BRETZEL GmbH
Antriebs- und Elektrotechnik

Mounting Instructions

for mounting of Groschopp drives

Mounting Instructions

Loose drives intended for mounting of Groschopp motors will be delivered ungreased.

The grease and the necessary fastening elements will be packaged separately. The Groschopp motors are divided in 2 groups based on their composition.

The following is to be considered during the mounting process.

Assembly:

Group 1 (E1a*/ E2a/ E3/ E4/ E5a/ E31/ E32/ E7/ E25/ Z2a/ VE31):**
1.1) shaft sealing has to be placed on the motor shaft.
1.2) mount screw or bevel wheel (during bolting the motor-shaft should be supported)
1.3) add the grease in the recommended amount
1.4) grease the filling port, if necessary use a screw and seal ring to seal it.
1.5) mount drive and screw it on (spring washers should be put under the screws).
The drive VE40 should be mounted without spring washers.

Group 2 (Z1b*/ Z3*/ Z5*/ Z10*/ Z8/ Z11/ Z14/ Z20/ Z23/ Z24/ D1a*/ D3a*/ SG80/ SG150/ SG300):
2.1) shaft sealing had to be placed on the motor shaft.
2.2) mount screw or bevel wheel (during bolting the motor-shaft should be supported)
2.3) mount drive and screw it on (screws from inside the drive should be supported by automatic seals on the inside and spring washers on the outside)
For drives with a * the flange should be moistened with sealing agent
2.4) add grease in the recommended amount
2.5) degrease lid surface and add sealing agent.
2.6) mount lid

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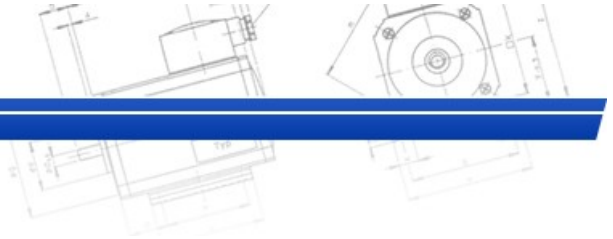

Amount of grease required (VE31 not included)

Group 1

type	amount of grease in g(= cm^3)
E 1 a	10
E 3; E 4	80
E 7	85
VE31-x-x	(see next page)
VE40-D-B	77
VE40-DI-HN	77
Z 2	60
SG 20, 2-3 staged	30
SG 80, 2-3 staged	40
SG 80, 4-5 staged	35
SG 150, 2-3 staged	210
SG 150, 4-5 staged	160
SG 300, 2-3 staged	320
SG 300, 4-5 staged	270

Group 2

type	amount of grease in g(= cm^3)
Z 1b*	25
Z 3*, Z 5*, Z 10*	80
Z 8	500
Z 11	250
D 3a*	135

* The grease amount stated is for the normal mounting positions (B3). Please contact us should you require assistance with any other mounting positions.

The sealing agent should be applied thin and uniformly. We use Loctite 5910 here.

After possible Separation already sealed parts should always be resealed.

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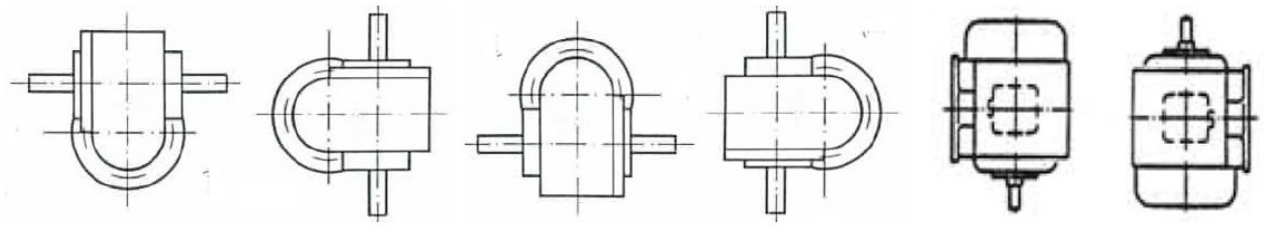
Amount of grease for the VE31, solid shaft

The drive usually does not come with vents. This norm dictates the grease amount for the drives mentioned above., without additional order- or customer-specifications we will use these values.

Possible mounting positions



Mounting position		[1] Amount of grease in g Centoplex H/0 1032208-8907 label 1061186-2901					
WN 0094.00	DIN EN 60034-7/ IEC 34-7 +	VE31-D... [2]	VE31-F... [2]	VE31-K... shaft [2]		VE31-G... shaft [2]	
				left	right	left	right
1		35^{+5}		45^{+5}		60^{+5}	
2		35^{+5}		45^{+5}	55^{+5}	45^{+5}	70^{+5}
3		35^{+5}		50^{+5}		65^{+5}	
4		35^{+5}		55^{+5}	45^{+5}	70^{+5}	45^{+5}
	V5	35^{+5}		50^{+5}		65^{+5}	
	V6	35^{+5}		55^{+5}		70^{+5}	

[1] Unless otherwise stated, the amount of grease for separately delivered grease is the maximum stated in the documentation.

[2]) from gear ratios 50 and up → 5g less grease

Amount of grease for the VE31, hollow shaft

All types and mounting positions	Gear-ratio up to 40:1 [1] Amount of grease in g	Gear-ratio from 50:1 [1] Amount of grease in g
VE31-DH...	25^{+5}	20^{+5}
VE31-FH...	25^{+5}	20^{+5}
VE31-KH...	25^{+5}	20^{+5}
VE31-GH...	25^{+5}	20^{+5}

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