

Manual for the replacement of the gearing GT2

Installation the gearing and the propeller spindle into the frame

Heat gearing frame to approx. 80°C

Force in the needle bearing NKI 60/25 at the external gearing carrier by applying pressure and fix the security ring I 82 x 2,5.

Force in the ball bearing 6011 at the external bearing ring and fix it with the security ring I 90 x 3.

Force in the external ring of the taper roller bearing 30205 A and fix it with bolts at several sides.

Force in undulated sealing 60 x 75 x 8 WA into the ring-nut of the bearing and move it on the propeller spindle. **Then**, force the inner bearing carrier of the needle sealing on the propeller spindle. Move aluminium spacer on the spindle. (After model 2011 you don't need the spacer)

Move in the propeller spindle into the frame. Force in the inner bearing carrier of the bearing 6011 into the propeller spindle by applying pressure. Move the aluminum spacer „shortly“ on the propeller spindle (with turned crank to the gear wheel). Use screws **8 x M8x16 10.9** to attach the gear wheel to the propeller spindle with 32 Nm. Use LOKTITE to secure it.

Brush the sealing ring thread with elastically surface sealing (LOKTITE 5926 or similar) and screw it into the thread frame.

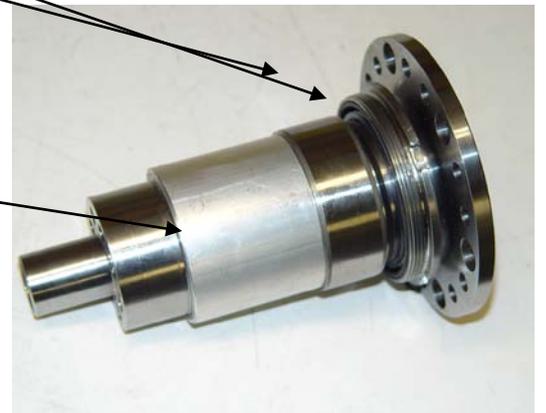
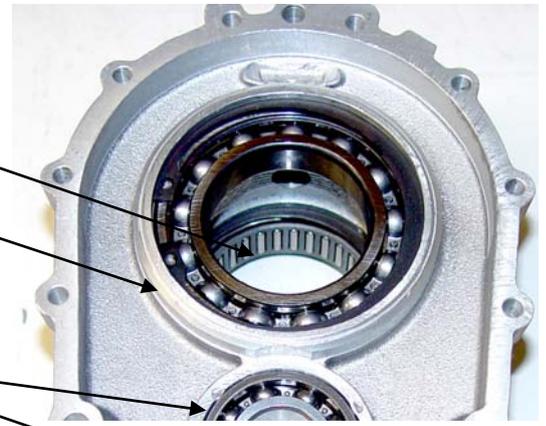
Screw the ventilation ring of the gearing with 28 Nm. Screw the oil drain screw (magnet) with 35 Nm.

Installation of the undulated sealing rings and bearings into the gearing cover

Heat gearing cover to approx. 80 °C

Push undulated sealing ring 25 x 40 x 7 WA into the frame. Push undulated sealing ring 36 x 52 x 7 BAUM into the frame. Push ball bearing 6205 at the external bearing carrier into the frame and with it with bolts at several sides.

Push pinion into the ball bearing 6205. Insert screw **M 8 x 70** with Nord Lock security into the pinion. (28 Nm)



Assembling of frame and cover

Clean plane surfaces of the frame and the cover of all oil. Brush both plane surfaces with surface sealing (e.g. LOCTITE 5926 or similar).

Insert two centering pins 8 x 30.

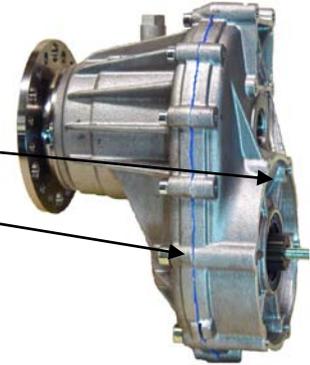
Bring together both halves of the gearing with slight hits (fiber hammer).

Screw gearing **8 M6 x 35** with 11 Nm. Secure screws with LOKTITE.

Put socket on the centering of the gearing and fix it from the inside with two Nord Lock M8 x 40 8.8 security screws.

Screw socket with four M8 x 100 8.8 screws and Nord Lock security plates as well as metal or fiber lock nuts with 28 Nm to the gearing.

Screw the two M8 x 40 screws with 28 Nm.



Move the gearing adapter on the tooth of the pinion.

Fix the screws of the pinion with 28 Nm through the charging level. Attention: Do not damage the gearing!

Bolt charging level screw with 15 Nm and save it with wire.

Screw gearing to the motor

Move gearing towards the center of the clutch.

Move gearing on the two spigots of the motor. Support contingently by soft hits (fiber hammer) at the center positions.



For the motor R 1100

Bolt starter with two screws M 8 x 40 8.8 and Nord Lock protection with 28 Nm. Bolt gearing with four screws M8 x 50 8.8 and Nord Lock protection with 28 Nm to the motor.

For the motor R 1200

Bolt starter and the fixation point above with three screws M8 x 65 8.8 and Nord Lock protection with 28 Nm. Bolt right side with two screws M8 x 50 8.8 and Nord Lock protection with 28 Nm.

Refill gearing oil: 300 ccm gearing with viscosity 140 (e.g. Castrol SAF XJ).

Change oil after the first 10 hours of usage.

Check regularly for potential loss of oil.

Change oil every 200 hours.