Assembly instructions

Instructions for fixed point

The insert parts (1 or 2) are needed for a fixed point, and are secured by the teeth against rotation.

By installing a fixed point, you have to use only the insert parts

(1) LW 1187  
  tolerance 0/1 mm
(2) LW 1188  
  tolerance 2/3 mm

The tolerance in vertical direction depends on the sub-construction.
assembly instructions

Instructions for horizontal loose point

bolt torque 5Nm

The insert parts (1 or 2) prevent a slipping in vertical direction. The two Teflon washers (3) permit sliding in the horizontal direction. The two Teflon washers have to installed between the spiderarm and the two SS-washer.
assembly instructions

instructions for loose point

The two Teflon washers (3) permit sliding in all directions. By installing a loose point, you have to use only the Teflon washers between spiderarm and SS-washers.

Tolerance balance in the spider

rotation of insert parts are possible every 22.5°
Spider (3) with head cap screw M16 DIN 912 A2 (1) and spring washer 16 DIN 7980 A2 (2) to be fixed to the sub-construction with a socket wrench 14.

The position of the spider (3) has to be checked with a spirit level (4), and fixed with an allen key 14 (5).
assembly instructions

Following this the spider (3) has to be locked by means of a torque wrench (6) with a torque of 130 Nm.

Further drillings have to be done into the sub-construction with a diameter 6 mm drill bit into the finished holes in the spider (3).
Finally the position of the spider (3) has to be fixed with two spring pins 6 x 35 DIN 1481 A2 (8).
## assembly instructions

### tool list

<table>
<thead>
<tr>
<th>title</th>
<th>supplier suggestion</th>
</tr>
</thead>
<tbody>
<tr>
<td>allen key</td>
<td>wrench width 14mm</td>
</tr>
<tr>
<td>torque wrench</td>
<td>socket wrench width 14 mm</td>
</tr>
<tr>
<td>drill</td>
<td>with drill bit Ø 8mm</td>
</tr>
<tr>
<td>hammer</td>
<td>500g</td>
</tr>
<tr>
<td>screw driver</td>
<td></td>
</tr>
<tr>
<td>spirit level</td>
<td>40 cm length</td>
</tr>
<tr>
<td>locking tool</td>
<td>LW 1302</td>
</tr>
<tr>
<td>torque wrench</td>
<td>for locking tool LW 1302 square hole 9mmx12mm</td>
</tr>
<tr>
<td></td>
<td></td>
</tr>
</tbody>
</table>