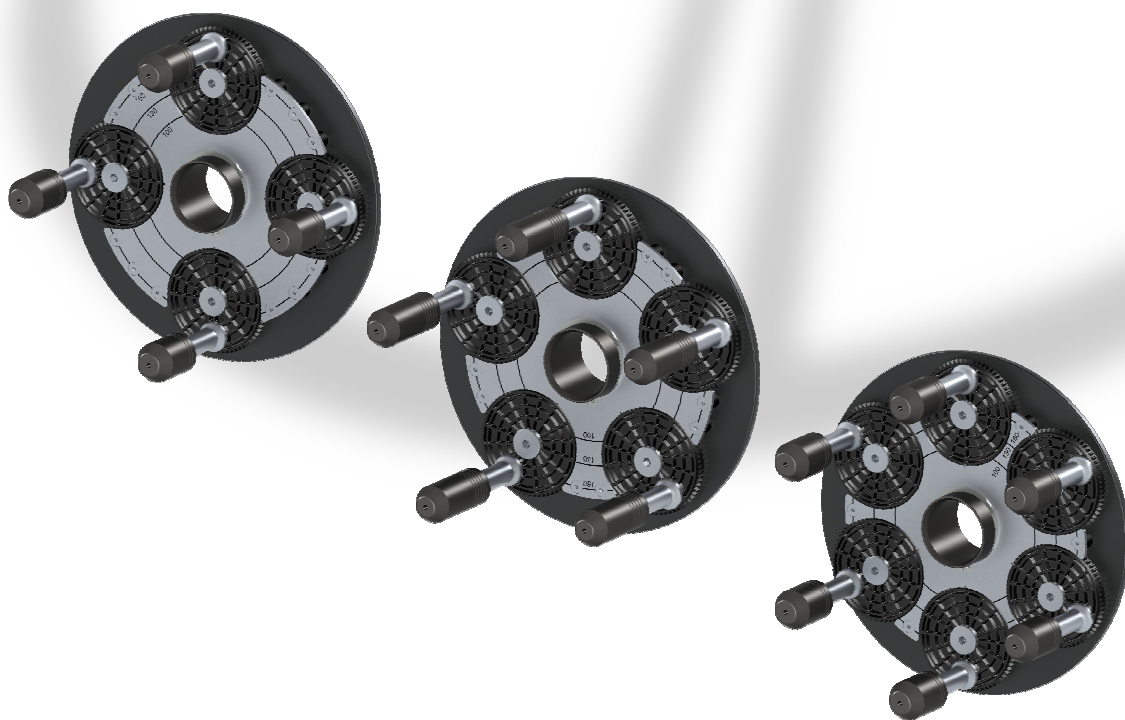


Assembly instruction

QuickPlate Series IV

valid from January 2014



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Provision of components according to production order
 Contact production manager to remove ambiguity
 Inspection of the components for surface defects, oxidation, sharp edges, thread damage and other irregularities
 If defective parts are identified, consult quality assurance

- All measurements stated in mm -

Step 1

200e008 027 Eccentric unit (pre-assembly)

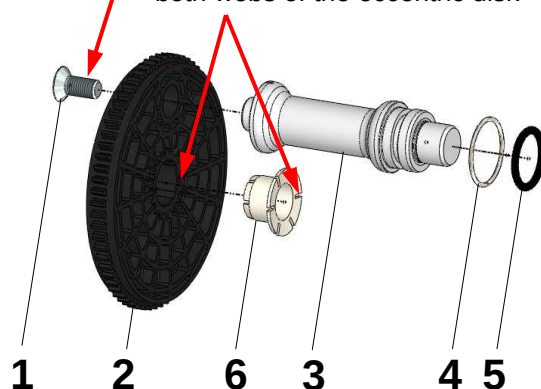
Fix stud (3) on eccentric disk (2) with countersunk screw (1). Put on spring clip (4), O-ring (5). Insert plain bearing (6) into eccentric disk (2).

Item:	Part No.:	Description:
1	D07991 05012	Countersunk screw 5x12
2	200e008 026	Eccentric disk (66 teeth)
3	273e008 027	Stud
4	DU FE16023	Spring clip
5	D03771 13002	O-ring 13x2
6	DU GL10012010	Plain bearing



Degrease thread and mount with adhesive Würth, high-strength (Part No. 0893270050)
 Tightening torque 3Nm

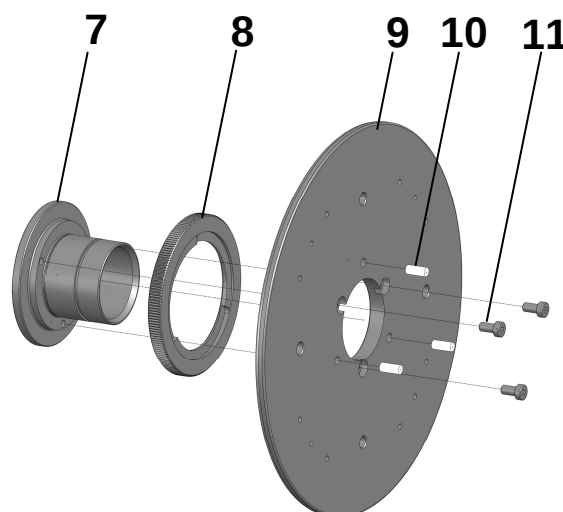
Align grooves of the plain bearing to both webs of the eccentric disk



Step 2

Put adjuster (8) and base plate (9) on adapter (7) and fix with cylinder screws (11). Insert the pins (10).

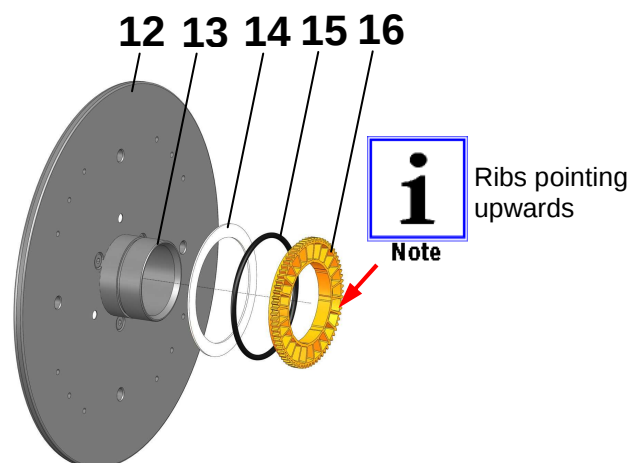
Item:	Part No.:	Description:
7	200e400 014	Adapter Ø40
8	200e008 031	Adjuster
9	249e008 012	Base plate (4-hole-plate)
	259e008 012	Base plate (5-hole-plate)
	269e008 012	Base plate (6-hole-plate)
10	200e008 033	Pin Ø5x12
11	D07984 05010	Cylinder screw M5x10



Step 3

Fit the adjusting washer (14) on the adapter (13).
After mounting O-ring (15) on the gear (16), position both parts on the adapter (13).

Item:	Part No.:	Description:
12	249e008 012	Base plate (4-hole-plate)
	259e008 012	Base plate (5-hole-plate)
	269e008 012	Base plate (6-hole-plate)
13	200e400 014	Adapter $\varnothing 40$
14	D00988 60751	Adjusting washer 60x75x1 (4-/5-hole-plate)
	D00988 63801	Adjusting washer 63x80x1 (6-hole-plate)
15	D03771 66003	O-ring 66x3
16	200e008 037	Gear 72T (4-hole-plate)
	200e008 038	Gear 75T (5-hole-plate)
	200e008 039	Gear 78T (6-hole-plate)

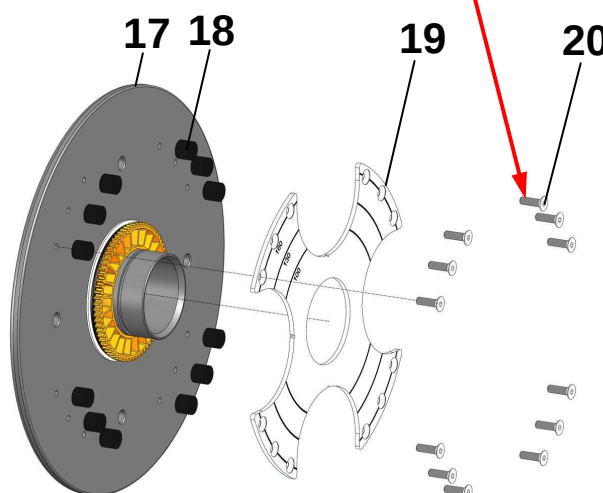
**Step 4**

Position spacer sleeves (18) on base plate (17) and mount cover (19) with countersunk screws (20) on base plate (17).

Cover (19): Make sure the labelling is clearly legible!

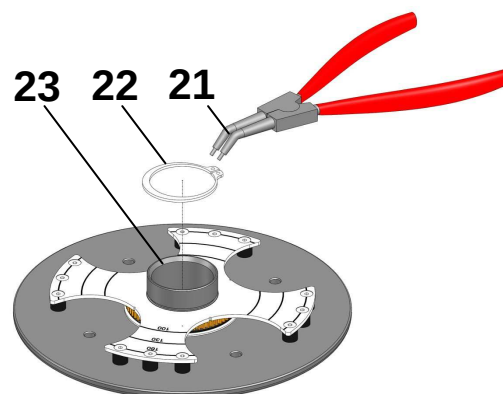
Item:	Part No.:	Description:
17	249e008 012	Base plate (4-hole-plate)
	259e008 012	Base plate (5-hole-plate)
	269e008 012	Base plate (6-hole-plate)
18	200e008 042	Spacer sleeve
19	249e008 013	Cover (4-hole-plate)
	259e008 013	Cover (5-hole-plate)
	269e008 013	Cover (6-hole-plate)
20	D07991 04014	Countersunk screw M4x14

Note Degrease thread and mount with adhesive Würth, high-strength (Part No. 0893270050)
Tightening torque 1-1,5Nm

**Step 5**

Mounting retaining ring (22) on Adapter (23) by circlip plier (21).

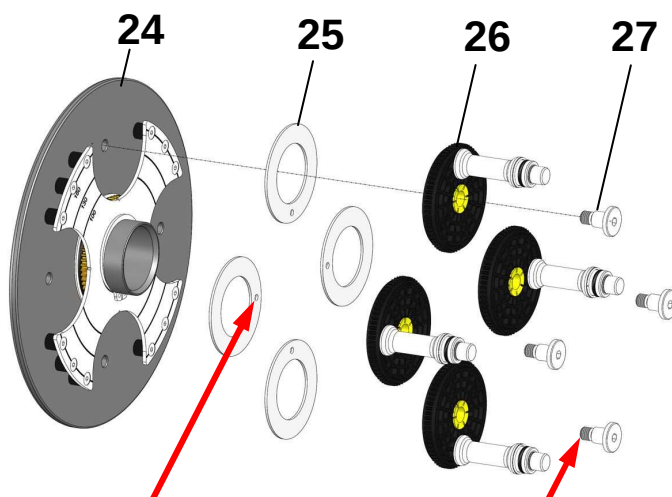
Item:	Part No.:	Description:
21	NONE	Circlip plier for shafts
22	D00471 46175VZ	Retaining ring $\varnothing 46 \times 1,75$
23	200e400 014	Adapter $\varnothing 40$



Step 6

Position eccentric units (26) with attached thrust washers (25) on base plate (24) and mount with bolts (27).

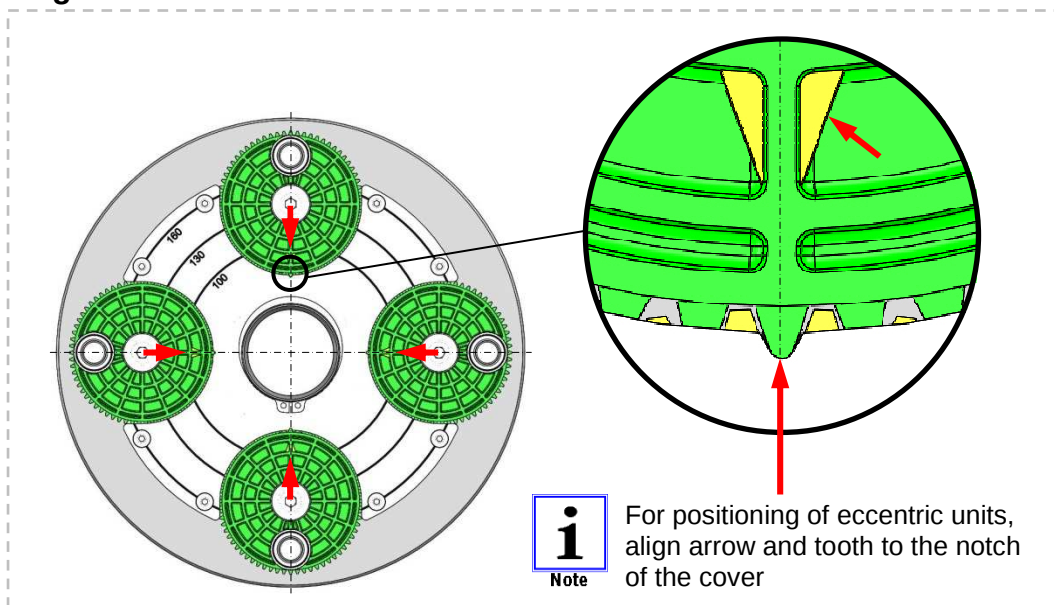
Item:	Part No.:	Description:
24	249e008 012	Base plate (4-hole-plate)
	259e008 012	Base plate (5-hole-plate)
	269e008 012	Base plate (6-hole-plate)
25	DU AN38062015	Thrust washer
26	200e008 027	Eccentric unit
27	200e008 032	Bolt

**Note**

Position spigot of eccentric disk into bore of thrust washer

**Note**

Grease thread
Tightening torque 8Nm

Alignment of eccentric units:**Note**

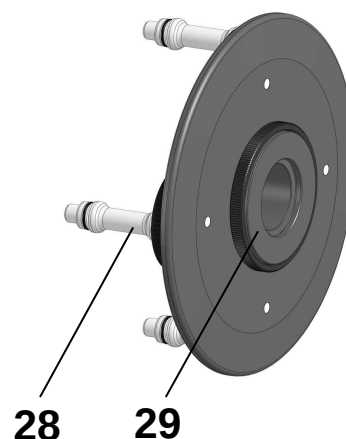
For positioning of eccentric units, align arrow and tooth to the notch of the cover

Step 7

Check free movement of all eccentric units (28) and fixing unit (29) by adjuster.

(Fixing the eccentric units on bolt circle)

Item:	Part No.:	Description:
28	200e008 027	Eccentric units
29	200e008 031	Adjuster



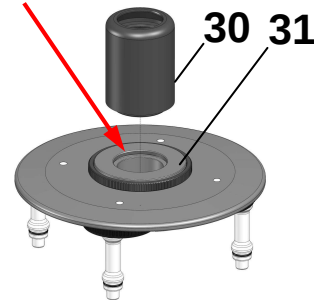
Pneumatic QuickPlate Series

Screw the pneumatic pressure piece (30) into the Adapter (31).

Item:	Part No.:	Description:
30	200e400 014	Adapter ø40
31	163 008 011	Pressure piece Hofmann-P ø40, short (-2014)
	163 008 012	Pressure piece Hofmann-P ø40, long (2014-)
	163 588 008	Pressure piece Cemb PN ø36
	163 589 008	Pressure piece Cemb PN ø40



Degrease threads of both parts and mount with adhesive Würth, medium-strength (Part No.0893243050)



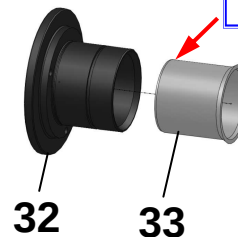
QuickPlate version ø28 to ø38

Press in reducing sleeve (33) into Adapter of QuickPlate Version ø40 (32).

Item:	Part No.:	Description:
32	200e400 014	Adapter ø40
33	290 280 014	Reducing sleeve ø40 to ø28
	290 360 014	Reducing sleeve ø40 to ø36
	290 380 014	Reducing sleeve ø40 to ø38



Degrease both parts and mount with adhesive LOCTITE 641



Laser marking according to drawings:

249 xxx xxx QuickPlate Series IV (4-hole-plate)
 259 xxx xxx QuickPlate Series IV (5-hole-plate)
 269xxx xxx QuickPlate Series IV (6-hole-plate)



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