

**Gear assembly DK08, DK09, DK 11 - 119, DK 12-18, DK 22 - 32, DK 42, DK 52, HD16, SR 25 - SR75**  
**Adjusting data for the overload clutch - Transmission oil**

Machine Type	Gear oil		Tightening Torque for the nut [Nm]		Friction Torque [Nm]			Position of disc spring
	Quantity [ml]	Type	M	I	M	I	at / gear step	
DK08/09	80 <sup>+10</sup>	A				9,5 - 11	pinion shaft	)
DK11	90 <sup>+10</sup>	A			5 - 10	5 - 10	drill spindle	)
DKS15	100 <sup>+10</sup>	A				9 - 10	pinion shaft	)
DK116/118/119	90 <sup>+10</sup>	A			8 - 10	8,5 - 10	pinion shaft	)
DK12-18	160 <sup>+10</sup>	A			12 - 14	9,5 - 11	pinion shaft	)
HD16/18	160 <sup>+10</sup>	B				13,5 - 14,5	pinion shaft	)
DK12/14 S DK 16 S	160 <sup>+10</sup>	A			8 - 10	6 - 8	pinion shaft	)
DK22	300 <sup>+10</sup>	A	90 <sup>+10</sup>	70 <sup>+10</sup>	130	100	drill spindle	)))
DK22 L	300 <sup>+10</sup>	A	110 <sup>+10</sup>	90 <sup>+10</sup>	150	140	drill spindle	)))
DK22 S	300 <sup>+10</sup>	A	70 <sup>+10</sup>	60 <sup>+5</sup>	100	90	drill spindle	)))
DK26	300 <sup>+10</sup>	A			28±2		pinion shaft	)
	hexagon nut for drill spindle tighten with 80Nm				90 - 110		drill spindle step 3	
DK32	300 <sup>+10</sup>	A	45 <sup>+5</sup>	40 <sup>+5</sup>	180	140	drill spindle	))((
DK32 S	300 <sup>+10</sup>	A	35 <sup>+5</sup>	30 <sup>+5</sup>	140	110	drill spindle	))((
DK34	400 <sup>+10</sup>	A		50 <sup>+5</sup>		230	drill spindle	))((
DK42	500 <sup>+10</sup>	A	170 <sup>+10</sup>		240		drill spindle	)))
DK42 B (E)	400 <sup>+10</sup>	A	45 <sup>+5</sup>		250		drill spindle	))((
DK42 L	500 <sup>+10</sup>	A	200 <sup>+10</sup>		270		drill spindle	)))
DK42 BL (EL)	400 <sup>+10</sup>	A	57 <sup>+5</sup>		280		drill spindle	))((
DK42 S	500 <sup>+10</sup>	A	120 <sup>+10</sup>		160		drill spindle	)))
DK42 BS (ES)	400 <sup>+10</sup>	A	30 <sup>+5</sup>		190		drill spindle	))((
DK52 (E)	400 <sup>+10</sup>	A	60 <sup>+5</sup>		370		drill spindle	))((
DK52 S (ES)	400 <sup>+10</sup>	A	50 <sup>+5</sup>		300		drill spindle	))((
SR25	160 <sup>+10</sup>	B			28±2		pinion shaft	)
	hexagon nut for drill spindle tighten with 80Nm				200 - 230		drill spindle	
SR35 SR38 SR68	300 <sup>+10</sup>	B			28±2		pinion shaft	)
	hexagon nut for drill spindle tighten with 80Nm				80 - 110		drill spindle step 3	
SR75	500 <sup>+10</sup>	B			28±2		pinion shaft	)
SR65	250 <sup>+10</sup>	B			28±2		pinion shaft	)

Gear oil	Type
A	Castrol alpha SP 150
B	Mobil SHC629

When assembling the gear please note:

- All parts of the clutch are to be oiled.
- For DK22 -DK52 tighten the hexagon nut approx. 30% higher, therefore the disks become planar, then release the nut and tighten it to the above given torque.
- tighten the nut softly to the tightening torque with the torque wrench in order not to overturn the adjusting torque.

I - machines with Intellitronik, M - Machines with motor protection switch

Blattnr.: 1/2	Gear assembly Adjusting torques - Gear oil	AM-Getriebe	06.06.2019
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Gear assembly HS40, HS50, TS40, TR40, TK40, WS75, WS75H												
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Machine Type	Gear oil		Tightening Torque for the nut [Nm]	Friction Torque [Nm] measured		Position of disc spring						
	Quantity [ml]	Type			at							
HS40	25	B										
HS50	50	B										
TS40	90	B										
TR40	30	B										
TK40	90	B		10 - 11,5	pinion shaft	)						
WS75	250 <sup>+10</sup>	B		40+5	pinion shaft	)						
WS75 H	250 <sup>+10</sup>	B		45+5	pinion shaft	)						
<table border="1"> <thead> <tr> <th>Gear oil</th> <th>Type</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>Castrol alpha SP 150</td> </tr> <tr> <td>B</td> <td>Mobil SHC629</td> </tr> </tbody> </table>							Gear oil	Type	A	Castrol alpha SP 150	B	Mobil SHC629
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Blattnr.: 2/2	Gear assembly Adjusting torques - Gear oil			AM-Getriebe	06.06.2019							