Pneumatic Drive Unit
Type 5 8002 7000
Techn. Doc. No. 352
and
Accessories for Pipe Cutting Machine

Repair Manual and Spare Parts List
Repair

General
In general, observe the safety regulations and instructions: refer to the operation and maintenance manual.
The disassembly and re-assembly is done only according to the technical drawing.
In case of damages, our service is at your disposal.

Do not disassemble the tool until you know whether the problem is in one of the modules.
Then only disassemble the tool as necessary to repair as required. Keep contaminants such as dirt and grit away from the internal parts at all times.

Always identify and correct the cause of the problem prior to re-assembling. Further wear and tool failure can result, if the original cause is not corrected.

Information for exact identification of the problem is given in the unit “Troubleshooting” of the operation manual.

Notice: The particular installation direction of the parts mentioned in the following process instructions is indicated in the drawings and the parts lists at the end of this instruction.

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

Disassembly

Preparing of the pneumatic drive unit for disassembly
• Clean the exterior of the drive unit.
• Disconnect energy supply and secure against restart.
• Disconnect pneumatic hose.
• Take cutting tool item 11, respectively item 12 (page 6) out of the tool holder item 8, 9 (page 8) and store it at a safe place.
• Remove drive unit item 1 (page 5) by pulling the ball lock bolts items 5 and 6 (page 8).

Disassembling drive unit modules
• Loosen 4 x M6 item 17 (page 17) and remove pneumatic motor item 1 from the gear item 2 (page 8).
• Loosen 4 x M6 item 39 (page 17) and remove cover hood item 3 (page 8).
Disassembling motor

- 4 x M6 item 17 were loosened (page 17) and pneumatic motor item 1 (page 8) was removed.
- Pull item 4 – 16 out of the motor housing item 1 (page 10).
- If necessary, continue disassembling according to the technical drawing.

Disassembling gear

- Before, loosen 2 x M6 item 17 and remove pneumatic motor item 1. (see “disassembling drive unit modules”)
- Remove snap ring item 37 (page 17), pull out lever item 35 together with items 33, 34 and 36. Continue disassembling, if necessary by knocking out the grooved cylindrical pin item 36.
- Loosen 4 x M6 item 29, pull the gear rim item 14 with the parts items 8, 9, 10, 11, 12, 13, 15 and 26 out of the gear housing item 1.
- Remove snap ring item 6 and pull pinion shaft item 2 with items 5 and 4 out of gear housing item 1.
- Loosen 4 x M5 item 32 and pull gear cover item 30 with the inner parts items 16, 19 and 24 out of gear housing item 1.
- Continue disassembling according to the technical drawings, if necessary.

Re-assembly

The re-assembly is done in the reverse order. 

Observe the following:

- Clean all parts before re-assembling.
- It is recommended to replace O-rings, bearings, radial shaft sealing rings and other sealings by new parts.

Vanes are considered worn, when their width is less than 14.5 mm.

In general, it is recommended to replace all wear parts during repair.
If the bearings item 6 and item 14 in the end plates item 5 and 13 (page 10) have been replaced, the spacing has to be redone (see fig. “end plate with spacer ring”).

The spacer ring must be placed 0.04 / 0.05 mm in front of the end plate. For this, the inner ball bearing ring has to be pressed into the direction of the snap ring.

„End plate with spacer ring“

Lubricant
Fill-up the gear with 25 g of grease.
Grease SPITZNAS reference number: 9 9902 0130 (400 g); 9 9902 0250 (100 g)

After finishing the assembly, a functional check of the drive unit must be done. (see technical specification of the operation and maintenance manual).

Tighten all screws and nuts according to the instructions, when re-assembling.

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<td>18 Nm</td>
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## Spare Parts List

**Description:** Part and drawing number:

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### Spare Parts List

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![Diagram of pipe cutting machine, assy.](image)
## Spare Parts List

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* Wear parts to be stored in case of continuous use
## Spare Parts List

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![Diagram of Pneumatic Drive Unit]

Translation of the original repair instruction, compiled: 10.08.17
## Spare Parts List

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![Diagram of Pivoting connection, assy.]

View rotated 90°
### Spare Parts List

**Description:** Part and drawing number

**Sensor block 9 2016 0080**

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* Wear parts to be stored in case of continuous use
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![Diagram of Sensor Block]
## Spare Parts List

**Description:**

**Gearbox**

**two-stage**

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### Spare Parts List

**Description:** Part and drawing number:

#### Gearbox two-stage

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<td>9 1905 1240</td>
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<td>Gearbox cover</td>
<td>5 8002 4090</td>
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<td>31</td>
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<td>Counter sunk screw</td>
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<td>Eccentric disc</td>
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<td>Cylinder pin</td>
<td>9 1631 0230</td>
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<td>35</td>
<td>1</td>
<td>Lever</td>
<td>9 3902 0280</td>
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<td>38</td>
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<td>Spring pressure piece</td>
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<td>40</td>
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<td>Bushing</td>
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* Wear parts to be stored in case of continuous use
<table>
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<tbody>
<tr>
<td><strong>Gearbox</strong> two-stage</td>
<td><strong>5 8002 4000</strong></td>
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**Spare Parts List**

- **Glued with Loctite 243**

- **Mounted with surface seal**

---

**Diagram:**

- Part 1: Glued with Loctite 243
- Part 38: Mounted with surface seal
- Part 29, 32: Mounted with surface seal
- Part 17: Mounted with surface seal
- Part 26, 31: Mounted with surface seal
# Spare Parts List

<table>
<thead>
<tr>
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<th>Part and drawing number:</th>
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<td><strong>5 8002 4000</strong></td>
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<tr>
<td>two-stage</td>
<td></td>
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</tbody>
</table>

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![Diagram of Gearbox](image)

**Note:**
- 40 glued

---

Translation of the original repair instruction, compiled: 10.08.17

22 Harbor Ave Norwalk, CT 06850
P: 1.888.584.5296 Int: 1.203.349.8150
info@csunitec.com www.csunitec.com
## Spare Parts List

<table>
<thead>
<tr>
<th>Item</th>
<th>Qty.</th>
<th>Description</th>
<th>Part and drawing no.</th>
<th>Remarks</th>
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<tr>
<td>1</td>
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<td>Guard, assy.</td>
<td>5 8003 8510</td>
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<td>1</td>
<td>Splash guard, assy.</td>
<td>5 8003 8650</td>
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<td>3</td>
<td>1</td>
<td>Star handle</td>
<td>5 6011 6210</td>
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<td>4</td>
<td>1</td>
<td>Threaded pin</td>
<td>9 1140 5050</td>
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<td>5</td>
<td>1</td>
<td>Tension sleeve</td>
<td>9 1630 0150</td>
<td></td>
</tr>
<tr>
<td>6</td>
<td>1</td>
<td>Cup spring</td>
<td>9 1801 0520</td>
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<tr>
<td>11</td>
<td>1</td>
<td>Pivot lock, assy.</td>
<td>2 1315 9200</td>
<td>Item 11 - 19</td>
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<td>Pivot ring piece</td>
<td>9 2126 0110</td>
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<tr>
<td>13</td>
<td>1</td>
<td>Hollow screw</td>
<td>9 2126 0130</td>
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<td>14</td>
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<td>Gasket</td>
<td>9 2126 0140</td>
<td>*</td>
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<td>15</td>
<td>1</td>
<td>Ball valve with handle</td>
<td>9 2014 0670</td>
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<td>16</td>
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<td>Connection</td>
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<td>17</td>
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<td>Connection nipple</td>
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<td>1</td>
<td>Hose coupling with tensioning screw</td>
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<td>19</td>
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* Wear parts to be stored in case of continuous use
## Spare Parts List

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<th>Description</th>
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</thead>
<tbody>
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<td>Guard with water connection</td>
<td>5 8003 8500</td>
</tr>
</tbody>
</table>

---

**Translation of the original repair instruction, compiled: 10.08.17**

22 Harbor Ave Norwalk, CT 06850
P: 1.888.584.5296 Int: 1.203.349.8150
info@csunitec.com    www.csunitec.com

CS Unitec, Inc
## Spare Parts List

<table>
<thead>
<tr>
<th>Item</th>
<th>Qty.</th>
<th>Description</th>
<th>Part and drawing number</th>
<th>Remarks</th>
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<tbody>
<tr>
<td>1</td>
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<td>Sleeve</td>
<td>5 8003 8820</td>
<td></td>
</tr>
<tr>
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<td>1</td>
<td>Intermediate piece</td>
<td>5 8003 8840</td>
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<tr>
<td>3</td>
<td>1</td>
<td>Scraper ring</td>
<td>H-9003-0900</td>
<td>*</td>
</tr>
<tr>
<td>4</td>
<td>1</td>
<td>Threaded head</td>
<td>5 8002 8860</td>
<td>glued in place</td>
</tr>
<tr>
<td>5</td>
<td>1</td>
<td>Eye bolt</td>
<td>5 8003 8850</td>
<td></td>
</tr>
<tr>
<td>6</td>
<td>1</td>
<td>Scraper ring</td>
<td>H-9003-0890</td>
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<td>7</td>
<td>1</td>
<td>Spring washer</td>
<td>9 3312 0010</td>
<td></td>
</tr>
<tr>
<td>8</td>
<td>1</td>
<td>Socket head screw</td>
<td>9 1112 3020</td>
<td></td>
</tr>
<tr>
<td>9</td>
<td>1</td>
<td>Threaded pin</td>
<td>9 1147 7010</td>
<td>glued in place</td>
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<tr>
<td>10</td>
<td>1</td>
<td>Rotary knob</td>
<td>5 8003 8810</td>
<td></td>
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<tr>
<td>11</td>
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<td>12</td>
<td>1</td>
<td>Bushing</td>
<td>5 8002 8890</td>
<td>glued in place</td>
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<td>13</td>
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<td>O-Ring</td>
<td>9 1901 3180</td>
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Spare Parts List

<table>
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<th>Description</th>
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<tr>
<td>Adjustment device</td>
<td>5 8003 8800</td>
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Diagram of the adjustment device with labeled parts:

- Part 1
- Part 2
- Part 3
- Part 4
- Part 5
- Part 6
- Part 7
- Part 8
- Part 9
- Part 10
- Part 11
- Part 12
- Part 13

Translation of the original repair instruction, compiled: 10.08.17
# Spare Parts List

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<th>Item</th>
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<th>Part and drawing number</th>
<th>Remarks</th>
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<tbody>
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<td>1</td>
<td>Adapter for blade</td>
<td>5 8003 8050</td>
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<tr>
<td>2</td>
<td>1</td>
<td>Clamp disc</td>
<td>5 8003 8070</td>
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<tr>
<td>3</td>
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<td>Nut</td>
<td>9 1209 0110</td>
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<td>4</td>
<td>1</td>
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<td>ø22.2 u. 30 mm</td>
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## Spare Parts List

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![Diagram of Adapter for blade, assy.]

1. 
2. 
3. 
4.
## Spare Parts List

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<td>1</td>
<td>Feather key</td>
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<td>1</td>
<td>Spacer disc for 45° bevelling cutter</td>
<td>5 8002 8040</td>
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Spare Parts List

Description: Part and drawing number:

Adapter for bevelling cutter, assy.  5 8002 9750

1

2

3

4

5

6
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<td>2</td>
<td>Wheel bolt I</td>
<td>5 8003 8130</td>
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<tr>
<td>3</td>
<td>2</td>
<td>Wheel bolt II</td>
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</tr>
<tr>
<td>4</td>
<td>2</td>
<td>Wheel I</td>
<td>5 8003 8150 *</td>
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</tr>
<tr>
<td>5</td>
<td>2</td>
<td>Wheel II</td>
<td>5 8003 8160 *</td>
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<tr>
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<td>2</td>
<td>Hook</td>
<td>5 8002 8170</td>
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<td>4</td>
<td>Nut</td>
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<td>2</td>
<td>Ball lock bolt</td>
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<tr>
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* Wear parts to be stored in case of continuous use
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### Spares Parts List

**Description:**
Chain tensioner small

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<td>1</td>
<td>Eye bolt</td>
<td>5 8003 8330</td>
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</tr>
<tr>
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<td>1</td>
<td>Scraper</td>
<td>H-9003-0890</td>
<td>*</td>
</tr>
<tr>
<td>4</td>
<td>6</td>
<td>Cup spring</td>
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<td></td>
</tr>
<tr>
<td>5</td>
<td>1</td>
<td>O-Ring</td>
<td>9 1901 3060</td>
<td>*</td>
</tr>
<tr>
<td>6</td>
<td>1</td>
<td>Threaded head</td>
<td>5 8002 8860</td>
<td>glued in place</td>
</tr>
<tr>
<td>7</td>
<td>1</td>
<td>Spring washer</td>
<td>9 3312 0010</td>
<td></td>
</tr>
<tr>
<td>8</td>
<td>1</td>
<td>Socket head screw</td>
<td>9 1112 3020</td>
<td></td>
</tr>
<tr>
<td>9</td>
<td>1</td>
<td>Rotary knob</td>
<td>5 8003 8320</td>
<td></td>
</tr>
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<td>10</td>
<td>2</td>
<td>Bolt</td>
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<td>glued in place</td>
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<td>Chain lock</td>
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* Wear parts to be stored in case of continuous use
## Spare Parts List

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![Diagram of chain tensioner small part](image)
### Spare Parts List

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<th>Remarks</th>
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<td>1</td>
<td>Carriage</td>
<td>5 8003 8110</td>
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<td>2</td>
<td>2</td>
<td>Wheel bolt</td>
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<tr>
<td>3</td>
<td>2</td>
<td>Wheel bolt II</td>
<td>5 8003 8140</td>
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</tr>
<tr>
<td>4</td>
<td>2</td>
<td>Wheel I</td>
<td>5 8003 8150</td>
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</tr>
<tr>
<td>5</td>
<td>2</td>
<td>Wheel II</td>
<td>5 8003 8160</td>
<td>*</td>
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<tr>
<td>6</td>
<td>1</td>
<td>Hook</td>
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</tr>
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<td>7</td>
<td>4</td>
<td>Nut</td>
<td>9 1203 0320</td>
<td>glued in place</td>
</tr>
<tr>
<td>8</td>
<td>2</td>
<td>Ball lock bolt</td>
<td>9 1650 0010</td>
<td></td>
</tr>
<tr>
<td>9</td>
<td>1</td>
<td>Bushing</td>
<td>5 8003 8200</td>
<td>glued in place</td>
</tr>
</tbody>
</table>

* Wear parts to be stored in case of continuous use

---

22 Harbor Ave Norwalk, CT 06850
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info@csunitec.com www.csunitec.com

Translation of the original repair instruction, compiled: 10.08.17
Spare Parts List

Description: Part and drawing number:

Guide carriage large

5 8010 8100
## Spare Parts List

### Chain tensioner large

<table>
<thead>
<tr>
<th>Item</th>
<th>Qty.</th>
<th>Description</th>
<th>Part and drawing number</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Rotary sleeve</td>
<td>5 8002 8410</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>Eye bolt</td>
<td>5 8002 8430</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td>Eye bolt II</td>
<td>5 8002 8440</td>
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<tr>
<td>4</td>
<td>2</td>
<td>Screwed lock pin</td>
<td>5 8002 8420</td>
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<tr>
<td>5</td>
<td>1</td>
<td>Threaded head</td>
<td>5 8002 8480</td>
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<td>6</td>
<td>1</td>
<td>Pressure spring</td>
<td>9 1803 3390</td>
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<tr>
<td>7</td>
<td>1</td>
<td>Nut</td>
<td>9 1203 0320</td>
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<tr>
<td>8</td>
<td>1</td>
<td>Wheel bolt</td>
<td>5 8002 8470</td>
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</tr>
<tr>
<td>9</td>
<td>2</td>
<td>Locking washer</td>
<td>9 1706 0120</td>
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<tr>
<td>10</td>
<td>2</td>
<td>Wheel</td>
<td>5 8002 8460</td>
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<td>11</td>
<td>2</td>
<td>Washer</td>
<td>9 3302 0110</td>
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<td>12</td>
<td>2</td>
<td>Scraper</td>
<td>H-9003-0910</td>
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<tr>
<td>13</td>
<td>1</td>
<td>Tensioning chain (19 links)</td>
<td>5 8002 8710</td>
<td></td>
</tr>
</tbody>
</table>

*Wear parts to be stored in case of continuous use.*
## Spare Parts List

<table>
<thead>
<tr>
<th>Description</th>
<th>Part and drawing number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Chain tensioner large</td>
<td>5 8002 8400</td>
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![Diagram of Chain Tensioner Large]

Translation of the original repair instruction, compiled: 10.08.17
### Spare Parts List

**Tightener Set**  

<table>
<thead>
<tr>
<th>Item</th>
<th>Qty.</th>
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<th>Part and drawing number</th>
<th>Remarks</th>
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</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Spindle nut 1</td>
<td>5 8001 6850</td>
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</tr>
<tr>
<td>2</td>
<td>1</td>
<td>Spindle nut 2</td>
<td>5 8001 6860</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td>Spindle</td>
<td>5 8001 6910</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>1</td>
<td>Tensioning segment small</td>
<td>5 8001 6830</td>
<td></td>
</tr>
<tr>
<td>5</td>
<td>1</td>
<td>Tensioning segment small</td>
<td>5 8001 6840</td>
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</tr>
<tr>
<td>Description:</td>
<td>Part and drawing number:</td>
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<td></td>
<td></td>
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<tr>
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<td>--------------------------</td>
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<td>Tightener Set</td>
<td>5 8002 6800</td>
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### Spare Parts List

<table>
<thead>
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<th>Item</th>
<th>Qty.</th>
<th>Description</th>
<th>Part and drawing number</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td></td>
<td>Spanner AF10</td>
<td>9 1301 0020</td>
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<tr>
<td>1</td>
<td></td>
<td>Spanner AF17</td>
<td>9 1316 0290</td>
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<td>1</td>
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<td>Spanner AF24</td>
<td>9 1316 0280</td>
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<tr>
<td>1</td>
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<td>Spanner AF30</td>
<td>9 1301 0120</td>
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<td>1</td>
<td></td>
<td>Spanner AF32</td>
<td>9 1301 0180</td>
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<tr>
<td>1</td>
<td></td>
<td>Pin spanner</td>
<td>9 1313 0040</td>
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</tbody>
</table>