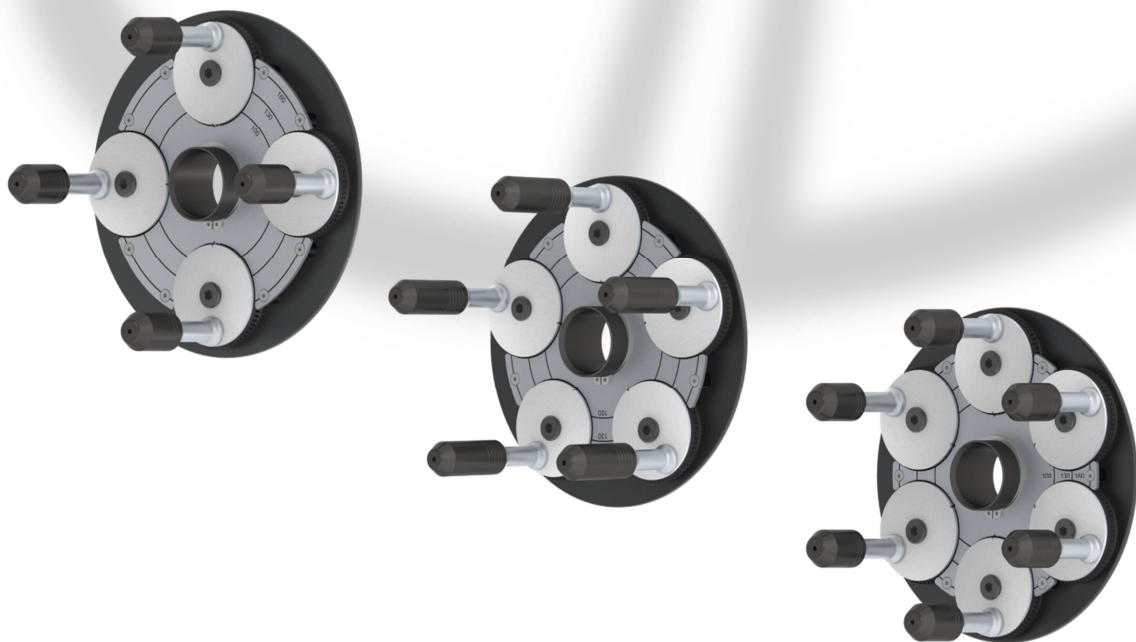


Assembly instruction

QuickPlate USA series V

2x9 013 400

valid from January 2020



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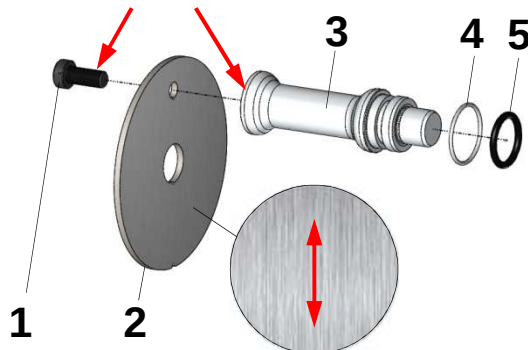
Step 1**200e008 053 tip retainer w/o eccentric disk (pre-assembly)**

Fix stud (3) with cylinder screw (1) on disk (2). Put on spring clip (4) and O-ring (5).

Item:	Part no.:	Description:
1	D07984 05012	Cylinder screw M5x12
2	200e008 051	Disk
3	273e008 031	Stud
4	DU FE16023	Spring clip
5	D03771 13002	O-ring 13x2



Degrease threads of both parts and mount with adhesive Würth, high-strength (Part no. 0893270050) tightening torque 4Nm

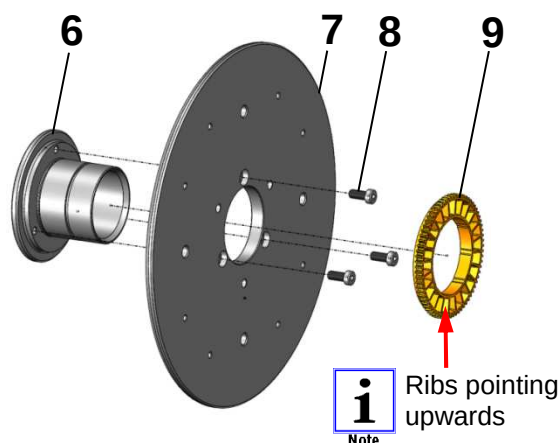


Mount the linear brushed surface on the side of the stud!

Step 2

Mount adaptor (6) with cylinders (8) on base plate (7) and fit on gear (9) subsequently.

Item:	Part no.:	Description:
6	200e400 015	Adaptor ø40
7	249e008 014	Base plate (4-hole-plate)
	259e008 014	Base plate (5-hole-plate)
	269e008 014	Base plate (6-hole-plate)
8	D07984 05012	Cylinder screw M5x12
9	200e008 037	Gear 72T (4-hole-plate)
	200e008 038	Gear 75T (5-hole-plate)
	200e008 039	Gear 78T (6-hole-plate)



Ribs pointing upwards

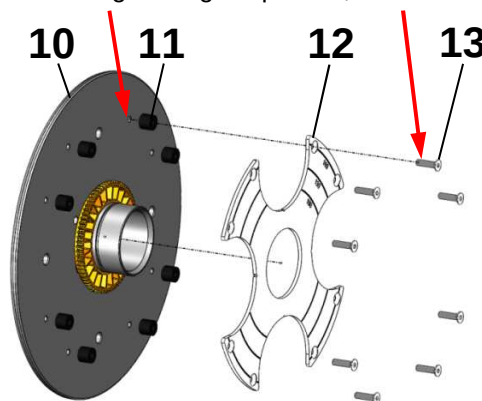
Step 3

Position spacer sleeves (11) on base plate (10). Mount cover (12) with countersunk screws (13) on base plate (10).

Item:	Part no.:	Description:
10	249e008 014	Base plate (4-hole-plate)
	259e008 014	Base plate (5-hole-plate)
	269e008 014	Base plate (6-hole-plate)
11	DU0000 00110	Spacer sleeve
12	249e008 013	Cover (4-hole-plate)
	259e008 013	Cover (5-hole-plate)
	269e008 013	Cover (6-hole-plate)
13	D10642 04016VZ	Countersunk screw M4x16



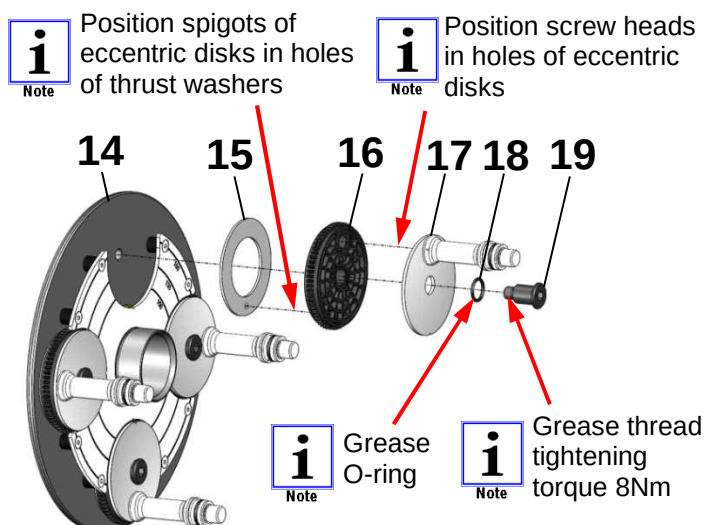
Degrease threads of both parts and mount with adhesive Würth, high-strength (Part no. 0893270050) tightening torque 1-1,5Nm



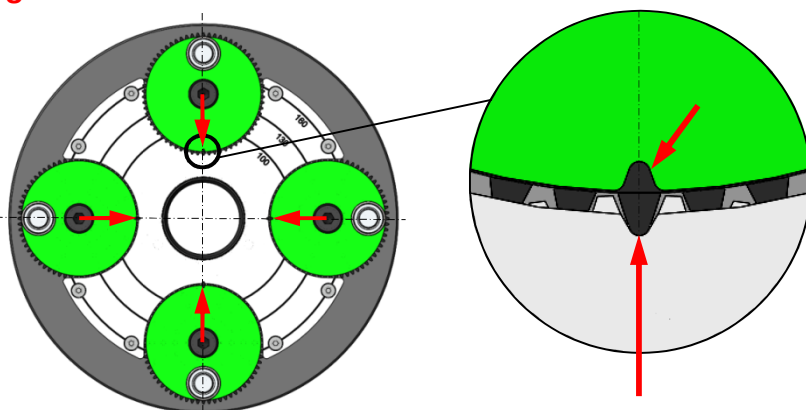
Step 4

Position tip retainers (17) and eccentric disks (16) with attached thrust washers (15) on base plate (14). Put on o-rings (18) on bolts (19). Screw eccentric units (15-17) with bolts (19) on base plate (14).

Item:	Part no.:	Description:
14	249e008 014	Base plate (4-hole-plate)
	259e008 014	Base plate (5-hole-plate)
	269e008 014	Base plate (6-hole-plate)
15	DU AN38062015	Thrust washer
16	200e008 026	Eccentric disk
17	200e008 053	Tip retainer
18	D03771 1190178	O-ring 11,91x1,78
19	200e008 052	Bolt



Alignment of eccentric units:



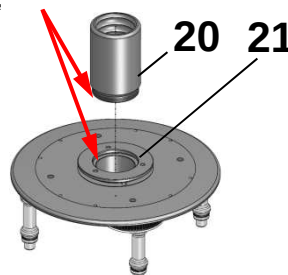
i Note
For positioning of the eccentric units, align notches in the disks to notches in the cover!

Pneumatic QuickPlate series

Screw the pressure piece (20) into adaptor (21).

Item:	Part no.:	Description:
20	163 008 012	Pressure piece Hofmann-P ø40
	163 589 008	Pressure piece Cemb PN ø40
21	200e400 015	Adaptor ø40

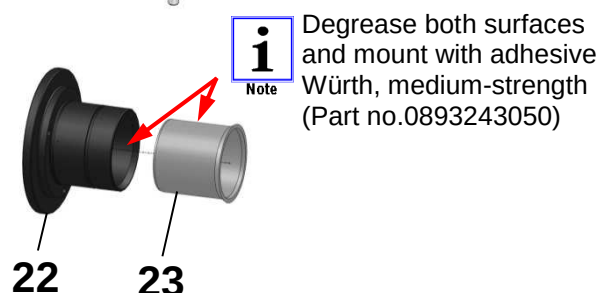
i Note
Degrease threads of both parts and mount with adhesive Würth, medium-strength (Part No.0893243050)



QuickPlate version ø28 to ø38

Insert reducing sleeve (23) into adaptor of the QuickPlate version ø40 (22).

Item:	Part no.:	Description:
22	200e400 015	Adaptor ø40
23	290 280 021	Reducing sleeve ø40 to ø28,56
	290 360 021	Reducing sleeve ø40 to ø36
	290 380 021	Reducing sleeve ø40 to ø38





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