

**Original instructions**

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**WARNING:** Before operating the tool, read carefully the following instructions and the Safety Guide instructions.

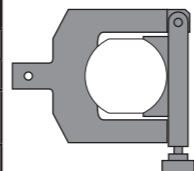
- To avoid damaging the tool during disassembly, use the recommended tools.
- Any repair on the motor shall be carried out in our workshops.

**Meaning of the pictograms**

	Left hand thread
	When reassembling, apply the recommended glue
	When reassembling, tighten to the required torque
	When reassembling, lubricate with the required grease

**Specific tools**

Description	part number
Special wrench of 56	6159603140
Special wrench of 72	6159610310
Gear ring disassembly tools	6159610110
Pin wrench	6158020110



Special wrench

The other tools are standard tools used in mechanical workshops.

**Disassembly**
**1 - Disconnect the cable from the tool by untightening the nut**

- 1 - **Disassembling the output shaft**
  - Lay the machine horizontally on a table.
  - Remove the retainer pin from the output shaft.
  - Be careful of the spring reaction.

**3 - Disassembling the motor**

- Place a special wrench of 56mm across flats in a vice.
- Place the machine in the wrench on the flats which are closest to the motor.
- Heat the gear ring with a torch.
- Untighten the motor - left-hand thread - using a special wrench of 56mm across flats.
- Remove the coupling sleeve and the drive pinion.

**4 - Disassembling the 1st reduction gear stage**

- Place a special wrench of 72mm across flats in a vice.
- The machine should imperatively be placed on the flats of the strain gauge.
- Heat the gear ring with a torch.
- Untighten the 1st stage gear ring with a special wrench of 56mm across flats before extracting the planet cage and the washer.
- Extract the planet cage and the washers.

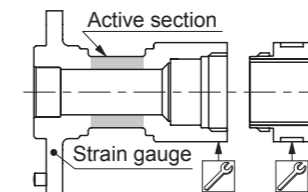
**5 - Disassembling the 2nd and 3rd reduction gear stages**

- Place a special 72mm wrench of across flats in a vice.
- The machine should imperatively be placed on the flats of the strain gauge.
- Using a torch, heat the flange nut.
- Using a special wrench of 72mm across flats, untighten the flange nut.
- Important:** leave the complete planet cages inside the gear rings before untightening them.
- Extract the complete planet cage from the 2nd stage.
- Extract the 3th stage planet cage.

**6 - Extract planet wheels, pins and the bearing from the planet cages**

To prevent any risk of ovalisation, make sure that the planet cages are in their housings before tightening the gear ring nut.

Under no circumstance shall the torques be applied at the active section of the strain gauge when assembling and disassembling, to avoid damaging the strain gauge.


**Complete reassembly**

Reassembly does not pose any problem in particular. It is important to follow all the indications which are provided, in the form of pictograms, on the drawing opposite.

Item	part number	Qty	Description
2	6156811010	1	Spindle spring
3	790.36	1	Locking pin
5	570.408	1	Protecting cap
6	6155952340	1	Spring guide
7	656.159	1	Lip seal
8	687.29	1	Circlip
9	658.61	1	O-Ring
10	6154751830	1	Planet cage
14	6154760830	1	Flange-fit gear ring
18	6156071500	1	Flange nut
19	6157901100	6	Pin
21	6154760710	1	Gear ring
22	6156420690	2	Washer
24	6155751030	1	Coupling sleeve
25	6153942560	1	Motor
28	6157880070	12	Needle bearing
31	6157581180	1	Bearing
32	6155952360	1	Stop
33	570.407	1	Protecting cover
34	6156100310	2	Screw
38	6157850680	1	Needle socket
39	6155210740	1	Output shaft 1"
40	6155703995	1	Deforming element
44	6155801160	1	Drive pinion
45	6154751520	1	Planet cage
46	6154701080	6	Planet wheel
47	6154751510	1	Planet cage
49	6154701120	4	Planet wheel
50	6156350330	4	Pin
51	6159381060	1	Connector

EME80-40J N°6151654350

