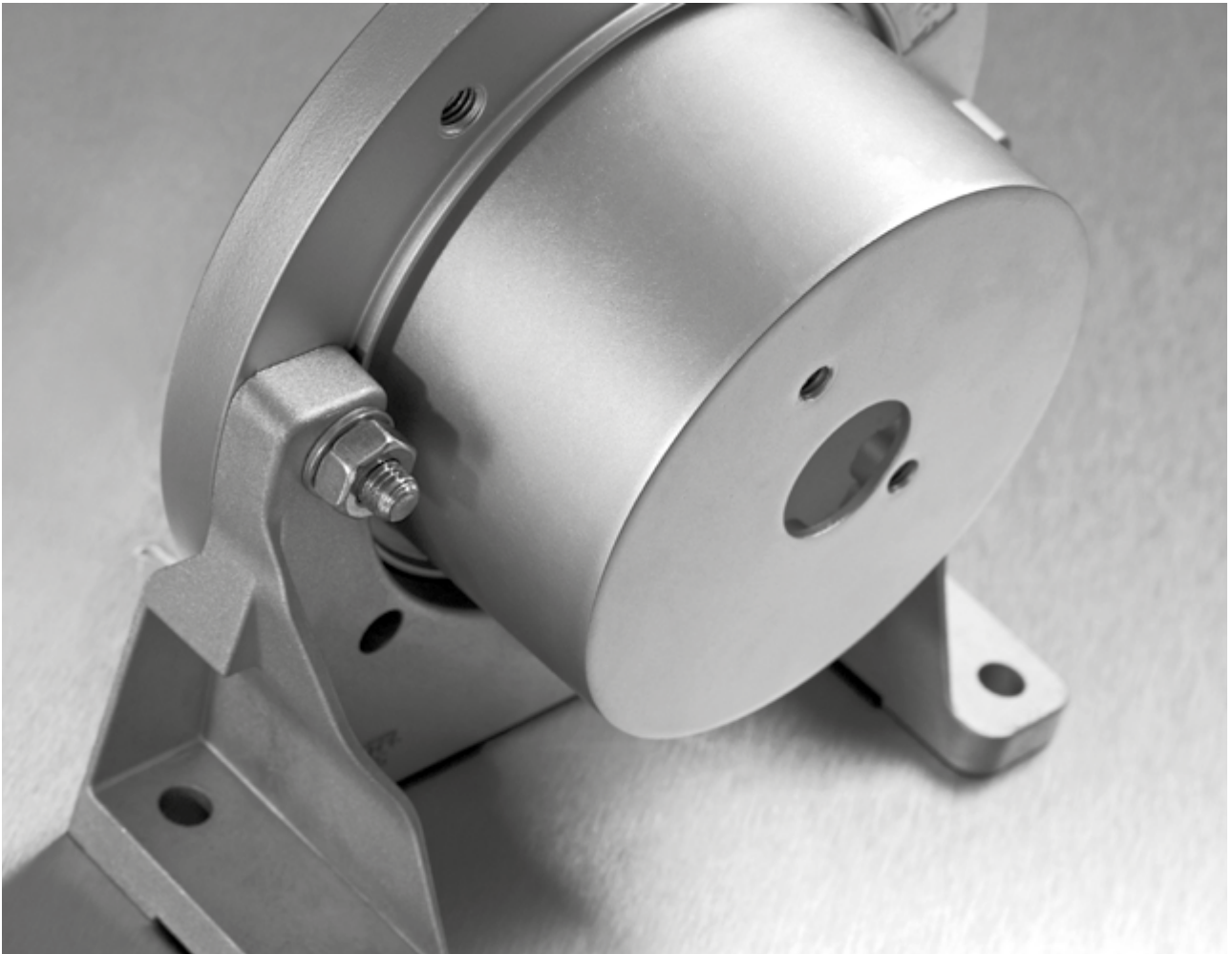


Solutions for Fluid Technology



ASSEMBLY INSTRUCTIONS

Bellhousing

1. GENERAL INFORMATION

Read these assembly instructions carefully and pay particular attention to the safety instructions!

3. APPROPRIATE USE

The bellhousing is to be used exclusively for the technical information according to the manufacturer's data. The manufacturer accepts no liability for damages which occur through structural alterations or inappropriate use.

4. ASSEMBLY OF THE BELLHOUSING

The bellhousing, which is delivered ready-to-assemble, is screwed over the double-sided centring device with the motor and pump components. (For assembling the coupling please see coupling instructions.)

Only the designated tapped holes should be used to attach the pump holder to the motor.

The thread length in the bellhousing must be fully utilised. The screw lengths should be defined accordingly on the motor side and the pump side.

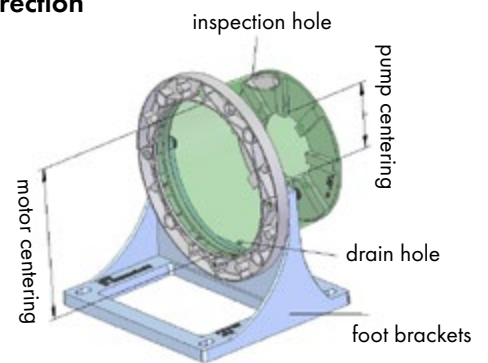
When using together with a foot bracket, the screws used to attach the motor in the foot bracket area should be of a length which allows them to protrude through the foot bracket and to be attached with a nut.

Please pay attention to the mounting direction of the bellhousing. See figures on the right.

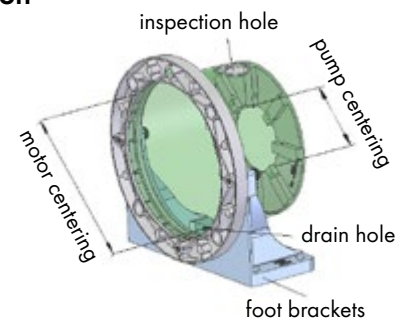
2. GENERAL HAZARD WARNING

Before you begin the assembly or disassembly you should ensure that the equipment is switched off and that it cannot be inadvertently switched on.

Mounting Direction PTFS



Mounting Direction PTFL



5. SCREW TORQUE

For safety purposes, the screws should generally be used with the appropriate, standard adhesives.

Ventilation, assembly and leak oil holes drilled into the side of the bellhousing should be sealed according to size and so that contact from the parts rotating in the bellhousing is not possible.

HBE offers sealing plugs or grating for this purpose.

If a requirement of the bellhousing is that it is oil-proof, this should be indicated in the order.

For cast iron bellhousings

Cheese head screw according to DIN 912 8.8	Torque ²⁾
M8	23 Nm
M10	46 Nm
M12	79 Nm
M16	195 Nm
M20	Up to size 350 = 300 Nm From size 400 = 395 Nm
M24	680 Nm

²⁾ Screw torque of the strength category 8.8;
Friction value 0.125

For aluminium bellhousings

Cheese head screw according to DIN 912 8.8	Torque ¹⁾
M8	12 Nm
M10	23 Nm
M12	40 Nm
M16	100 Nm
M20	190 Nm

¹⁾ Screw torque of the strength category 5.6

For steel bellhousings

Cheese head screw according to DIN 912 10.9	Torque ³⁾
M8	34 Nm
M10	67 Nm
M12	115 Nm
M16	290 Nm
M20	Up to size 350 = 490 Nm From size 400 = 560 Nm
M24	970 Nm

³⁾ Screw torque of the strength category 10.9;
Friction value 0.125

6. DISPOSAL

The disposal of packaging or of the product at the end of its operating life must be carried out in compliance with legal regulations and guidelines.

The materials must be disposed of properly as follows:

- Metal
- Plastics
- Sealings (residual waste)
- etc.

HBE hydraulic
components



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