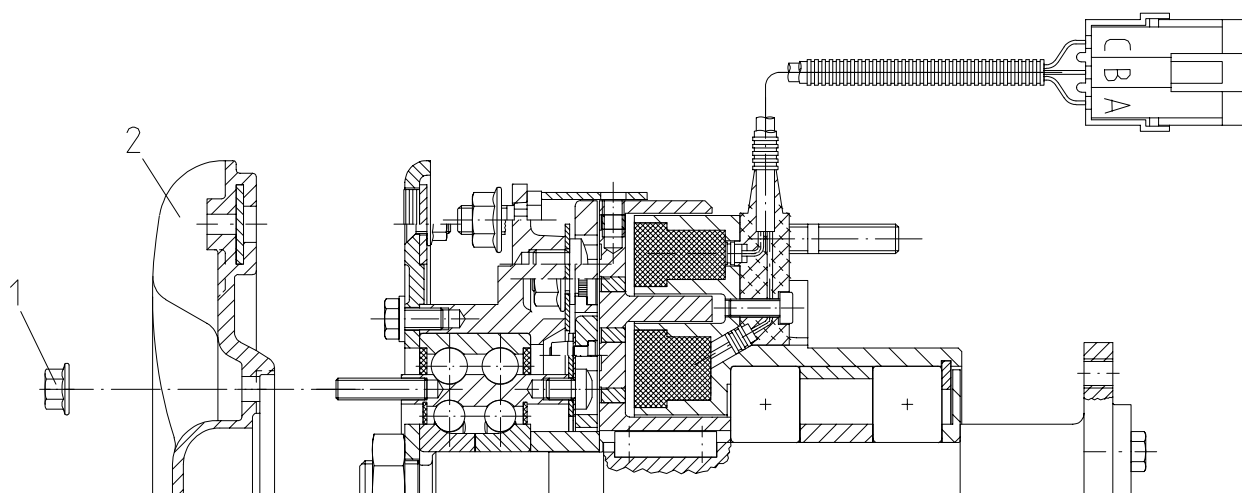
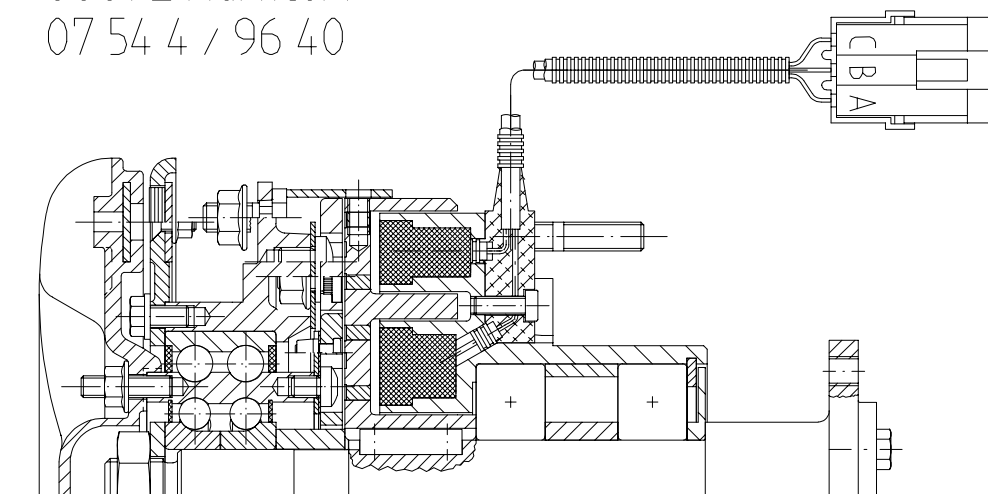


Repair instructions for LA1.2.0118Y and LA1.2.119Y

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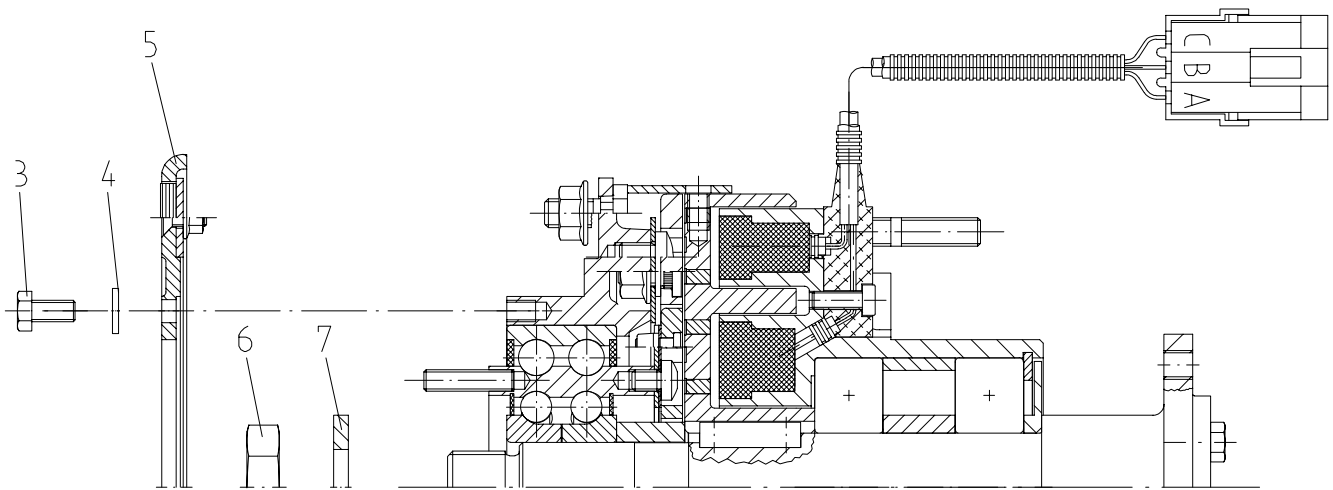


1) Loose hexagon head nut M6 (1).

2) Remove aluminium fan (2) by hand.
Mind the acceleration of the
permanent magnets.

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Page 1

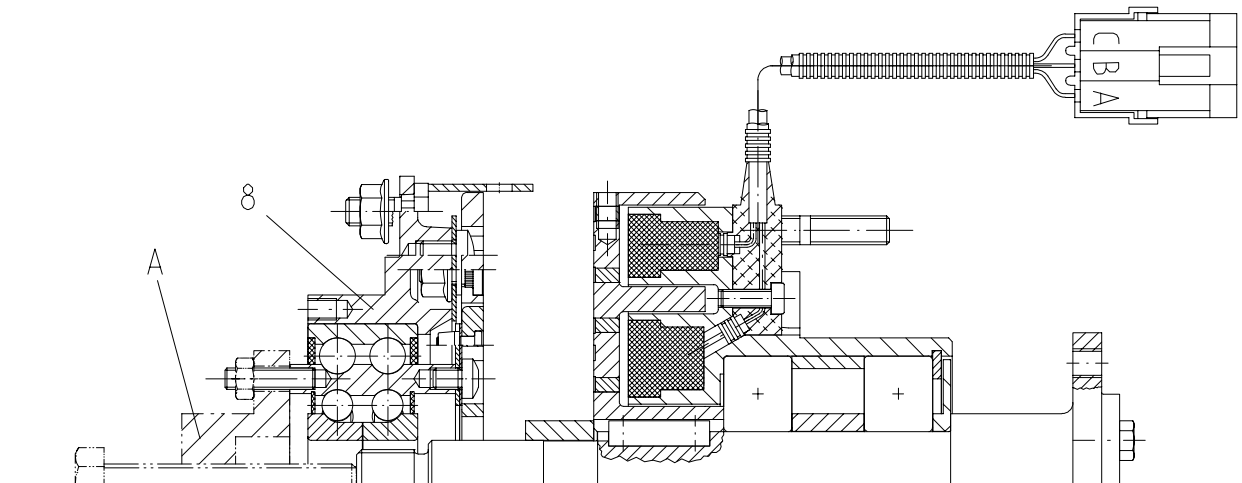


3) Loose hexagon head screw (3) and remove washers (4).

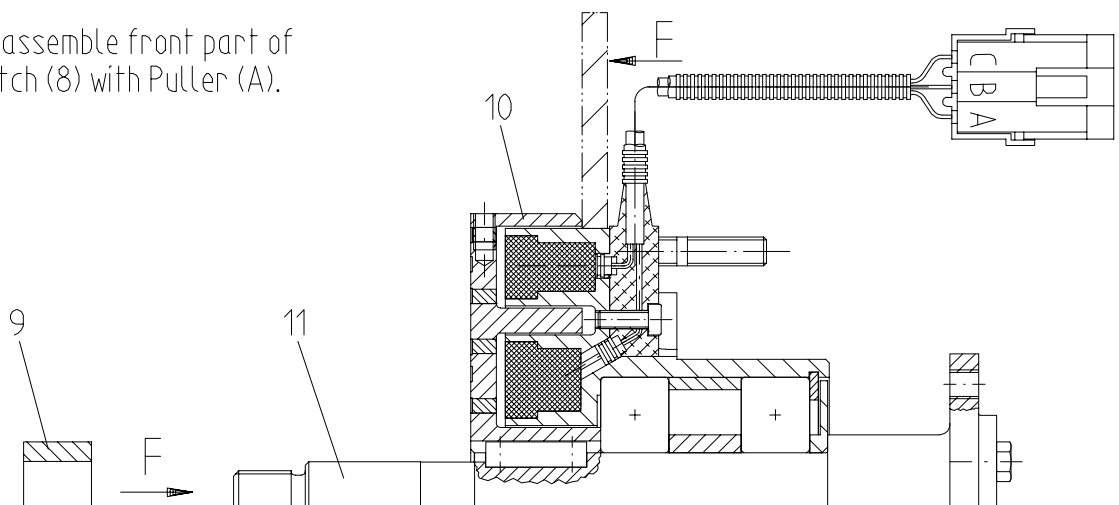
5) Remove fan.

4) Dismantle the permanent magnet ring (5).

6) Remove hexagon head nut M20×1.5 (6). Remove washer (7).



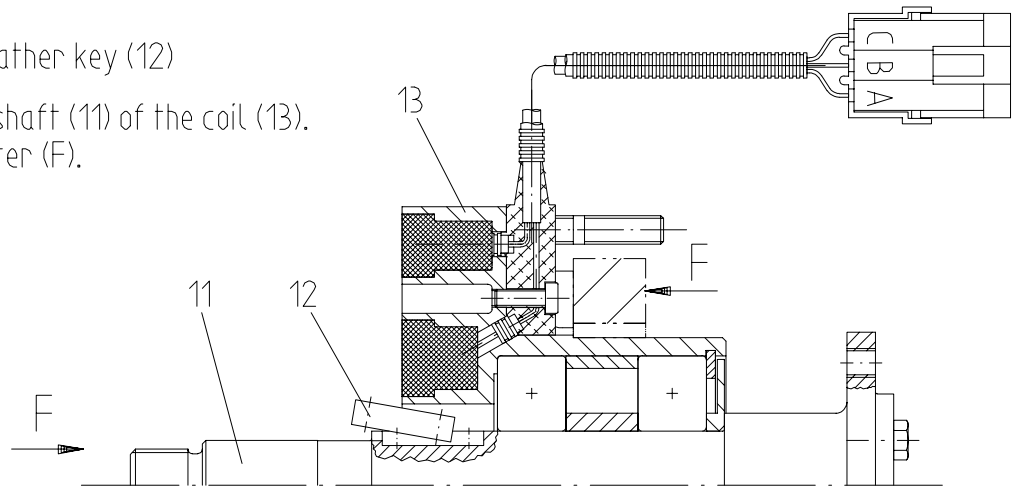
7) Disassemble front part of clutch (8) with Puller (A).



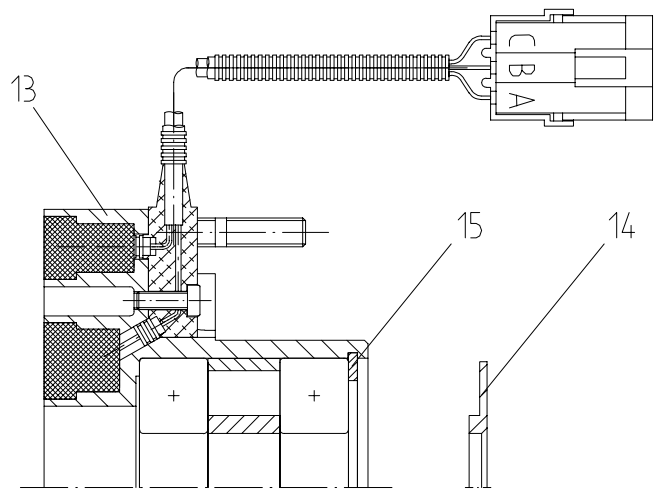
8) Remove spacer (9).

9) Press the shaft (11) of the rotor (10). Follow the letter (F).

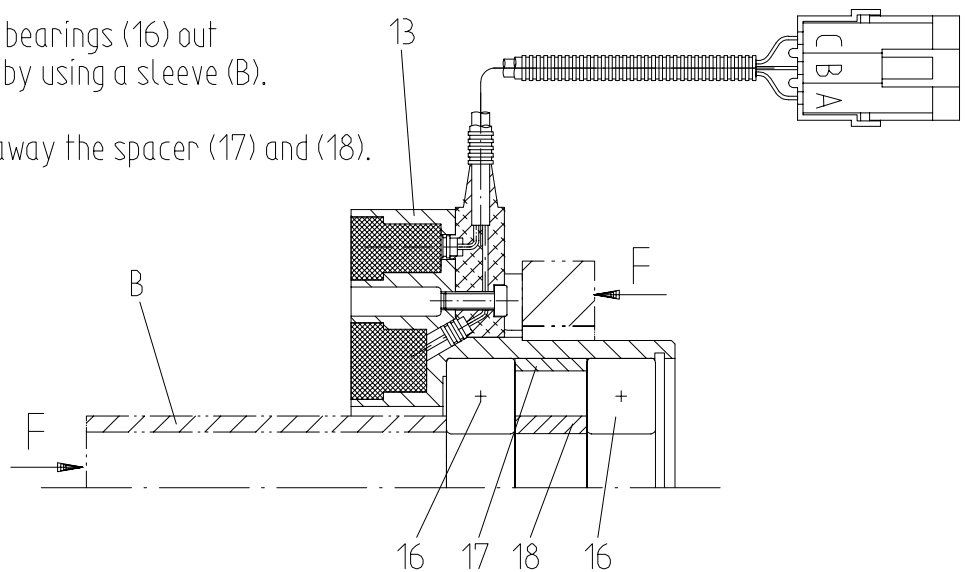
- 10) Remove feather key (12)
- 11) Press the shaft (11) of the coil (13).
Follow letter (F).



- 12) Remove gasket (14) from shaft.
- 13) Take out circlip (15) from coil (13).



- 14) Press the ball bearings (16) out of the coil (13) by using a sleeve (B).
- 15) Don't through away the spacer (17) and (18).



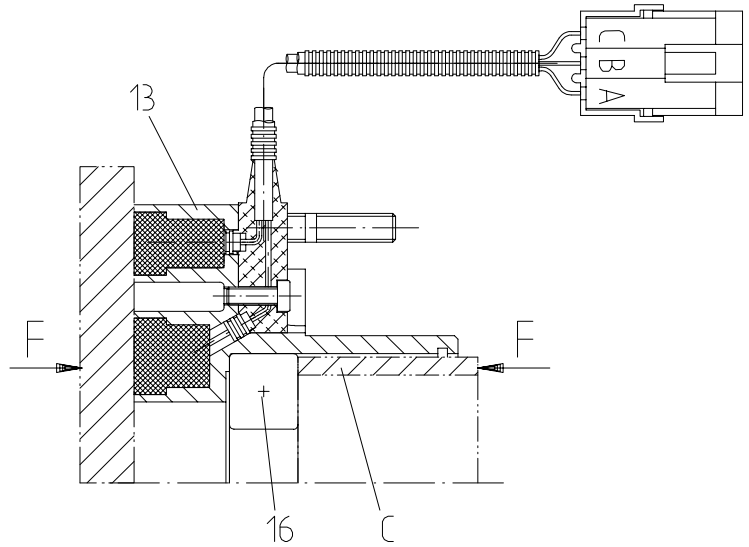
Renew the following parts
when reassemble the clutch:

clutch-front-part (8)
rotor (10)
2 × ball bearings (16)

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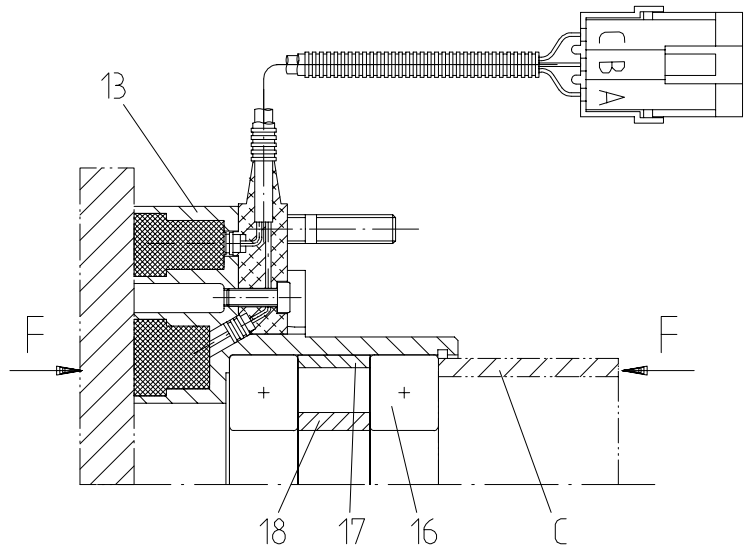
Assembly instruction

- 16) Press the ball bearing (16) into the coil (13).
(Note: Press only the outer ring of the bearing. See (F).

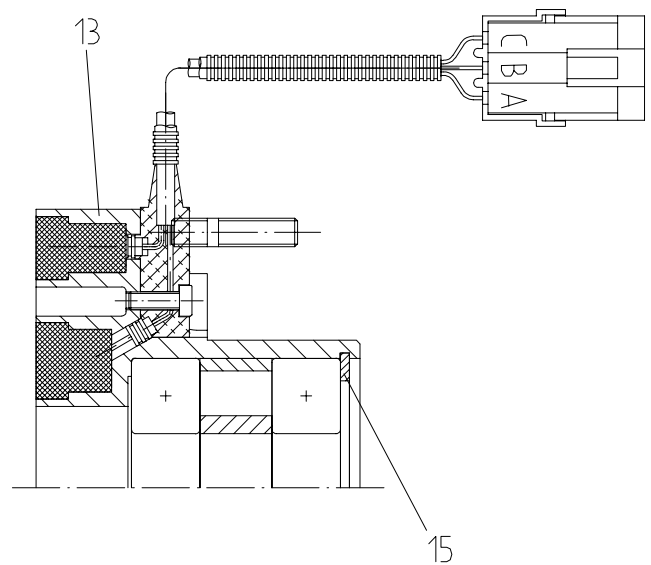


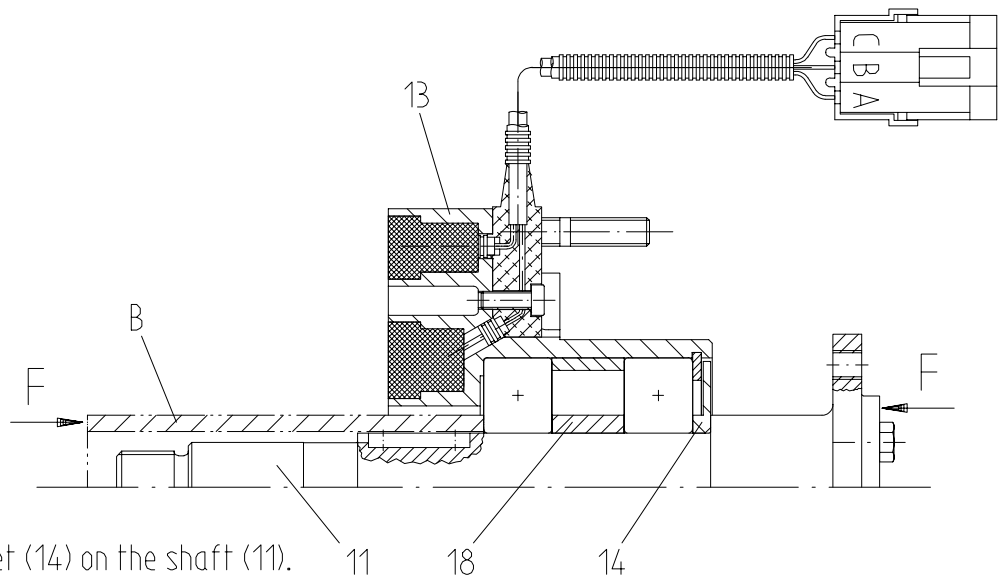
- 17) Insert spacer (17) and (18) into the coil (13).

- 18) Press the ball bearing (16) into the coil (13).
(Note: Press only on the outer ring of the bearing. See (F).



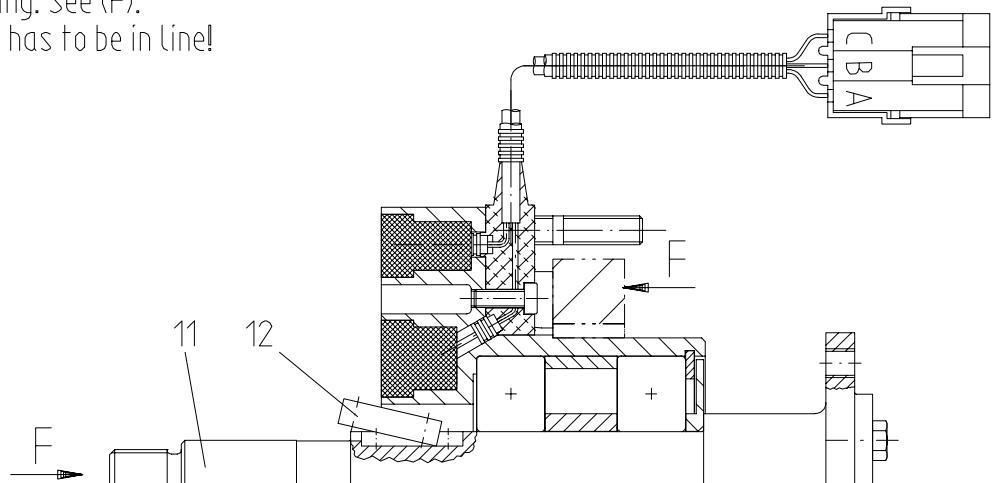
- 19) Replace circlip (15) into the coil (13).



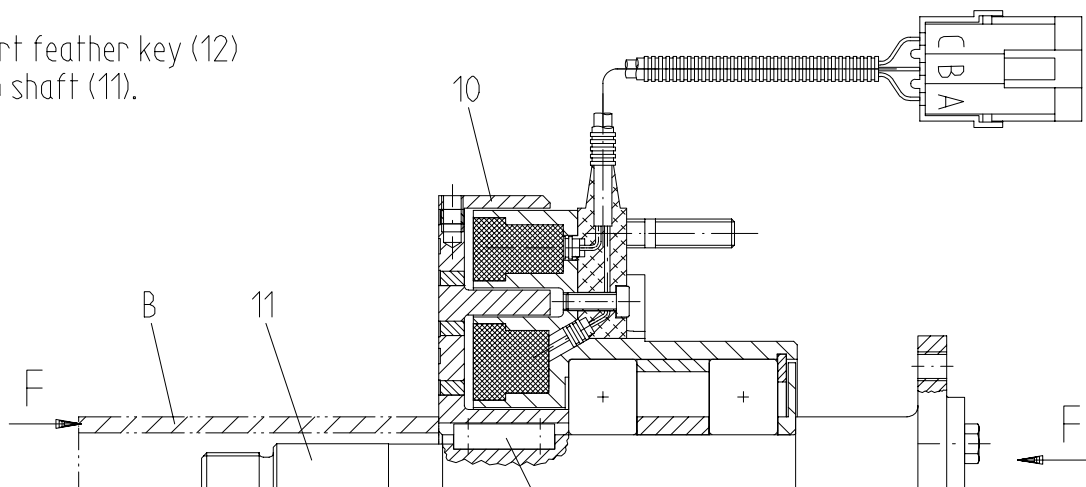


20) Push gasket (14) on the shaft (11).
(Take care for the right position)

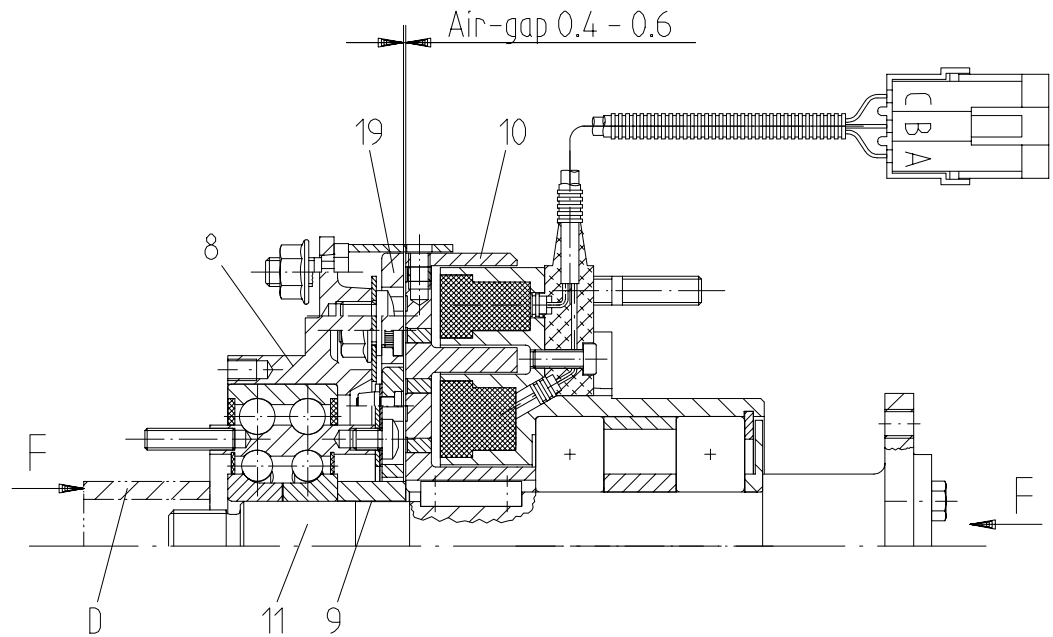
21) Press the coil (13) onto the shaft (11).
(Note: Press only the inner ring
of the bearing. See (F).
Spacer (18) has to be in line!



22) Insert feather key (12)
into shaft (11).



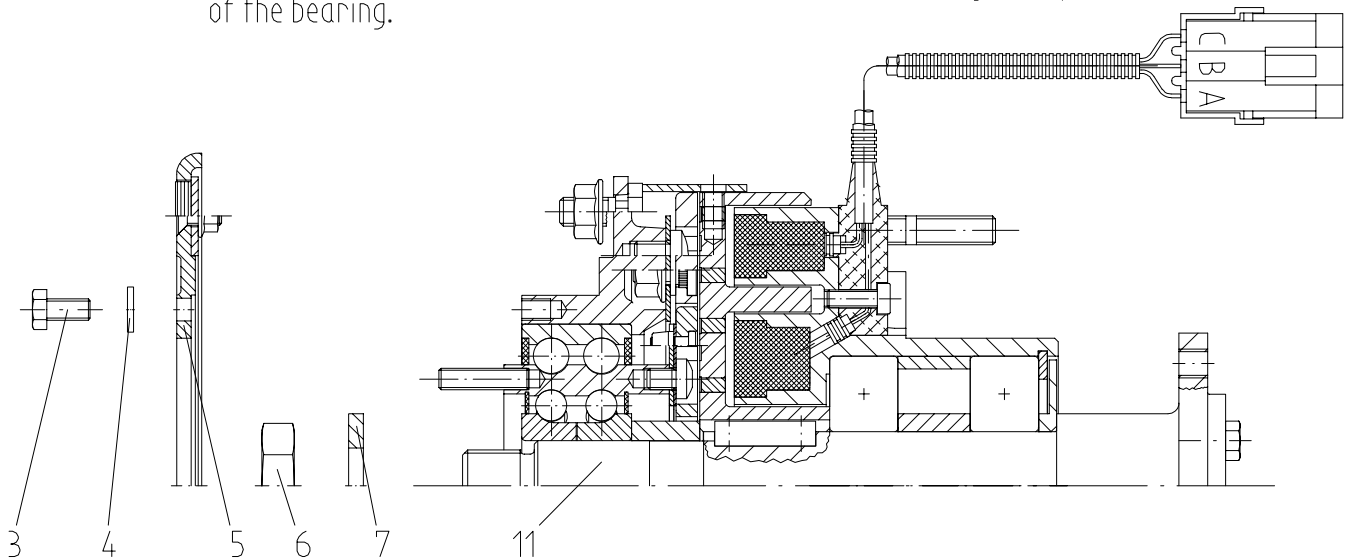
23) Press the rotor (10) on to
the shaft (11). Use a sleeve (B).
Look after the position of the feather key (12).



24) Push spacer (9) on to the shaft (11).

25) Press the clutch front part (8) with sleeve on to the shaft. Press only on the inner ring of the bearing.

26) Check the air-gap 0.4 - 0.6 mm between rotor (10) and core disc (19).
If necessary put tolerated washers between bearing inner ring and spacer (9).



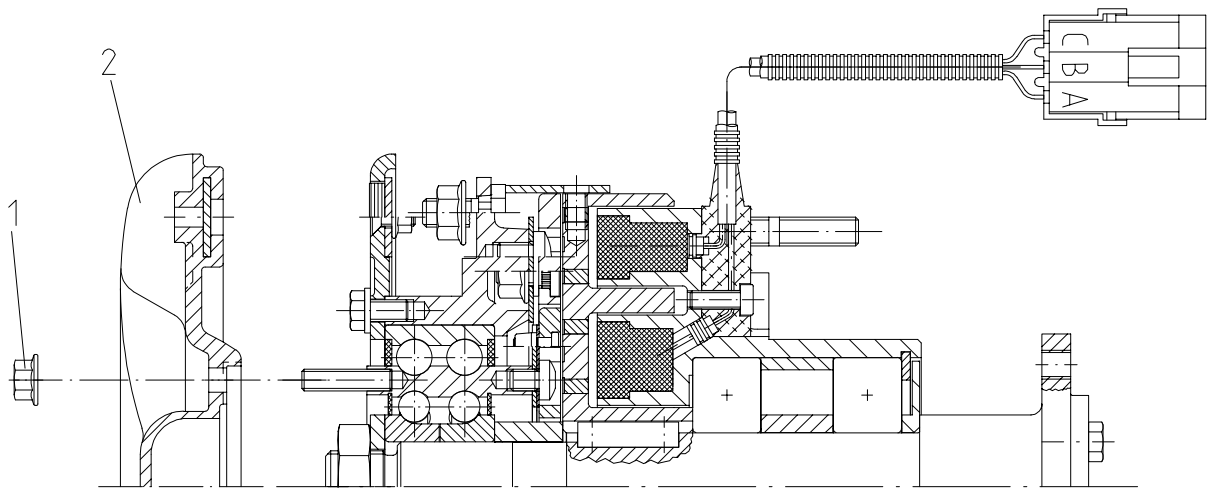
27) Push washer (7) on to the shaft (11).

28) Assemble hexagon head nut M20×1.5 (6).
Torque $M_a = 90 \text{ Nm}$
Secure hexagon head nut with locking paint

31) Bolt the permanent magnet ring (5) with three hexagon head screws M6×12-8.8 and washers (4) on to the clutch front part.
Torque $M_a = 10 \text{ Nm}$

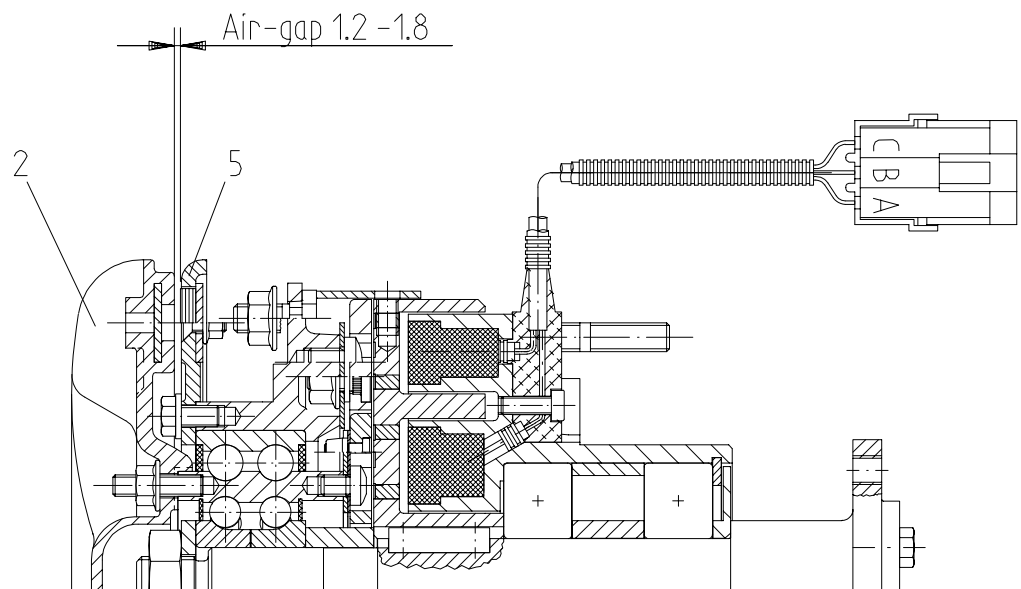
29) Assemble fan.

30) Assemble permanent magnet ring (5)



32) Assemble aluminium fan (2).

33) Screw the aluminium fan (2)
on to the clutch front part
with hexagon head nut M6-8 (1).
Torque Ma = 10 Nm



34) Check air-gap 1.2 - 1.8 mm between
fan (2) and permanent magnet ring (5).