

Pneumatic Drive Unit Type 6 1014 0050

Techn. Dok.- Nr. 351



Illustration can differ from the original

Repair Manual and Spare Parts List

Repair

Disassembly

Disassembly and re-assembly should only be performed with assistance of the sectional drawing and/or the exploded view. Observe the safety instructions of the operation and maintenance manual.

Remove lever valve with oiler from the motor housing. Screw out nipple item 217, remove pressure spring item 215 and ball item 209. Remove pin item 212, take away valve lever item 211 and pull valve pin item 210 out of sealing seat. Loosen locking screws items 204 and 206. Screw off adjusting screw item 210 only if necessary.

Screw off complete motor from gear housing item 20. Remove exhaust ring item 17 from the motor housing item 1, pull out inner motor parts and continue disassembling.

Loosen worm gear completely from the gear housing item 20. Screw off bearing cover item 48 (attention: is fitted with Loctite-screw locking), loosen sealing ring item 46 and take worm wheel set item 44 out of the worm gear housing item 40. Press out antifriction bearing.

Press planetary gear parts out of the gear housing, resp. loosen by slight pushing of the front side on a wooden support and pull it out. Continue disassembling the gear parts. All parts, especially the vanes item 11 have to be checked with regard to wear and tear and damages.

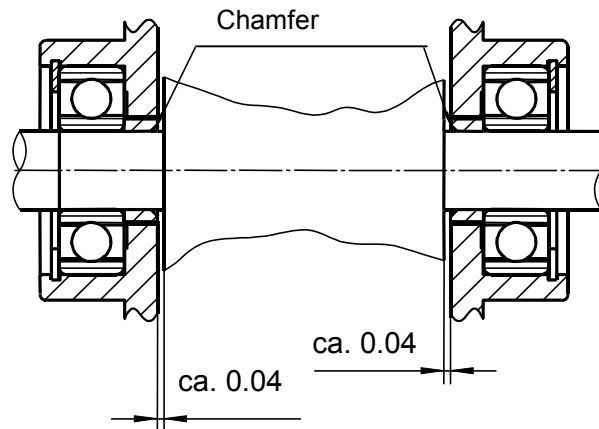
Assembly

The assembly is performed basically in the opposite order as the disassembly.

Ensure that the motor is precisely aligned.

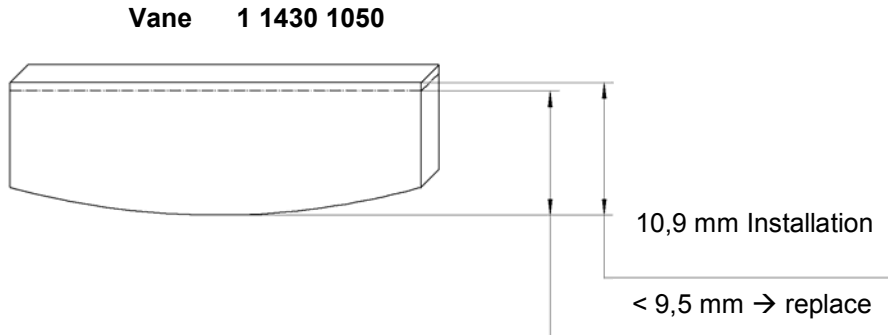
The clearance between the rotor item 10 and the end plates item 4 and 12 should be at the front and at the back 0.04 mm. (see fig. 2). The chamfers in the spacer rings item 7 and item 15 must point to the middle of the rotor. The cylinder bushing has to be correctly oriented before being fitted.

Figure 2:



The position of the lever valve can be determined with the help of the adjusting shims.

Replace wear parts – in particular the vanes – when necessary. Vanes are considered worn, if their width is less than 9,5 mm.



Check after assembly			
Operating pressure (flow pressure)	p	bar	6
Free speed	n free spee	1/min	180-210
Air consumption)	V		1.3 – 1.45
Noise level at 1 m distance	ca.	dB(A)	89-92
Temperature increase at drive (worm wheel)	Max. 60° after 3 min.		

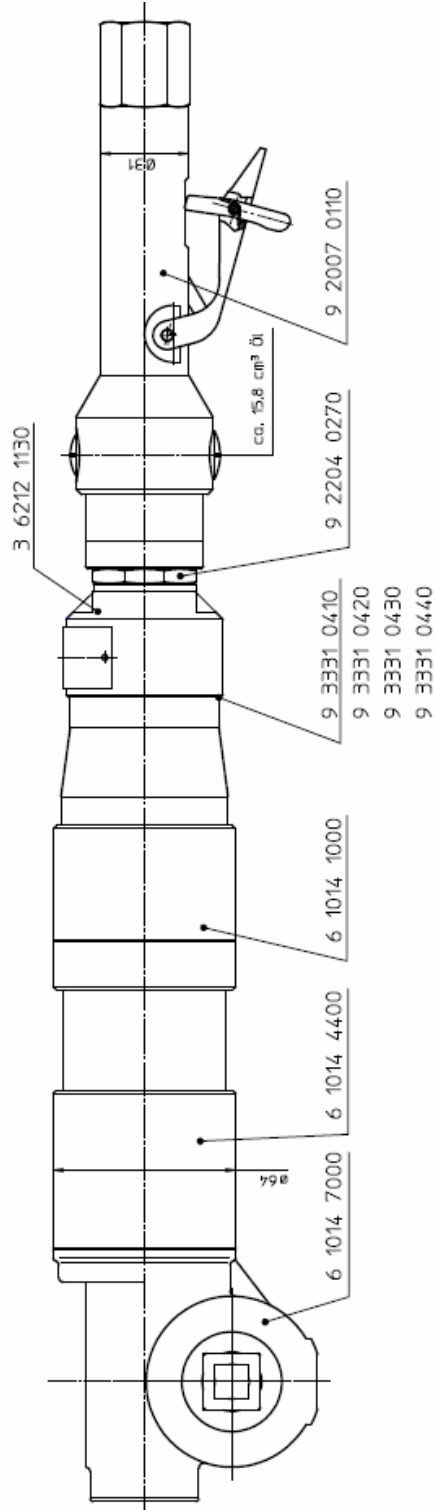
Spare Parts

Only original spare parts may be used. There is no warranty for damages and liability is disclaimed, if non-original spare parts and accessories are used.



Spare Parts List					
Description:				Part and drawing number:	
Pneumatic Drive Unit				6 1014 0050	
Item	Qty.	Description	Part and drawing no.		Remarks
	1	Pneumatic motor	6 1014 1000		see extra list
	1	Gearbox	6 1014 4400		see extra list
	1	Output unit, assy.	6 1014 7000		see extra list
	1	Lever throttle with oiler	9 2007 0110		see extra list
	1	Connection	3 6212 1130		
	1	Adjusting washer	9 3331 0410		
	1	Adjusting washer	9 3331 0420		
	1	Adjusting washer	9 3331 0430		
	1	Adjusting washer	9 3331 0440		
	1	Double nipple	9 2204 0270		

Spare Parts List	
Description:	Part and drawing number:
Pneumatic Drive Unit	6 1014 0050



Spare Parts List					
Description:				Part and drawing number:	
Pneumatic Motor				6 1014 1000	
Item	Qty.	Description	Part and drawing no.		Remarks
1	1	Motor housing	6 1014 1010		
2	1	O-ring	9 1901 3220	*	
3	1	O-ring	9 1901 2070	*	
4	1	End plate	3 6341 1110		
5	1	Grooved ball bearing	9 1001 0090		
6	1	Snap ring	9 1703 0050		
7	1	Spacer ring	3 6341 1080		
8	1	Cylinder bushing	1 1430 1020		
9	2	Spiral pin	9 1642 0080		
10	1	Rotor	3 6349 1030		
11	4	Vane	1 1430 1050		
12	1	End plate	5 1202 1100		
13	1	Grooved ball bearing	9 1003 0020	*	
14	1	Snap ring	9 1703 0070		
15	1	Spacer ring	5 1202 1080		
16	1	Silencer mat	3 6339 1770		
17	1	Exhaust ring	3 6339 1180		
		*Wear parts to be stored in case of continuous use			

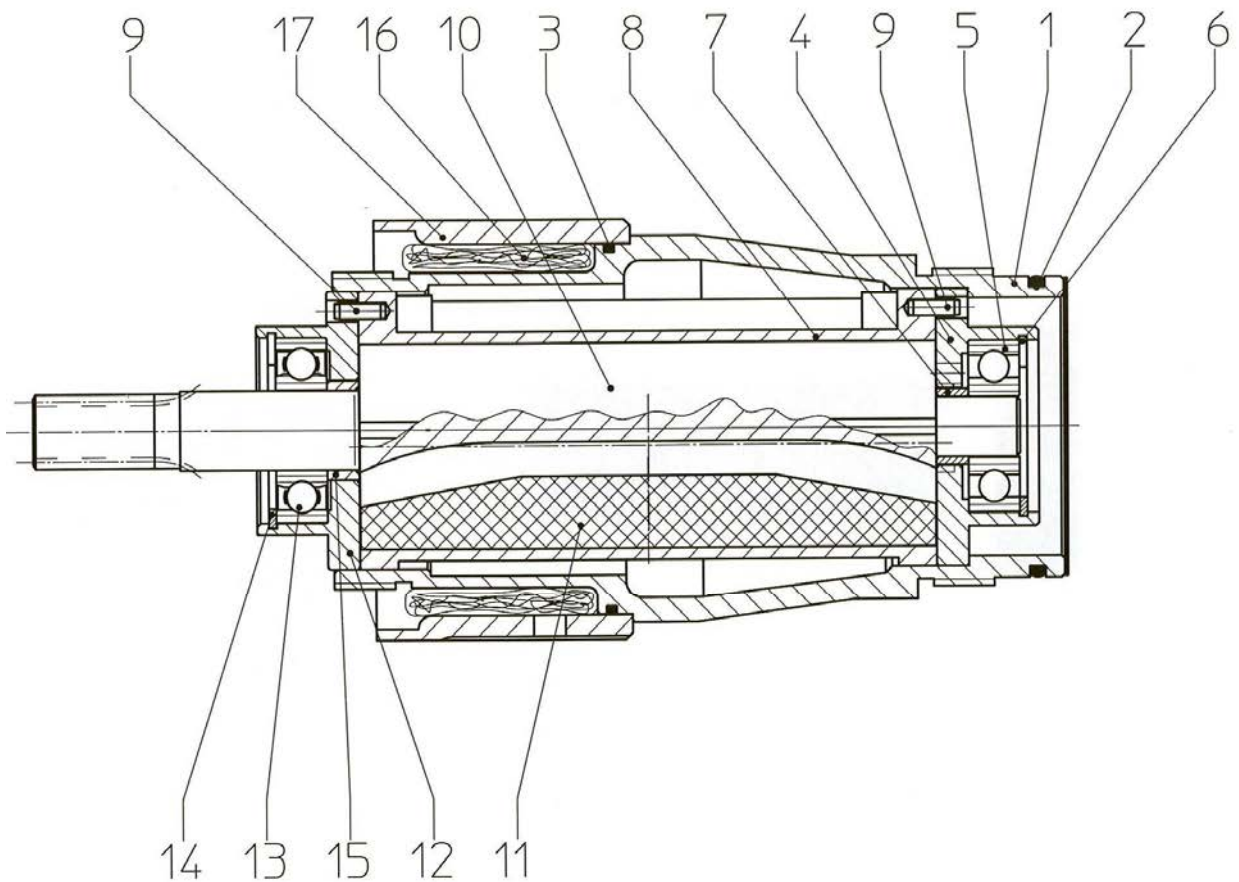
Spare Parts List

Description:

Pneumatic Motor

Part and drawing number:

6 1014 1000



Spare Parts List					
Description:				Part and drawing number:	
Gearbox				6 1014 4400	
Item	Qty.	Description	Part and drawing no.		Remarks
20	1	Gearbox housing	6 1014 4010		
21	1	O-ring	9 1901 2130	*	
22	1	Cover plate	6 1014 4190		
23	1	Shaft sealing ring	9 1905 1080		
24	1	Grooved ball bearing	9 1002 0050	*	
25	1	Planet carrier	6 1014 4030		
26	1	Grooved ball bearing	9 1001 0030	*	
27	2	Planet wheel	6 1014 4040		
28	4	Needle cage	9 1015 0390		
29	2	Planet wheel bolt	3 6339 4050		
30	1	Pinion	6 1014 4170		
31	1	Adjusting washer	9 3331 0130		
32	1	Grooved ball bearing	9 1001 0450	*	
33	1	Snap ring	9 1702 0020		
34	1	Grooved ball bearing	9 1002 0050	*	
35	1	Coupling	6 1014 7030		
		*Wear parts to be stored in case of continuous use			

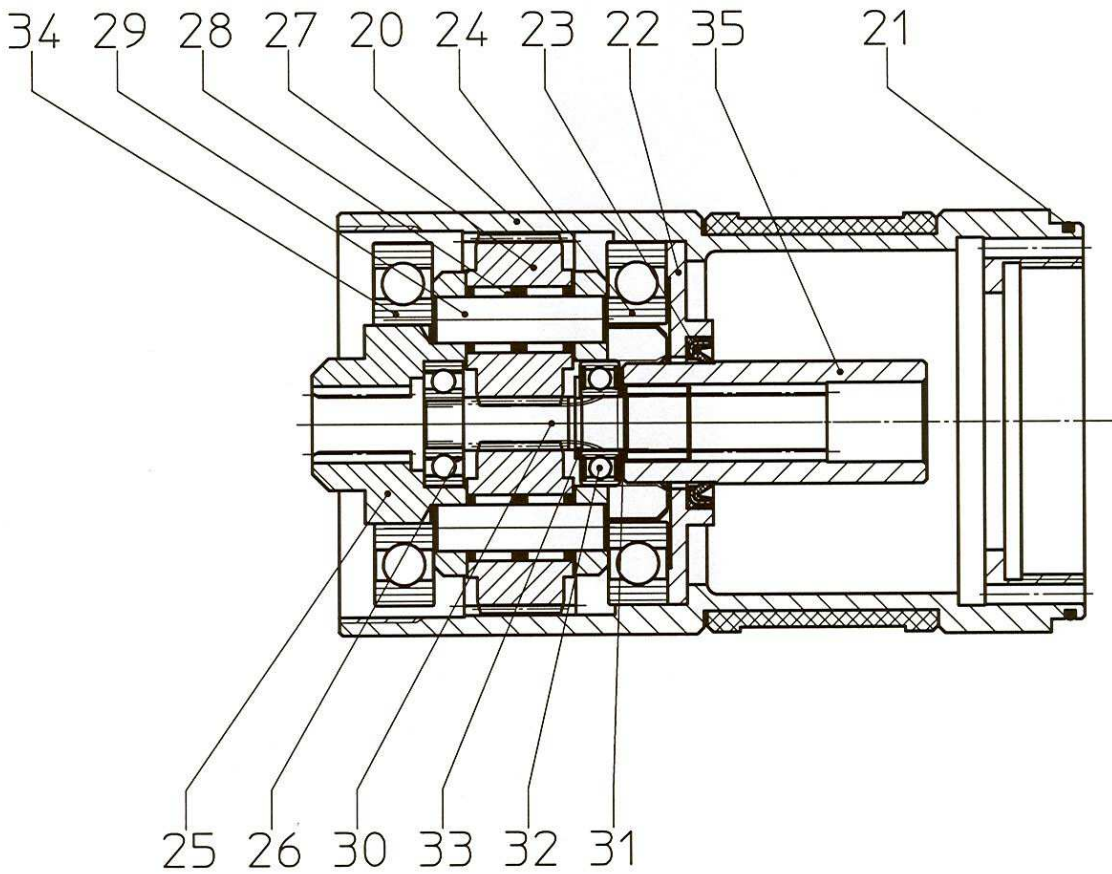
Spare Parts List

Description:

Gearbox

Part and drawing number:

6 1014 4400



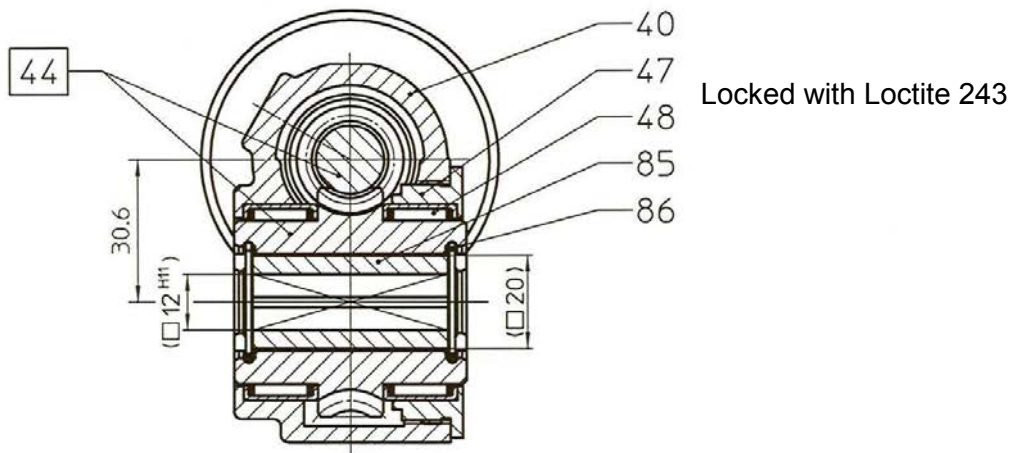
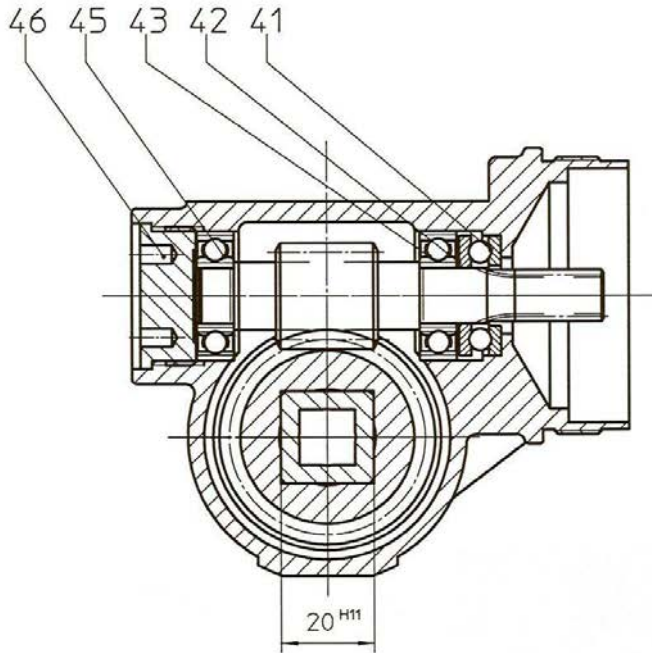
Spare Parts List

Description:

Part and drawing number:

Output Unit

6 1014 7000



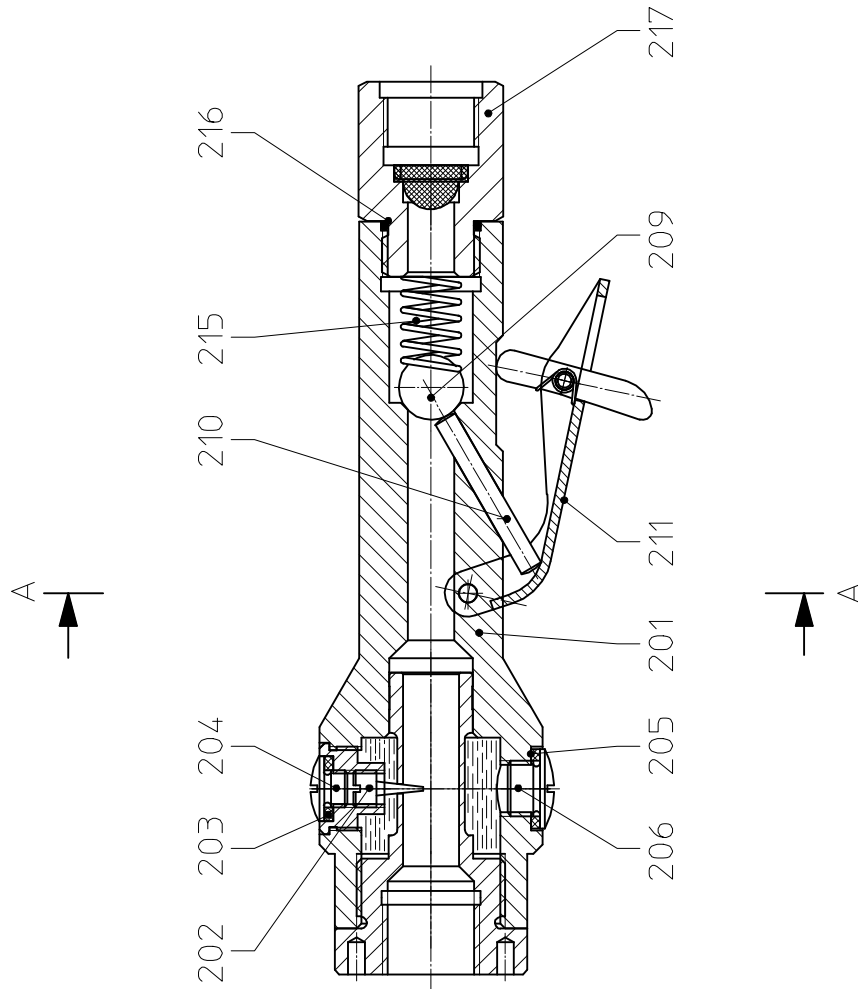
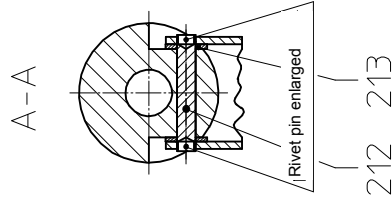
Spare Parts List

Description:

Lever Valve with Oiler

Part and drawing number:

9 2007 0110



Note:

Sketch:



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