

FIGURE 30 Lubricate the friction disc (16) with oil (16).
 (16) oil: metal friction disc and coupling (14).

CAUTION

Check coupling's condition of rotation freely.

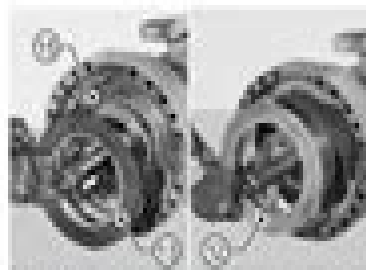


FIGURE 31 Mount parts in the following sequence: internal shaft disc (16), friction disc (15), and external intermediate disc (13).



FIGURE 32 Mount the thrust disc (15), springs (17), and screws (18).

CAUTION

Check disc (15) rotation direction and the engagement of shaft and screw (18) correctly.

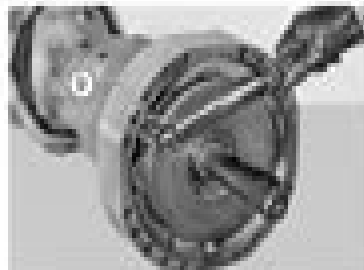


FIGURE 33 Tighten screws (18) sequentially and in several stages to a torque of 20 ~ 30 N·m.



FIGURE 34 Fit a coil spring (20) on the brake cylinder (19). Connect the connector pin (21) to a fixed end (22) in the main body (23).

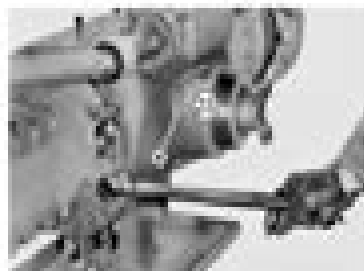


FIGURE 35 Fasten the pin to the brake cylinder (20) and fasten the pin with screws and washers (24).

(5) NOTE:

Tighten screws to make the coupling faces just touch each other.

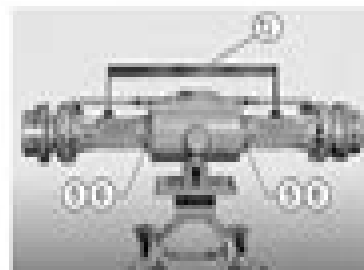


FIGURE 36 Using tool T1 (25) during T2 (26). Check that the pins are loose, then slowly back them out across (26) and replace (26) using the ultra-crease method. Tightening torque 200 ~ 300 N·m.



FIGURE 37 Adjusting pressure
 When adjusting the brake, connect a hydraulic pump to the pressure hole of the negative brake and introduce pressure of 0.1 ~ 0.2 MPa to release the brake disc.



FIGURE 38 Rotate the pin (15) counter clockwise until it reaches the end of stroke and a slight torque is obtained.

(5) NOTE:

All working clearance between discs are eliminated as a result of this operation.

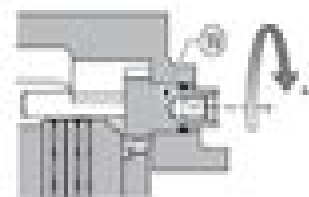


FIGURE 39 Rotate pin (15) clockwise to stop the screw into clearance.
 Allow with two friction discs: 3 turns + 3 mm clearance (0.75 mm).
 Allow with three friction discs: 3 turns clearance 1 mm.

(5) NOTE:

Every turn of the pin produces a clearance of 0.1 mm.



FIGURE 40 Release pressure. If the cable (16) is not fast with screw (25) coated with Loctite (14). Tighten screw to a torque of 20 ~ 30 N·m.

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