

## CALIBRATING MECHANISM AB21

Dismantling - Reassembling

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Fig. 1

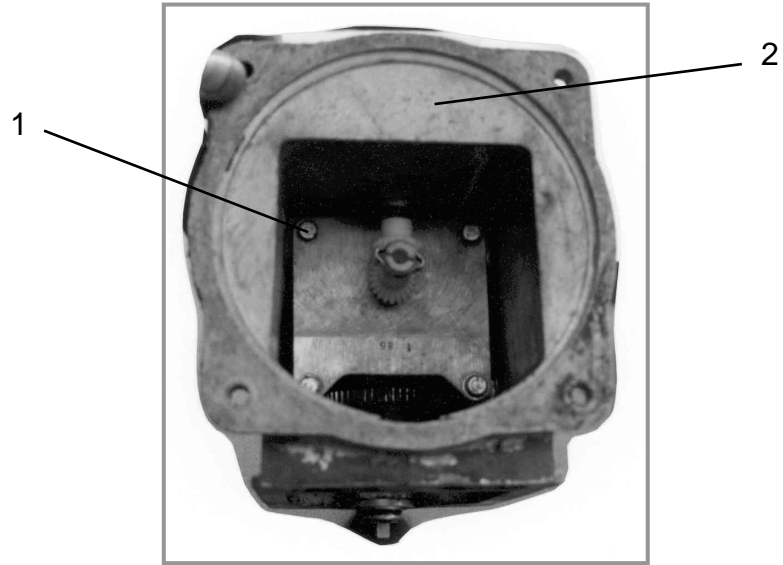


Fig. 2

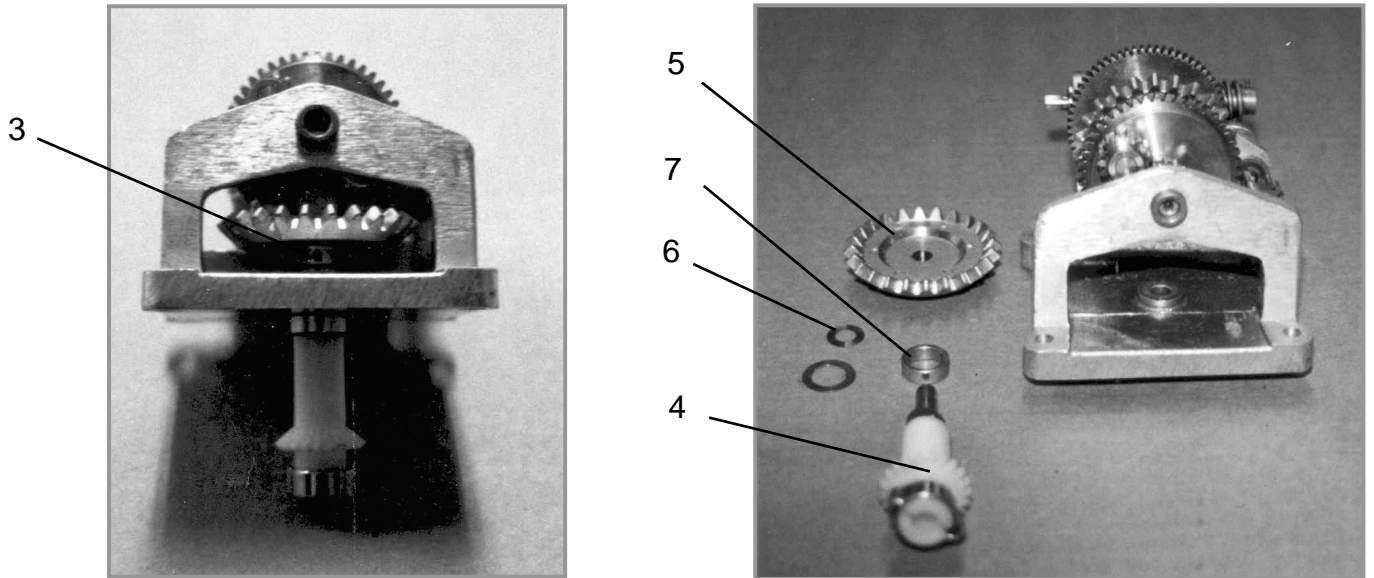
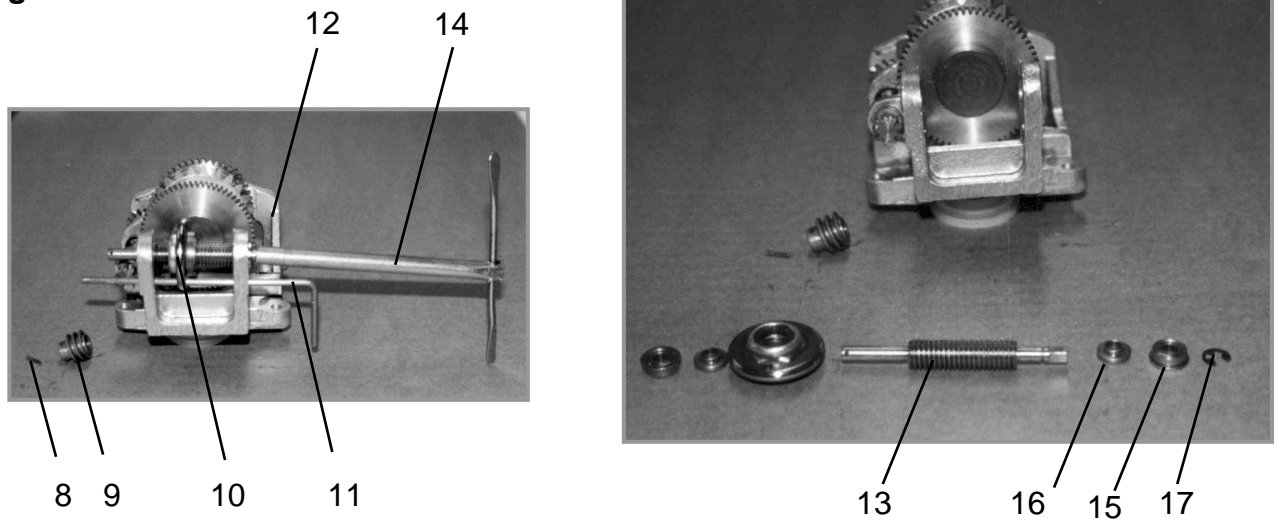


Fig. 3



## DISMANTLING OF CALIBRATING MECHANISM AB 21

### 1. Dismantling the mechanism from the box : (Fig.1)

- Remove the 4 screws (1) fixing the mechanism to the box (2).  
Remove the mechanism from the box.

### 2. Dismantling the outlet axle : (Fig.2)

- Remove the pin (3),
- Remove the shaft pinion (4),
- Take down the conical pinion (5),
- Take down the washers (6),
- Take down the guide (7).

### 3. Dismantling the driving screw : ( Fig.3 )

- Remove the pin (8),
- Remove the screw (9),
- Immobilise the roller (10) by putting the pin (11) through the holes in the frame (12) and the roller (10).
- Turn the driving screw (13) using the key (14).
- Unscrew to detach the roller (10) from the driving screw (13).
- Remove the screw (13) from the frame (12).
- Remove the ball bearing (15) and the thrust bearing (16).
- Remove the circlips (17).
- Remove the second ball bearing and the second thrust bearing.

Fig. 4

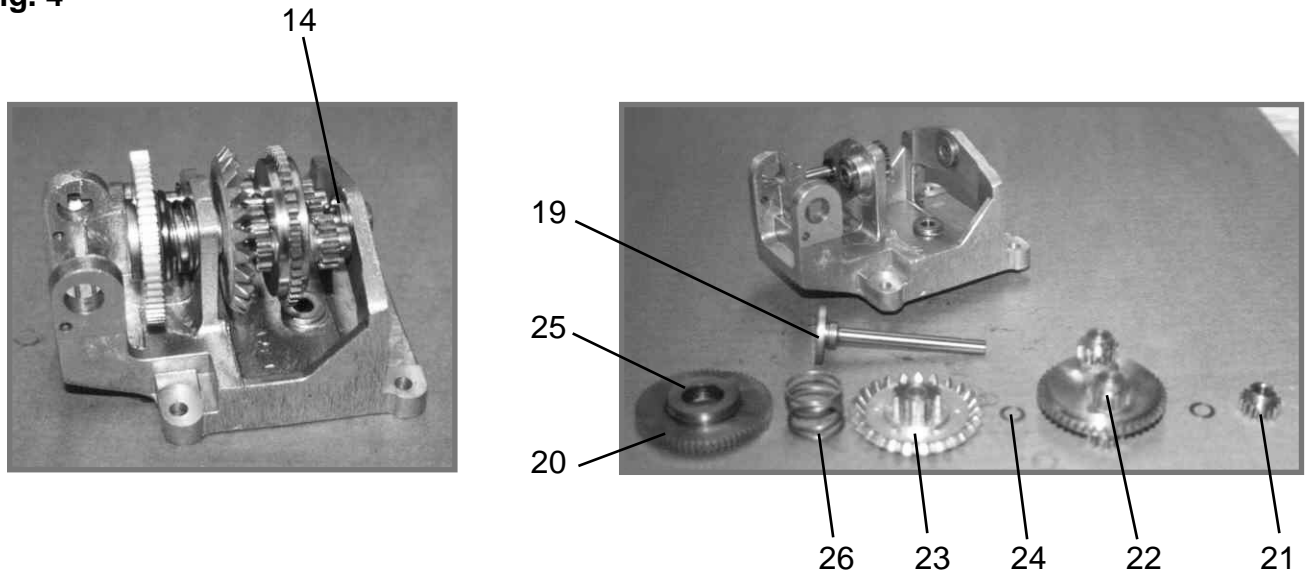


Fig. 5

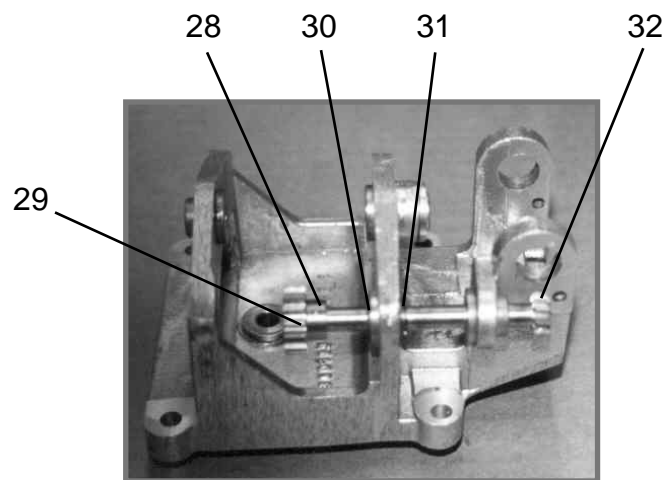
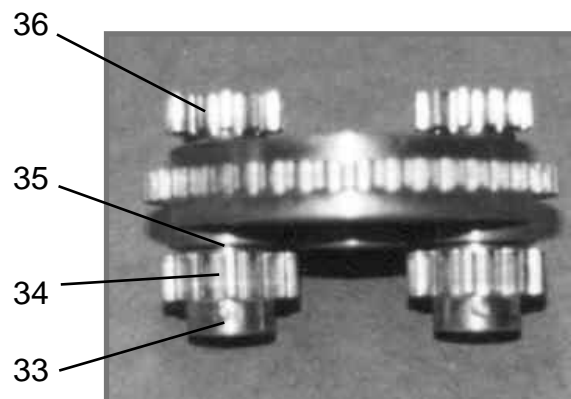


Fig. 6



## 4. Dismantling the friction-disc : ( Fig .4 )

- Remove the pin (18) from the friction-disc (19).
- Push the friction-disc forward until the pinion (20), level with the friction-disc, comes up to the frame.
- Separate the pinion from the disc and remove the latter from the frame.

Remove alternately :

- The pinion (21),
- The driving pinion (22),
- The conical pinion (23),
- The washers (24).

With the friction disc removed from the frame, remove :

- The thrust bearing and the thrust plate (25),
- The pinion (20),
- The spring (26),

## 5. Dismantling of the drive axle from the driving pinion : (Fig.5)

- Remove the pin (28),
- Remove the pinion (29),
- Dismantle the two circlips (30),
- Remove the washers (31),
- Remove the wheel shaft (32).

## 6. Dismantling the driving pinion : ( Fig.6 )

- Remove the pin (33),
- Remove the pinion (34),
- Remove the washer (35),
- Remove the pinion shaft (36).

Fig. 1

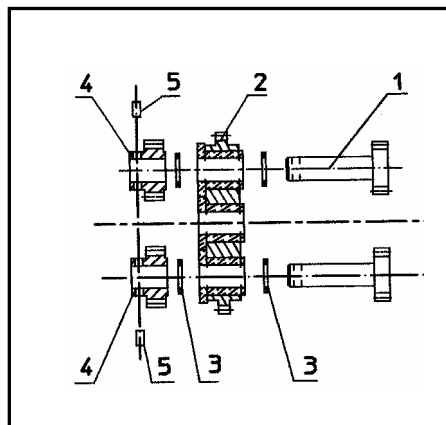


Fig. 2

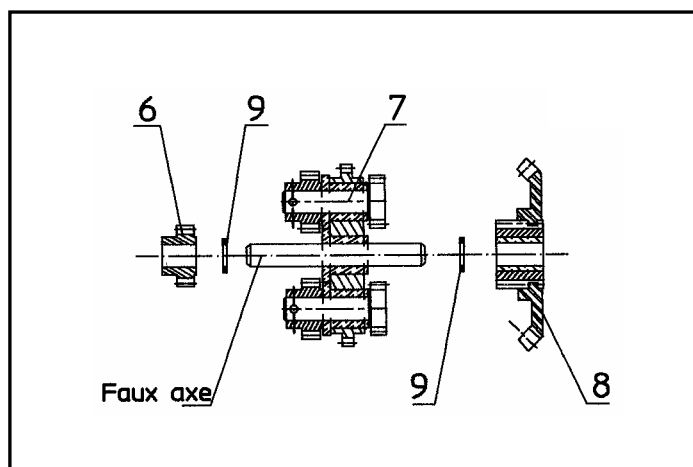
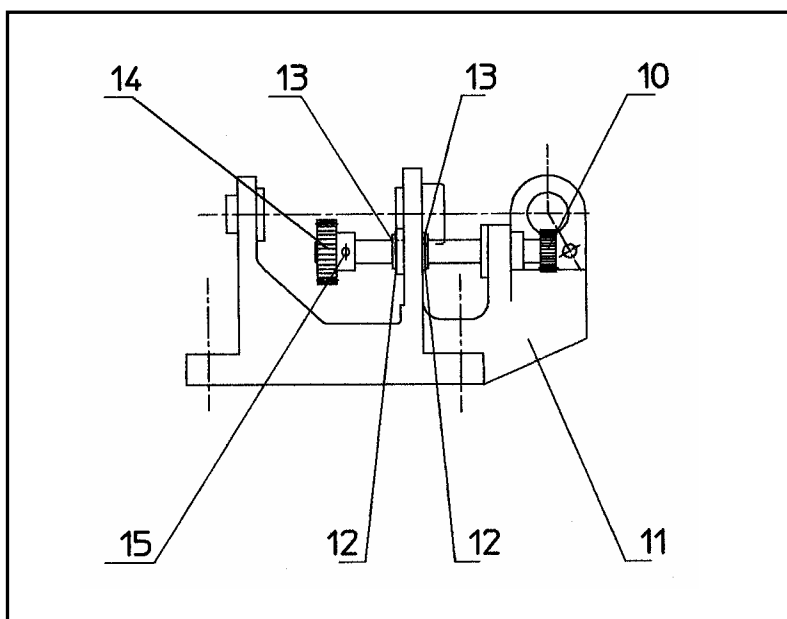


Fig. 3



## REASSEMBLING OF CALIBRATING MECHANISM AB 21

### 1. Prepare the driving pinion : ( Fig.1 )

- Assembly the shaft pinion (1) on the pinion (2).
- Assembly the washers (3).
- Assembly the pinion (4).
- Installation of the pin (5).

Control :

To make sure that all the pins of the satellites are in the same axis

### 2. Assembling the group pinion, driving pinion, conical pinion : ( Fig.2 )

On the axle, assembly :

- The driving pinion (7). To make sure that all the pins of the satellites are in the same axis.
- The washers (9).
- The conical pinion (8).
- The pinion (6).

No rotational movement at the time of the installation of the pinions (6) and (8).

Control :

To make sure that there is no hard point by manually checking the good rotation of the unit

### 3. Assembling the drive axle from the driving pinion : (Fig.3)

- Assembly the wheel shaft (10) on the body (11).
- Assembly the washers (12).
- Assembly the 2 circlips (13).
- Assembly the pinion (14).
- Installation of the pin (15).

Control :

To turn the unit manually and to check :

- The good rotation of the unit.
- No the hard point.



Fig. 4

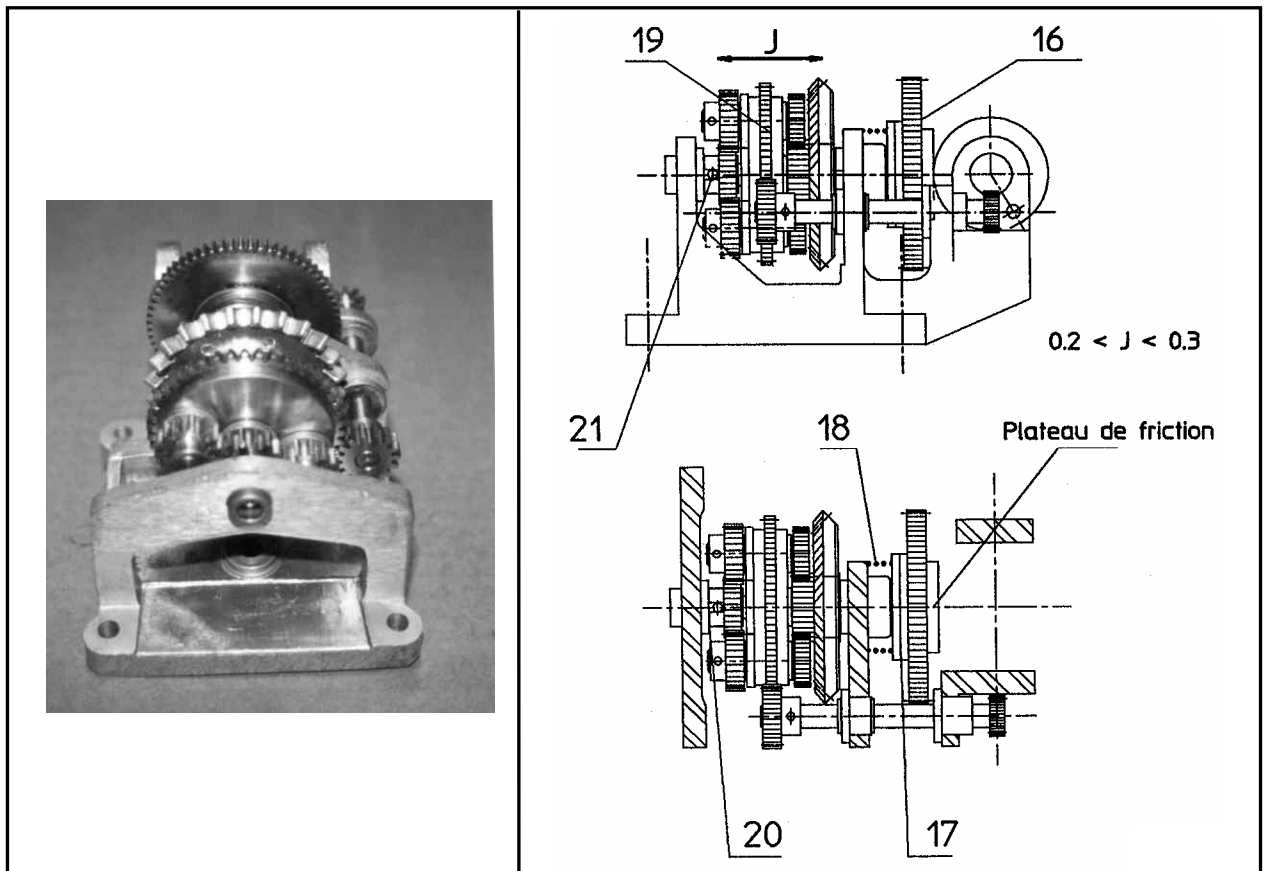
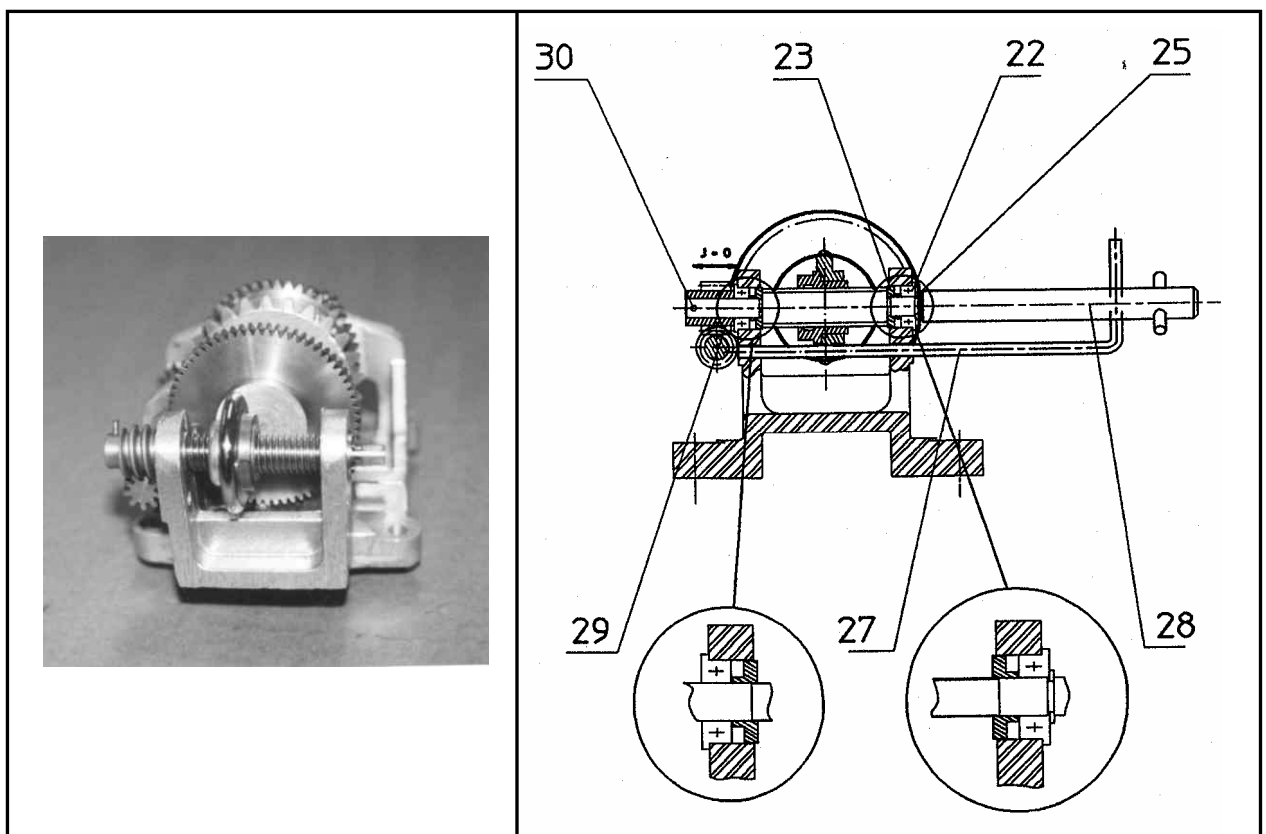


Fig. 5



## 4. Assembling the friction-disc : (Fig.4 )

On the friction disc, assembly :

- The pinion (16).
- The thrust bearing (17) and the thrust plate.
- The spring (18).

Installation of the friction-disc on the body and :

- Assembly the driving pinion (19) by pushing the false axis with the friction disk.
- Assembly the washers (20).
- Installation of the pin (21)friction disk.

Control :

To turn the unit manually and to check :

- The good rotation of the unit.
- No the hard point.
- Control side play  $0.2 < J < 0.3$ .

## 5. Assembling the driving screw : ( Fig.5 )

- Assembly the ball bearing (22) and the thrust bearing (23) on the driving screw (24).
  - Put the circlips on (25).
  - Assembly the second ball bearing and the second thrust bearing on the body.
  - Installation of the screw (24) and the roller(26).
  - Immobilise the roller (26) by putting the pin (27) through the holes in the body and the roller (26).
  - Turn the driving screw (24) using the key (28).
- (To locate the roller (26) in the middle of the friction disk)
- Assembly the screw (29).
  - Installation of the pin (30).

Control :

To turn the roller to the hand and to check:

- No blocking in rotation.
- Side play no one.

Fig. 6

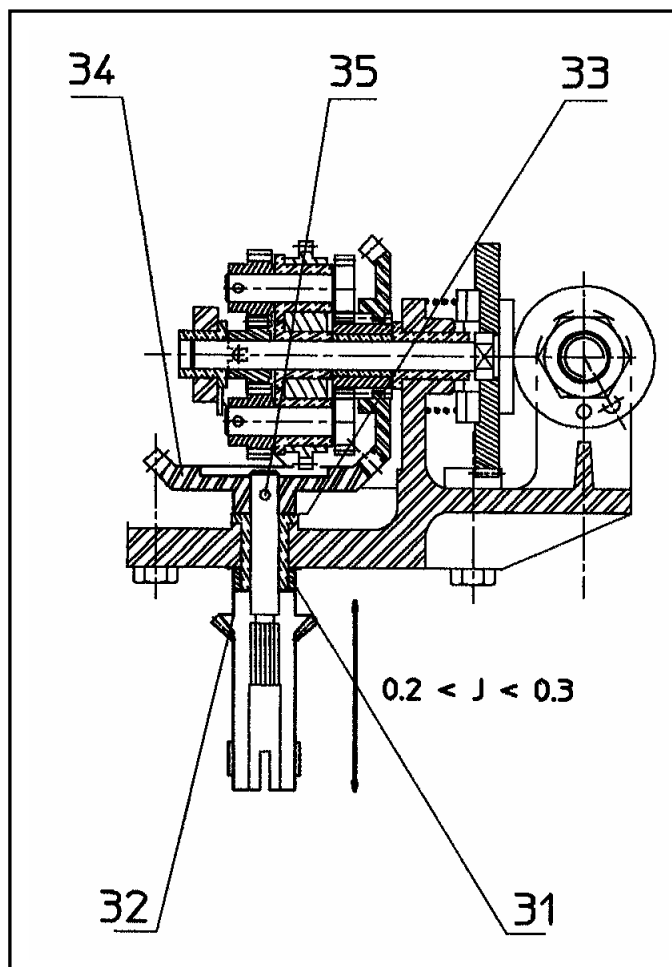
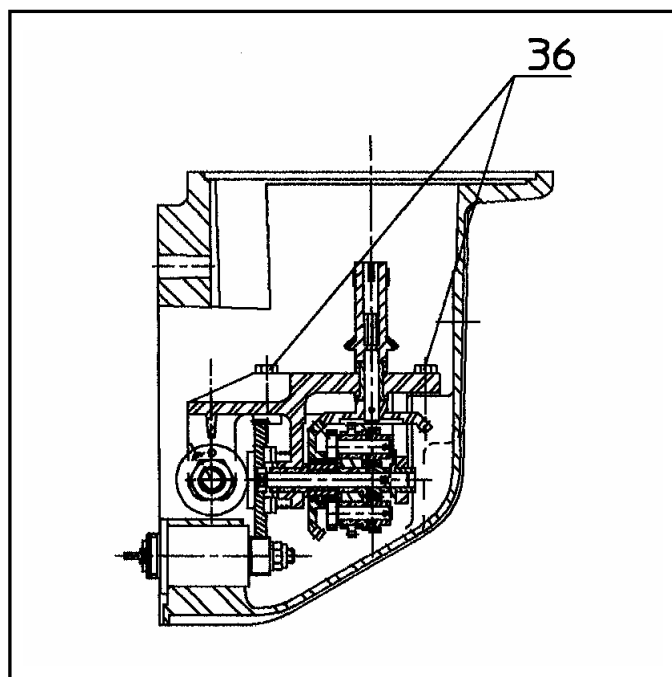


Fig. 7



## 6. Assembling the outlet axle : (Fig.6)

- Assembly the guide (31) on the shaft pinion (32).
- Assembly the washers (33).
- Assembly the shaft pinion (32) on the body.
- Assembly the conical pinion (34).
- Installation of the pin (35).

### Control :

- Correct operation of the mechanism.
- No the hard point.
- Side play  $0.2 < J < 0.3$

## 7. Assembling the mechanism to the box : ( Fig 7)

- Put the mechanism from the box.
- Assembly the 4 screws (36) fixing the mechanism to the box.

### Control :

- Operational test with swivel joint while making turn the mechanism manually.
- No the hard point.