

Assembly Instructions

2_9 009 __ 0

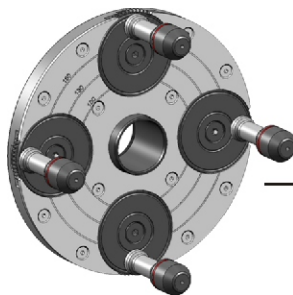


HAWEKA®

As at: February 2010

QuickPlate

Series II



All the individual parts and sub-assemblies required are detailed in the piece lists of the production and/or assembly order.

In case of doubt, consult with the head of assembly or dispatch.

Malfunctions can only be avoided by observing these Assembly Instructions precisely!

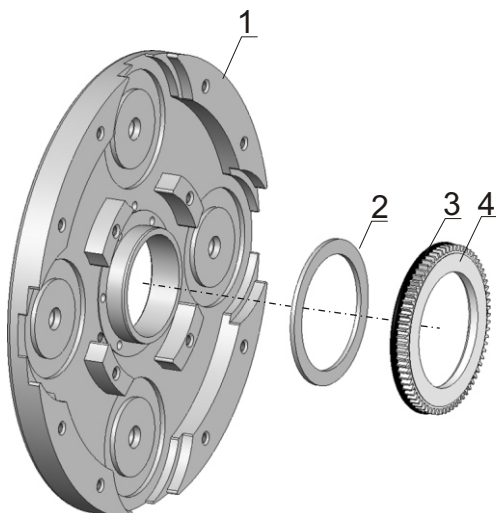
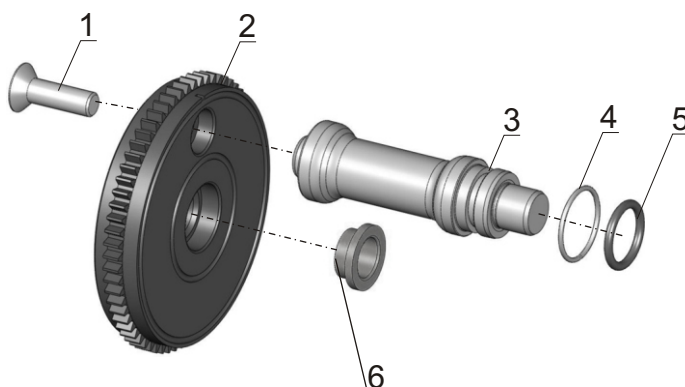
It is essential to check all the individual parts used for surface errors, oxidation, sharp edges, broken threads and other kinds of damage. Put dubious parts to one side and inform the quality assurance department.

Step 1

200e008 017 Eccentric unit

- Assemble the primary bolt (Item 3) to the eccentric disk (Item 2) with the countersunk screw (Item 1).
Then glue the countersunk screw (Item 1) with Loctite!
- Mount the spring clip (Item 4) and O-ring (Item 5).
- Press in the Flange Bush (Item 6).

Item	Article No.:	Designation:
1	D07991 06020	Countersunk screw M6x20
2	200e008 018	Eccentric disk
3	273e008 022	Primary bolt
4	DU FE16023	Spring clip ø16
5	D03771 13002	O-ring ø13x2
6	DU BU1606	Flange Bush



Step 2

- Assemble the O-ring (Item 3) onto the head cogwheel (Item 4).
- Position the thrust washer (Item 2) and head cogwheel with O-ring (Items 3+4) onto the base plate (Item 1).

Item	Article No.:	Designation:
1	2_9e008 003	Base plate
2	200e008 004	Thrust washer t=2mm
3	D03771 67003	O-Ring ø67x3
4	200e008 0__	Head cogwheel

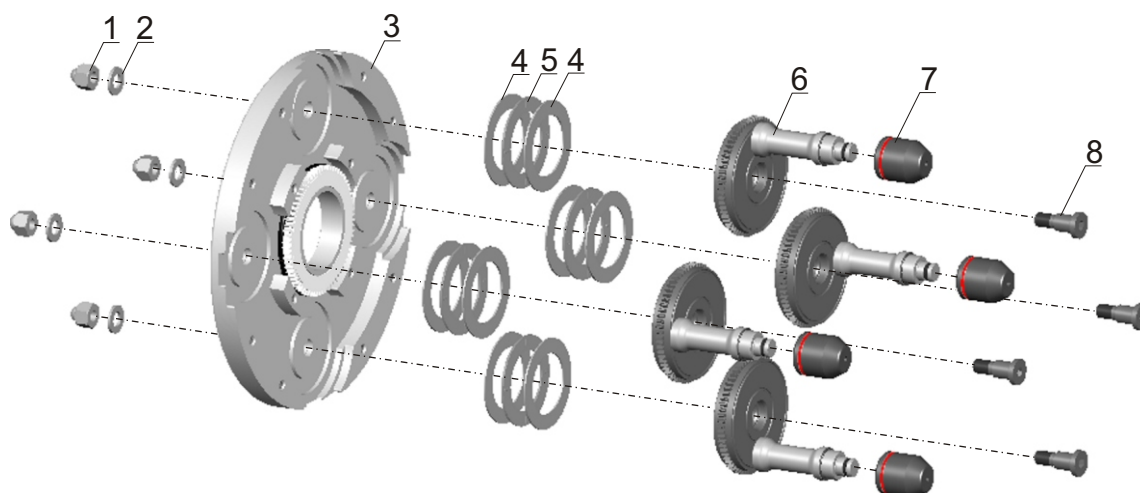
Base plates:	Head cogwheels:
-249e008 003 4-fold	-200e008 013 4-fold
-259e008 003 5-fold	-200e008 014 5-fold
-269e008 003 6-fold	-200e008 015 6-fold

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Step 3

- The number of eccentric units (Item 6) is detailed in the piece list of the production and/or assembly order!
- Place the axial bearing disks (Item 4) and axial needle roller cage onto the base plate (Item 3).
- Then position the eccentric unit (Item 6) and plug on the bolt head (Item 7). (see Pages 3+4 for arrangement of bolt heads)



In order to adjust synchronous running, the notch (2) on the eccentric disk must be aligned with the corner (1) of the base plate! (see Fig. 1)

Subsequently check the positioning of the eccentric units with the assembly hole gauge! (see Fig. 2)

- Lastly, insert the threaded bolt (Item 8) into the eccentric unit (Item 6), mount with washer (Item 2) and cap nut (Item 1).

Item	Article No.:	Designation:
1	D00986 00008	Cap nut M8
2	D00125 00008	Washer ø8,4x16x1,6
3	2_9e008 003	Base plate
4	DU AS35052	Axial bearing disk
5	DU AXK35052	Axial needle roller cage
6	200e008 017	Eccentric unit
7	273e008 0__	Bolt head
8	200e008 011	Threaded bolt

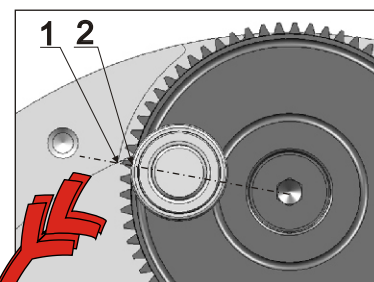


Fig.1

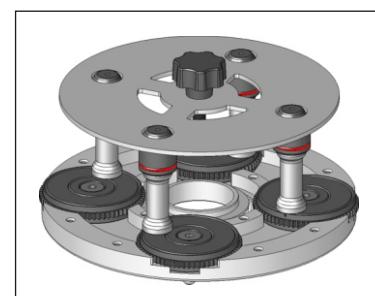
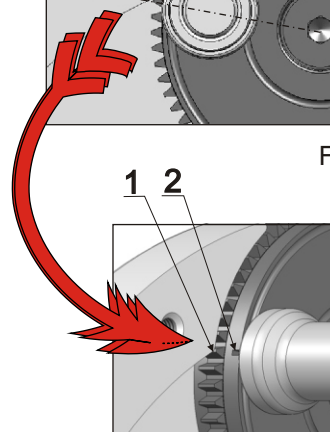


Fig.2

Assembly Instructions

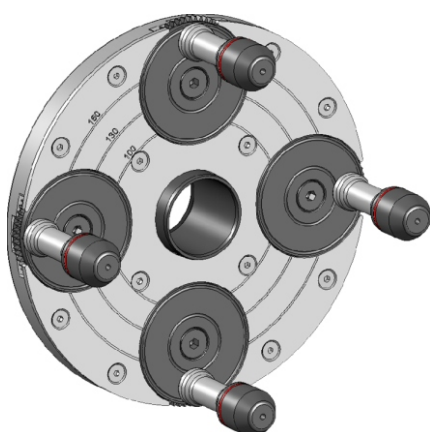


QuickPlate

Series II

QuickPlate 4

Order No.: 249 009 xx0



Models

Standard
(in the scope of supply)



273e008 002
Head length: 28 mm
Blunt cone
Ø 24,5 mm

Option I



273e008 004
Head length: 48 mm
Blunt cone
Ø 24,5 mm

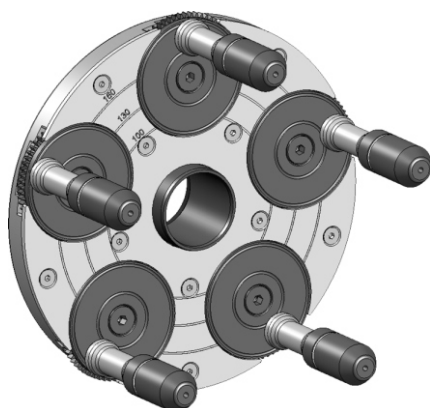
Option II



273e008 011
Head length: 48 mm
Sharp cone
Ø 22,5 mm

QuickPlate 5

Order No.: 259 009 xx0



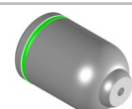
Models

Standard:
(in the scope of supply)



273e008 011
Head length: 48 mm
Sharp cone
Ø 22,5 mm

Standard:
(in the scope of supply)



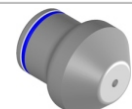
273e008 006
Head length: 38 mm
Spherical collar
Ø 24,5 mm

Option I



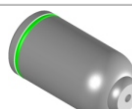
273e008 004
Head length: 48 mm
Blunt cone
Ø 24,5 mm

Option II



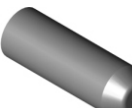
273e008 009
Head length: 38 mm
Range/Landrover
Ø 34,0 mm

Option III



273e 008 007
Head length: 48 mm
Spherical collar
Ø 24,5 mm

Option IV



273e 008 023
Head length: 55,6 mm
Sharp cone
Ø 19,0 mm

Assembly Instructions

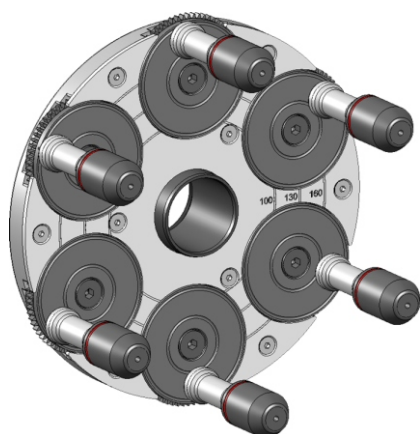


QuickPlate

Series II

QuickPlate 6

Order No.: 269 009 xx0



Models

Standard:
(in the scope of supply)



273e008 003
Head length: 38 mm
Blunt cone
Ø 24,5 mm

Option I

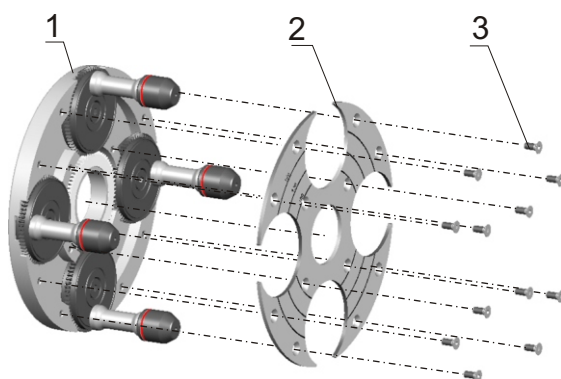


273e008 011
Head length: 48 mm
Sharp cone
Ø 22,5 mm

Option II



273e008 025
Head length: 58 mm
Sharp cone
Ø 22,5 mm



Step 4

- Before starting the assembly work, ensure that the labelling on the cover is easily legible. (Labelling: see drawings 2_9e008 002)
- Then position the cover (Item 2) on the base plate (Item 1) and mount with countersunk screw (Item 3).

Item	Article No.:	Designation:
1	2_9e008 003	Base plate
2	2_9e008 002	Cover
3	D07991 05012	Countersunk screw M5x12

Covers:

- 249e008 002 4-fold
- 259e008 002 5-fold
- 269e008 002 6-fold

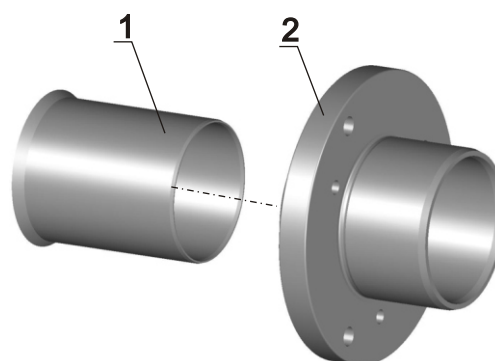
Step 5

- QuickPlates ø28, ø36 and ø38 are lined with reducer sleeves.
- To do so, press the reducer sleeve (Item 1) into the adapter (Item 2) and fix it with Loctite.

Item	Article No.:	Designation:
1	290 __ 0 001	Reducer sleeve
2	200e400 008	Adapter

Reducer sleeves:

- 290 280 001 ø28
- 290 360 001 ø36
- 290 380 001 ø38

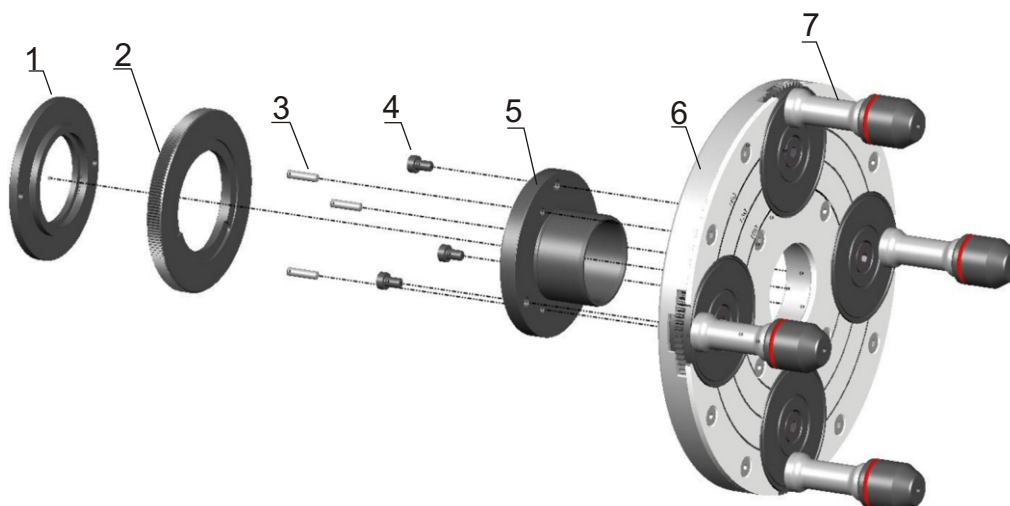


Assembly Instructions



QuickPlate

Series II



Step 6

- Plug the cylindrical pins (Item 3) into the adapter (Item 5).
- Position the adapter (Item 5) in the base plate (Item 6) and fasten with cylindrical screws (Item 4).
- Screw the adjuster (Item 2) hand-tight onto the adapter (Item 5), until the eccentric units (Item 7) are blocked.
- Subsequently mount the thrust ring (Item 1) onto the adapter (Item 5) and fix with Loctite.

Item	Article No.:	Designation:
1	200e400 002	Thrust ring
2	200e008 019	Adjuster (brake)
3	D00007 04016	Cylindrical pin $\varnothing 4 \times 6 \times 16$
4	D07984 05008	Cylindrical screw M5x8
5	200e400 008	Adapter (for QuickPlate $\varnothing 28$, $\varnothing 36$ or $\varnothing 38$ with reducer sleeve)
6	2_9e008 003	Base plate
7	200e008 017	Eccentric unit

Step 7

Functional test:

- Synchronous running of the eccentric disk
- Locking mechanism



Note

The QuickPlates are subsequently labelled by laser at Haweka.
(Labelling: see drawings 2_9 xxx xxx)