



Technical requirement:

1. Before assembly, the sizes of the parts should be qualified, without bump, scratches, corrosion, oxidation and others affected assembling and sealing performance.
2. Ratio 1 : 1 Gear model 4.2337 Gear teeth number 19/19
3. Input speed: 540 rpm
4. Gearbox electroplating
5. Ship without oil, Brush anti-rust oil among parts of the gearbox
6. The torque before install oil seal is as follows
Input torque? 100-200Nmm
gearbox torque? 280-480Nmm
7. Gearbox under 0.035 MPa pressure test for 20 seconds, no leakage
8. Each ball matter torque between 25Nm to 31Nm
9. Clean all fork parts before assembly, please see fork fork assembly assembly diagram, copper set of allowed axial channeling

32	900-30248	3290-02 Normal plate rivets for name	1			
31	907-00001	3290-02 Normal plate rivets for name	2			
30	910-00013	3290-02 Normal plate rivets for name	1			
29	909-600082	Adjust paper	6	fishpaper		
28	909-60002	Adjust paper	6	fishpaper		
27	909-20042	Adjust paper	1-2	Q235	φ25.5*φ32*0.3	
26	909-20041	Adjust paper	1-2	Q235	φ25.5*φ32*0.1	
25	909-10005	Washer	45#			
24	909-20148	Washer	Q235			
23	908-40004	circclip for shaft	2	65Mn	φ25.4*2	
22	907-60006	Allen solid plug	3		9/16"-18UNC(Blo	
21	907-60001	Allen solid plug	1		1/8"-27(Blo	
20	907-10002	Hex flang bolts	4	35#	5/16"-18UNC*19	
19	907-10001	Hex flang bolts	12	35#	5/16"-18UNC*21	
18	906-20001	6.4723.5 Type B	flit key	45#		
17	905-40002	11.222.0 ring	3	rubber adhesive	for 9/16"	
16	905-40001	O ring	4	rubber adhesive	7171.8	
15	905-20011	Hollow double lip	seal	nitrile rubber	25.4738.177	
14	905-20050	Hollow double lip	seal	nitrile rubber	25.4750.878	
13	904-20005	tapered roller bearing	PEE/DCr15		L44610/L4464	
12	903-60002	2190 clutch	1	20CrMnTi		
11	909-10055	25.5738733.2	seal	20CrMnTi		
10	903-50003	2190 Copper bush		HPb59-1		
9	903-10145	3290-02 Output Shaft		40Cr		
8	903-30165	3290-02 Input Shaft		40Cr		
7	902-20009	2190 Holes precision	forging	HT200	M:4.2333	
6	902-20010	2190 The interplate	precision forging	HT200	M:4.2333	
5	901-40051	3290 Solid thin cover		HT200		
4	901-20009	19473 The hollow long cover		HT200		
3	901-20008	19473 Solid long cover		HT200		
2	901-20044	3290-02 long cover		HT200		
1	901-10008	2190 fork box		HT200		

Item	Model	Part name	Qty	Material	Remark
Gearbox					
					Scale 1:2
					Ratio 1:1
					Weight 13Kg

设计					
校对					
审核批准					
标记	处数	更改原因	应标明	14.11.16	
			签名	年月日	



REV:09
-1