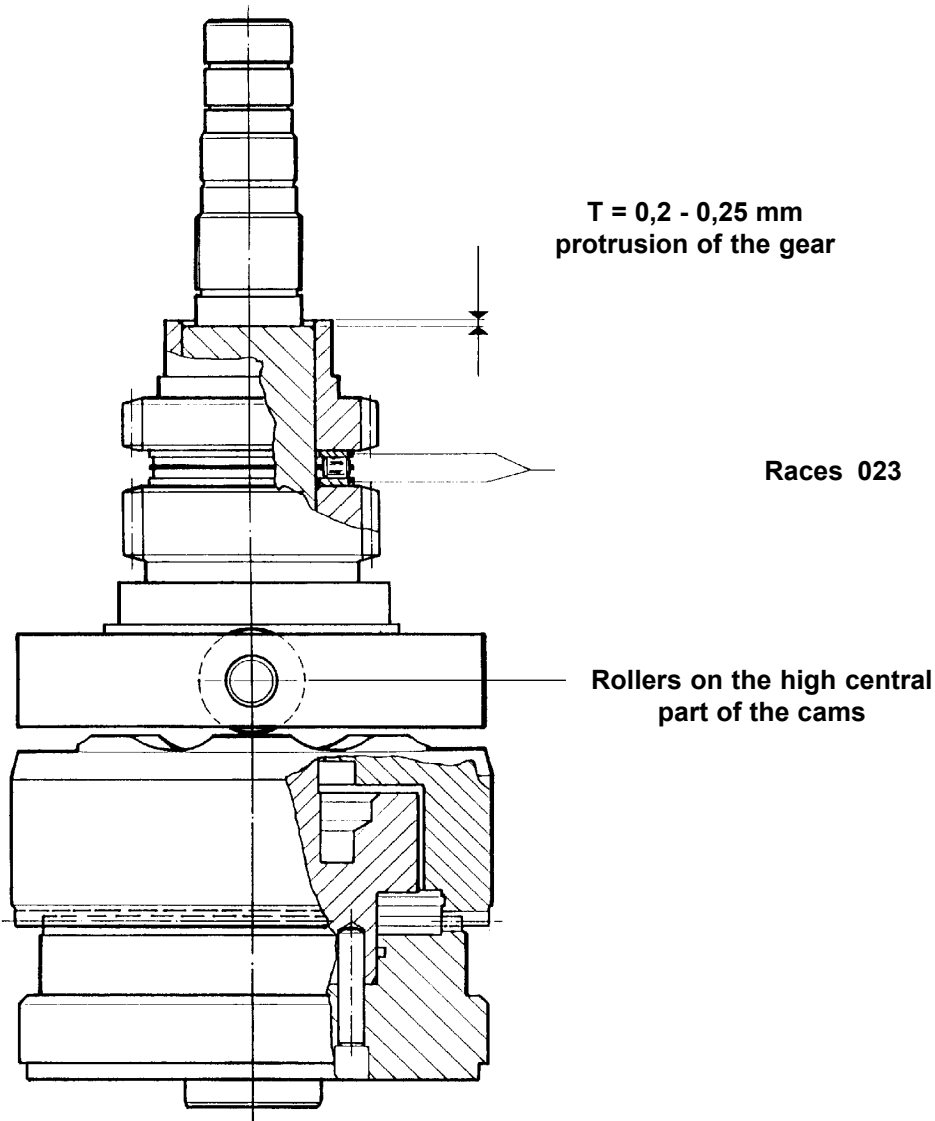


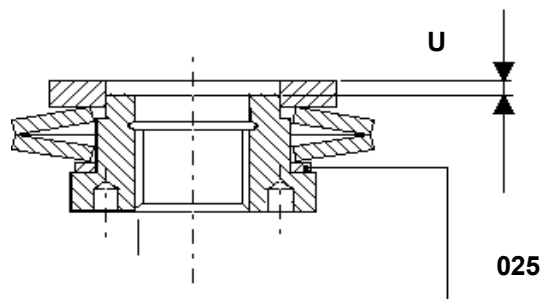


If any of the parts composing the central sub-assembly (except the satellite carrier 007), has to be substituted it is necessary on reassemble to check and reset the distances T and U which determine the correct loading of the spring.
Reassemble the parts, as shown in the figure, with the HIRTH teeth in contact and the rollers sitting on the raised parts of the cams, check that value of T is inside of the range indicated (0,2 - 0,25 mm).
If it is not then grind new races 023 to bring the value of T within the prescribed tolerance.



Assemble the parts as shown, then check that the value of U is between the ranges in the table below.
If it is not then gring a new distance piece 025 to it so that U falls within the ranges specified in the table.

Turret size	Value U (mm)
TOE 120	1,8
TOE 160	2,1
TOE 200	1,7
TOE 250	2
TOE 320	3
TOE 400	4





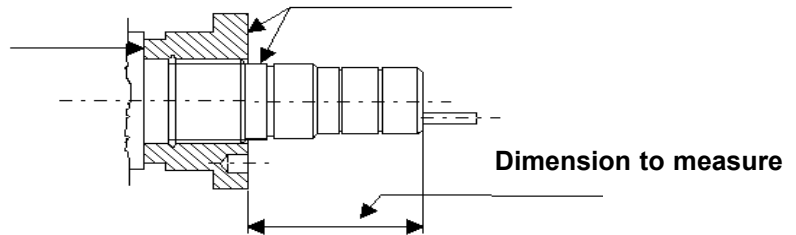
WHEN RE-ASSEMBLING EVERYTHING

- Insert the keys 309 into their corresponding key-ways (identical marks), keeping the threaded holes towards the 020 ring nut and in contact with the bottom of the key-ways.
- Check that pinion 008 has a good sliding fit. If it does not, take it off and assemble it the other way with respect to the keys.
- Check that the ring nut is thoroughly tightened. To make sure of this follow these instructions::

Before final assembly, temporarily set aside parts 026-307-025, screw down the ring nut until it touches its seating, measure the distance between the end of the divider 005 and the top surface of the ring, mark the position of the ring nut in respect to the divider.

Mark here

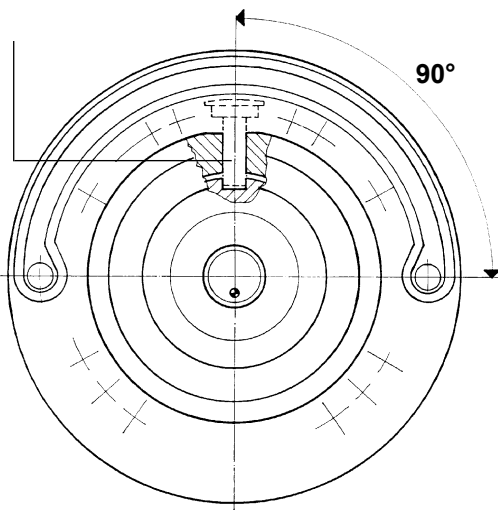
Ring nut in contact



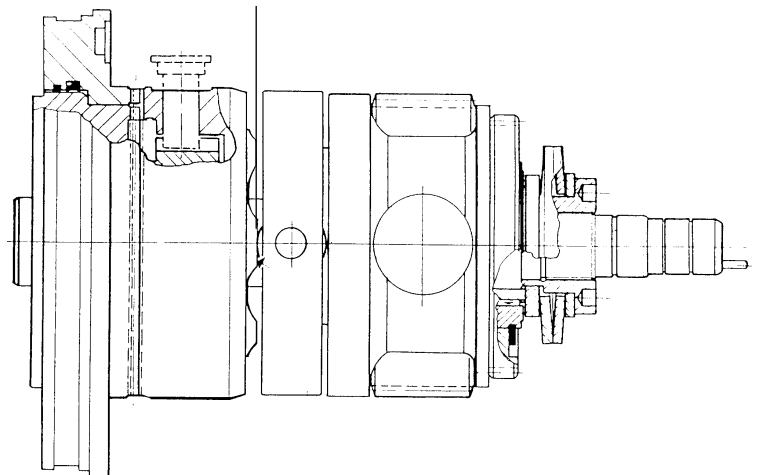
Then unscrew the ring nut, assemble the elements 026-307-025; screw on the ring nut, check that it reaches the same position as before. Make this check by measuring the distance and observing that marks coincide.

Before inserting the central sub-assembly into the carcass, rotate the satellite carrier 007 until the sealing of the latch is in perpendicular position towards the coolant interception holes of the crown 002; insert the latch 017 rotate the satellite carrier 007 by hand until the HIRTH teeth engage (rollers on the high level parts of the cams). Release the latch.

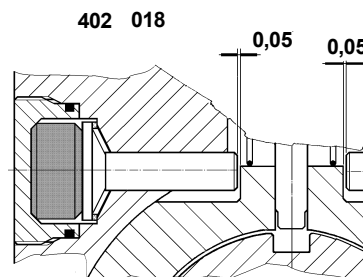
Lock socket



Rollers on the high levels of the cams



After assembling all the parts add right amount of the correct type of lubricant to the carcass through the oil hole (see page 19).



Lubricate O-ring 318 with heavy grease or vaseline.