

Gearboxes supplied separately for mounting on Groschopp motors are usually supplied without grease. Lubrication and necessary fastenings will be supplied separately. Gearbox constructions can be separated into two groups.

Group 1

- 1.1 Fit shaft seal on motor shaft.
- 1.2 Mount worm or pinion (support motor shaft).
- 1.3 Fill gearbox with correct quantity of Lubricant.
- 1.4 Remove any Lubricant from the gearbox opening, if necessary close it with screw and sealing washer.
- 1.5 Fit and screw down gearbox (fit Lock washers under screws). The gearboxes VE40 will be mounted at the motors without lock washers. For the gearbox VE40-D-H the positions 1.1 and 1.2 will be inapplicable.

Group 2

- 2.1 Fit shaft seal on motor shaft.
- 2.2 Mount worm or pinion (support motor shaft).
- 2.3 Fit and screw down gearbox (screws fitted from inside the gearbox should be fitted with sealing washers; external screws with Lock washers. Gearboxes marked with a * flange must have sealing compound applied before fitting).
- 2.4 Fill gearbox with correct quantity of Lubricant.
- 2.5 Apply sealing compound to gearbox cover.
- 2.6 Screw down cover.

Group 1

Type	Lubricant quantity cm ³
E 1 a	10
E 3; E 4;	80
E 7	85
VE31-D-X	35
VE31-F-X	35
VE31-K-X	50
VE31-G-X	70
VE 40-D-B	77
VE 40-D-H	77
Z 2	60
SG 20, 2-3 stage	30
SG 80, 2-3 stage	40
SG 80, 4-5 stage	35
SG 150, 2-3 stage	210
SG 150, 4-5 stage	160
SG 300, 2-3 stage	320
SG 300, 4-5 stage	270

Group 2

Type	Lubricant quantity cm ³
Z 1b*	25
Z 3*; Z 5*; Z 10*	80
Z 8	500
Z 11	250
Z 14; Z 20	130
Z 22; Z 23; Z 24	150
D 1a*	40
D 3a*	135

* The mentioned Lubricant quantities are values for normal fitting position (B 3). For other fitting positions please send your inquiry to our company.

Spread sealing compound thinly and equally.
Groschopp uses Loctite 5910.

When components that have been joined with sealing compound are separated, new sealing compound must be applied before reassembly.