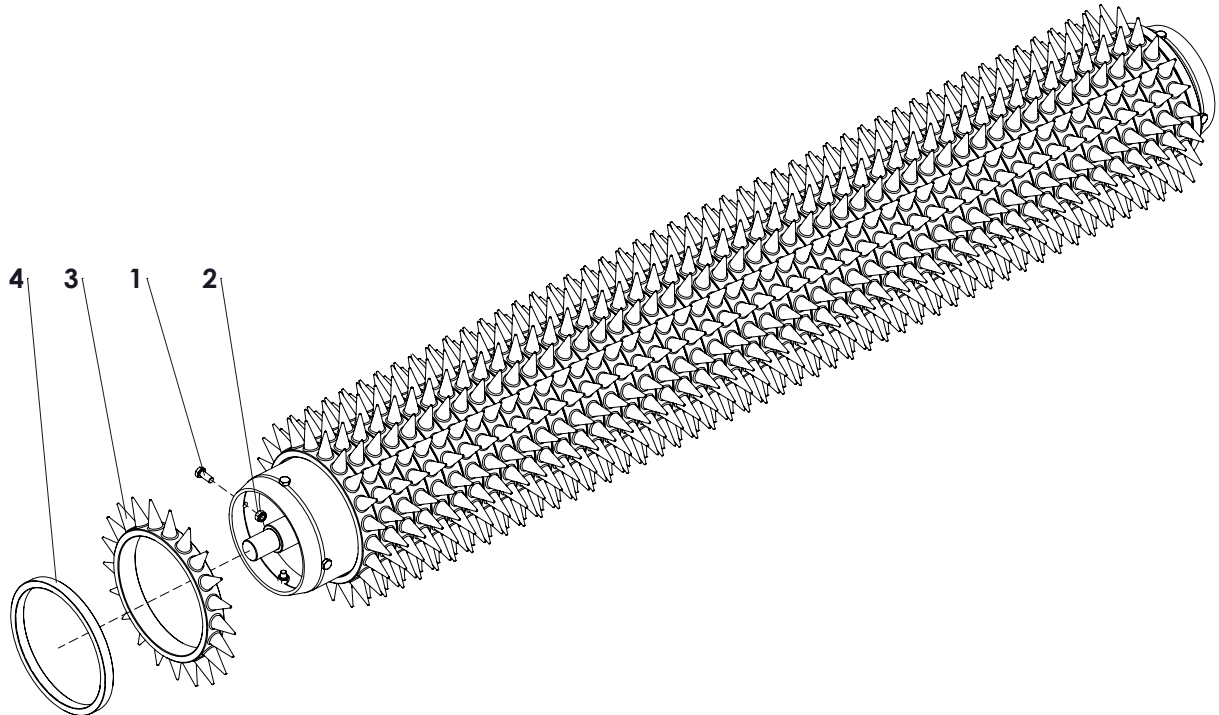
ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA 1100	QUA 1500
1	444.050.133	Seed element casing		15	21
2	444.058.510	Seed element rotor		15	21
3	444.034.760	Seed element valve		15	21
4	870.032.160	Circlip d=32 - DIN 471		15	21
5	412.020.450	Washer		15	21
6	830.060.060	Self Lock Nut M6 - ISO 10511		30	42
7	804.060.160	Bolt M6 x 16 - ISO 4017		30	42
8	422.169.167	Shaft		0	1
	422.169.128	Shaft		1	0
9	468.180.706	Bearing block		2	2
10	410.160.182	Bush		2	2
11	713.300.130	Bearing 6006 LLU		2	2
12	422.169.166	Shaft		0	1
	422.169.125	Shaft		1	0
13	830.080.080	Self Lock Nut M8 - ISO 10511		24	28
14	878.050.320	Roll pin Ø5x32		2	2
15	804.080.160	Bolt M8 x 16 - ISO 4017		24	32
16	804.060.300	Bolt M6 x 30 - ISO 4017		2	2
17	864.080.030	Washer M8 - ISO 7089		4	4
18	444.200.550	Guide Block support		2	2
19	444.201.442	Guide lock block		1	1
20	464.025.270	Center plate		1	1



ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA 1100	QUA 1500
1	804.100.450	Bolt M10 x 45 - ISO 4017		7	7
2	468.049.152	Plate L=1592		0	1
3	878.050.320	Roll pin Ø5x32		2	2
4	864.200.030	Washer M20 - ISO 7089		1	1
5	804.080.250	Bolt M8 x 25 - ISO 4017		8	8
6	864.080.024	Large washer M8 - DIN 9021		1	1
7	804.100.800	Bolt M10 x 80 - ISO 4017		2	2
8	468.011.002	Cover plate		1	1
9	474.209.171	Agitator shaft		0	1
	474.209.132	Agitator shaft		1	0
10	713.200.140	Bearing 6204-C-2HRS		1	1
11	468.020.704	Cover plate		1	1
12	804.080.350	Bolt M8 x 35 - ISO 4017		4	4
13	494.161.051	Hopper		0	1
	494.122.051	Hopper		1	0
14	468.180.704	Bearing block		1	1
15	464.041.752	Guide strip		1	1
16	406.110.600	Distance bush Ø20/Ø10.5 L=60		2	2
17	464.063.134	Valve adjustment		1	1
18	866.080.020	Spring Washer M8 - DIN 127		8	8
19	836.080.402	Closed Knob M8 - Din 6335		1	1
20	864.080.043	Washer M8 - DIN 7349		8	8
21	402.100.182	Distance bush		4	4

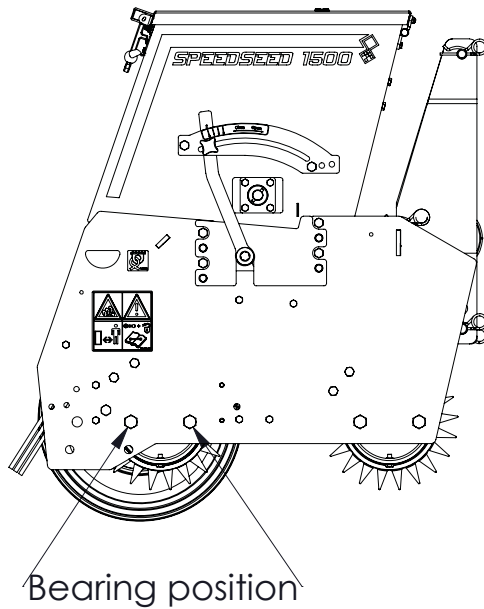


ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA 1100	QUA 1500
1	864.100.030	Washer M10 - ISO 7089		6	6
2	830.100.100	Self Lock Nut M10 - ISO 10511		5	5
3	804.100.450	Bolt M10 x 45 - ISO 4017		3	3
4	804.100.300	Bolt M10 x 30 - ISO 4017		1	1
5	864.100.031	Large washer M10 - DIN 9021		1	1
6	802.100.650	Bolt M10 x 65 - ISO 4014		1	1
7	484.014.004	Weldment sprocket		1	1
8	635.000.776	Sprocket 3/8" (06B) simplex Z24 Hex 16.2		1	1
9	631.000.489	Chain 3/8x7/32", L=524		1	1
10	638.090.090	Chain connector 3_8 inch 6B Simplex		1	1
11	814.080.450	Bolt M8 x 45 - DIN 912		4	4
12	830.080.080	Self Lock Nut M8 - ISO 10511		5	5
13	878.050.320	Roll pin Ø5x32		2	2
14	804.080.160	Bolt M8 x 16 - ISO 4017		2	2
15	830.060.060	Self Lock Nut M6 - ISO 10511		2	2
16	864.080.030	Washer M8 - ISO 7089		3	3
17	804.080.250	Bolt M8 x 25 - ISO 4017		3	3
18	804.060.120	Bolt M6 x 12 - ISO 4017		2	2
19	468.011.002	Cover plate		1	1
20	713.200.140	Bearing 6204-C-2HRS		2	2
21	468.020.704	Cover plate		1	1
22	402.210.100	Distance bush		1	1
23	884.060.250	Key 6x6x25 - DIN 6885		1	1
24	468.180.702	Bearing block		2	2
25	464.050.300	Cover mounting bracket		3	3
26	468.051.250	Spanner plate		1	1
27	820.080.550	Mushroom head bolt M8x55		1	1
28	444.300.350	Spanner roll		1	1
29	864.080.024	Large washer M8 - DIN 9021		2	2
30	830.080.080	Self Lock Nut M8 - ISO 10511		1	1
31	402.100.182	Distance bush		4	4
32	631.009.100	Chain 3/8x7/32", L=1028.7mm		1	1
33	638.090.090	Chain connector 3_8 inch 6B Simplex		1	1

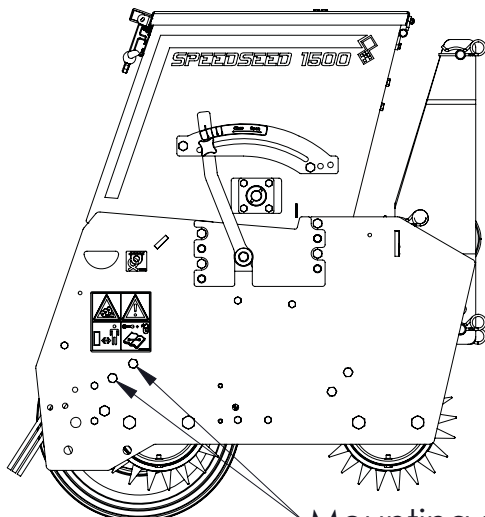
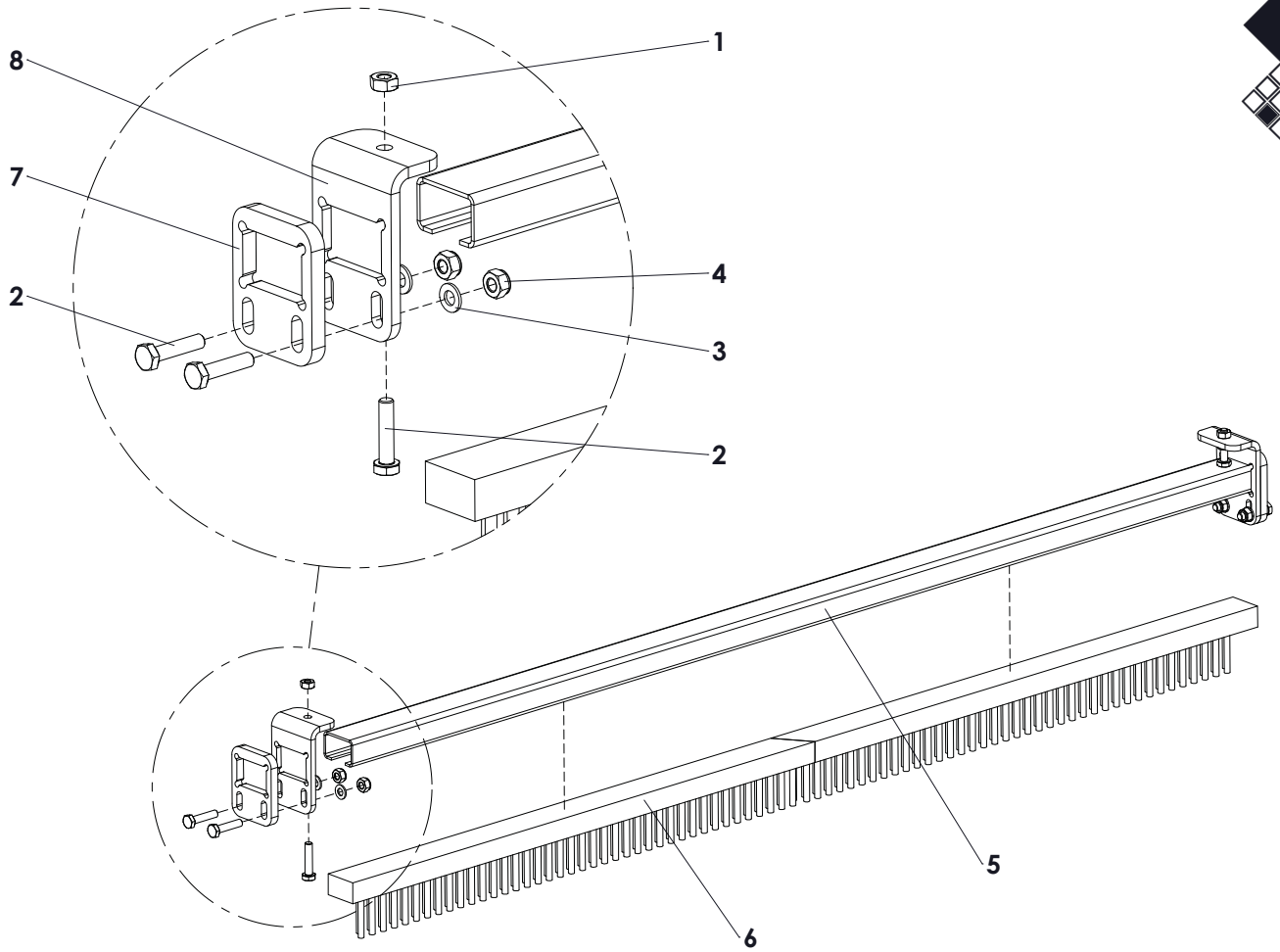


Option: Rear roller with spikes

Kit no.: 1100 - 224.120.000  
1500 - 224.160.002



ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA 1100	QUA 1500
1	804.080.200	Bolt M8 x 20 - ISO 4017		8	8
2	830.080.080	Self Lock Nut M8 - ISO 10511		8	8
3	316.272.029	Spiked Segment		36	49
4	402.174.150	Spacer		2	2

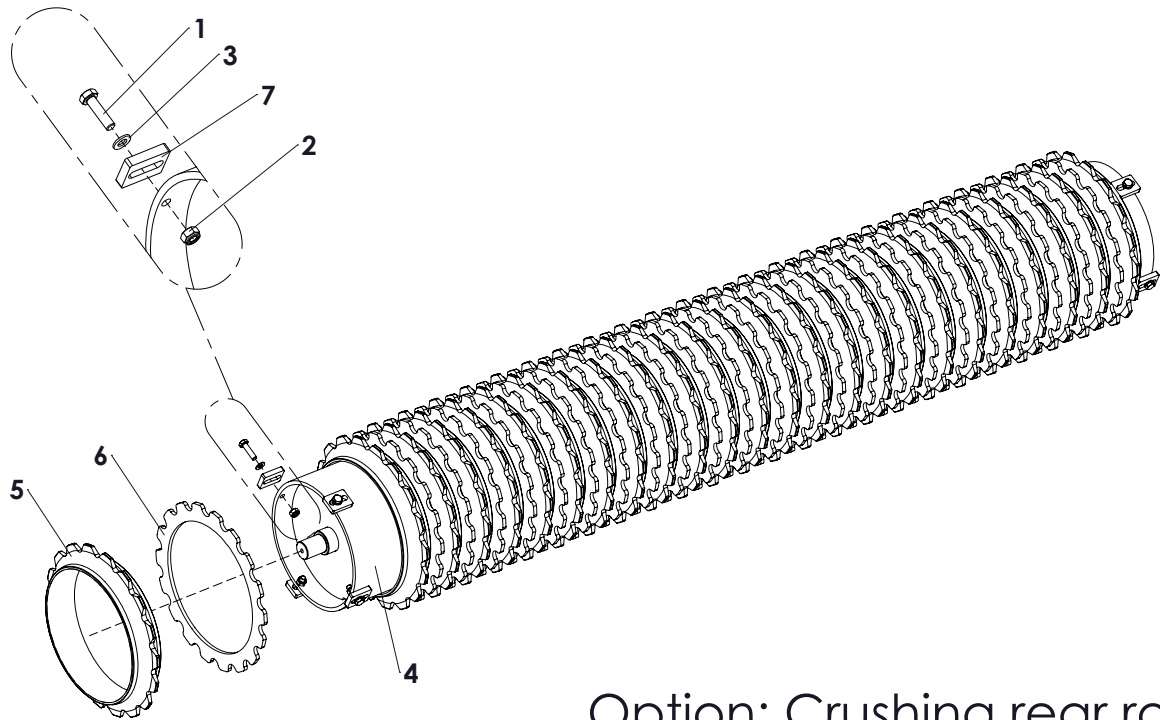


Mounting position  
Brush scraper

Option: Brush scraper complete

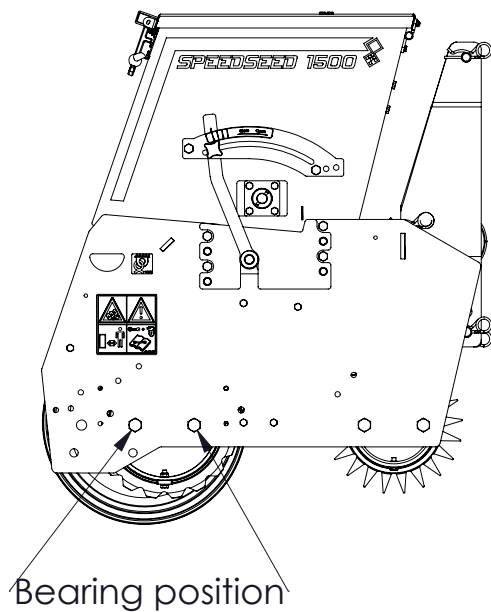
Kit no.: 1100 - 490.809.013  
1500 - 490.809.017

ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA 1100	QUA 1500
1	826.100.100	Nut M10 - DIN 934		4	4
2	804.100.450	Bolt M10 x 45 - ISO 4017		6	6
3	864.100.030	Washer M10 - ISO 7089		4	4
4	830.100.100	Self Lock Nut M10 - ISO 10511		4	4
5	468.039.164	Brush profile		0	1
	468.039.132	Brush profile		1	0
6	486.061.640	Brush WL=60 L=835		0	2
	486.061.250	Brush WL=60 L=1250		1	0
7	468.121.000	Spacer brush scraper		2	2
8	468.081.100	Clamp bracket brush scraper		2	2



Option: Crushing rear roller

Kit no.: 1100 - 224.120.006  
1500 - 224.160.006

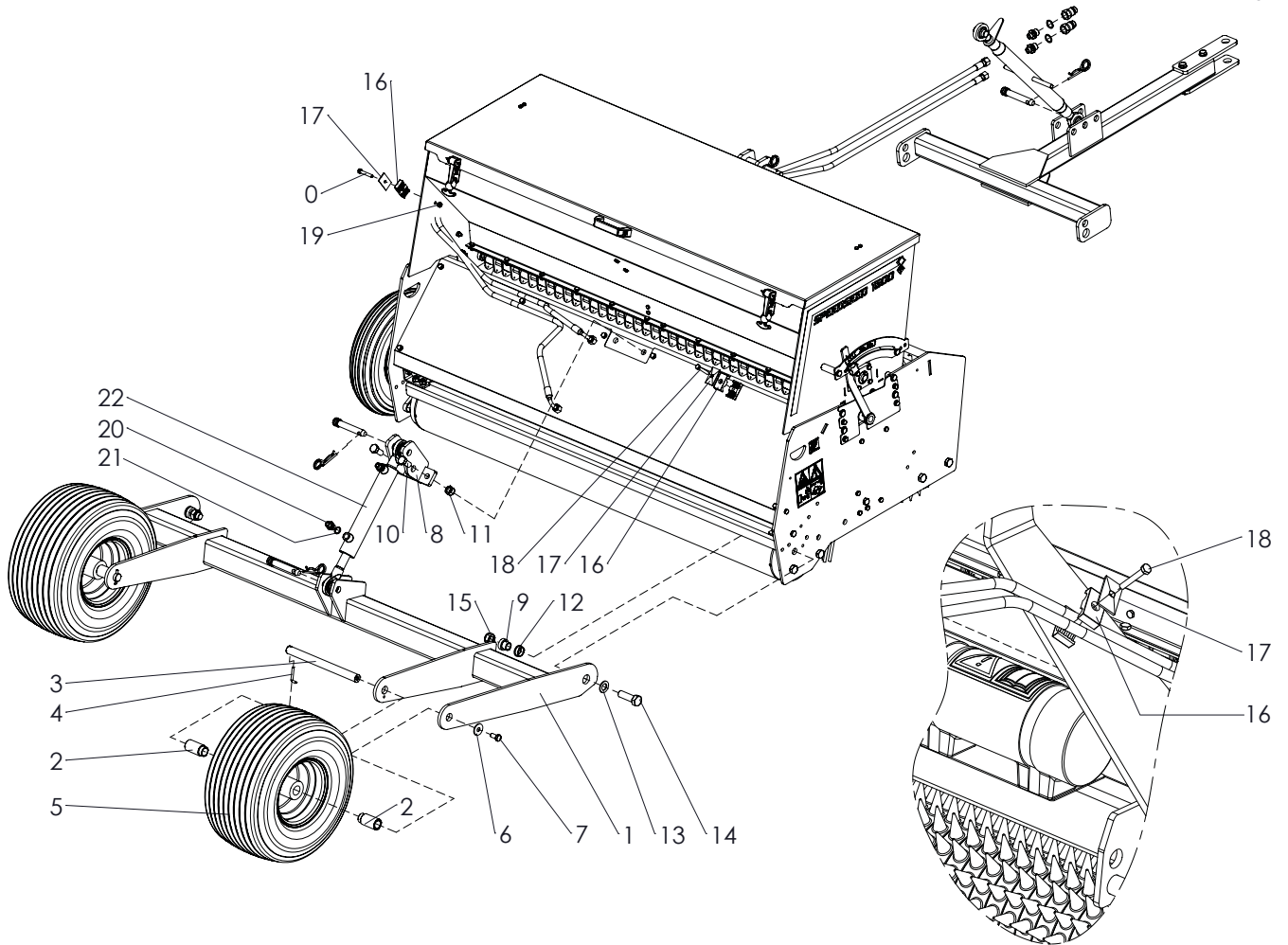


ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA 1100	QUA 1500
1	804.080.300	Bolt M8 x 30 - ISO 4017		8	8
2	830.080.080	Self Lock Nut M8 - ISO 10511		8	8
3	864.080.030	Washer M8 - ISO 7089		8	8
4	488.219.125	Rear roller		1	0
	488.219.164	Rear roller		0	1
5	316.292.055	Cast ring 9"		18	25
6	468.060.285	Spacer ring		19	24
7	468.080.400	Lock strip		8	8

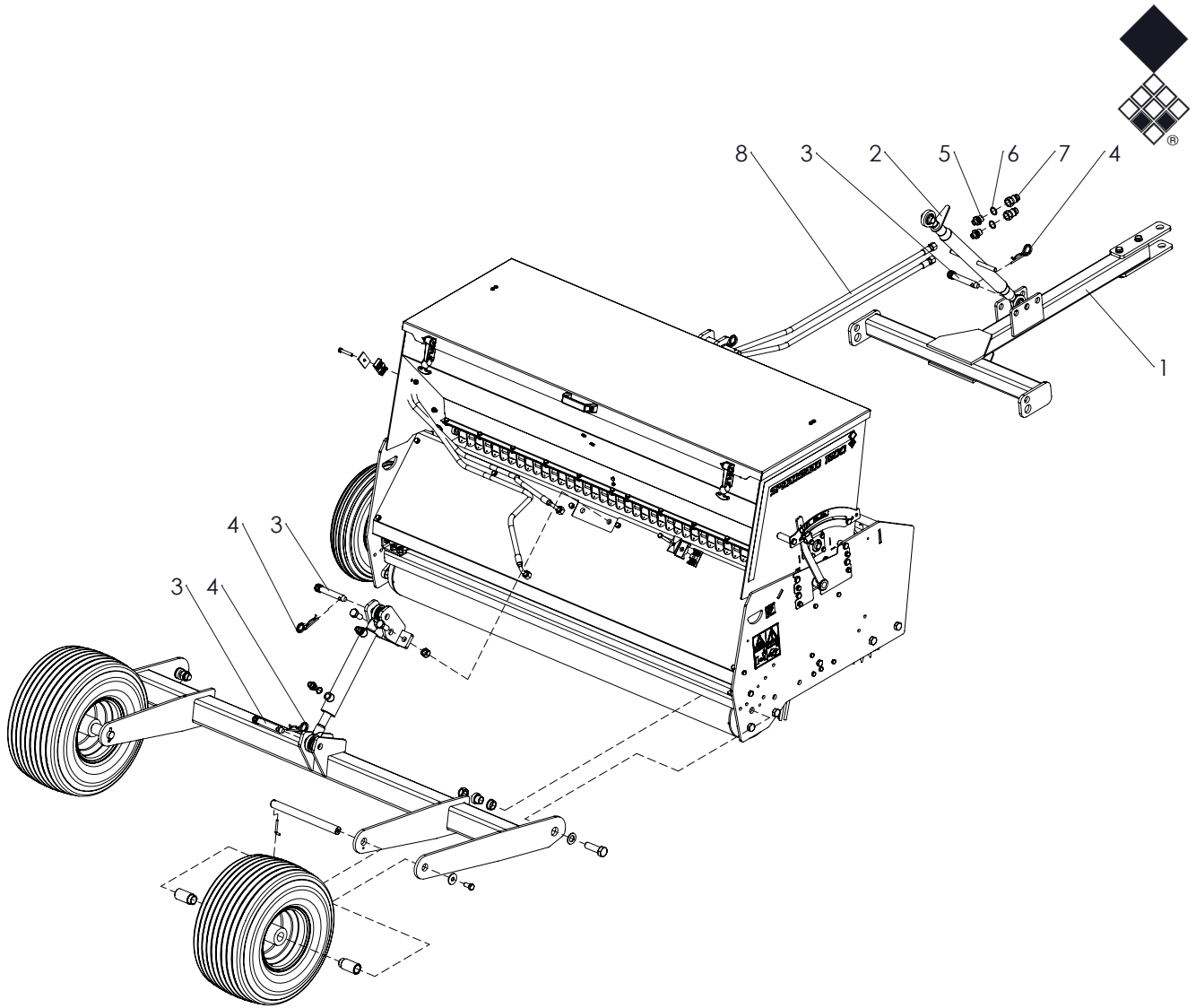


Option: Wheel kit

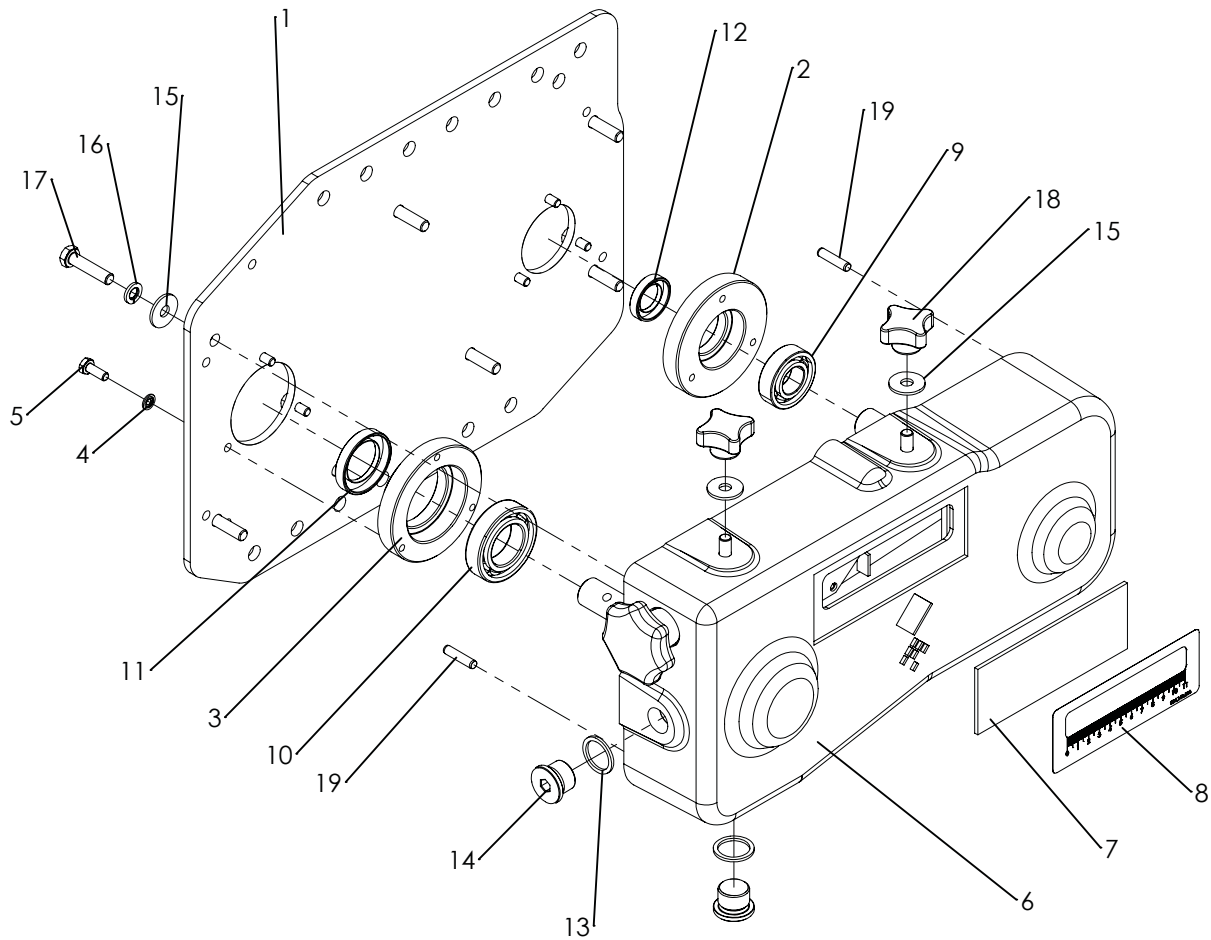
Kit no.: 1100 - 224.120.002  
1500 - 224.160.000



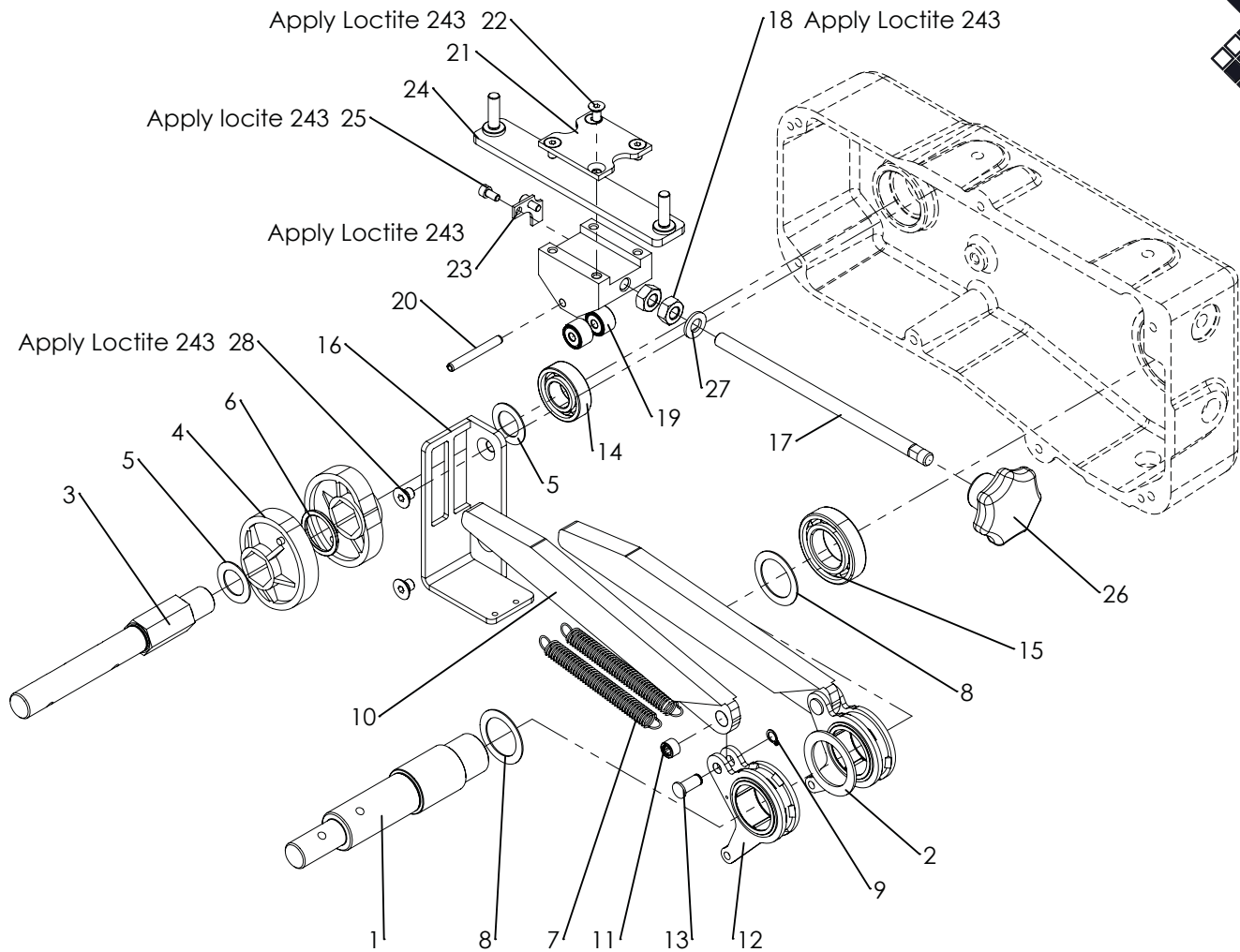
ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA 1100	QUA 1500
1	494.070.170	Weld Assy Frame Bogy		0	1
	494.070.130	Weld Assy Frame Bogy		1	0
2	404.250.700	Distance Bush Wheel		4	4
3	416.252.940	Wheel Shaft		2	2
4	424.060.480	Lock Pin		2	2
5	511.542.236	Wheel Complete		2	2
6	864.120.031	Large washer M12 - DIN 9021		2	2
7	804.120.250	Bolt M12 x 25 - ISO 4017		2	2
8	466.080.161	Bracket cylinder bogy		1	1
9	404.200.270	Bush Bogy		2	2
10	804.160.350	Bolt M16 x 35 - ISO 4017		2	2
11	830.160.160	Self Lock Nut M16-ISO 10511 Class 10		2	2
12	404.250.130	Nylon collar bush Ø35/Ø30/Ø25 L=12.5		2	2
13	864.200.030	Washer M20 - ISO 7089		2	2
14	802.200.650	Bolt M20 x 65 - ISO 4014		2	2
15	830.200.200	Self Lock Nut M20 Din 985 h=17		2	2
16	547.150.150	Hose clamp 2x15mm		6	8
17	547.300.510	Cover plate hose clamp 2x15 - 2x18		3	4
18	802.080.550	Bolt M8 x 55 - ISO 4014		3	2
19	830.080.080	Self Lock Nut M8 - ISO 10511		2	1
20	544.170.120	Nipple BSP 3_8" x pipe 12 (M18)		2	2
21	874.170.020	Copper washer 3_8		2	2
22	534.252.006	Hydr. Cylinder 25/40, stroke 200 - 2 x 19.4		1	1



ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA 1100	QUA 1500
1	494.063.076	Drawbar Bogy Double Eye Coupling		1	1
2	478.257.970	Toplink		1	1
3	521.191.120	Top Link Pin		3	3
4	523.051.000	R-clip Round 5, DIN 11024		3	3
5	543.170.210	Nipple BSP 3_8" x 1_2" 60deg		2	2
6	874.210.020	Copper washer 1_2		2	2
7	545.210.800	Quick connector male 1/2"		2	2
8	541.173.200	Hydraulic hose		1	1

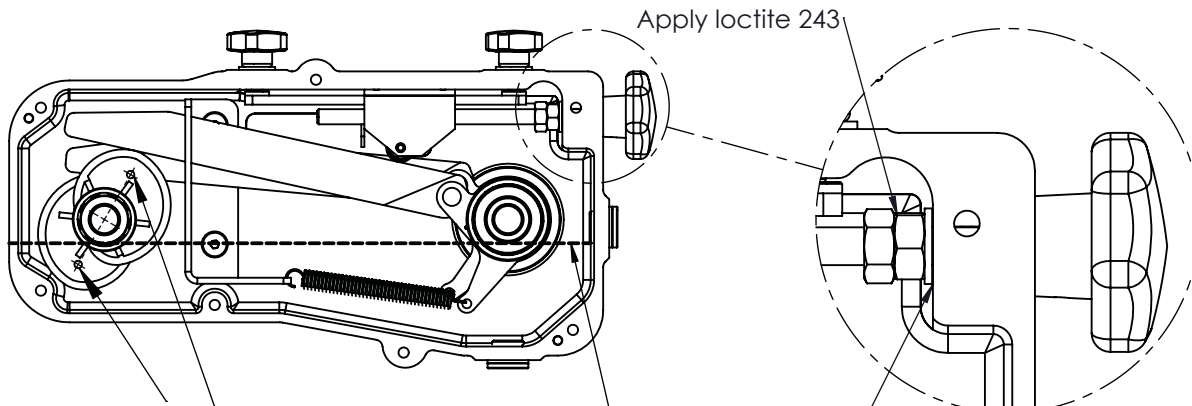


ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA
1	468.064.060	Lid plate		1
2	434.210.850	Bearing hub Ø42		1
3	434.230.850	Bearing hub Ø55		1
4	874.060.020	Bonded seal ring M6		6
5	804.060.160	Bolt M6 x 16 - ISO 4017		6
6	448.380.800	Casted gearbox housing		1
7	444.021.380	Window		1
8	934.140.510	Gauge decall		1
9	711.200.120	Bearing 6004		2
10	711.300.132	Bearing 6006		2
11	762.300.080	Oil seal 30-45-8		1
12	762.200.070	Oil seal 20-32-7		1
13	874.210.020	Copper washer 1_2		2
14	549.210.200	Blind plug G1/2		2
15	864.080.024	Large washer M8 - DIN 9021		9
16	866.080.020	Spring Washer M8 - DIN 127		7
17	804.080.350	Bolt M8 x 35 - ISO 4017		7
18	836.080.402	Closed Knob M8 - Din 6335		2
19	876.060.260	Parallel pin ISO 8734 - 6 x 26		2
	623.200.400	Gearbox complete		



ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA
1	422.351.382	Shaft		1
2	444.020.500	Washer		1
3	422.242.020	Shaft		1
4	444.200.730	Excenter		2
5	868.032.100	Shim Ø20xØ32x1.0 DIN988	Quantity depending on clearance	
6	406.280.030	Spacer		1
7	575.010.800	Spring		2
8	868.042.100	Shim Ø30xØ42x1.0 DIN988	Quantity depending on clearance	
9	870.008.080	Circlip d=8 - DIN 471		2
10	464.152.702	Rocker strip		2
11	721.080.080	Bearing HK0808		2
12	442.200.980	Rocker arm assembly		2
13	418.080.200	Pin		2
14	711.200.120	Bearing 6004		1
15	711.300.132	Bearing 6006		1
16	470.120.550	Guide		1
17	852.102.100	Threaded rod M10x210		1
18	826.100.100	Nut M10 - DIN 934		2
19	721.060.120	Roller bearing		2
20	878.060.500	Roll Pin 6 x 50 - ISO 8752		1
21	468.040.530	Lock plate		1
22	816.060.122	Bolt M6 x 12 - DIN 7991		4
23	468.020.490	Indicator		1
24	468.061.620	Slider bracket		1
25	814.050.100	DIN 912 M5 x 10 --- 10C		2
26	836.100.630	Knob M10 with set screw		1
27	864.100.030	Washer M10 - ISO 7089		1
28	816.080.100	Bolt M8 x 10 - DIN 7991		2

**Timing, Spindle adjustment and Oil level**



Apply loctite 243

Keep  $\pm 2\text{mm}$  (0.08") clearance distance between washer and casing! Adjustment must rotate smooth.

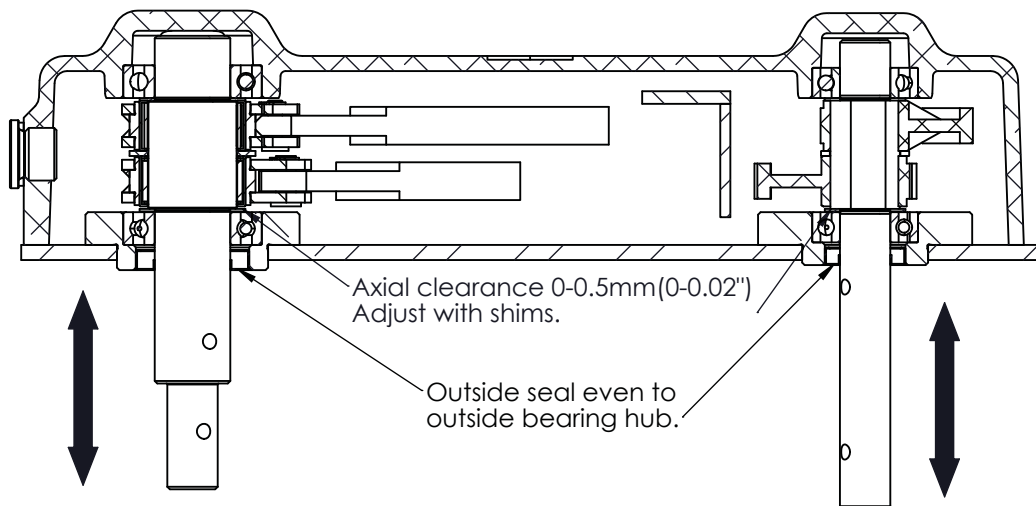
Warning! Make sure the excenters are positioned correct:

- The nodge has to be faced outwards.
- Timing: 180° shifted from each other

If not correctly installed a shocked rotation will occur at the output shaft.

Fill gearbox with  $\pm 1,4\text{L}$  (0.37gal.) 80W90 oil  
Fill till oil level line (Bottom level plug)

**Axial clearance**

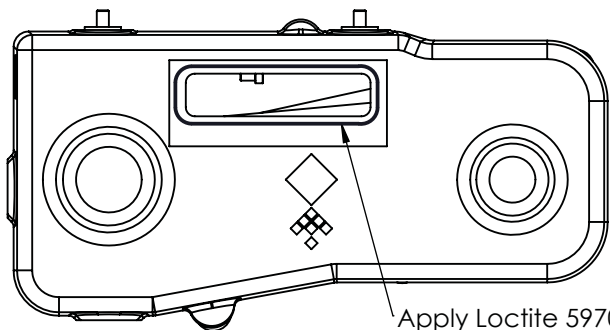


Axial clearance 0-0.5mm (0-0.02")  
Adjust with shims.

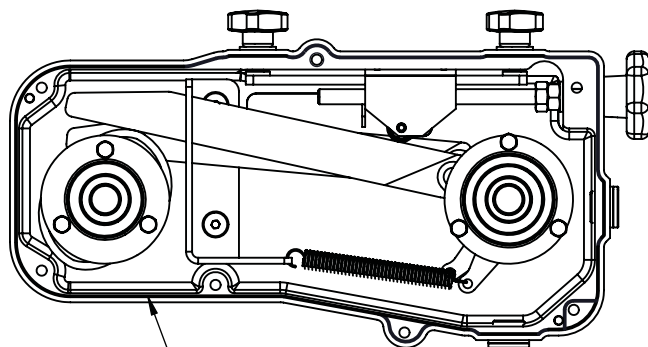
Outside seal even to outside bearing hub.

**Sealing plan**

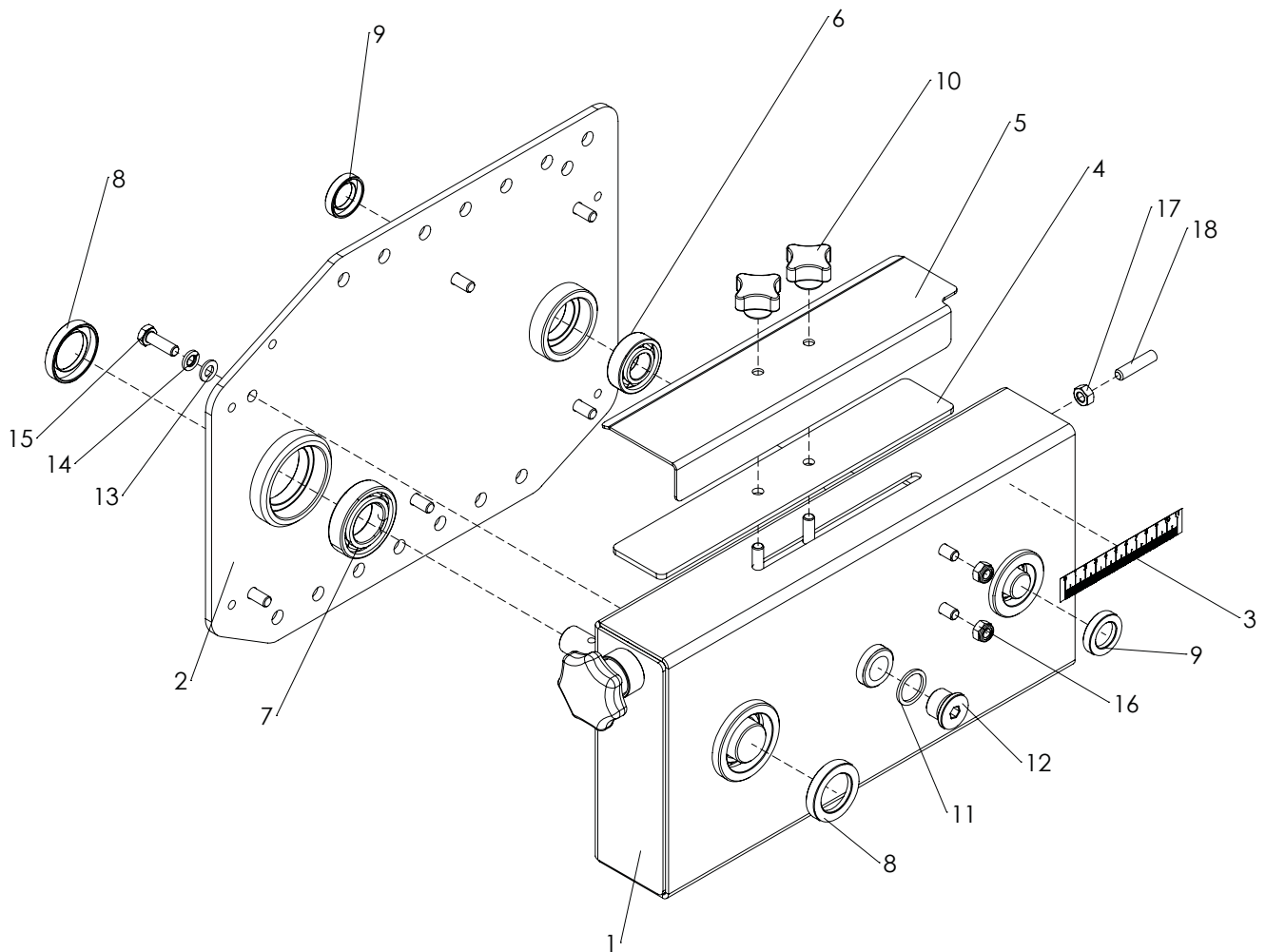
1. Put sealing paste (Loctite 5970) on the gearbox housing according to the closed line as shown on the pictures below.
2. Make sure to put sealing paste around the threaded holes.
3. Make sure to clean the edges from excess sealant.



Apply Loctite 5970 (acid free sealing paste)

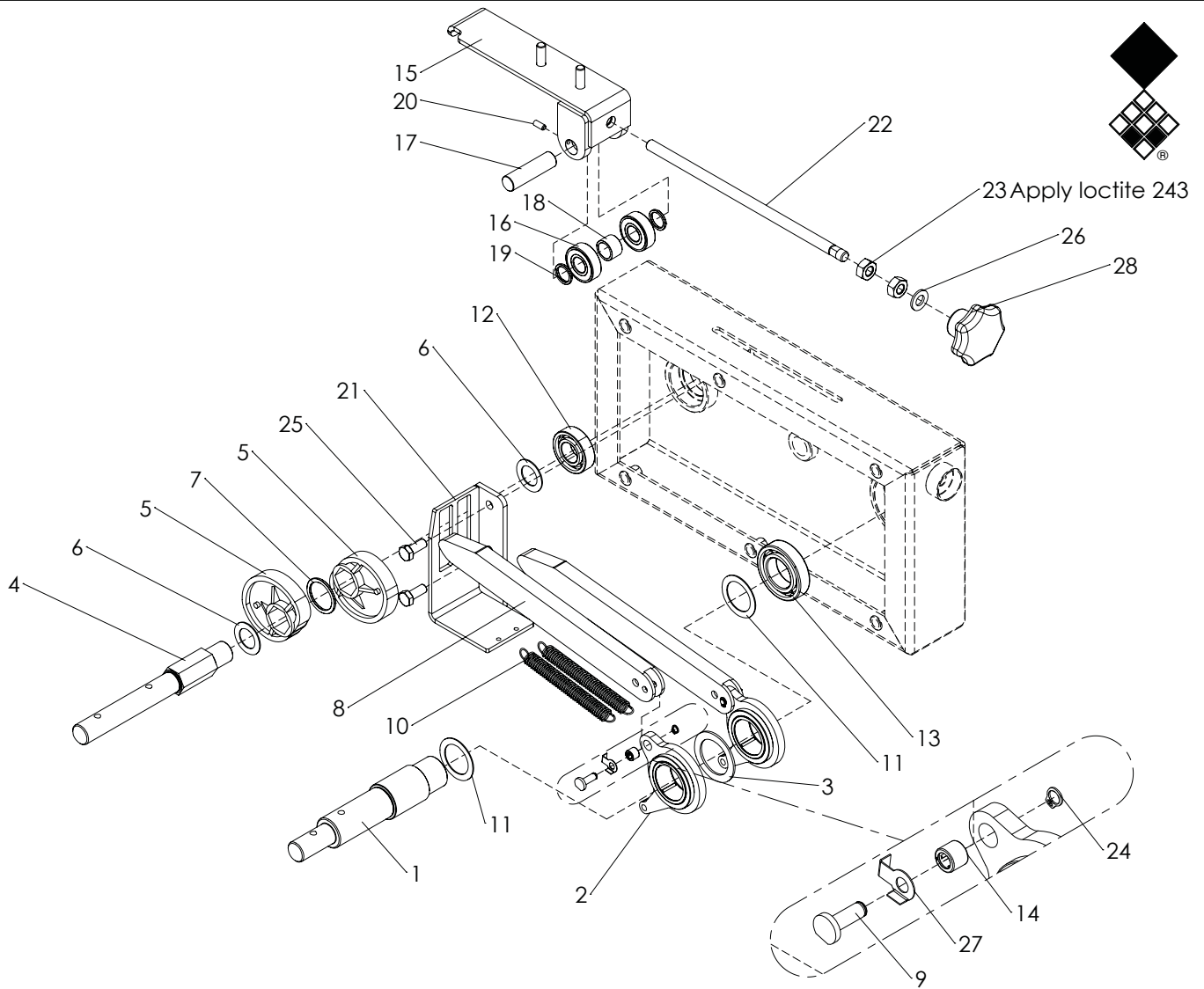


Apply Loctite 5970 (acid free sealing paste)



ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA
1	470.034.052	Gearbox housing		1
2	470.064.004	Gearbox lid		1
3	922.340.014	Gauge decall		1
4	444.032.900	Slider seal		1
5	468.022.900	Indicator		1
6	711.200.120	Bearing 6004		1
7	711.300.132	Bearing 6006		1
8	762.300.080	Oil seal 30-45-8		2
9	762.200.070	Oil seal 20-32-7		2
10	836.080.402	Closed Knob M8 - Din 6335		2
11	874.210.020	Copper washer 1_2		1
12	549.210.200	Blind plug G1/2		1
13	864.080.030	Washer M8 - ISO 7089		6
14	866.080.020	Spring Washer M8 - DIN 127		6
15	804.080.250	Bolt M8 x 25 - ISO 4017		6
16	830.080.080	Self Lock Nut M8 - ISO 10511		2
17	826.080.080	Nut M8 - DIN 934		1
18	818.080.350	Set screw M8x35 - DIN 913		1
	623.246.405	Gearbox complete		

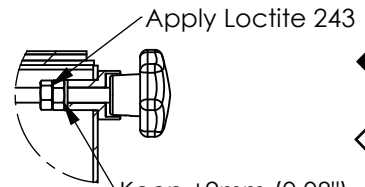
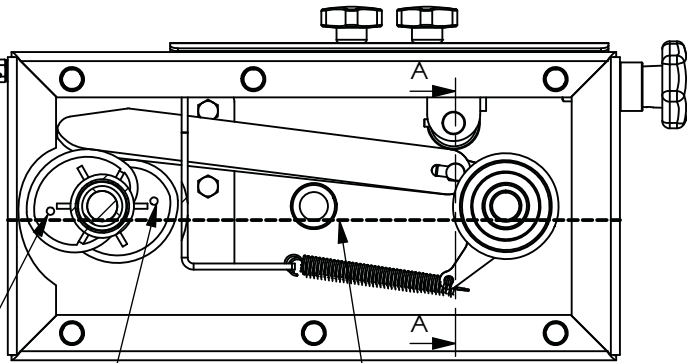




ITEM	PART NUMBER	DESCRIPTION	REMARKS	QUA
1	422.351.382	Shaft		1
2	478.019.101	Pivot point		1
3	444.020.500	Washer		1
4	422.242.020	Shaft		1
5	444.200.730	Excenter		2
6	868.032.100	Shim Ø20xØ32x1.0 DIN988	Quantity depending on clearance	
7	406.280.030	Spacer		1
8	464.152.600	Swing arm		2
9	418.060.190	Pin		2
10	575.010.800	Spring		2
11	868.042.100	Shim Ø30xØ42x1.0 DIN988	Quantity depending on clearance	
12	711.200.120	Bearing 6004		1
13	711.300.132	Bearing 6006		1
14	721.060.080	Bearing HK0608		2
15	470.041.980	Slider bracket		1
16	713.150.110	Bearing 6202-LLU		2
17	414.150.550	Shaft		1
18	406.150.132	Bush		1
19	406.150.020	Bush		2
20	818.050.120	Set screw M5 x 12 - DIN 913		2
21	470.041.190	Guide		1
22	852.102.500	Threaded rod M10x250		1
23	826.100.100	Nut M10 - DIN 934		2
24	870.006.070	Circlip d=6 - DIN 471		2
25	804.080.200	Bolt M8 x 20 - ISO 4017		2
26	864.100.030	Washer M10 - ISO 7089		1
27	874.060.240	Lock washer		2
28	836.100.630	Knob M10 with set screw		1

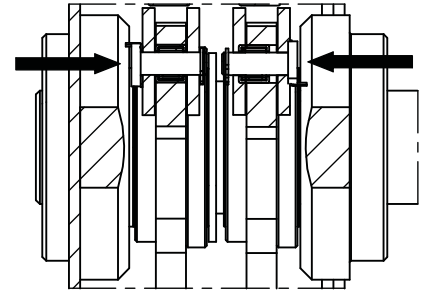
**Timing, Spindle adjustment and Grease level**

Adjust till max. output is 4:1



Keep  $\pm 2\text{mm}$  (0.08") clearance distance between washer and casing! Adjustment must rotate smooth.

**SECTION A-A**  
Place pins from correct side and fold lock plate.

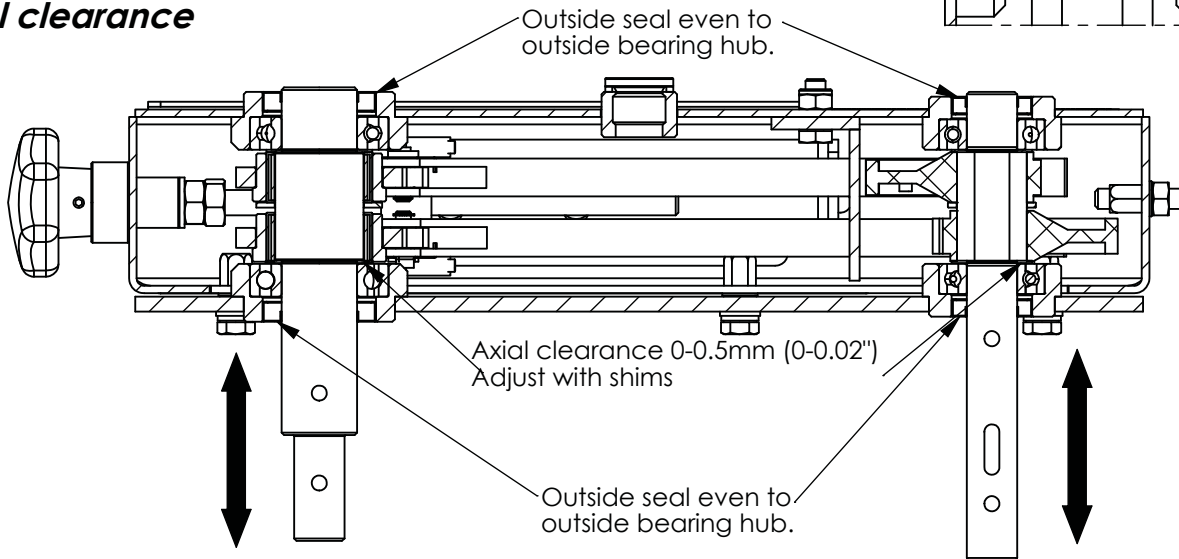


Warning! Make sure the excenters are positioned correct: Fill gearbox with  $\pm 2.8\text{kg}$  (6.17lbs.) EP0 grease Fill till level line (Bottom level plug)

- The nodge has to be faced outwards.
- Timing:  $180^\circ$  shifted from each other.

If not correctly installed a shocked rotation will occur at the output shaft.

**Axial clearance**



**Sealing plan**

1. Place sealing paste (Loctite 5970) on gearbox housing as shown in the pictures below. When the guide (1) is removed also apply sealant to the bolts.
2. Place gearbox lid on gearbox housing.
3. Fill bolt holes with silicone sealing before mounting the bolts of the gearbox lid.
4. Make sure to clean the edges of excess sealant.

