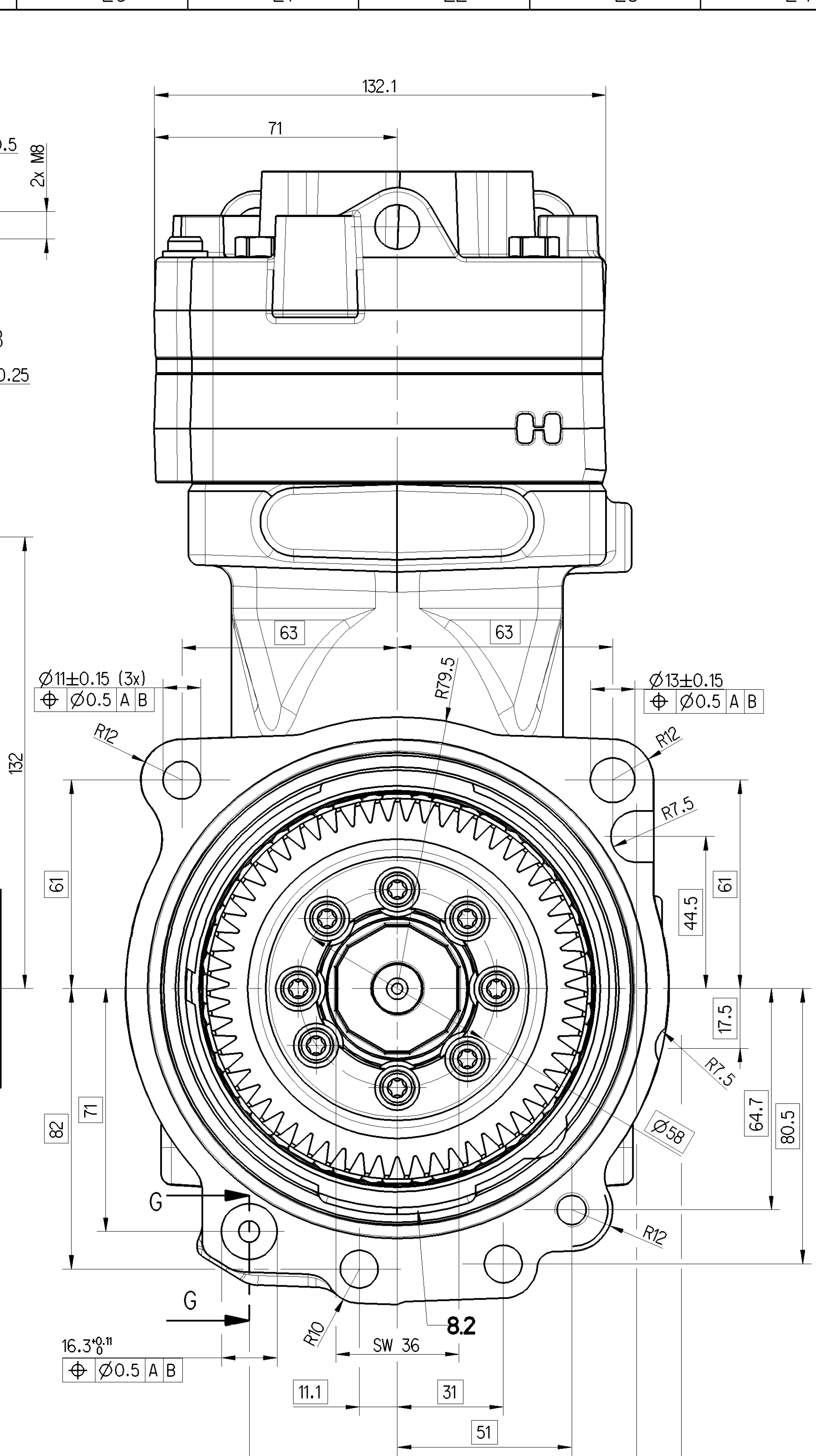
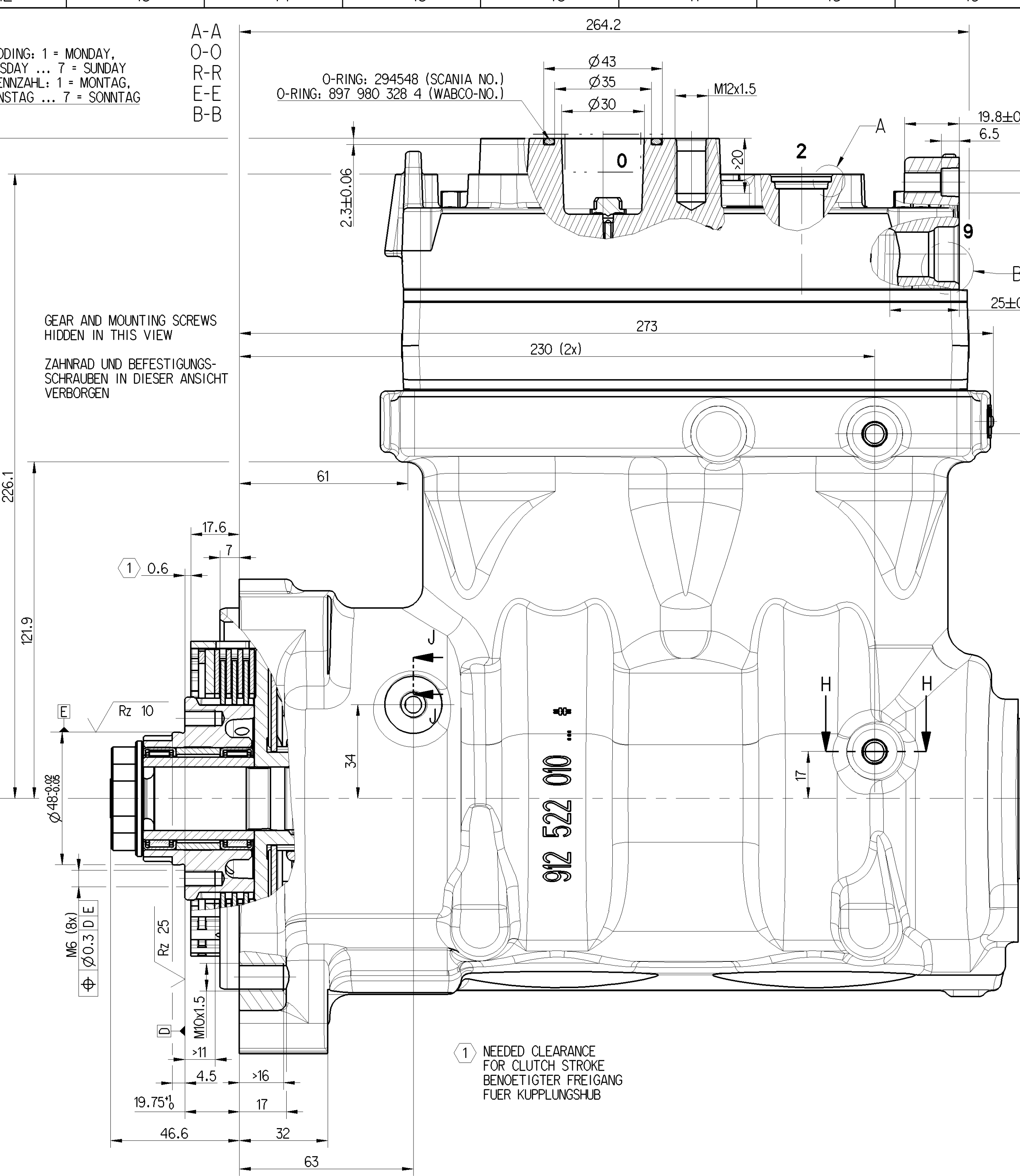
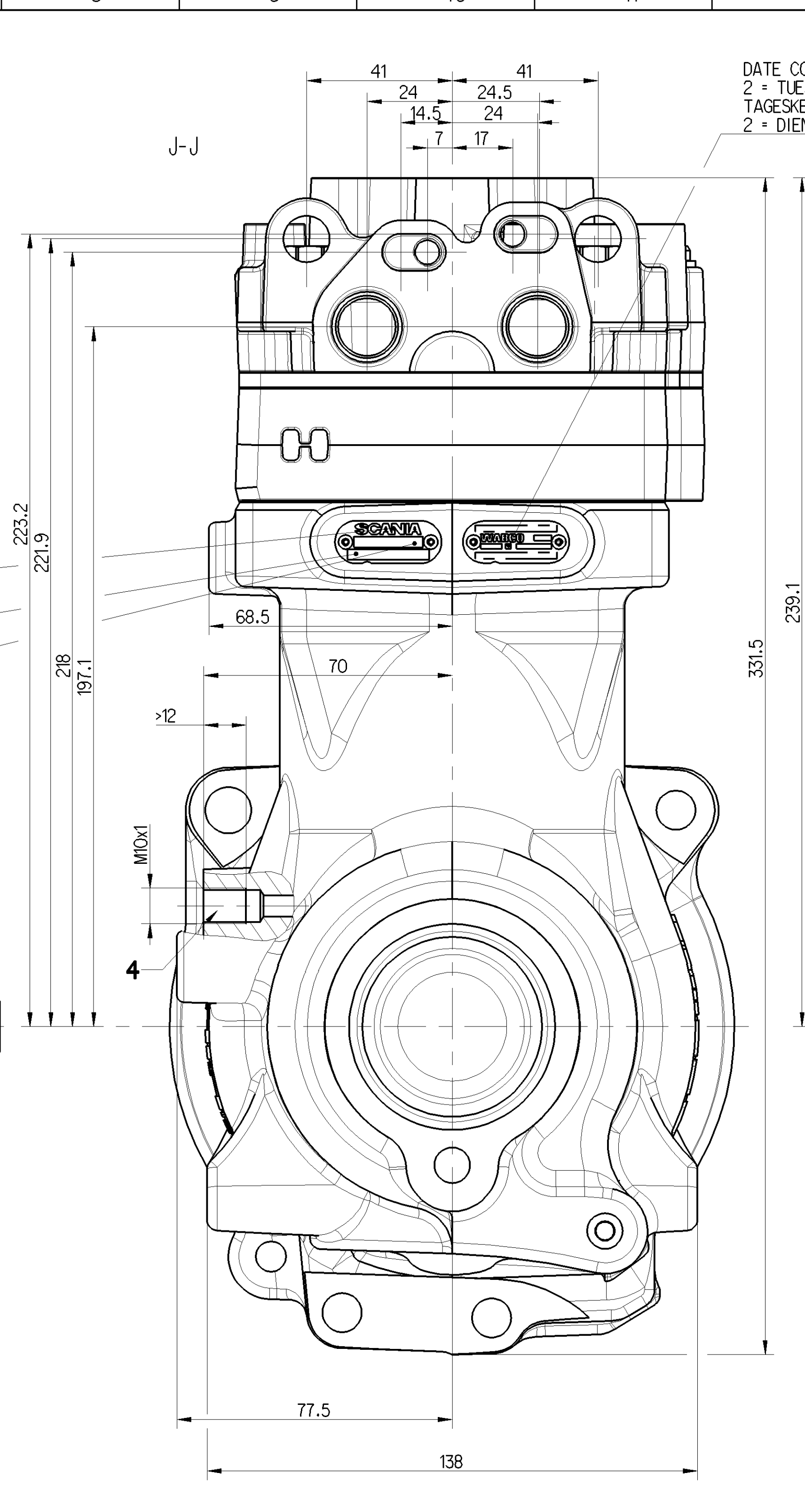
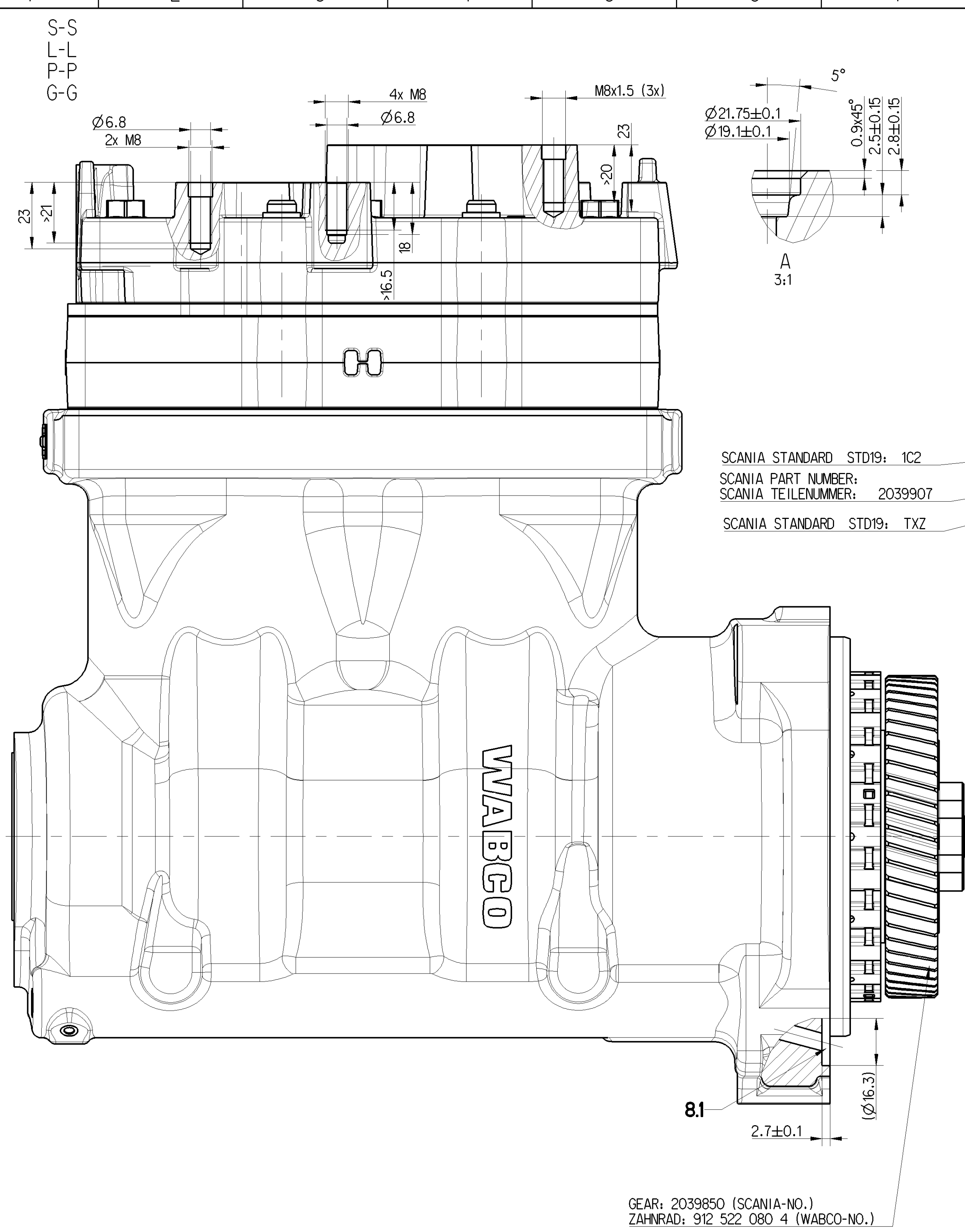




WORKING MEDIUM : AIR
BETRIEBSMEDIUM : LUFT

COOLANT : WATER WITH ANTIFREEZE
KÜHLMEDIUM : WASSER MIT FROSTSCHUTZ

BORE : Ø 85 mm
BOHRUNG : Ø 85 mm

STROKE : 56 mm
HUB : 56 mm

SWEEP VOLUME : 636 cm³
HUBRAUM : 636 cm³

MAX. WORKING SPEED : nmax = 3000 min⁻¹
MAX. BETRIEBSDREHZAHL : nmax = 3000 min⁻¹

OVERSPEED (MAX. 4 SEC.) : nue = 1.3 x nmax
UEBERDREHZAHL (MAX. 4 SEC.) : nue = 1.3 x nmax

END PLAY OF CRANKSHAFT
AXIALSPIEL DER KURBELWELLE : 0.02 ... 0.05 mm

LUBRICATION SUPPLIED FROM ENGINE
UMLAUFSCHMIERUNG MIT DRUCKÖLANSCHLUSS

MAX. WORKING PRESSURE : p = 14 bar **
MAX. BETRIEBSDRUCK : p = 14 bar **

MAX. PRESSURE (TEMPORARILY MAX. 4 SEC.) : p = 16 bar **
MAX. DRUCK (ZEITWEISE MAX. 4 SEC.) : p = 16 bar **

** MEASURING POINT: DISCHARGE PORT
MESSPUNKT: DRUCKANSCHLUSS

0 SUCTION PORT
SAUGANSCHLUSS

2 DISCHARGE PORT
DRUCKANSCHLUSS M ≤ 25 Nm

8.1 OIL SUPPLY
DRUCKÖLANSCHLUSS

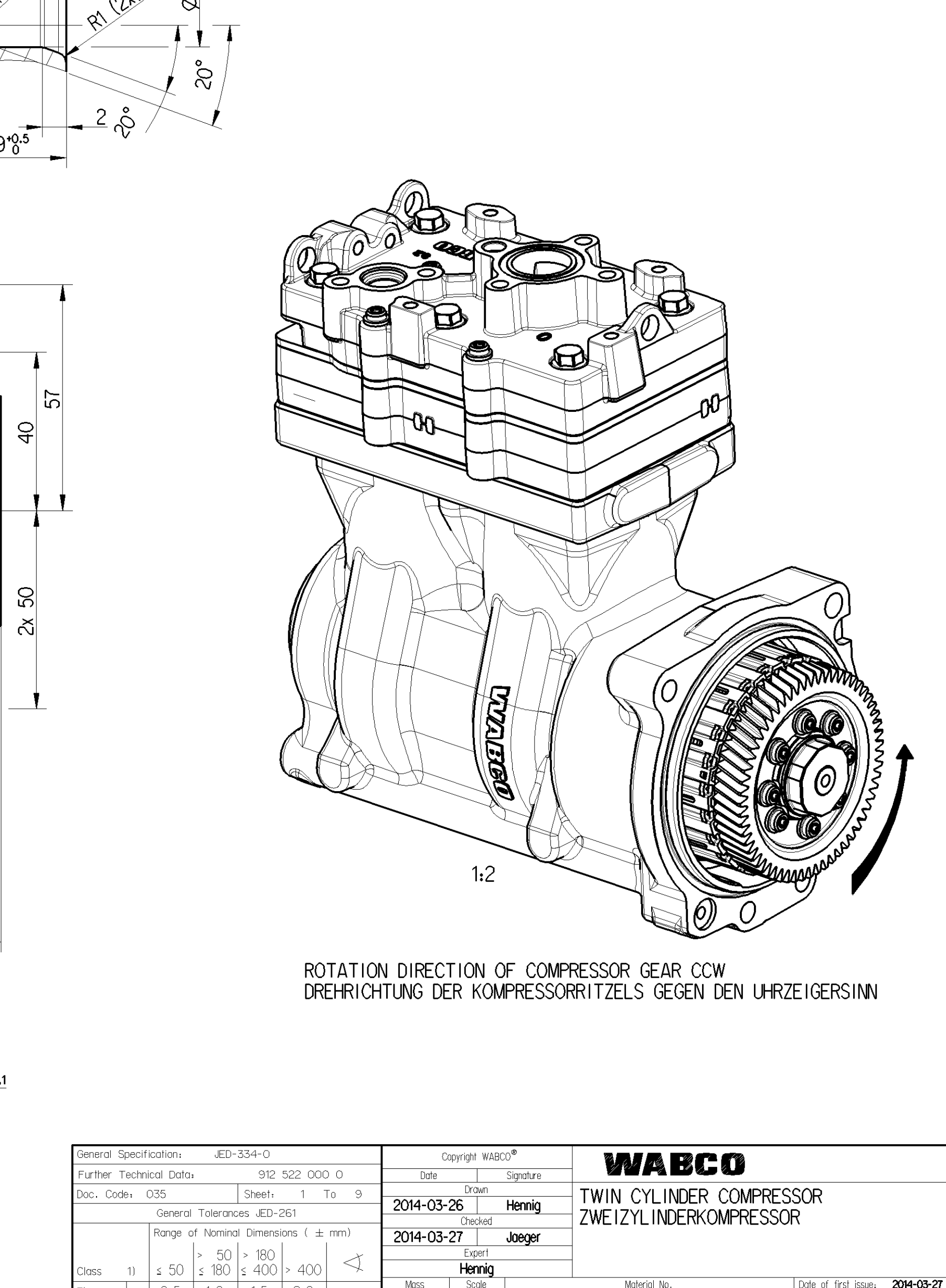
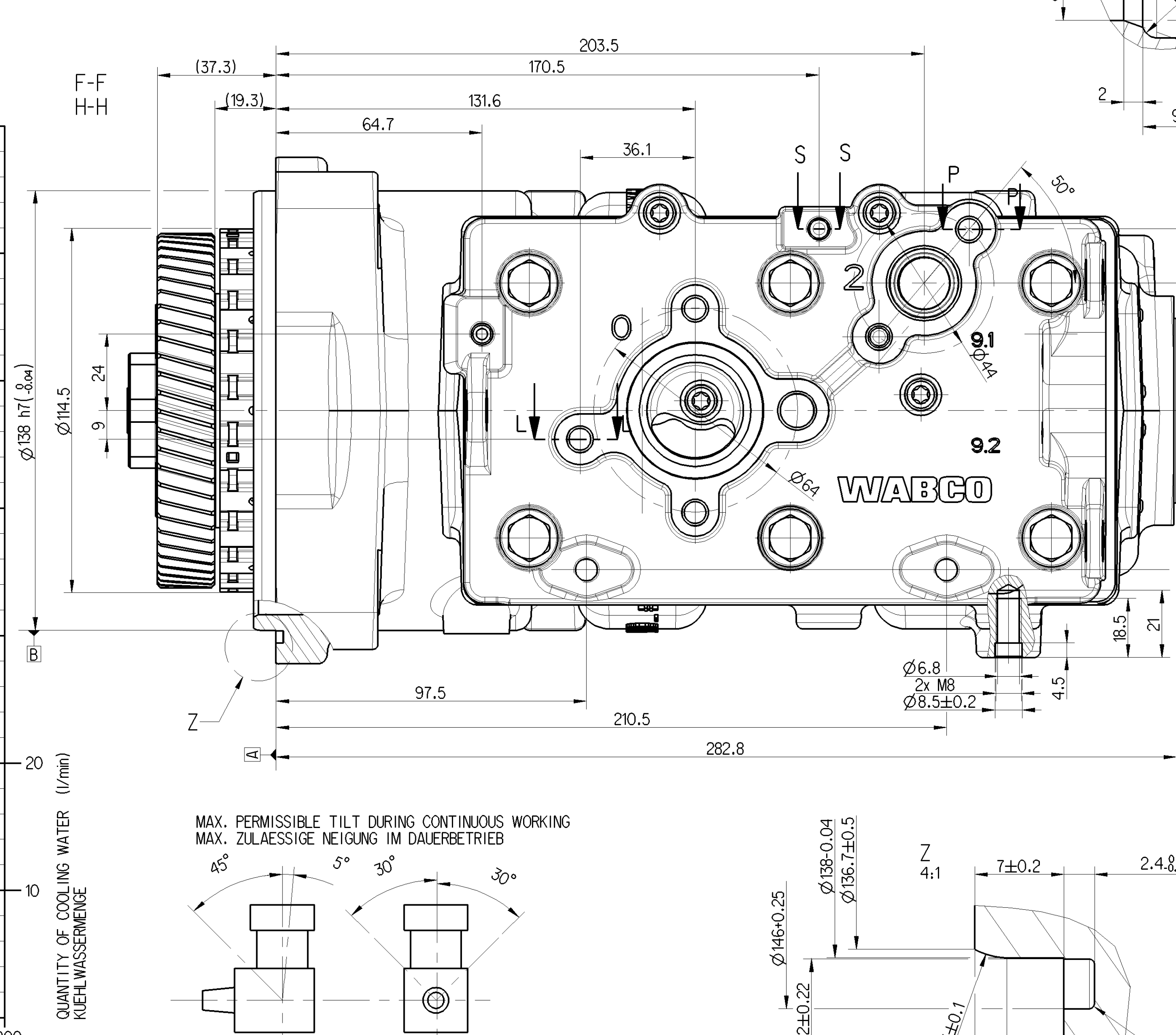
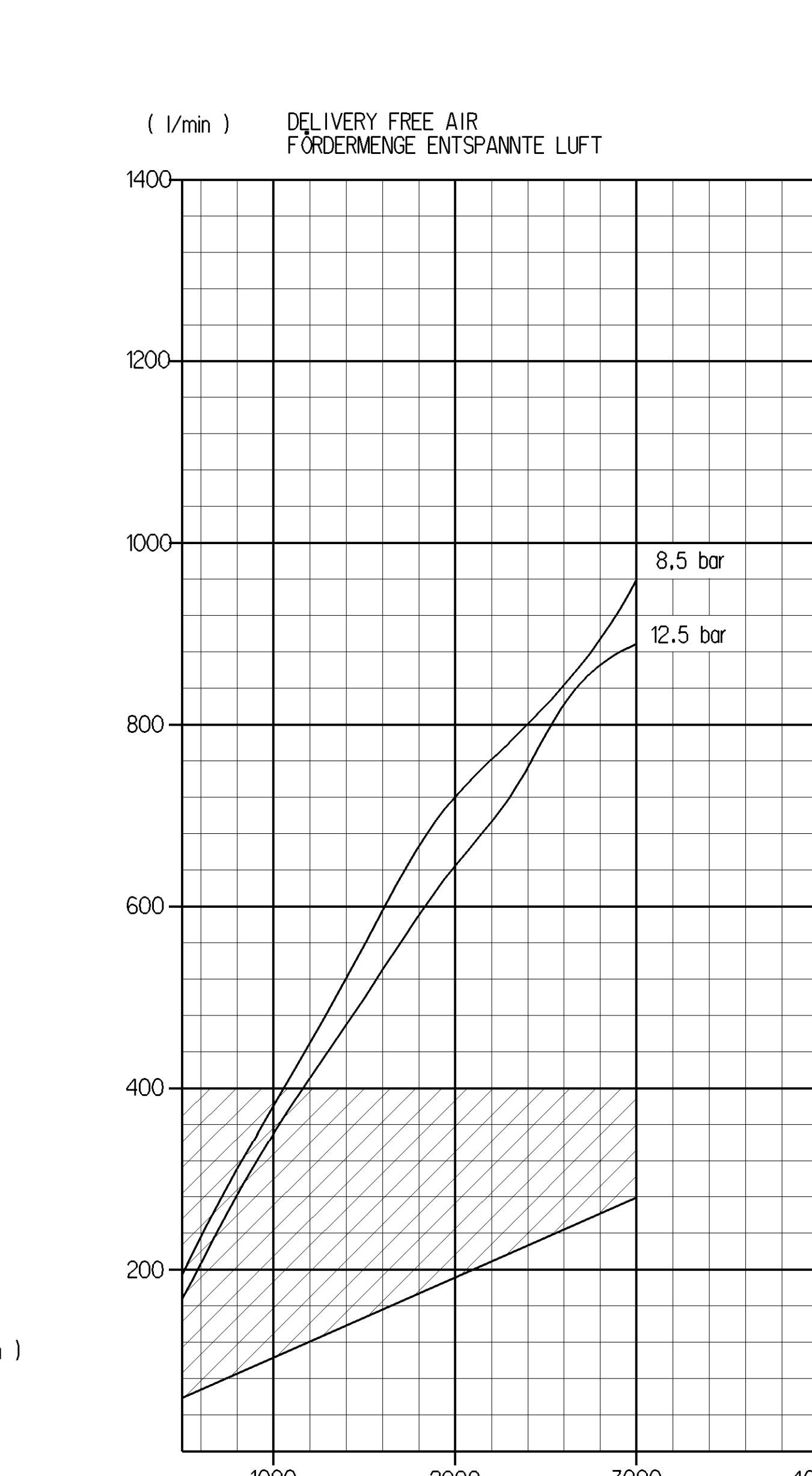
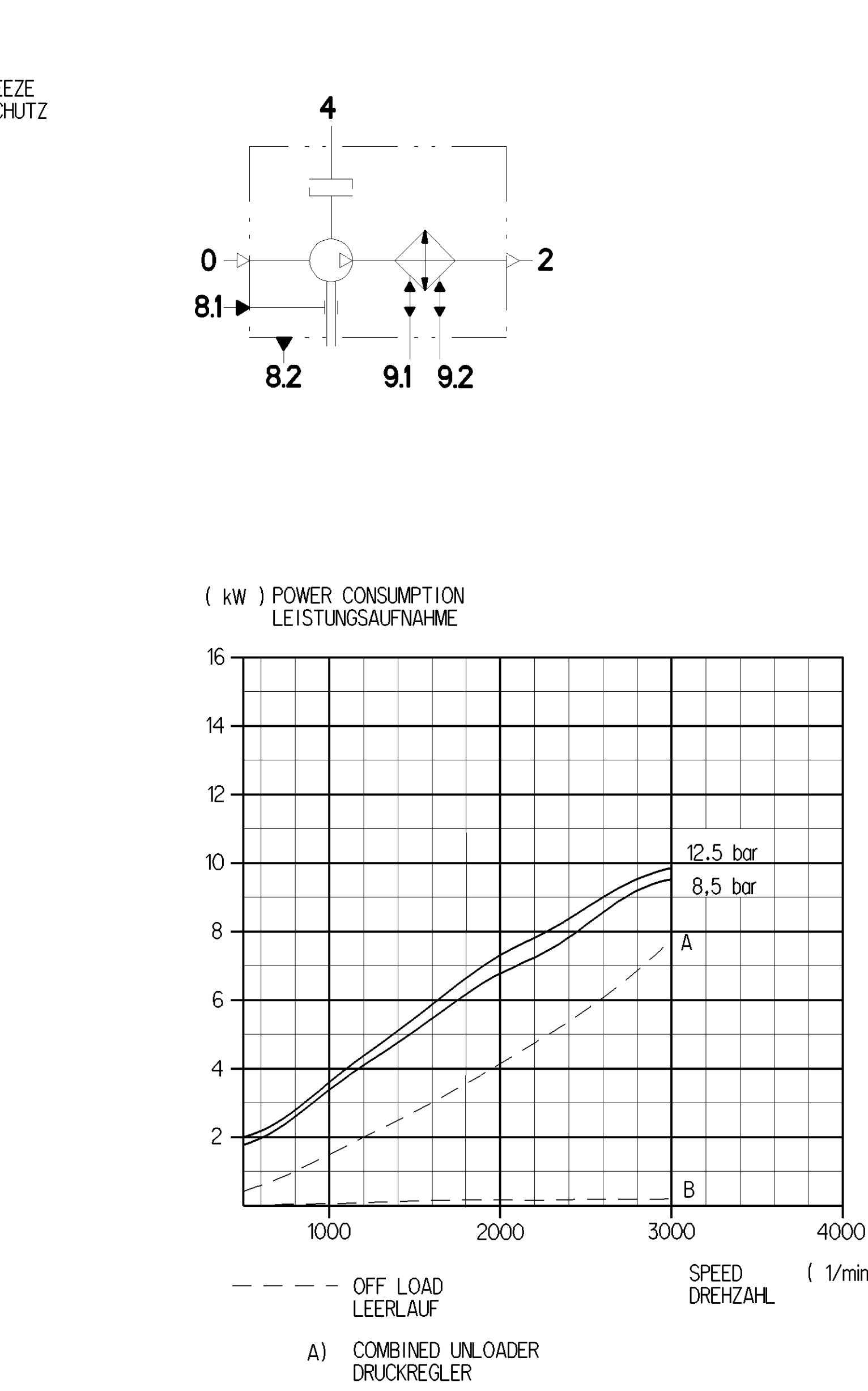
8.2 OIL DRAIN
ÖLRÜCKLAUF

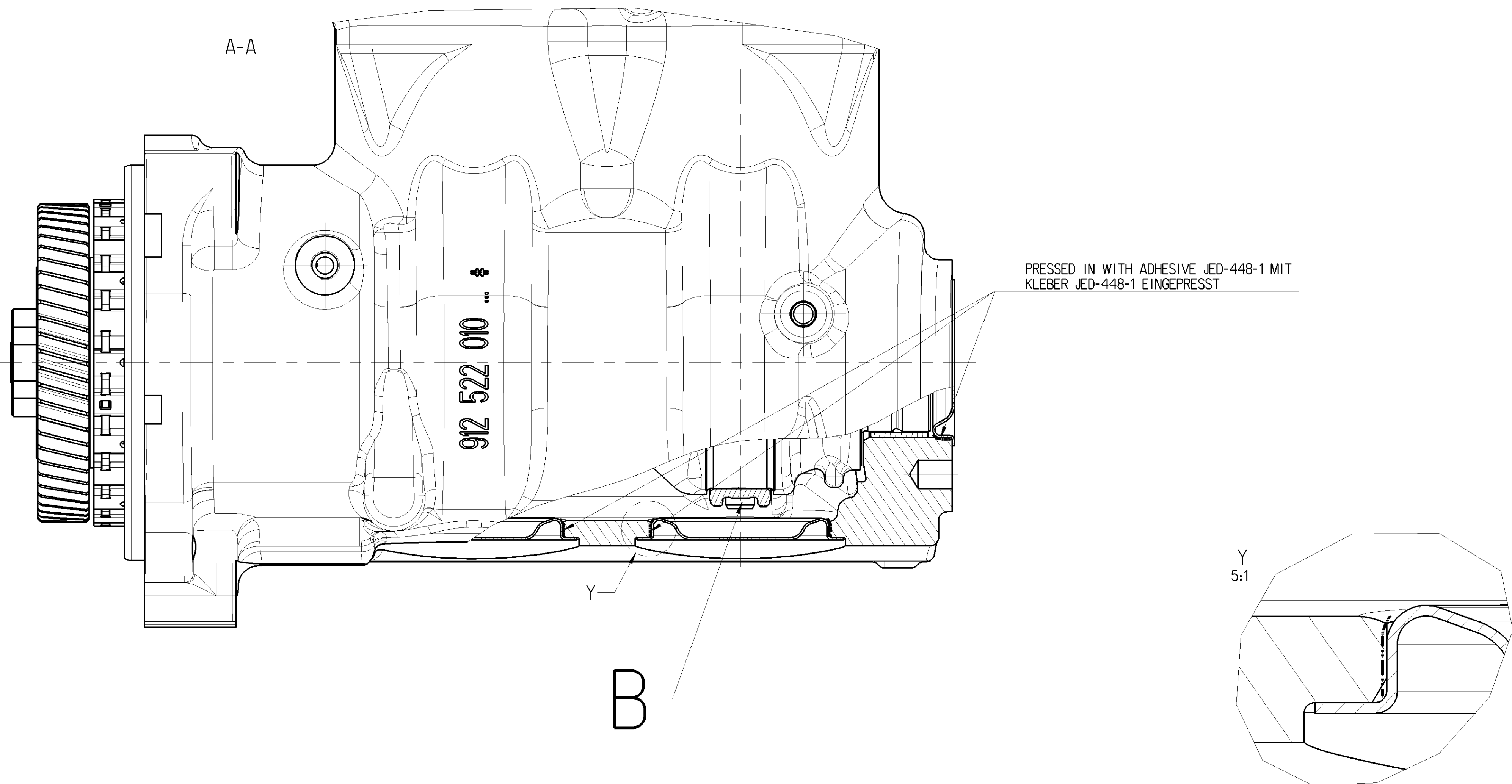
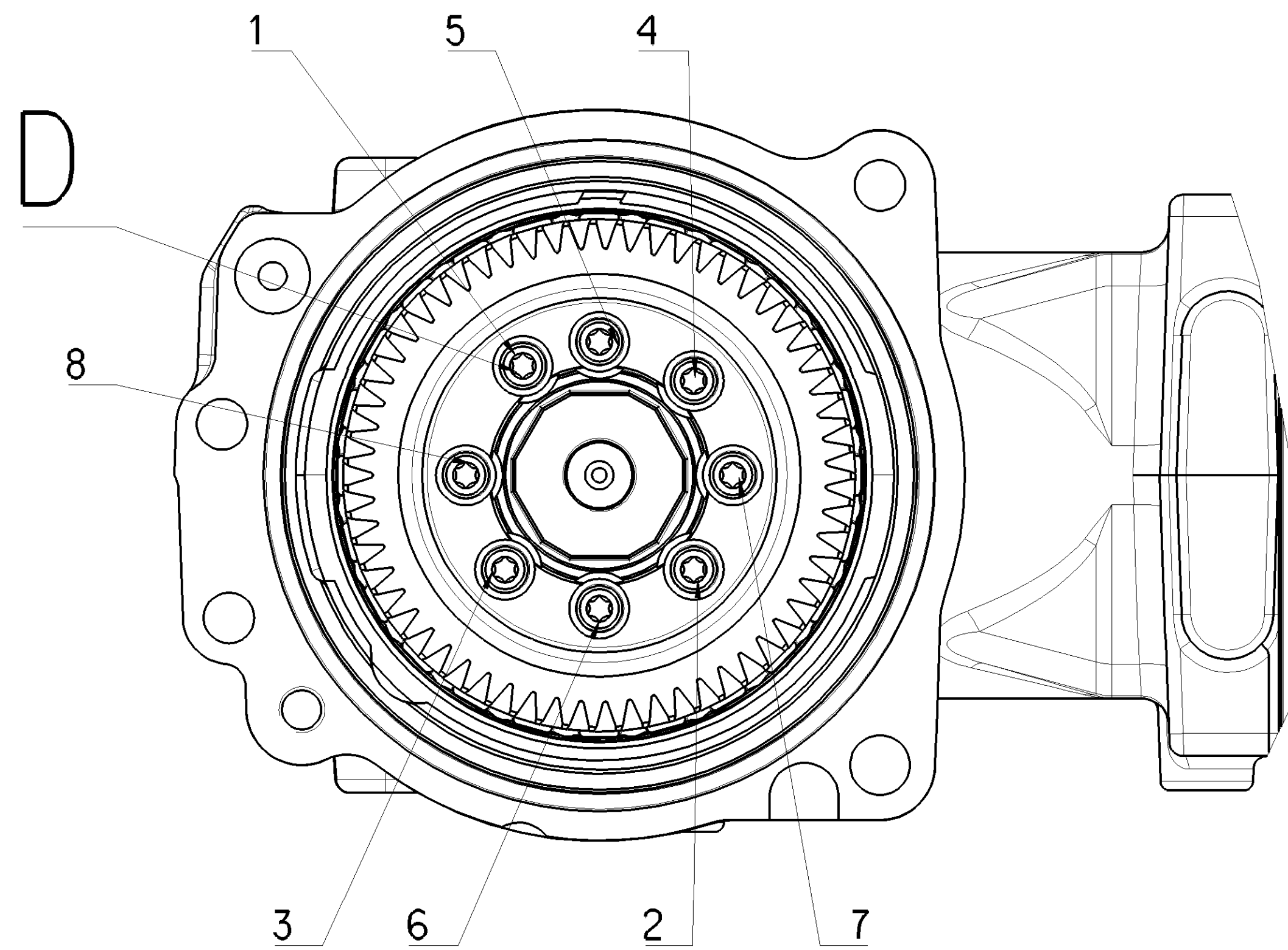
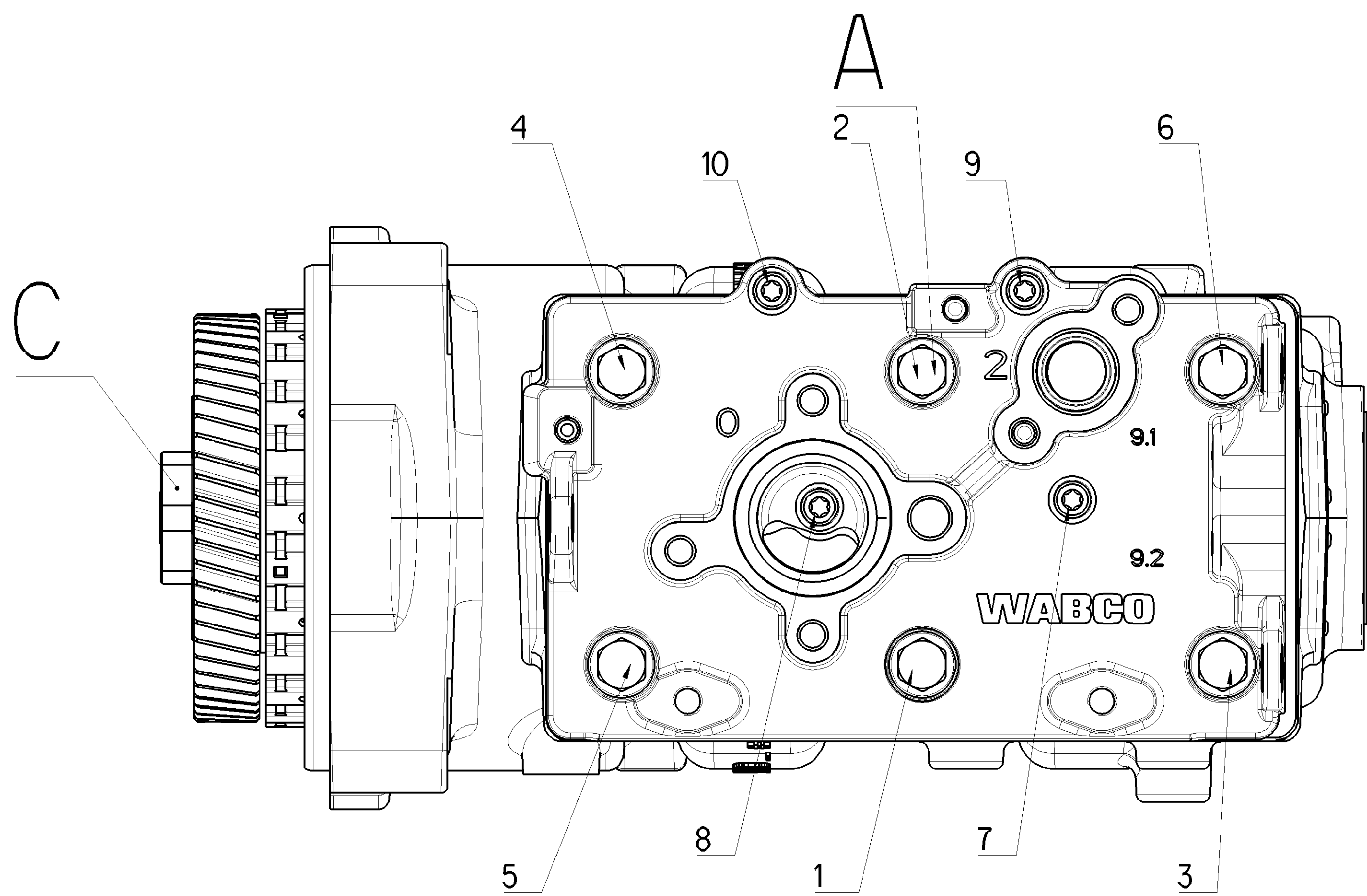
9 COOLANT CONNECTION
KÜHLMITTELANSCHLUSS M ≤ 25 Nm

4 CLUTCH CONTROL PORT
STEUERANSCHLUSS DER KUPPLUNG M ≤ 25 Nm

CLUTCH ACTUATION PRESSURE : 5 bar
PRESSURE BUILD-UP TIME: 0.5 - >5 bar < 0.8 sec
VENTING TIME: 5 - >0.5 bar < 0.8 sec

KUPPLUNGSBETÄTIGUNGSDRUCK: 5 bar
DRUCKAUFBAUZEIT: 0,5 - >5 bar < 0,8 sek
ENTLUEFTUNGSZEIT: 5 - >0,5 bar < 0,8 sek

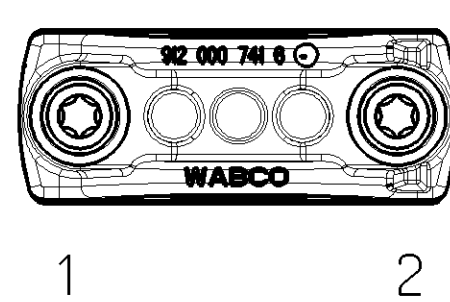




PRESSED IN WITH ADHESIVE JED-448-1 MIT
KLEBER JED-448-1 EINGEPRESST

Assembly Instruction / Montageanweisung

A	Step Schritt	Sequence Reihenfolge	Torque [Nm] Drehmoment	Rotation Angle [°] Drehwinkel	Threshold Torque [Nm] Schwellmoment
	1	1,2,3,4,5,6,1	20 ± 2	----	----
	2	1,2,3,4,5,6	----	90 +10/-5	20 ± 2
	3	1,2,3,4,5,6	----	90 +10/-5	25 ± 2
	4	7,8,9,10	7 ± 2	----	----
	5	7,8,9,10	----	90 +10/-5	----
B	Step Schritt	Sequence Reihenfolge	Torque [Nm] Drehmoment	Rotation Angle [°] Drehwinkel	Threshold Torque [Nm] Schwellmoment
	1	1,2	6 ± 0.6	----	----
	2	1,2	----	70 +15/-5	6 ± 0.6
C	Step Schritt	Torque [Nm] Drehmoment		Rotation Angle [°] Drehwinkel	Remark Vermerk
	1	100		----	DISMANTLING AFTER TIGHTENED LÖSEN NACH DEM ANZIEHEN
	2	45 ± 5		----	----
	3	----		95 ± 5	----
D	1	10 ± 1		----	----
	2	----		90 ± 10	----



CLEANLINESS REQUIREMENT			
SOFT PARTICLES ARE ALLOWED UP TO 2 mm X 0.1 mm X 0.1 mm			
FIBERS ARE ALLOWED UP TO A MAXIMUM DIAMETER OF 0.1 mm AND A MAXIMUM LENGTH OF 10 mm.			
CHAMBER	SURFACE AREA	VOLUME	SPECIFICATION
OIL	4000 cm ²	-	JED-593 CLASS II
WATER	907 cm ²	-	JED-593 CLASS I
AIR	1520 cm ²	-	JED-593 CLASS III

ADHESIVE JED-448-1 APPLIED IN THIS AREA AROUND
KLEBER JED-448-1 IN DIESEM BEREICH RINGSUM EINGESETZT

General Specification: JED-534-1				Copyright WABCO®		WABCO	
Further Technical Data: 912 522 000 0				Doc. Code: 035		Sheet: 1 To: 5	
General Tolerances: ISO 201				2014-03-26		Henig	
Range of Nominal Dimensions (± mm)				2014-03-27		Joeger	
Class II ± 50				Min. 26.5		Material No. 912 522 000 0	
Class III ± 50				1.1		Date of first issue: 2014-03-27	
Class IV ± 50				A O		Doc. Code: 005	
Class V ± 50				Pro/E		Language: DE	
Class VI ± 50				A O		Sheet: 2/2	
Class VII ± 50				A O		Version: 1.0	
Class VIII ± 50				A O		Revision: 500	
Class IX ± 50				A O		912 522 001 0	
Class X ± 50				A O		912 522 001 0	
Class XI ± 50				A O		912 522 001 0	
Class XII ± 50				A O		912 522 001 0	
Class XIII ± 50				A O		912 522 001 0	
Class XIV ± 50				A O		912 522 001 0	
Class XV ± 50				A O		912 522 001 0	
Class XVI ± 50				A O		912 522 001 0	
Class XVII ± 50				A O		912 522 001 0	
Class XVIII ± 50				A O		912 522 001 0	
Class XIX ± 50				A O		912 522 001 0	
Class XX ± 50				A O		912 522 001 0	
Class XXI ± 50				A O		912 522 001 0	
Class XXII ± 50				A O		912 522 001 0	
Class XXIII ± 50				A O		912 522 001 0	
Class XXIV ± 50				A O		912 522 001 0	
Class XXV ± 50				A O		912 522 001 0	
Class XXVI ± 50				A O		912 522 001 0	
Class XXVII ± 50				A O		912 522 001 0	
Class XXVIII ± 50				A O		912 522 001 0	
Class XXIX ± 50				A O		912 522 001 0	
Class XXX ± 50				A O		912 522 001 0	
Class XXXI ± 50				A O		912 522 001 0	
Class XXXII ± 50				A O		912 522 001 0	
Class XXXIII ± 50				A O		912 522 001 0	
Class XXXIV ± 50				A O		912 522 001 0	
Class XXXV ± 50				A O		912 522 001 0	
Class XXXVI ± 50				A O		912 522 001 0	
Class XXXVII ± 50				A O		912 522 001 0	
Class XXXVIII ± 50				A O		912 522 001 0	
Class XXXIX ± 50				A O		912 522 001 0	
Class XL ± 50				A O		912 522 001 0	
Class XLI ± 50				A O		912 522 001 0	
Class XLII ± 50				A O		912 522 001 0	
Class XLIII ± 50				A O		912 522 001 0	
Class XLIV ± 50				A O		912 522 001 0	
Class XLV ± 50				A O		912 522 001 0	
Class XLVI ± 50				A O		912 522 001 0	
Class XLVII ± 50				A O		912 522 001 0	
Class XLVIII ± 50				A O		912 522 001 0	
Class XLIX ± 50				A O		912 522 001 0	
Class L ± 50				A O		912 522 001 0	
Class LI ± 50				A O		912 522 001 0	
Class LII ± 50				A O		912 522 001 0	
Class LIII ± 50				A O		912 522 001 0	
Class LIV ± 50				A O		912 522 001 0	
Class LV ± 50				A O		912 522 001 0	
Class LVI ± 50				A O		912 522 001 0	
Class LVII ± 50				A O		912 522 001 0	
Class LVIII ± 50				A O		912 522 001 0	
Class LVIX ± 50				A O		912 522 001 0	
Class LX ± 50				A O		912 522 001 0	
Class LXI ± 50				A O		912 522 001 0	
Class LXII ± 50				A O		912 522 001 0	
Class LXIII ± 50				A O		912 522 001 0	
Class LXIV ± 50				A O		912 522 001 0	
Class LXV ± 50				A O		912 522 001 0	
Class LXVI ± 50				A O		912 522 001 0	
Class LXVII ± 50				A O		912 522 001 0	
Class LXVIII ± 50				A O		912 522 001 0	
Class LXIX ± 50				A O		912 522 001 0	
Class LXX ± 50				A O		912 522 001 0	
Class LXXI ± 50				A O		912 522 001 0	
Class LXXII ± 50				A O		912 522 001 0	
Class LXXIII ± 50				A O		912 522 001 0	
Class LXXIV ± 50				A O		912 522 001 0	
Class LXXV ± 50				A O		912 522 001 0	
Class LXXVI ± 50				A O		912 522 001 0	
Class LXXVII ± 50				A O		912 522 001 0	
Class LXXVIII ± 50				A O		912 522 001 0	
Class LXXIX ± 50				A O		912 522 001 0	
Class LXXX ± 50				A O		912 522 001 0	
Class LXXXI ± 50				A O		912 522 001 0	
Class LXXXII ± 50				A O		912 522 001 0	
Class LXXXIII ± 50				A O		912 522 001 0	
Class LXXXIV ± 50				A O		912 522 001 0	
Class LXXXV ± 50				A O		912 522 001 0	
Class LXXXVI ± 50				A O		912 522 001 0	
Class LXXXVII ± 50				A O		912 522 001 0	
Class LXXXVIII ± 50				A O		912 522 001 0	
Class LXXXIX ± 50				A O		912 522 001 0	
Class LXXXX ± 50				A O		912 522 001 0	
Class LXXXXI ± 50				A O		912 522 001 0	
Class LXXXXII ± 50				A O		912 522 001 0	
Class LXXXXIII ± 50				A O		912 522 001 0	
Class LXXXXIV ± 50				A O		912 522 001 0	
Class LXXXXV ± 50				A O		912 522 001 0	
Class LXXXXVI ± 50				A O		912 522 001 0	
Class LXXXXVII ± 50				A O		912 522 001 0	
Class LXXXXVIII ± 50				A O		912 522 001 0	
Class LXXXXIX ± 50				A O		912 522 001 0	
Class LXXXXX ± 50				A O		912 522 001 0	
Class LXXXXXI ± 50				A O		912 522 001 0	
Class LXXXXXII ± 50				A O		912 522 001 0	
Class LXXXXXIII ± 50				A O		912 522 001 0	
Class LXXXXXIV ± 50				A O		912 522 001 0	
Class LXXXXXV ± 50				A O		912 522 001 0	
Class LXXXXXVI ± 50				A O		912 522 001 0	
Class LXXXXXVII ± 50				A O		912 522 001 0	
Class LXXXXXVIII ± 50				A O		912 522 001 0	
Class LXXXXXIX ± 50				A O		912 522 001 0	
Class LXXXXXX ± 50				A O		912 522 001 0	
Class LXXXXXXI ± 50				A O		912 522 001 0	
Class LXXXXXXII ± 50				A O		912 522 001 0	
Class LXXXXXXIII ± 50				A O		912 522 001 0	
Class LXXXXXXIV ± 50				A O		912 522 001 0	
Class LXXXXXXV ± 50				A O		912 522 001 0	
Class LXXXXXXVI ± 50				A O		912 522 001 0	
Class LXXXXXXVII ± 50				A O		912 522 001 0	
Class LXXXXXXVIII ± 50				A O		912 522 001 0	
Class LXXXXXXIX ± 50				A O		912 522 001 0	
Class LXXXXXXX ± 50				A O		912 522 001 0	
Class LXXXXXXXI ± 50				A O		912 522 001 0	
Class LXXXXXXXII ± 50				A O		912 522 001 0	
Class LXXXXXXXIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIV ± 50				A O		912 522 001 0	
Class LXXXXXXXV ± 50				A O		912 522 001 0	
Class LXXXXXXXVI ± 50				A O		912 522 001 0	
Class LXXXXXXXVII ± 50				A O		912 522 001 0	
Class LXXXXXXXVIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIX ± 50				A O		912 522 001 0	
Class LXXXXXXXI ± 50				A O		912 522 001 0	
Class LXXXXXXXII ± 50				A O		912 522 001 0	
Class LXXXXXXXIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIV ± 50				A O		912 522 001 0	
Class LXXXXXXXV ± 50				A O		912 522 001 0	
Class LXXXXXXXVI ± 50				A O		912 522 001 0	
Class LXXXXXXXVII ± 50				A O		912 522 001 0	
Class LXXXXXXXVIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIX ± 50				A O		912 522 001 0	
Class LXXXXXXXI ± 50				A O		912 522 001 0	
Class LXXXXXXXII ± 50				A O		912 522 001 0	
Class LXXXXXXXIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIV ± 50				A O		912 522 001 0	
Class LXXXXXXXV ± 50				A O		912 522 001 0	
Class LXXXXXXXVI ± 50				A O		912 522 001 0	
Class LXXXXXXXVII ± 50				A O		912 522 001 0	
Class LXXXXXXXVIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIX ± 50				A O		912 522 001 0	
Class LXXXXXXXI ± 50				A O		912 522 001 0	
Class LXXXXXXXII ± 50				A O		912 522 001 0	
Class LXXXXXXXIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIV ± 50				A O		912 522 001 0	
Class LXXXXXXXV ± 50				A O		912 522 001 0	
Class LXXXXXXXVI ± 50				A O		912 522 001 0	
Class LXXXXXXXVII ± 50				A O		912 522 001 0	
Class LXXXXXXXVIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIX ± 50				A O		912 522 001 0	
Class LXXXXXXXI ± 50				A O		912 522 001 0	
Class LXXXXXXXII ± 50				A O		912 522 001 0	
Class LXXXXXXXIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIV ± 50				A O		912 522 001 0	
Class LXXXXXXXV ± 50				A O		912 522 001 0	
Class LXXXXXXXVI ± 50				A O		912 522 001 0	
Class LXXXXXXXVII ± 50				A O		912 522 001 0	
Class LXXXXXXXVIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIX ± 50				A O		912 522 001 0	
Class LXXXXXXXI ± 50				A O		912 522 001 0	
Class LXXXXXXXII ± 50				A O		912 522 001 0	
Class LXXXXXXXIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIV ± 50				A O		912 522 001 0	
Class LXXXXXXXV ± 50				A O		912 522 001 0	
Class LXXXXXXXVI ± 50				A O		912 522 001 0	
Class LXXXXXXXVII ± 50				A O		912 522 001 0	
Class LXXXXXXXVIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIX ± 50				A O		912 522 001 0	
Class LXXXXXXXI ± 50				A O		912 522 001 0	
Class LXXXXXXXII ± 50				A O		912 522 001 0	
Class LXXXXXXXIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIV ± 50				A O		912 522 001 0	
Class LXXXXXXXV ± 50				A O		912 522 001 0	
Class LXXXXXXXVI ± 50				A O		912 522 001 0	
Class LXXXXXXXVII ± 50				A O		912 522 001 0	
Class LXXXXXXXVIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIX ± 50				A O		912 522 001 0	
Class LXXXXXXXI ± 50				A O		912 522 001 0	
Class LXXXXXXXII ± 50				A O		912 522 001 0	
Class LXXXXXXXIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIV ± 50				A O		912 522 001 0	
Class LXXXXXXXV ± 50				A O		912 522 001 0	
Class LXXXXXXXVI ± 50				A O		912 522 001 0	
Class LXXXXXXXVII ± 50				A O		912 522 001 0	
Class LXXXXXXXVIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIX ± 50				A O		912 522 001 0	
Class LXXXXXXXI ± 50				A O		912 522 001 0	
Class LXXXXXXXII ± 50				A O		912 522 001 0	
Class LXXXXXXXIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIV ± 50				A O		912 522 001 0	
Class LXXXXXXXV ± 50				A O		912 522 001 0	
Class LXXXXXXXVI ± 50				A O		912 522 001 0	
Class LXXXXXXXVII ± 50				A O		912 522 001 0	
Class LXXXXXXXVIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIX ± 50				A O		912 522 001 0	
Class LXXXXXXXI ± 50				A O		912 522 001 0	
Class LXXXXXXXII ± 50				A O		912 522 001 0	
Class LXXXXXXXIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIV ± 50				A O		912 522 001 0	
Class LXXXXXXXV ± 50				A O		912 522 001 0	
Class LXXXXXXXVI ± 50				A O		912 522 001 0	
Class LXXXXXXXVII ± 50				A O		912 522 001 0	
Class LXXXXXXXVIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIX ± 50				A O		912 522 001 0	
Class LXXXXXXXI ± 50				A O		912 522 001 0	
Class LXXXXXXXII ± 50				A O		912 522 001 0	
Class LXXXXXXXIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIV ± 50				A O		912 522 001 0	
Class LXXXXXXXV ± 50				A O		912 522 001 0	
Class LXXXXXXXVI ± 50				A O		912 522 001 0	
Class LXXXXXXXVII ± 50				A O		912 522 001 0	
Class LXXXXXXXVIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIX ± 50				A O		912 522 001 0	
Class LXXXXXXXI ± 50				A O		912 522 001 0	
Class LXXXXXXXII ± 50				A O		912 522 001 0	
Class LXXXXXXXIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIV ± 50				A O		912 522 001 0	
Class LXXXXXXXV ± 50				A O		912 522 001 0	
Class LXXXXXXXVI ± 50				A O		912 522 001 0	
Class LXXXXXXXVII ± 50				A O		912 522 001 0	
Class LXXXXXXXVIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIX ± 50				A O		912 522 001 0	
Class LXXXXXXXI ± 50				A O		912 522 001 0	
Class LXXXXXXXII ± 50				A O		912 522 001 0	
Class LXXXXXXXIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIV ± 50				A O		912 522 001 0	
Class LXXXXXXXV ± 50				A O		912 522 001 0	
Class LXXXXXXXVI ± 50				A O		912 522 001 0	
Class LXXXXXXXVII ± 50				A O		912 522 001 0	
Class LXXXXXXXVIII ± 50				A O		912 522 001 0	
Class LXXXXXXXIX ± 50				A O		912 522 001 0	
Class LXXXXXXXI ± 50				A O		912 522 001 0	
Class LXXXXXXXII ± 50				A O		912 522 001 0	
Class LXXXXXXXIII ± 50</							