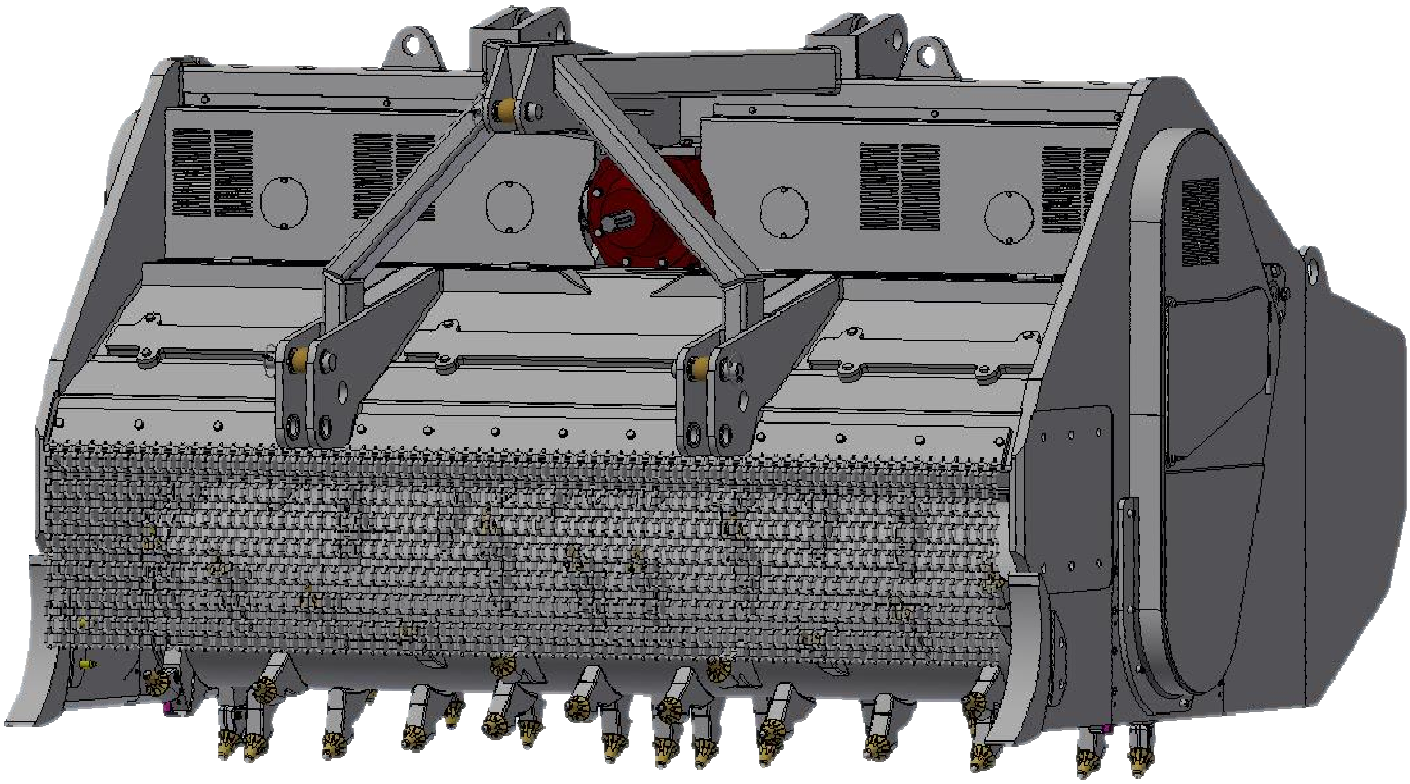
Copy of the operating manual original and spare parts list

(Keep for Future Use)

SBF 24



Stehr

Soil stabilization grinder

04/2024

Technical Information

Soil stabilisation milling machines with belt drive

Gear train damage

Damage occurs every now and then on the soil stabilisation milling machines to the planetary gears located within the rotor.
Through unannounced visits by our staff to several construction sites, we were able to establish that the drive belt tension was not correctly set on many of the machines being used there.
In one case, for example, we were assured that the belt tension is regularly corrected only for us to establish that the tensioning mechanisms for the belts were already rusted solid.
Uneven belt tension is by far the most frequent cause of gear train damage.

1. **Uneven belt tension**

   If the drive belts' tension is not regularly checked / corrected, the situation arises after a while that the tension of the belts differs from one side to the other.

   As a result of this the more firmly tightened belt transfers more output onto the associated planetary gear train than the less tightened one.
   In extreme cases the situation can arise that for a while one belt alone is transferring the entire output and thus also only one planetary gear train is doing any work.
   This inevitably leads to this gear train being overloaded and ultimately to it breaking down.

   Equal belt tension on both sides of the milling drive unit is therefore eminently important.
   Using a frequency meter the tension can be checked and, if necessary, corrected very easily within just a few minutes.

   We would point out that in the event of damage to a gear train and any resulting warranty claim the defect gear train and both drive belts must be sent to us in every case.
   After checking the pattern of damage on the gear train and the belts, we will then decide whether grounds for a warranty claim exist or the whether damage has been caused by the circumstances described above.

2. Cornering while milling

During the milling of straight lanes the planetary gears in the rotor are subjected almost exclusively to radial loading.
This loading comes from the transmission of force via the belt drive.
The drive is designed for this type of loading and it causes no problems.

If, however, the machine corners while the milling cutter is in the ground, axial forces also arise.
Up to a certain level these forces too are absorbed by the extremely robustly designed gear train mounting.
However, if the forces become to great, this is no longer possible and the gear train breaks down.

The machines must therefore take only very wide corners in order to keep the axial loading of the gear train within bounds.
The approved radius for any cornering may not exceed 50 metres.
Milling by driving in tight circles is most definitely not approved.

Gear train damage caused by excessive axial loading is very easy to identify when inspecting the defective part.
Please note that in such cases no right to any warranty claim exists.

Stehr Baumaschinen GmbH
Technical support
21.01.2009

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Copy of the EC – declaration of conformity original

EC Machinery Directive 2006/42/EC, Appendix II A

1. We herewith declare that the ground stabilising system dust-free

   Type : Stehr **SBF 24**

2. conforms to the following corresponding regulations:

   2006/42/EC

3. Applied harmonised European norms:

   DIN EN ISO 12100 parts 1+2 **Machinery safety, general design guidelines**

4. Applied European norms (norm designs)

   Mobile Road Construction Machines

   EN500-2:2006+A1:2008 **Generelly requirements**
   EN500-3:2006+A1:2008 **Special requirements re: ground stabilising milling cutters**

5. Applied national technical safety regulations, in particular

   UVV Civil Engineering, VBG 40

6. Certification Series No.:

7. (Jürgen Stehr) Manufacturer: Stehr Baumaschinen GmbH
   MD

8. Documentation Officer: Jürgen Stehr, Am Johannesgarten 5, 36318 Schwalmtal-Storndorf

If the Stehr device is modified without our approval, this declaration ceases to be valid.

1. Introduction

The SBF 24 soil stabilization grinder from ***Stehr*** is a product based on the latest technology.

An absolute maximum of reliability is guaranteed by Stehr's tremendous experience combined with the most modern production and testing procedures, including life expectancy testing of all important components and the highest demands on quality.

This guide includes:

- Safety Regulations
- Operating Instructions
- Maintenance Instructions
- Troubleshooting

This guide helps

- Simplify familiarization with the equipment
- Avoid malfunctions caused by improper operation

Adherence to the maintenance instructions

- Increases reliability during use on construction sites
- Extends the useful life of the equipment
- Reduces repair costs and downtime

The Stehr Baumaschinen GmbH assumes no liability or warranty for the function of the equipment in the following circumstances:

- Operation for other than conventional uses
- Utilization in a manner not described in this guide

All warranties expire in cases of

- Damage caused by operator error or negligence
- Damage due to insufficient maintenance
- Use of inappropriate operating agents and materials

This guide was prepared for use by operating and maintenance personnel on site and should be maintained with the equipment.

Equipment is to be operated only in accordance with this guide.

Comply with all safety regulations.

Adhere to the "Safety Rules for the Operation of Road Rollers and Soil Compactors" as prepared by the Earthworks and Road Construction Trade Guild and standard accident prevention policies as applicable.

We reserve the right to make unannounced changes in the course of any technical advancements and improvements.

The preceding and following instructions do not augment the warranty and liability terms within ***Stehr*** Baumaschinen GmbH's General Business Terms & Conditions.

We wish you the best of success with your ***Stehr*** system.

Stehr Baumaschinen GmbH
Am Johannesgarten 5
36318 Schwalmtal
Tel. + 49 (0) 6630-91844-0
Fax + 49 (0) 6630-91844-99
E-mail: sekretariat@stehr.com

2. Technical Data

Stehr - SBF Soil Stabilization Grinder

Type	SBF 24
Grinding Width	2400 mm
Grinding Depth, max.	600 mm
Weight	4670 kg
Rotor ∅	800 mm
Rotor Speed	310 rpm
Drive	PTO
PTO Output	1000 rpm
Power Requirement	
Min.:	170 kW
Max.:	210 kW

3. Safety Regulations

3.1 Safety regulations in the operating and maintenance instructions:

These symbols are used to indicate potential hazards to individuals, the equipment or machinery parts.

DANGER	
	High risk dangers, which, if not prevented, will result in serious injury or death.

WARNING	
	Medium risk dangers, which, if not prevented, may result in serious injury or death.

CAUTION	
	Low risk dangers, which, if not prevented, may result in slight or some injury.

This ***Stehr*** machine has been built with today's technology and in accordance regulations in place at the time.
Nevertheless, this machinery can pose a danger to people and property if it is

- not properly used
- operated by untrained personnel
- inappropriately altered or modified
- and if safety precautions are not adhered to

Any individual, who is involved in the operation, maintenance and repair of the grinder, must read and follow these safety regulations. The using company may require the individual to verify such by his or her signature.

Furthermore, standard accident prevention rules, generally recognized technical safety and traffic regulations, as well as country-specific ordinances and statutes apply.

3.2 Intended Utilization

This equipment is only to be used for

- stabilization of roadway foundations and road surfaces
- asphalt recycling during road construction
- sealing of sanitary landfills

DANGER

This equipment may not be used in explosive atmosphere

The system can be a source of danger when used for purposes other than those for which it is intended. The manufacturer assumes no liability for any damages resulting from any such use other than those for which the system was intended.

3.3 Who is authorized to operate the machine?

Only trained, specially oriented and authorized individuals over 18 years of age may drive and operate the machine. Responsibilities must be clearly defined and adhered to for operating the equipment.

Any person under the influence of alcohol, medications or drugs may not operate the machine.

Maintenance and repair work demands special knowledge and skills and may only be performed by trained specialist personnel.

3.4 Modifications and Alterations of the System

For reasons of safety, modifying the machine independently is not allowed and in such cases the operating licence ceases to be valid.

Original parts and accessories have been designed specially for the machine. We would like to explicitly point out that we do not grant permission for the use of any parts or special accessories that have not been provided by us. Fitting or using such products can also compromise your active or passive driving safety. The manufacturer is not liable for any damages resulting from the use of any parts or special accessories not produced by us.

3.5 Equipment Safety Stickers

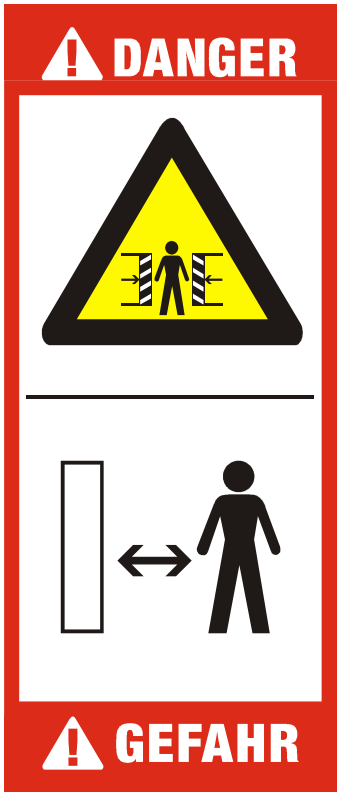
Please ensure that all the safety labels are complete and legible!
Please replace any damaged or illegible labels!



Danger: rotating shafts



Warning: injuries to hand



Danger of crushing



Warning: injuries to feet



Warning of dangerous area



Danger from falling cover or shaft



Read operating instructions



Warning of flying grindings



Danger: rotating shafts



Danger: running belts

3.6 Transporting the machine

Driving on public roads is prohibited due to exceeding the axle load and the permissible total weight and is only permitted on construction sites!!!

4. Set-Up and Adjustments

4.1 Mounting on Towing Vehicle



Warning: Please contact us to determine if your prime mover is suitable for use with the grinder.

Suitable prime movers may be:
Tractors with enough power to pull the grinder (see technical data), which are equipped with a Vario- or Super creep gearbox. The tractor must be able to drive less than 0,4 km/h.
Driving speed while working normally is between 300 m/h and 1000 m/h, depending to the grinding deeph and the kind of soil.
Tractors which do not meet these criterions are not suitable.

The 3-point hydraulic system is used for mounting on the towing vehicle.



DANGER

Ensure that there is no one between the towing vehicle and the soil stabilization grinder.

The connector points must be freely accessible.
Remove hydraulic hoses from the danger area.

The following points must be checked on the towing vehicle:

1. Traverse rods must be the same length and be rotated open as widely as possible (do not insert them into the oblong openings).
2. Do not set the lower attachment hook too rigidly. Simply connect it between the pivot points of the yoke.
3. **NOTE**: It is advantageous to use a hydraulic upper guide unit as this allows the system to be finely adjusted during operation.

4.2 Adjusting the Universal Shaft

DANGER

Do not operate the grinder without the safety shields of the universal shaft.

The length of the universal shaft must correspond exactly with the respective type of towing vehicle (especially important when the towing vehicle is changed often).

Shafts that are too long create axial pressure on the gear's input shaft, which can lead to unauthorized bearing play or complete failure of the angular gear.

1. Determine the shortest interval that arises under any conditions between the power take-off input stub on the towing vehicle and the machine itself.
2. Insert the universal-shaft halves into the towing-vehicle and system (do not push the profile tubes together), hold next to one another and mark the length to be shortened (paying attention to the maximum overlap).
3. Shorten the two profile tubes equally. The plastic protective tubes should be ca. 2 cm shorter than the profile tubes.
4. Install the shortened universal shaft and try out a variety of raising and upper guide unit positions before engaging the PTO. Operation can only be made once you have ensured that the universal shaft has an optimal fit in all positions.
5. The **PTO output** on the towing vehicle and the grinder must match **(1000/min)**.
6. The system has 3 holes for coupling the lower attachment hook. The lowermost hole should only be used for transport purposes (movement on a lowboy) so as to avoid undesired angling of the universal shaft. The middle hole is usually the one best suited for operation.

The PTO must be turned off when the system is being raised!!! (no later than ca. 5 cm above ground level) If it is not turned off, any further raising will create an angling of the universal shaft, which can damage the shaft and the transmission.
Make use of the adjustable turn-off during raising if the towing vehicle is so equipped.

5. Before First Use

The operator must observe:

DANGER

Persons must be at a safe distance from the operating area.

- You must be aware of all the functions of the machine.
- You must have full knowledge of the machine's operating and steering elements as well as its mode of operation.
- Evaluate your area of work.
- Employ the grinding system only for its intended use.
- Use protective equipment i.e. helmet, protective glasses, hard-toed boots.
- Secure the site.
- Do not modify or alter the machine on independently.
- Only use machine when it is in perfect technical condition.
- Keep a safe distance to edges, slopes, overhangs and unstable soil.

6. Working with the Grinder

GEFAHR

- **Ensure individuals keep a safe distance from the danger zone and the rotor's operating area.**
- **Stay clear of the back of the grinder while in operation. Danger of flying ground-up particles.**

The machine can be raised and lowered using the lower attachment hook of the towing vehicle. This is also how the operating depth is set.

The towing vehicle's PTO may only be turned on when the grinder is above the ground.

Turning on the PTO only should be done by low rpm of vehicle`s engine. Afterwards the revolutions can be ingreased.
When PTO is turned on, the grinder can be lowered to begin grinding.

Turning on the PTO while the grinder is in the ground can result in damage to the grinder and the PTO clutch of the towing vehicle.

Changing the angle of pitch using the hydraulic upper guide unit and changing the rate of forward motion will affect the processing results and the mixture quality.
The mixture quality can also be influenced using the rear mixing valve. If this mixing valve is kept closed, the material being blended remains in the grinder's rotor area longer, which enhances the mixing effect. As a rule, it is sufficient to drag the mixing valve in floating position along the ground. This also helps smooth out the mixed material.

Only engage the drive unit and drive levels when the machine is not in motion.

Do not engage the rapid drive while the rotor is in a lowered position or has been turned on.



During the milling process you should avoid driving around corners with a radius of less than 100 metres.
Going around corners while milling puts a high axial strain on the machine in the area of the epicyclic gear train mounted in the rotor.
Milling in tight corners with radii of less than 50 metres or in circles is forbidden, as this would definitely cause damage to the machine. In such cases any guarantee claims are null and void.

7. Maintenance

DANGER

Ensure the grinder drive unit is off and has come to a complete stop before inspecting the grinder tools.
Keep clear of danger area when grinder is in operation.

DANGER

Never work in the grinder compartment unless the grinder and mixer valve have been secured against shifting downward.

WARNING

Ensure the grinder drive unit is off and has come to a complete stop before opening the belt guard.

WARNING

Ensure the grinder drive unit is off and has come to a complete stop before opening the universal shaft covers and greasing the shafts.

CAUTION

Driving parts (gears, belt drive) get hot during operation. Avoid burns.

Maintenance of the machinery consists for the most part of checking and changing the transmission oils, greasing the universal shaft between the grinder and the towing vehicle, as well as lubricating the connecting shafts between the intermediate gear and the belt drive. Regular visual inspections of V-belt tension and condition are also required.
For the universal joint it is important that the sliding sleeves be lubricated and not just the joints, otherwise the thrust may become too great and damage the grinder's intermediate gear and the towing vehicle's PTO.

This universal shaft must be lubricated every **20 hours** or **twice a week**. The other two shafts must be greased every **250 hours** or **semiannually**.
In addition, a visual inspection of the grinder tools must also be made prior to each use, and defective or missing tools replaced as needed. Inspect more often if the grinder is being used constantly or in rocky soil. Failure to replace defective or missing grinder tools will cause unnecessary wear to the tool holders, which can involve costly repairs.

7.1 Wear

The soil stabilization grinder is a tool whose method of operation requires that it be pulled through the soil as it grinds. As it moves, the mixing or grinding part of the device is filled with the material to be ground. This process leads unavoidably to mechanical abrasion in those parts of the grinder that descend into the soil and/or in those parts where the ground material passes through. This kind of wear cannot be avoided and depends to a great extent on the respective soil characteristics.

For this reason the grinder should be regularly inspected for wear. Those areas showing wear should be protected against further abrasion by adding new steel welds or wearing plates.



Notice: Signs of wear on the grinder void any warranty entitlements!!!

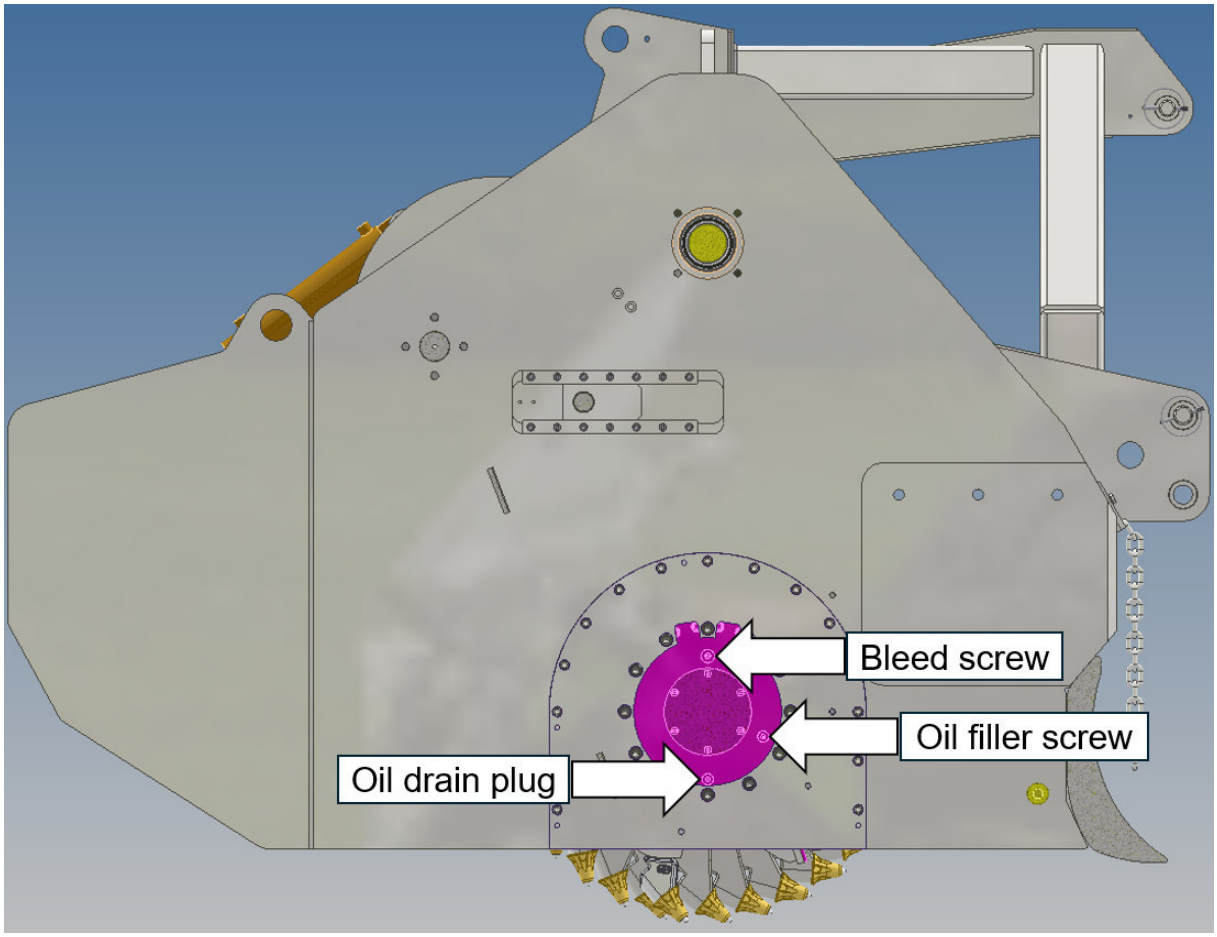
7.2 Oil Types and Quantity

Angular Gear:
Fill capacity 4.0 liters
Castrol Transmax Limited Slip LL 75W-140

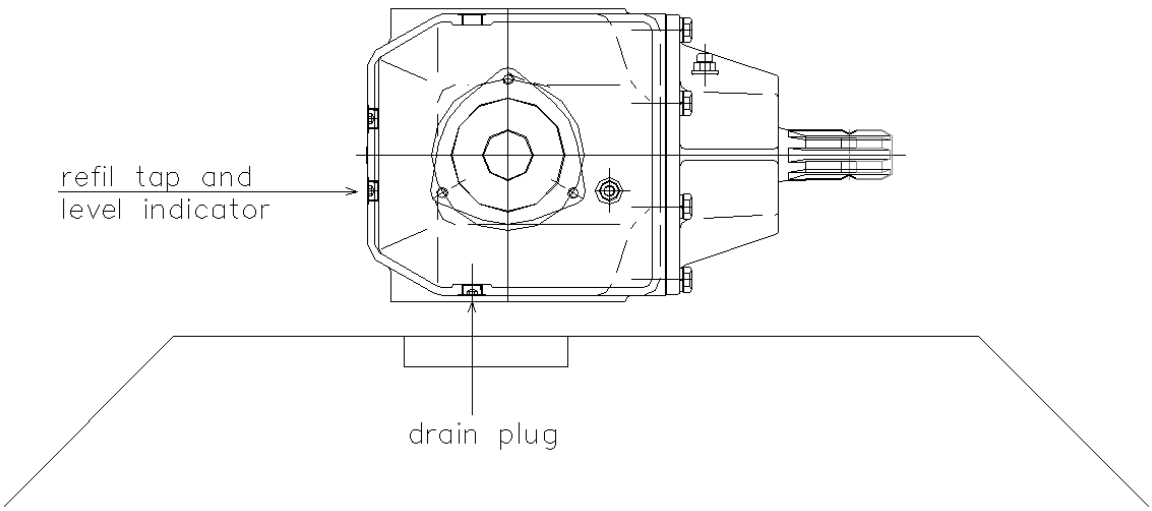
Rotor Planet Gear:
Fill capacity 3 liters
Castrol Transmax Limited Slip LL 75W-140

The first transmission oil change is to be made after the initial **100 hours of operation** for all types of transmissions, then after **every 250 hours of operation**. An oil change must be made at least **once a year.** Oil changes made when the engine is at operating temperature prevent the build-up of oil sludge.
Dispose of waste oil in accordance with local ordinances.

Rotor Planet Gear



Angular Gear



7.3 Belt Drive

WARNUNG

Ensure the grinder drive unit is off and has come to a complete stop before opening the belt guard.

V-belts are to be inspected for damage and proper tension once a week. Check them more often during heavy use or if unusual noises are heard. Please check the belt tension using the OPTIBELT frequency gauge (optional equipment).

<u>Warning:</u> The tension test is always carried out with the milling drive at a standstill and at a maximum belt temperature of 50°C.

7.3.1 Using frequency gauge to check tension:

After opening belt guard, just hit the belt on its long, straight side with a hammer or something else to make it swinging. Now take the frequency gauge and hold it nearly beside the belt at the middle position between the both form wheels. After about 1 second you can see the frequency on the display of the measuring instrument. If necessary the tension can be increased now (see following table). This method is very easy and fast and guaranties optimum belt tension.



Picture 1: Checking belt tension using frequency gauge

7.3.2 Thighten the belts

Belts are tightened using a tensioning roller. The tensioning roller is adjusted using a tension screw.



Picture 2: Thigtening the belt using a tension screw.

When installing new belts, the tension must be checked more frequently after the milling machine has been put into operation and corrected if necessary.
Particular care must be taken to ensure that the belt tension is even on both sides of the drive to avoid overloading a drive train.
If a visual inspection of the belt drive reveals significant wear or damage, the belts must be replaced completely as a set.

Belt tension parameters

Type	Frequency of New Belt	Frequency of Used Belt	Change in Length of New Belt	Change in Length of Used Belt
SBF 24	33.6 Hz	29.5 Hz	15.2 mm	12.3 mm

The frequency value for running belts applies after approx. 30 minutes of use.

7.4 Overload Protection

Cam shut-off coupling in the input universal shaft at max. 3500 Nm.

7.5 Grinder Chisels

WARNING

Do not use a steel hammer as it can shatter the carbide chisel. Always wear gloves and eye protection due to the risk of splinters when changing the tools.

The grinder chisels are kept in place by clamping sleeves in the holes of the chisel holder. To replace the chisels, simply use a hammer and punch to knock them out of the sleeves from behind. Use a copper hammer to tap the new chisels in place from the front.

7.6 Welding Work on the Rotor

When doing welding work on the rotor, always connect the ground to the rotor itself, not to the housing. Keep the amount of heat transferred as low as possible to avoid warping and distortion. The rotor must be balanced after additional grinder tools have been installed.
When welding work is carried out on the housing, earthing connection must be made via the housing not via the rotor.

7.7 Expansion tank

There are 3 plastic tanks attached to the milling machine. These are each connected to one of the gearboxes with a hose. On the one hand, they serve to ventilate the gearbox and, on the other hand, they serve as a collecting tank for the gearbox oil when it expands as a result of heating.

Do not pour oil into these tanks!!!

7. Uses

Sealing of sanitary landfills

Recultivation of mining areas, restoration work

Soil stabilization during road construction by blending in special binding agents

Improving the substructure without the costly exchange of materials

Incorporation of Glorit

Soil aeration

Grinding up and mixing of thin asphalt surfaces

8. Parts Catalog / Preface

You can only be assured of problem-free operation when ORIGINAL ***Stehr*** PARTS are being used. All warranties expire when other-than-original parts are used.

Our respective warranty terms apply for delivery of spare parts.

> The listing of parts and part numbers has been completed from an economical and technical aspect. Additional spare parts are not recommended.

Our branches and general agents maintain a good stock of spare parts. Please contact your nearest representative first when ordering parts.

We reserve the right to make changes and modifications without notice in the course of technical advancements and improvements.

Information and illustrations contained in this catalog may not be duplicated and distributed, nor be used for the purpose of competition. All rights under copyright law are expressly reserved.

Please include the following for all spare parts orders:

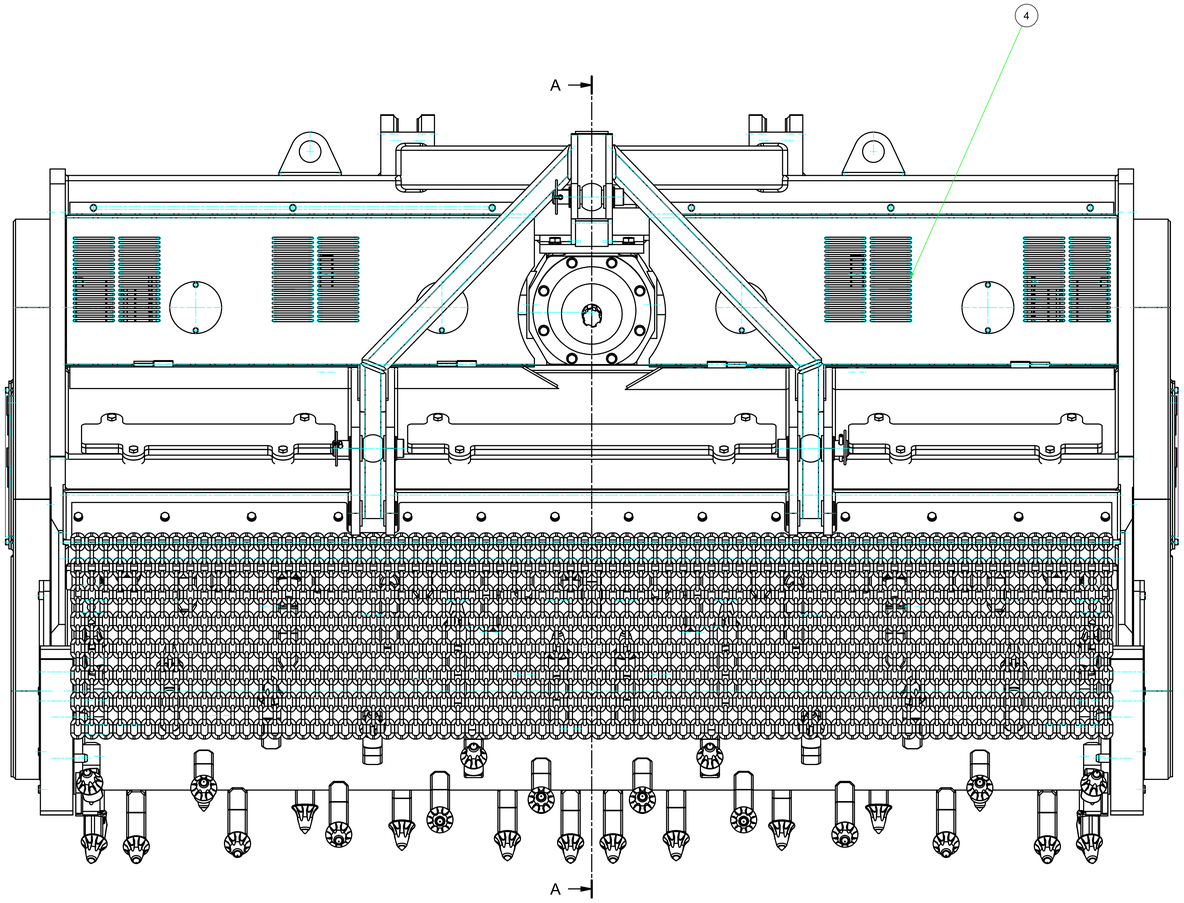
1. Equipment Type
2. Serial Number
3. Part Number
4. Quantity
5. Nomenclature
6. Shipping Type (mail, freight, rush, air, sea cargo, express)
7. Delivery Address (mail, rail, airport)

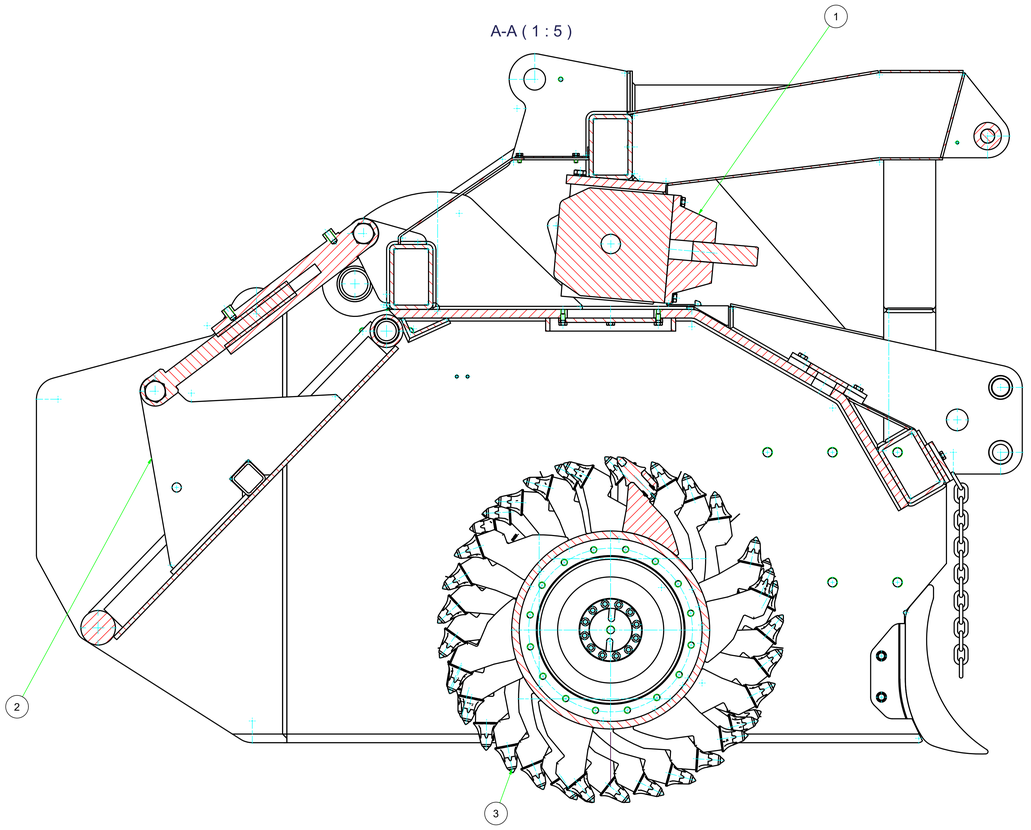
Parts orders cannot be processed without this information.

We shall determine the shipping type at our discretion if no shipping preference is stated.

Acceptance and forwarding of telephone orders is made exclusively for the account of and at the risk of the ordering party.

USE ONLY ORIGINAL *STEHR* PARTS!



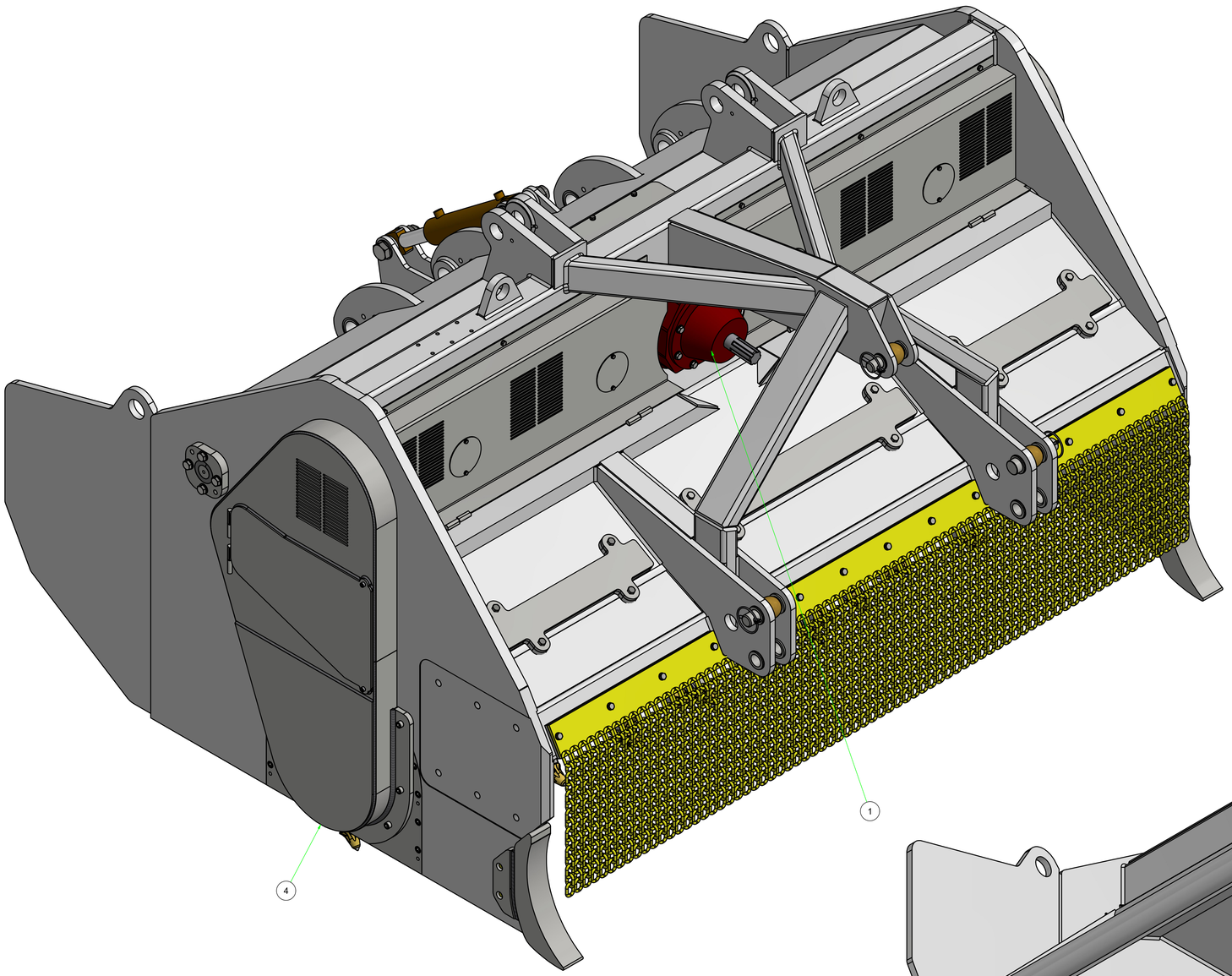


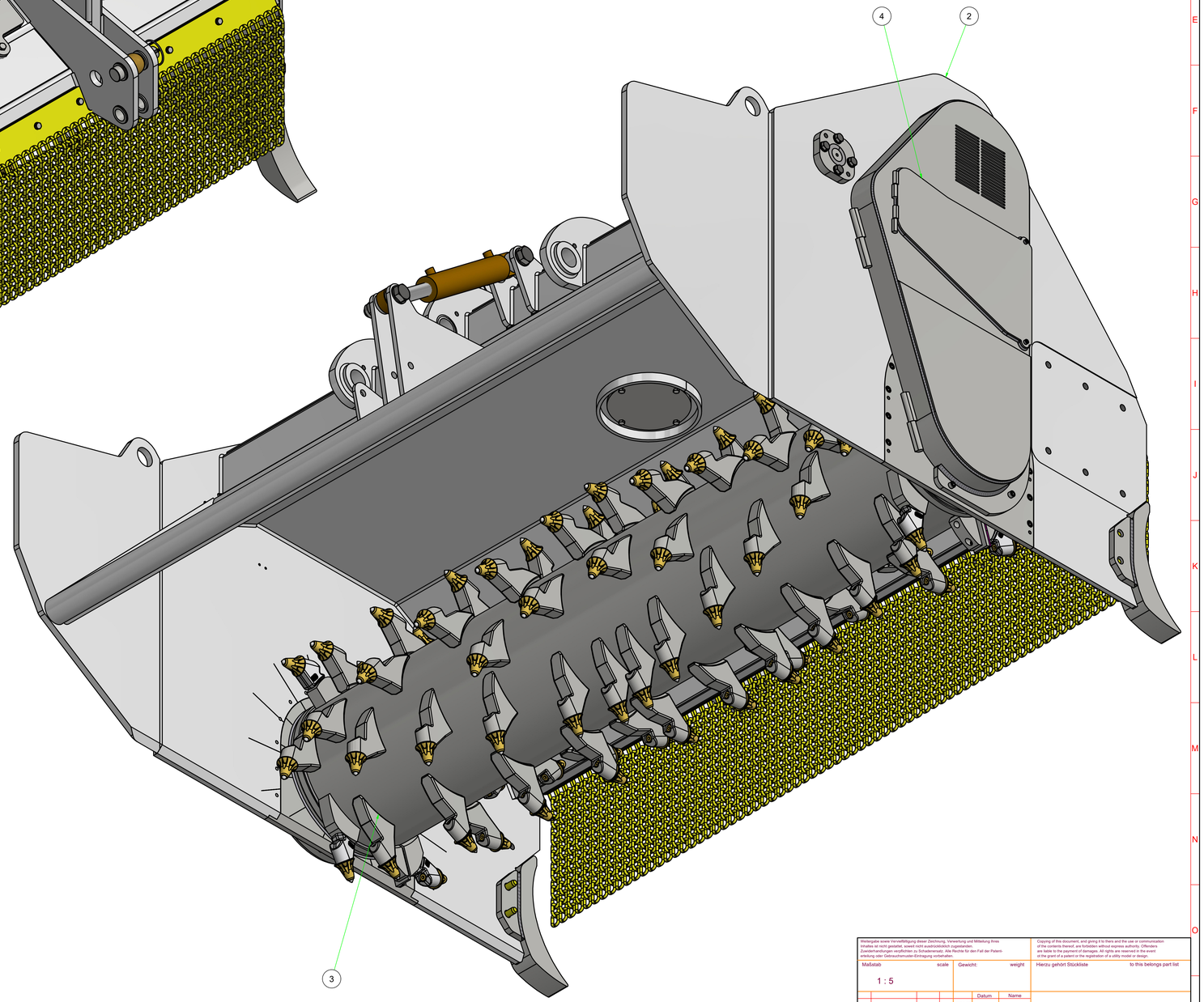
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Maßstab scale	Gewicht: weight	Hierzu gehört Stückliste	to this belongs part list
1 : 5			
	Datum / Name	assembly	
Gezeichnet			
Kontrolliert			
Norm			
Spezialmaschinen Stehr		SBF-4100	1 A0
Status / Änderungen	Datum / Name		

Revision





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Maßstab / scale	Gewicht: / weight	Hierzu gehört Stückliste / to this belongs part list
1 : 5		

	Datum	Name
Gezeichnet		
Kontrolliert		
Norm		

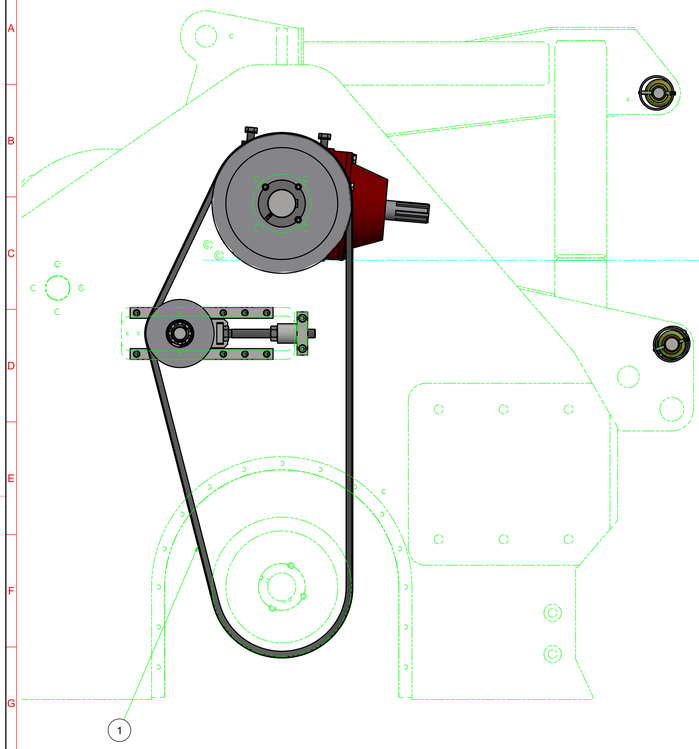
assembly

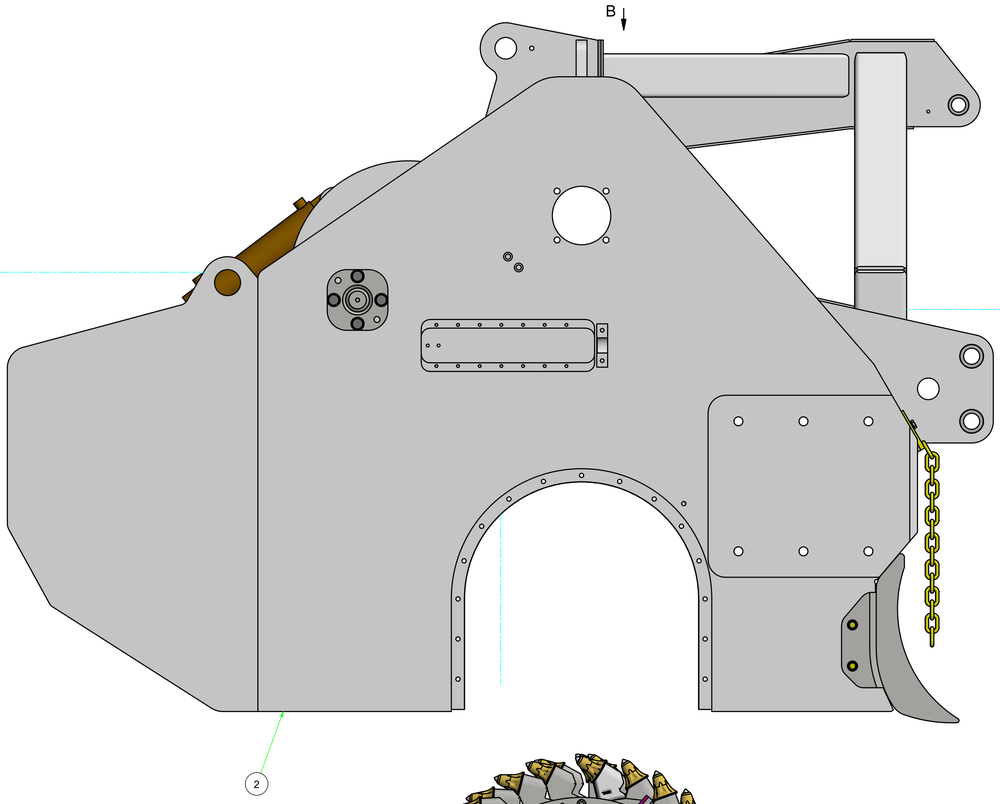
Spezialmaschinen Stehr

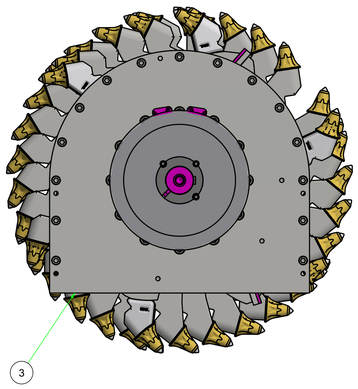
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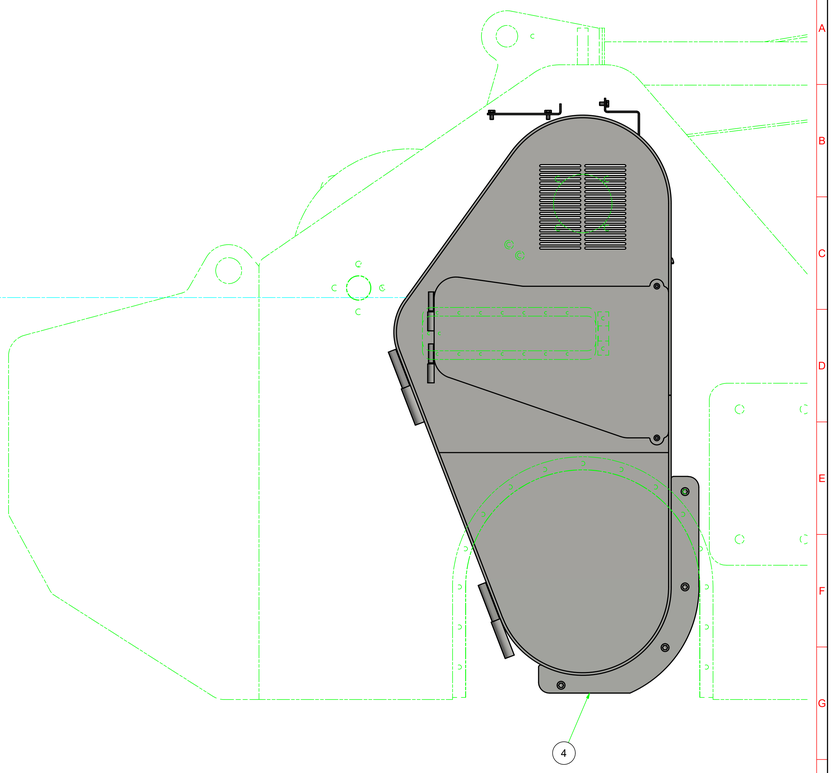
Status	Änderungen	Datum	Name

Revision

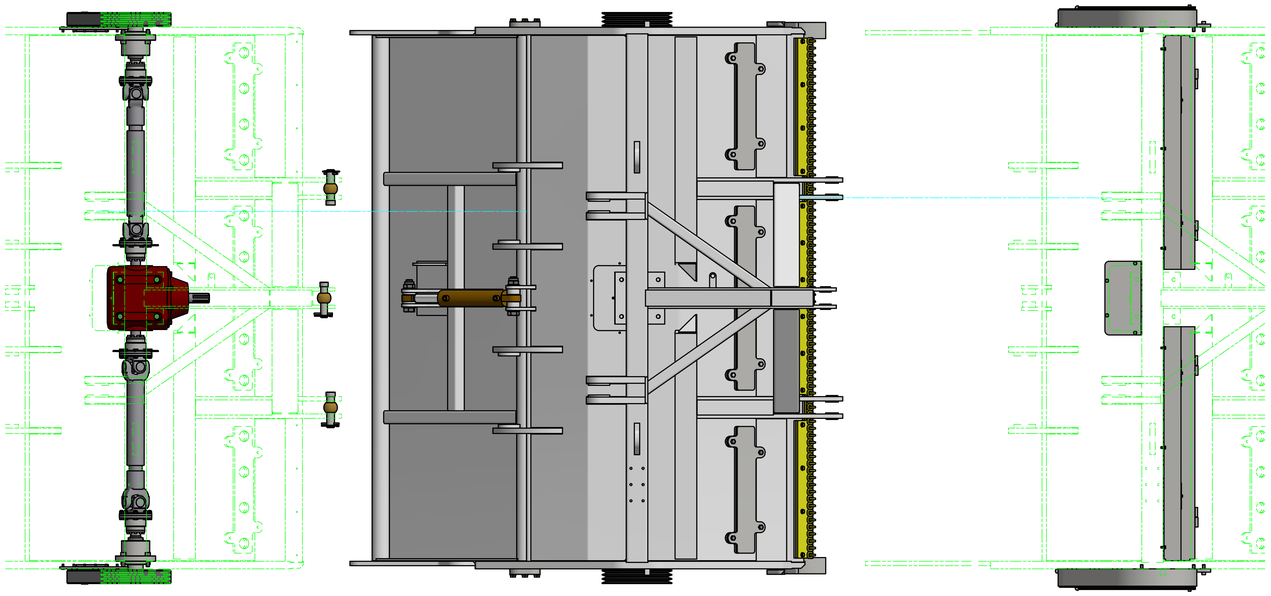








B (1 : 10)



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Maßstab / scale	Gewicht: / weight	Hierzu gehört Stückliste / to this belongs part list
1 : 5		

	Datum	Name
Gezeichnet		
Kontrolliert		
Norm		

assembly

Spezialmaschinen Stehr

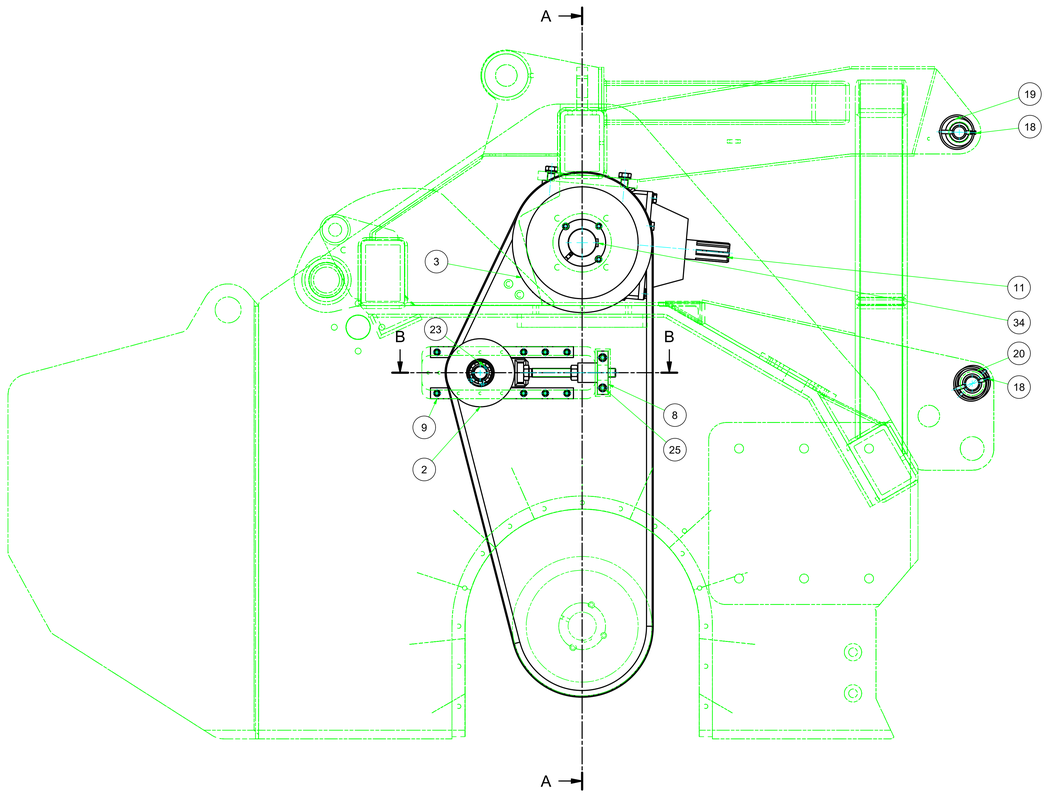
SBF-4100 | 3 | A0

Status	Änderungen	Datum	Name

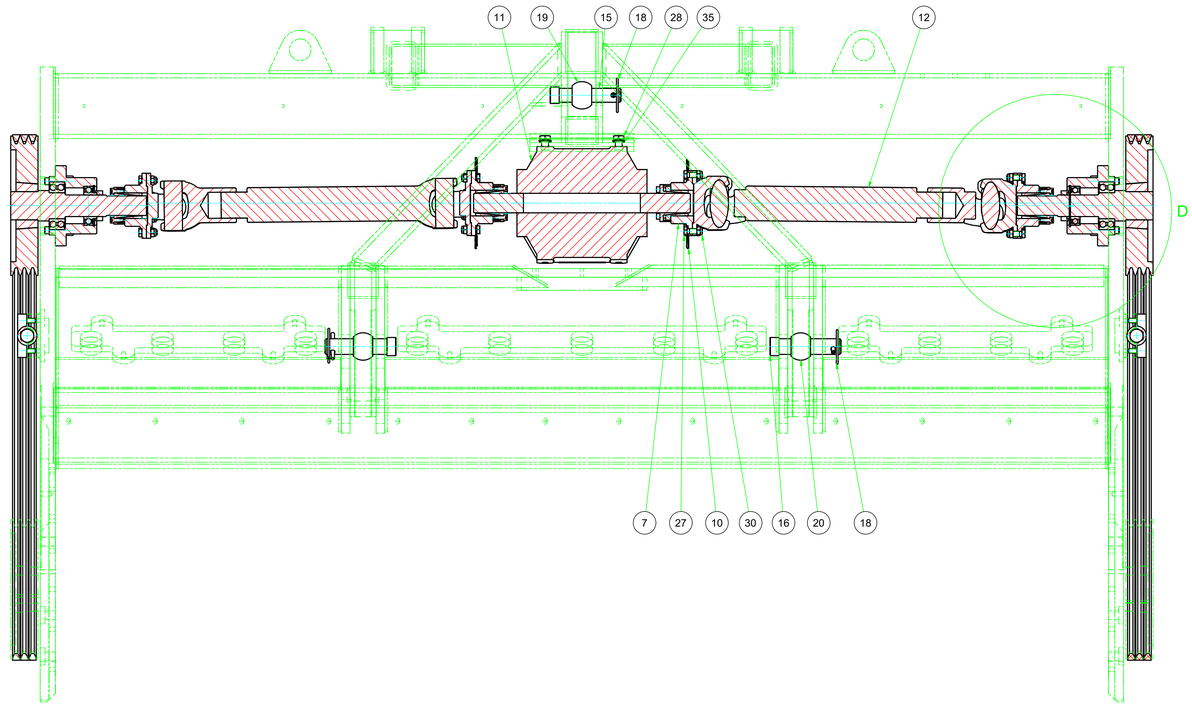
Revision

Parts list assembly

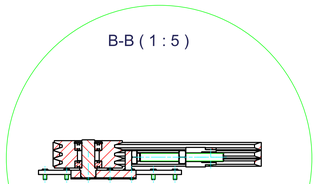
Item	No.	Description	Drawing number
1	1	Drive	Ant-4100
2	1	Housing	Geh-4100
3	1	Rotor	Rot-4100
4	1	Cladding	Vek-4100



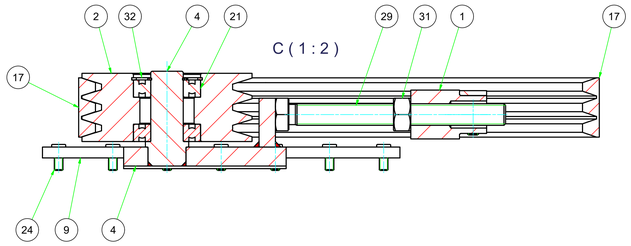
A-A (1 : 5)



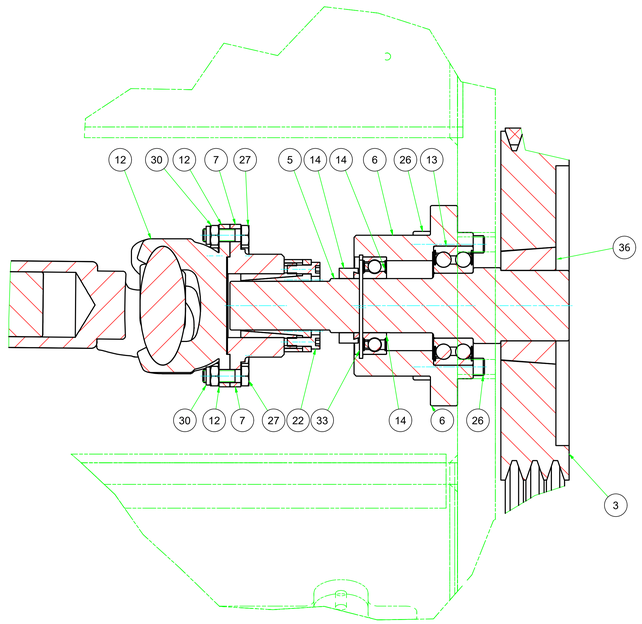
B-B (1 : 5)



C (1 : 2)



D (1 : 2)

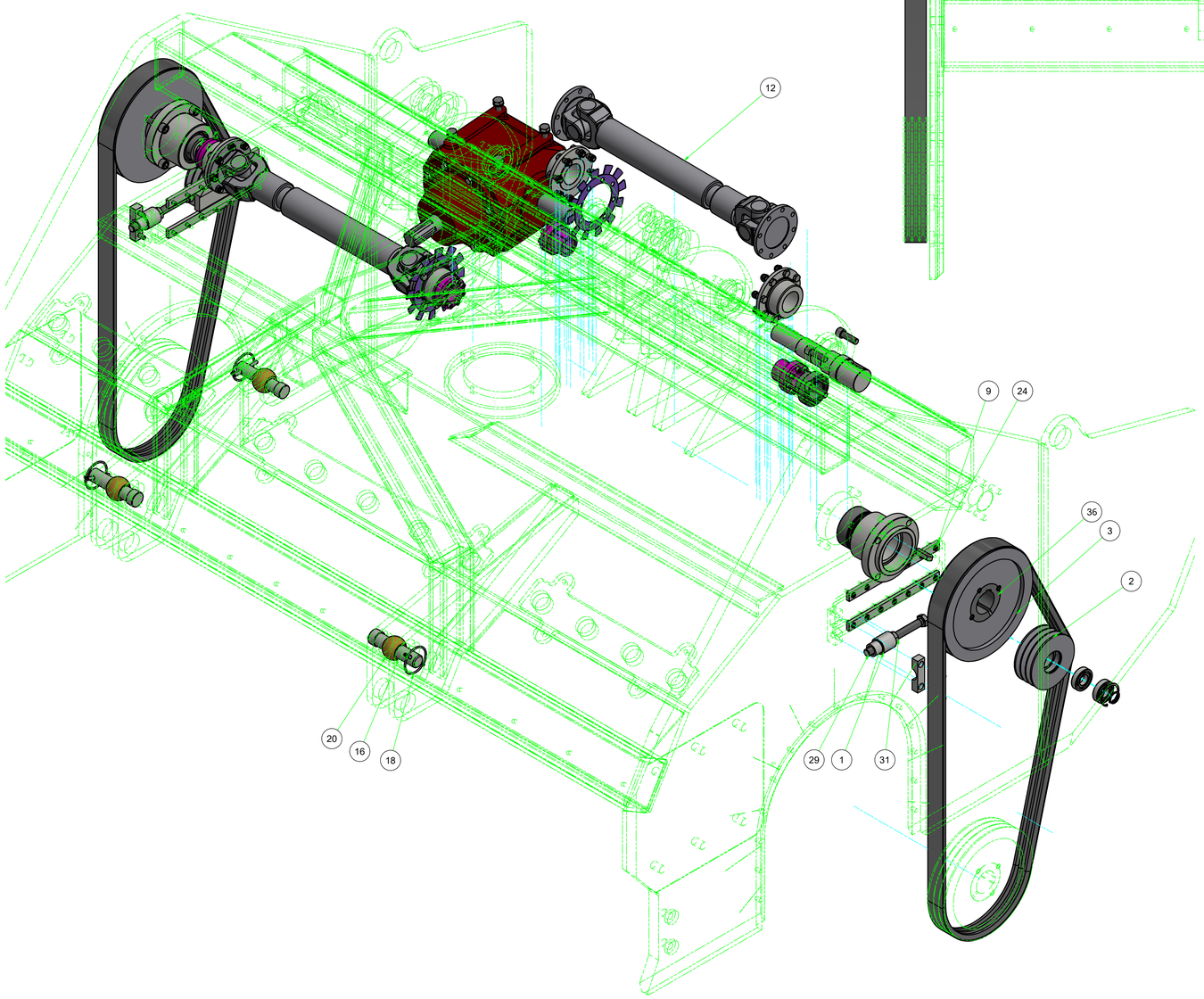


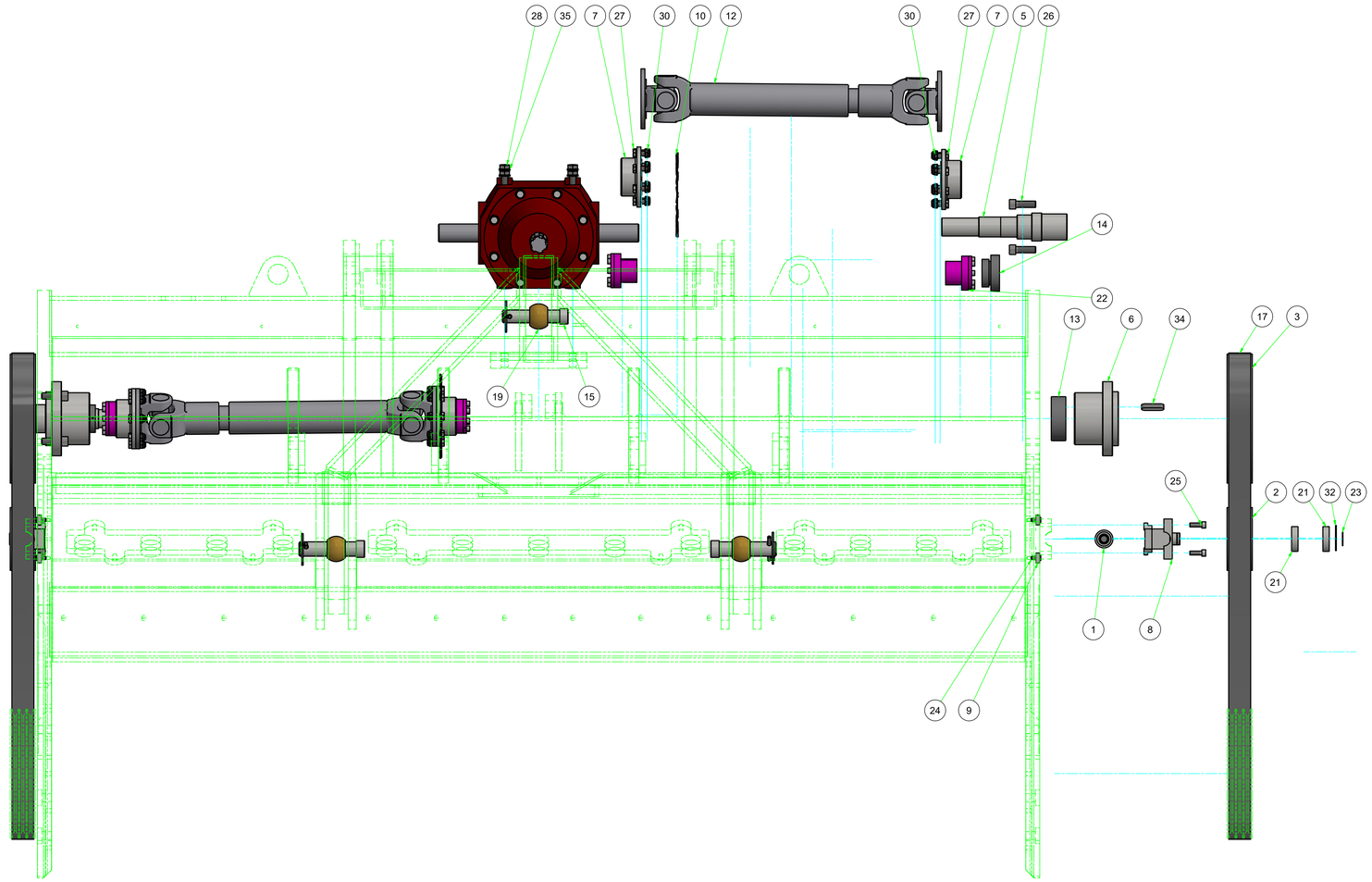
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Maßstab scale: 1 : 5	Gewicht: weight		Hierzu gehört Stückliste: to this belongs part list
		Datum / Name	
	Gezeichnet		drive
	Kontrolliert		
	Norm		
Spezialmaschinen Stehr			Ant-4100 — 1 / A0

Revision





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Maßstab / scale	Gewicht: / weight	Hierzu gehört Stückliste / to this belongs part list
1 : 5		

	Datum	Name
Gezeichnet		
Kontrolliert		
Norm		

drive

Sportstmaschinen Stehr

Ant-4100

2

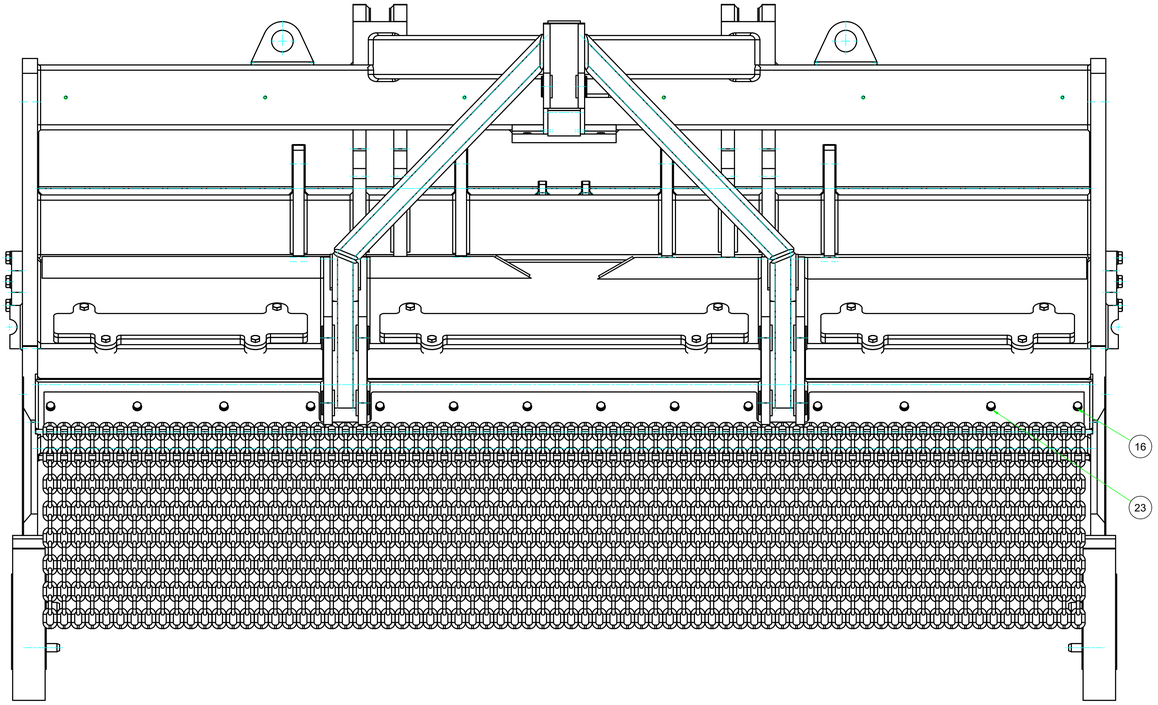
A0

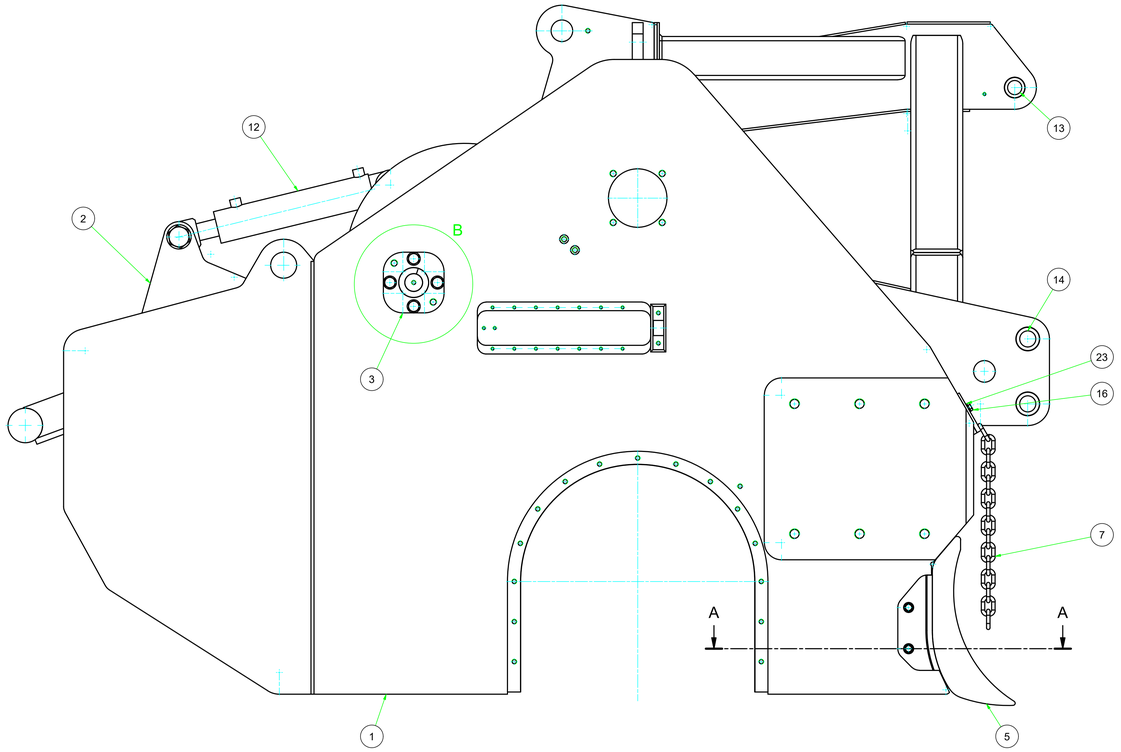
Status	Änderungen	Datum	Name

Revision

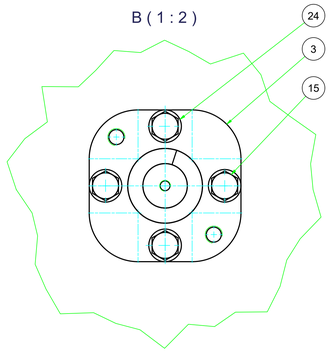
Parts list drive Ant 4100

Item	No.	Description	Drawing number	Article No.
1	2	Bushing	Ant-4005	ST 6000931
2	2	Tensioning roller	Ant-0106	ST 600091
3	4	Belt pulley	Ant-0108	ST 60007
4	2	Clamping slide	Ant-4110	ST 600093
5	2	Shaft	Ant-4209	ST 6000194
6	2	Adapter	Ant-4206	ST 6000193
7	4	Flange	Ant-4214	ST 6000121
8	2	Clamping device	Ant-4303	ST 6000934
9	4	Strip	Ant-4401	ST 600094
10	2	Fan	Ant-4715	ST 6000120
11	1	Bevel gear		SV 60062
12	2	Joint shaft		ST 600012
13	2	Angular contact ball bearing		ST 6000195
14	2	Tension bearing		ST 6000196
15	1	Top link pin		SD 12336
16	2	Bottom link pin		SD 9168
17	2	Power belt		ST 60001 BP
18	3	Linch pin		SD 38
19	1	Upper link ball		SD 33010
20	2	Lower link ball		SD 33007
21	4	Grooved ball bearing		ST 60009
22	4	Clamping set		ST 6000192
23	2	Retaining rings for shafts		SD 30A
24	28	Cylinder head screw		SD 9120816109
25	4	Cylinder head screw		SD 9121030109
26	8	Cylinder head screw		SD 9121650109
27	32	Hexagon screw		SD 9331235109
28	4	Hexagon screw		SD 9331650109
29	2	Hexagon screw		SD 9332020010
30	32	Hexagon nut with clamping part		SD 98012109
31	2	Hexagon nut		SD 93420109
32	2	Retaining ring		SD 62I
33	2	Retaining ring		SD 90I
34	2	Feather key		SD 6885181156
35	4	Locking washer		SD HLS16
36	2	Taper bush		ST 6000101

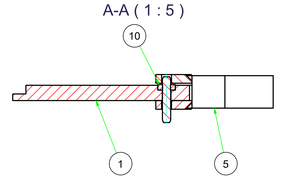


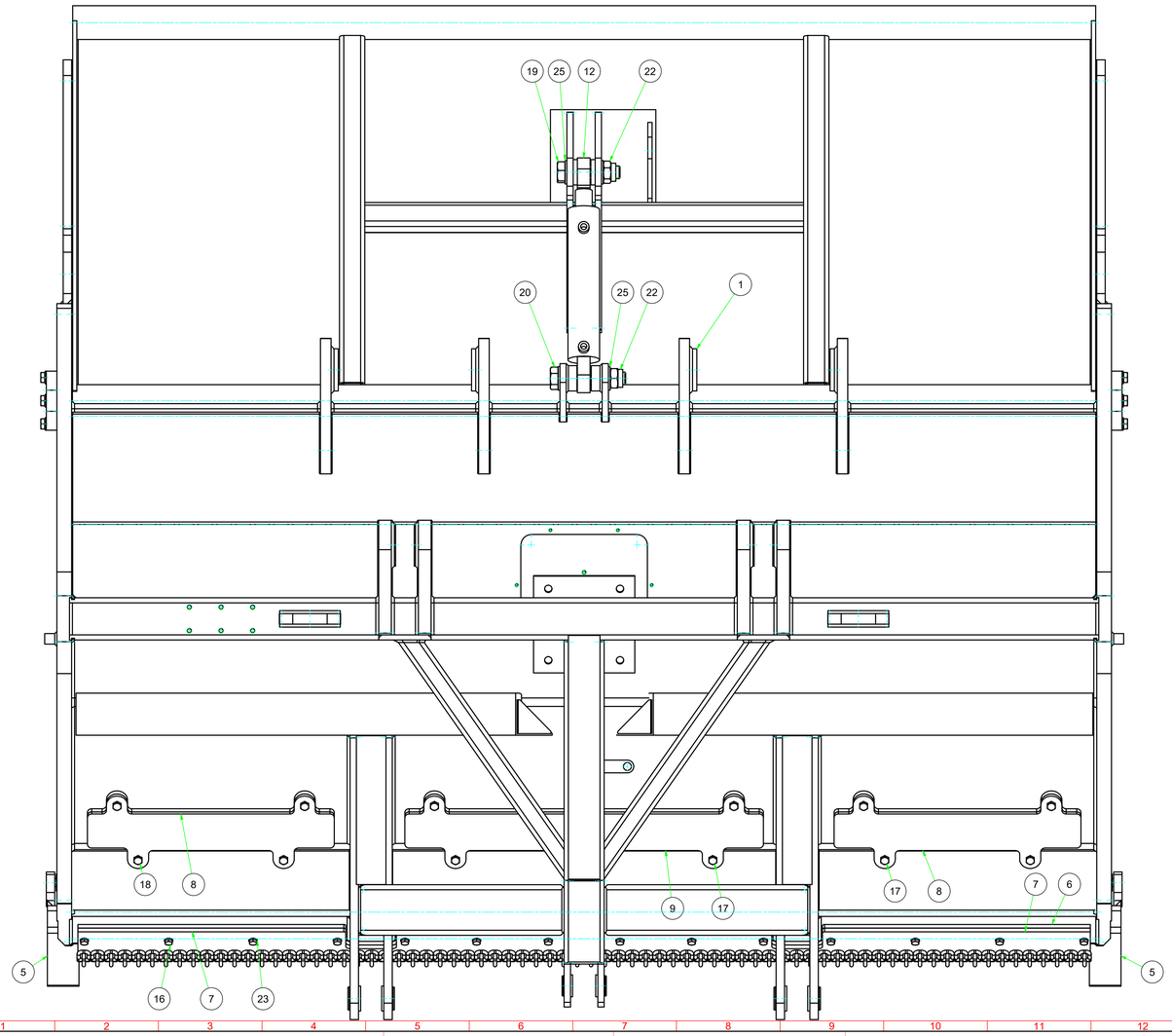


B (1 : 2)



A-A (1 : 5)





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Maßstab / scale	Gewicht: / weight	Hierzu gehört Stückliste / to this belongs part list
1 : 5		

	Datum	Name
Gezeichnet		
Kontrolliert		
Norm		

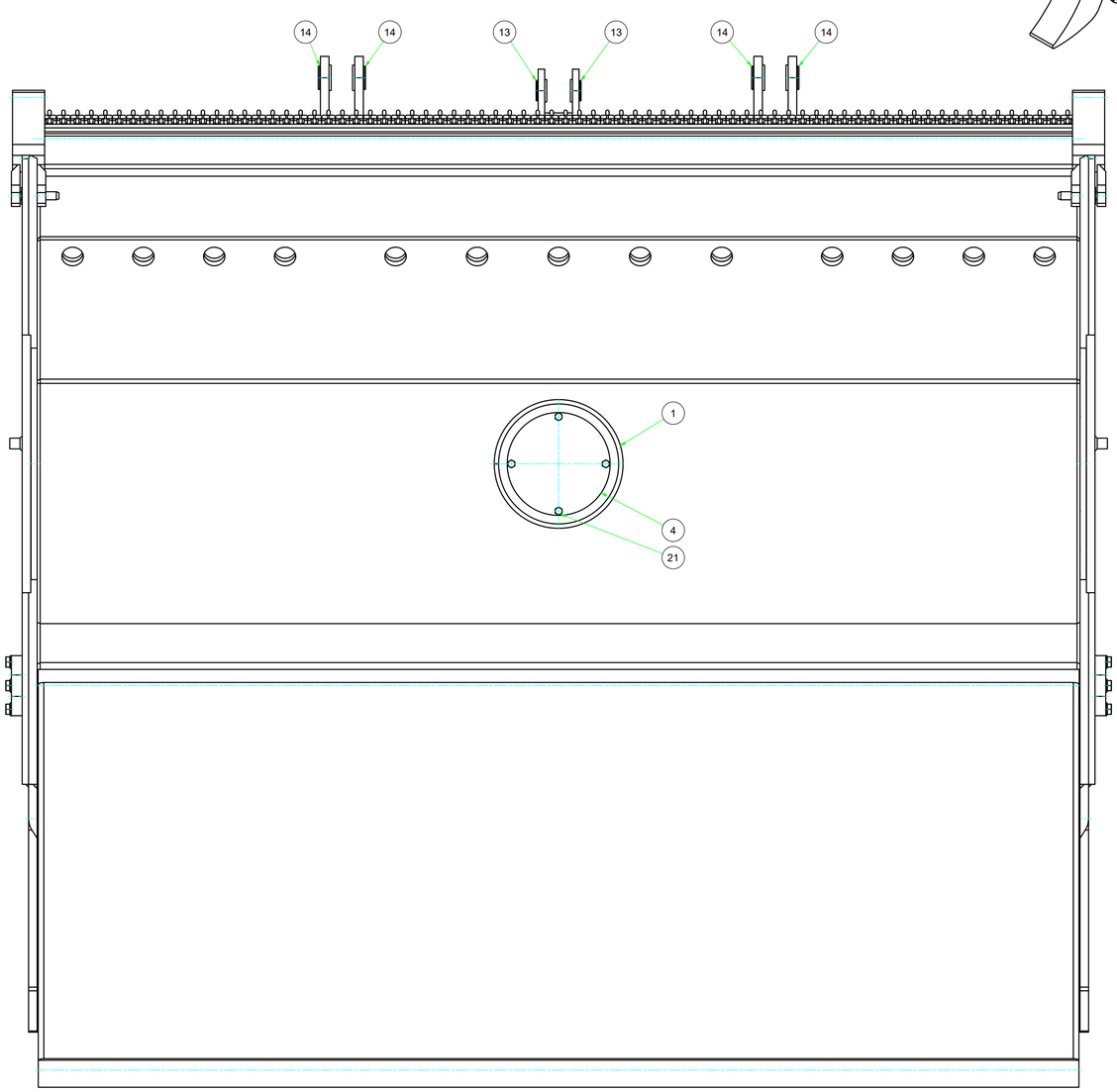
housing

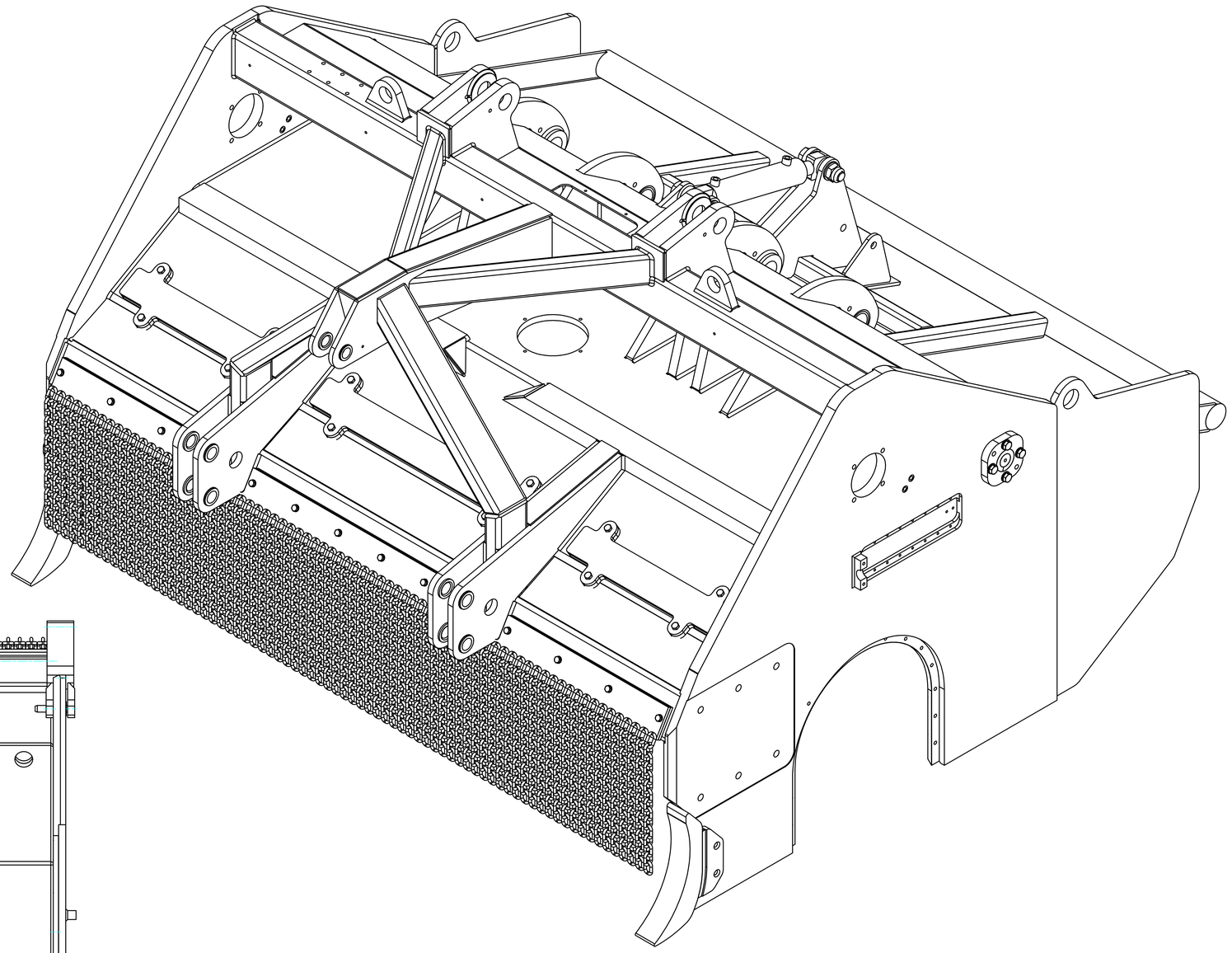
Spezialmaschinen Stehr

Geh-4100 | 1 | A0

Blatt	Änderungen	Datum	Name

Revision





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Maßstab / scale	Gewicht: / weight	Hierzu gehört Stückliste / to this belongs part list
1 : 5		

	Datum	Name
Gezeichnet		
Kontrolliert		
Norm		

housing

Spezialmaschinen Stehr

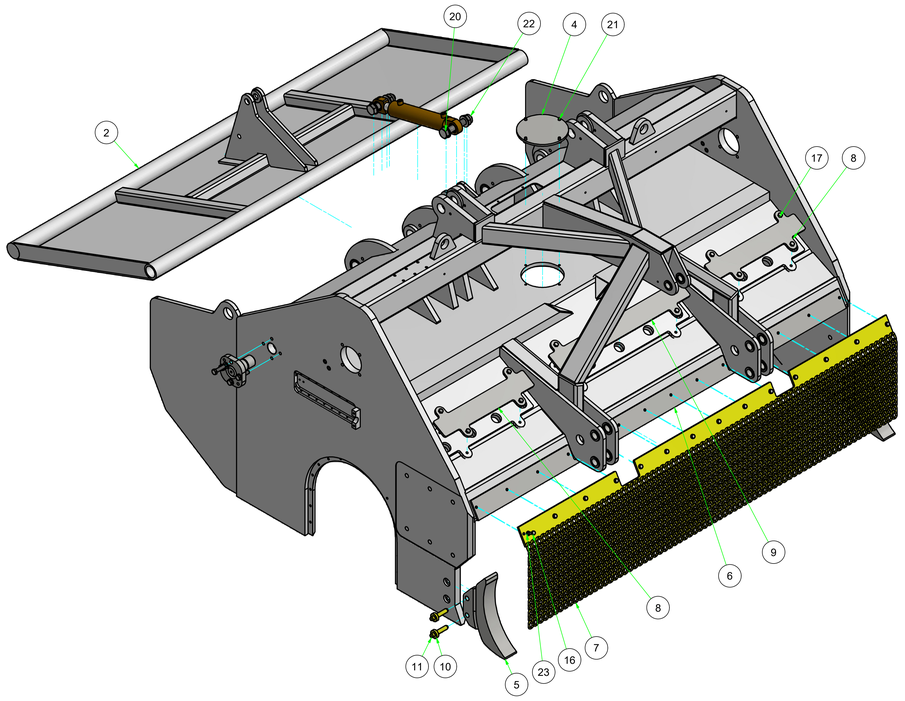
Geh-4100

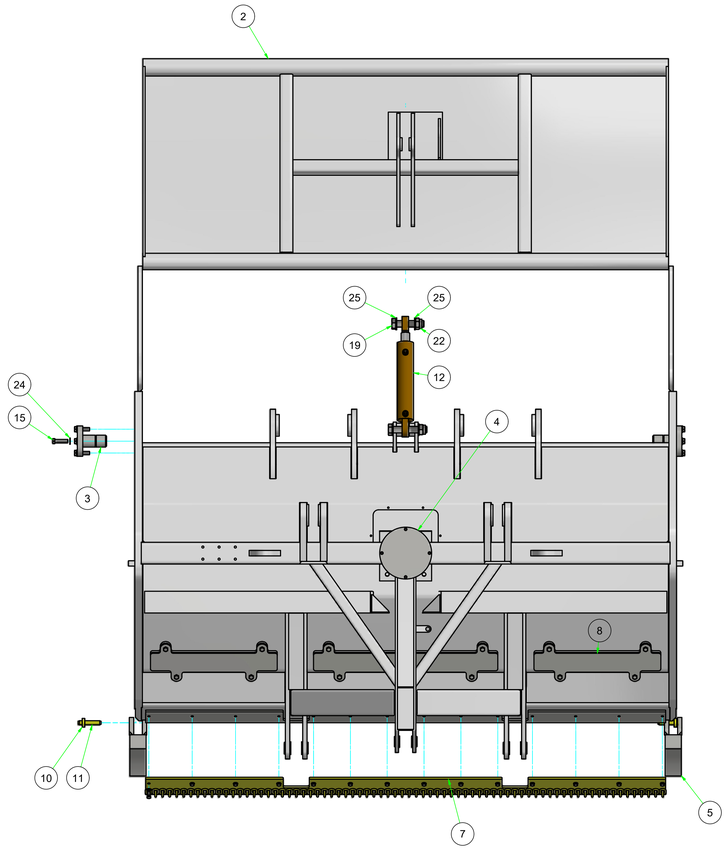
2

A0

Blatz	Änderungen	Datum	Name

Revision





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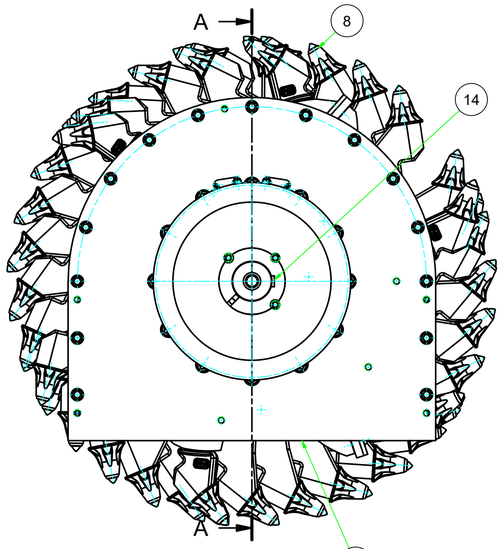
Maßstab scale: 1 : 5	Gewicht: weight	Hierzu gehört Stückliste	to this belongs part list
	Datum / Name	housing	
	Gezeichnet		
	Kontrolliert		
	Norm		
Status / Änderungen	Datum / Name	Geh-4100	3 A0

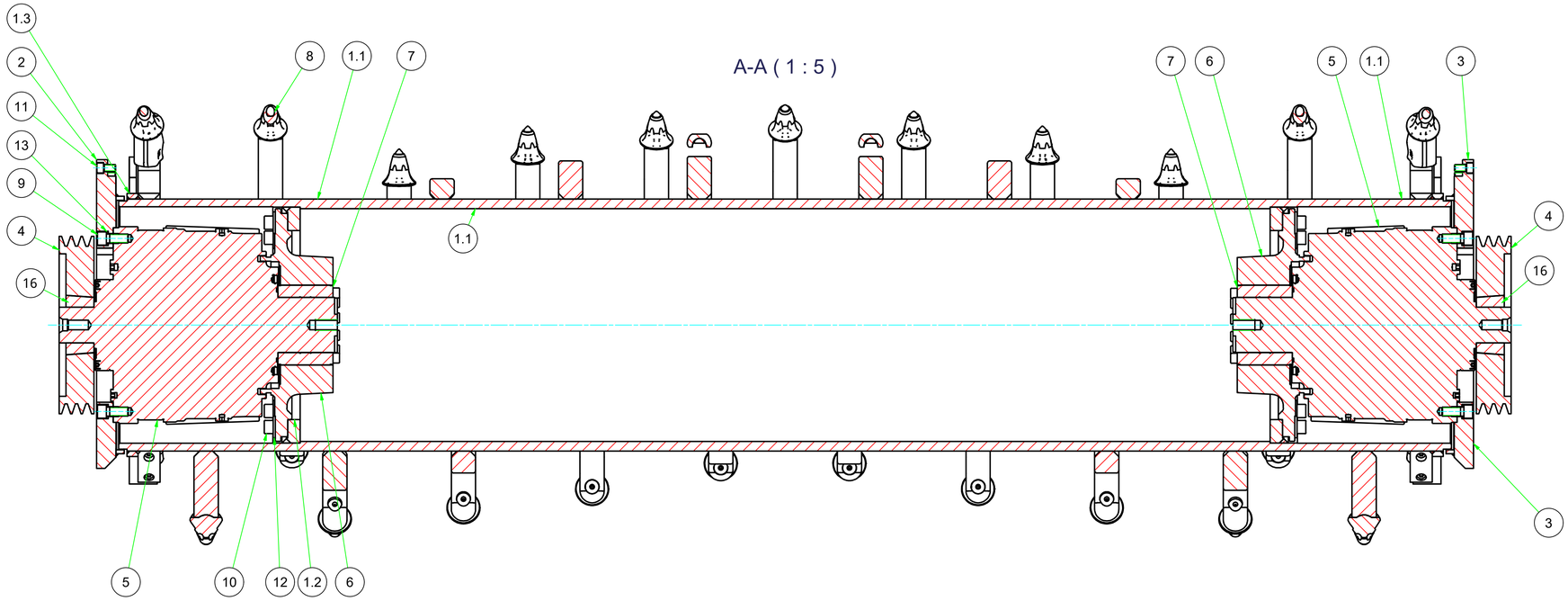
Spezialmaschinen Stehr

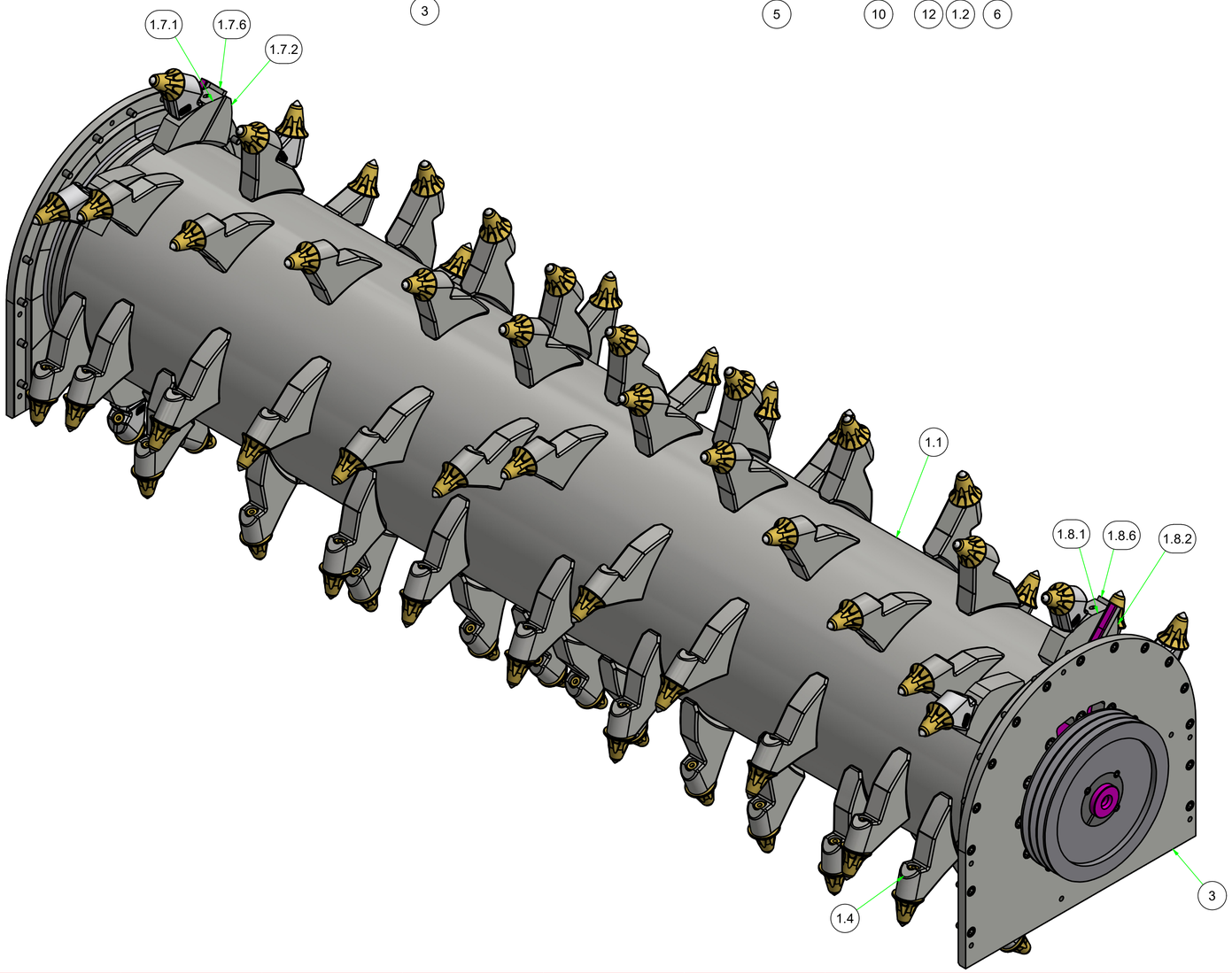
Revision

Parts list housing Geh 4100

Item	No.	Description	Drawing number	Article No.
1	1	Housing SBF 24	Geh-4110	ST 6000014
2	1	Tailgate	Geh-4050	ST 6000019
3	2	Axle support	Geh-4007	ST 60000191
4	1	Cover	Geh-4107	ST 60000192
5	2	Corner knife	Geh-4180	ST 600041 New
6	1	Sheet	Geh-4338	ST 60000194
7	1	Chain conveyor	Geh-4340	ST 60000193
8	2	Sheet	SBF 24-2-Geh-5047-V10	ST 60000016
9	1	Sheet	SBF 24-2-Geh-5048	ST 60000017
10	4	Tooth locking set		ST 600042 New
12	1	Hydr. cylinder		ST 6000142
13	2	Drill bush		ST 907013511
14	8	Drill bush		ST 907013512
15	8	Hexagon screw		SD 9331660109
16	14	Hexagon screw		SD 9331025109
17	8	Hexagon screw		SD 9331210109
18	4	Hexagon screw		SD 9331225109
19	1	Hexagon screw		SD 9313013010
20	1	Hexagon screw		SD 9313016010
21	4	Hexagon screw		SD 9331020109
22	2	Hexagon nut		SD 9853010
23	14	Shim		SD 12510
24	8	Shim		SD 12517
25	4	Shim		SD 12530







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Maßstab scale	Gewicht: weight	Hierzu gehört Stückliste to this belongs part list
1 : 5		

	Datum	Name
Gezeichnet		
Kontrolliert		
Norm		

rotor

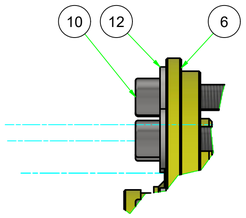
Spezialmaschinen Stehr

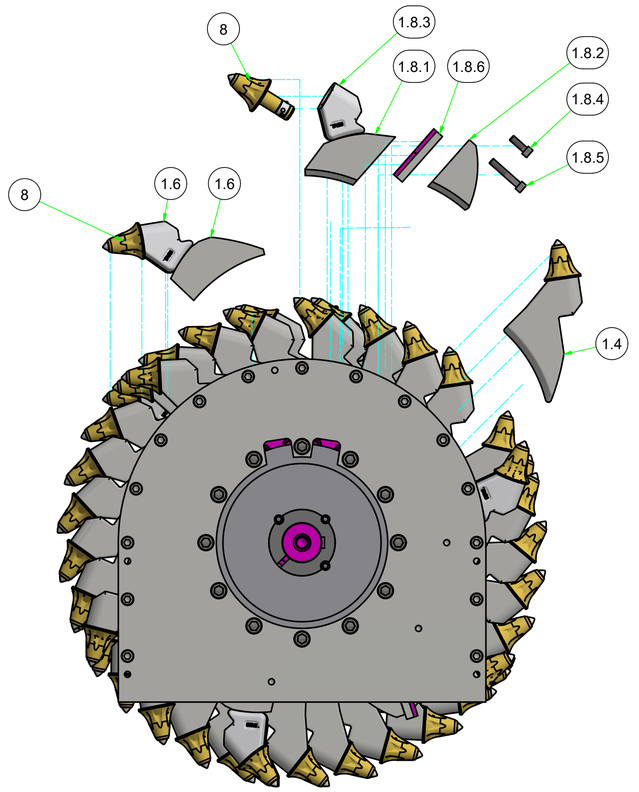
Rot-4100 | 1 | A1

Status	Änderungen	Datum	Name

Revision

B (1 : 2)





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Maßstab / scale	Gewicht: / weight	Hierzu gehört Stückliste / to this belongs part list
1 : 5		

	Datum	Name
Gezeichnet		
Kontrolliert		
Norm		

rotor

Spezialmaschinen Stehr

Rot-4100

2

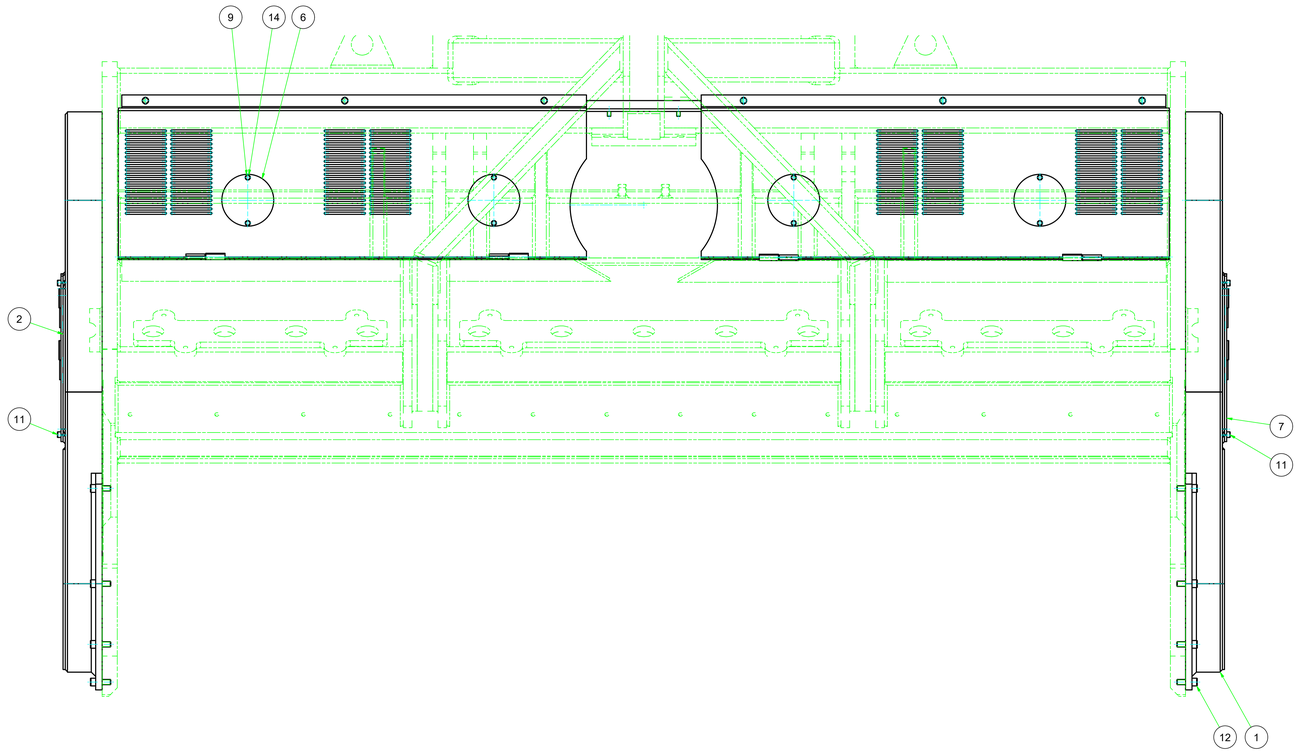
A1

Status	Änderungen	Datum	Name

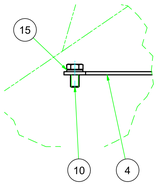
Revision

Parts list Rotor Rot 4100

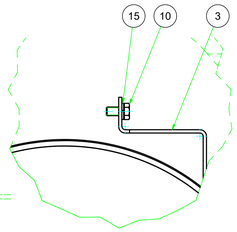
Item	No.	Description	Drawing number	Article No.
1	1	Rotor	Rot - 4110	ST 600016
1.1	1	Pipe	Rot - 4111	
1.2	2	Sheet	Rot - 4112	
1.3	2	Flat	Rot - 4113	
1.4	69	Tooth holder		ST 1017211
1.5	3	Tooth support left	Rot - 4140	
1.5.1	3	Chisel holder		ST 1028 BE
1.5.2	3	Welding holder		ST 1017211
1.6	3	Tooth support right	Rot - 4130	
1.6.1	3	Chisel holder		ST 1028 BE
1.6.2	3	Welding holder		ST 1017211
1.7	2	Special chisel Interchangeable holder Right		ST 101795
1.7.1	1	Tooth holder	Rot - 4115	ST 101791
1.7.2	1	Tooth holder	Rot - 4116	ST 101792
1.7.3	1	Holder		ST 1028 BE
1.7.4	1	Socket head screw		SD 9121030109
1.7.5	1	Socket head screw		SD 9121060109
1.7.6	1	Peeling bar knife		ST 10161
1.8	2	Special chisel Interchangeable holder Left	Rot-4160	ST 101796
1.8.1	1	Tooth holder	Rot - 4115	ST 101793
1.8.2	1	Tooth holder	Rot - 4116	ST 101794
1.8.3	1	Holder		ST 1028 BE
1.8.4	1	Socket head screw		SD 9121030109
1.8.5	1	Socket head screw		SD 9121060109
1.8.6	1	Peeling bar knife		ST 10161
2	1	Bearing shield, L SWT	Rot - 4180	ST 6000175
3	1	Bearing shield, R	Rot - 4190	ST 6000176
4	2	Belt pulley	Ant - 0108	ST 60007
5	2	Planetary gear		ST 6020R
6	2	Drive flange		ST 600017RNew
7	2	Clamping set		ST 600019R
8	79	Chisel		ST 1024
9	24	Socket head screw		SD9121640109
10	32	Socket head screw		SD9121645109
11	30	Cylinder head screw		SD9121225109
12	32	Spring washer		SD 679616
13	24	Locking washer		SD HLS16
14	2	Feather key		SD 6885181156
15	2	Wear ring		ST 6000166
16	2	Taper bush		ST 6000101

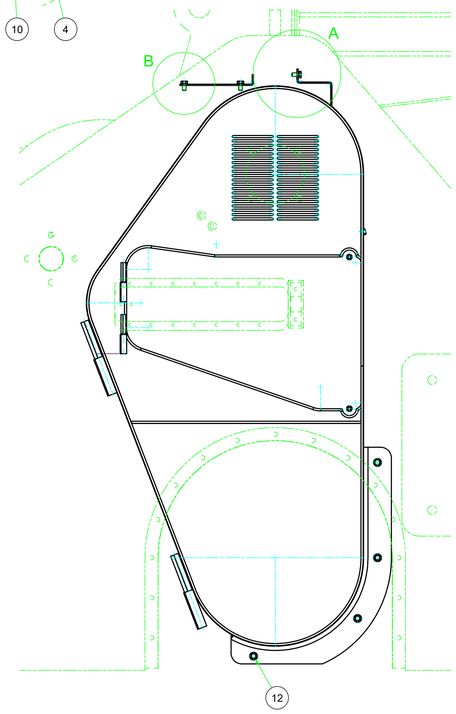


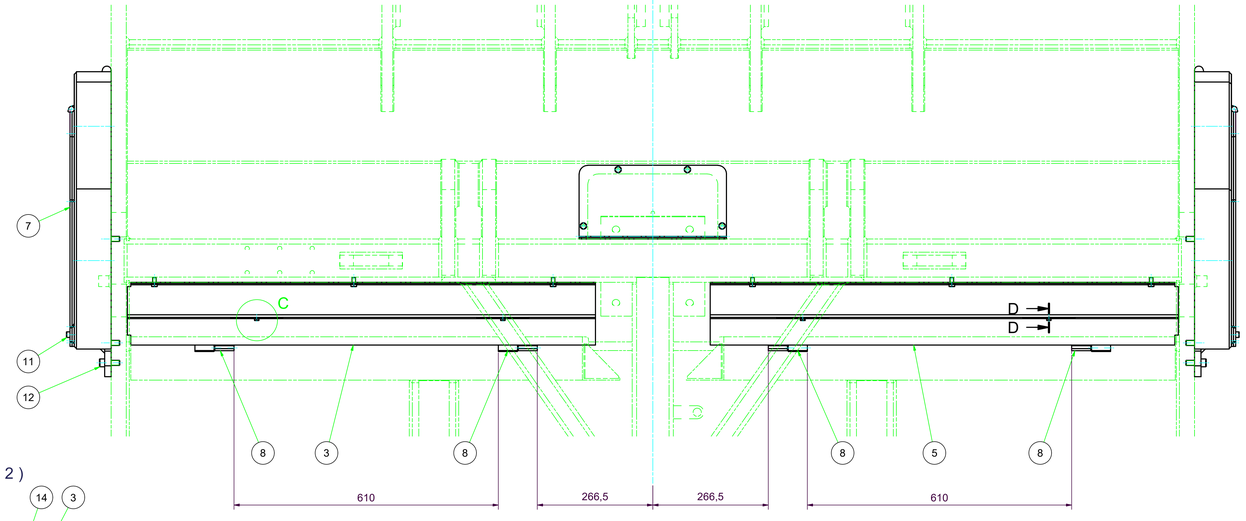
B (1 : 2)



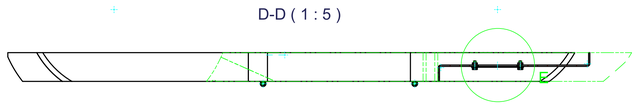
A (1 : 2)



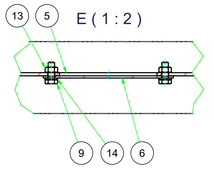




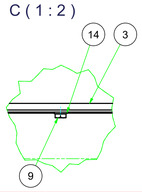
D-D (1 : 5)



E (1 : 2)



C (1 : 2)

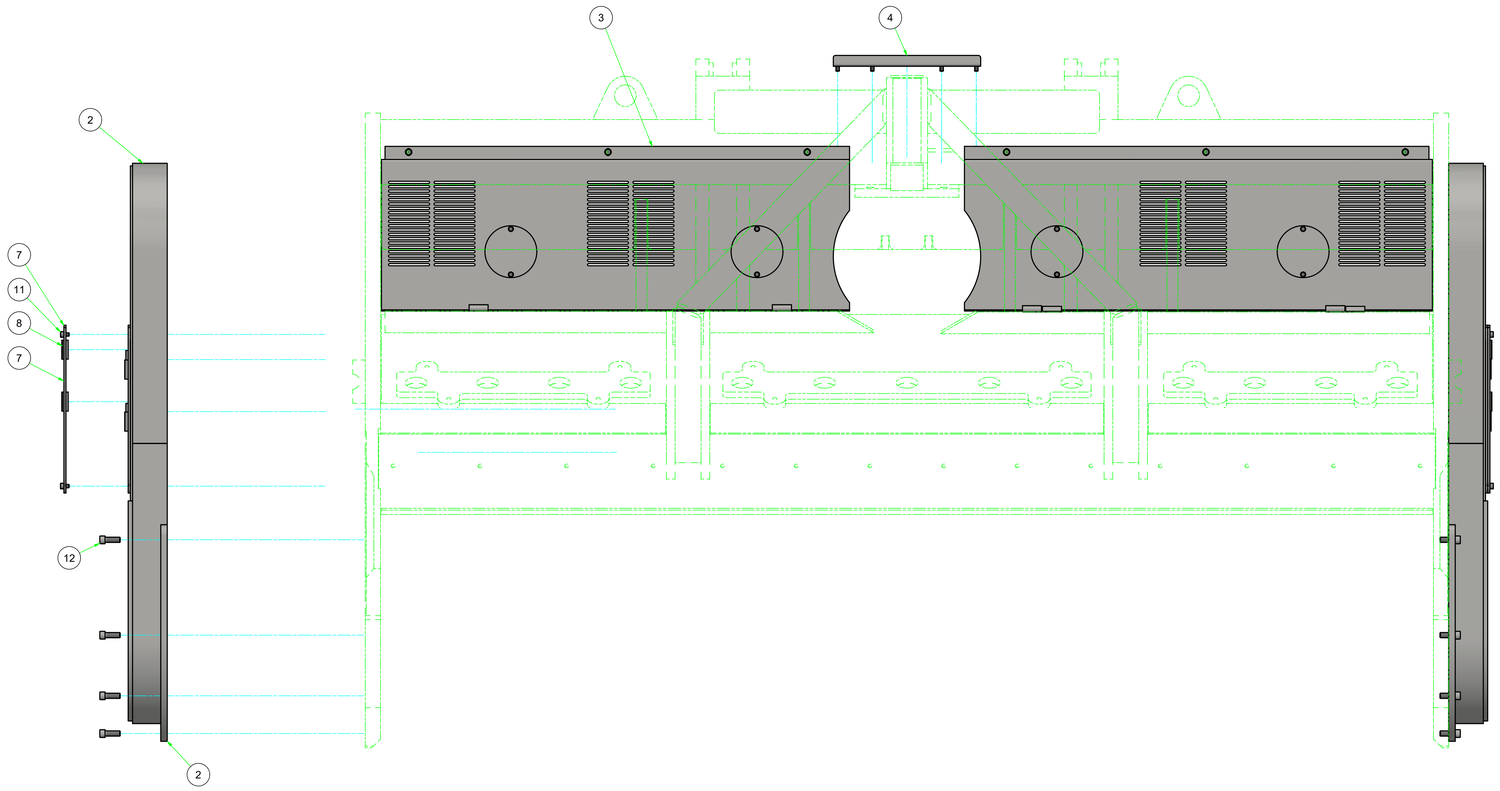


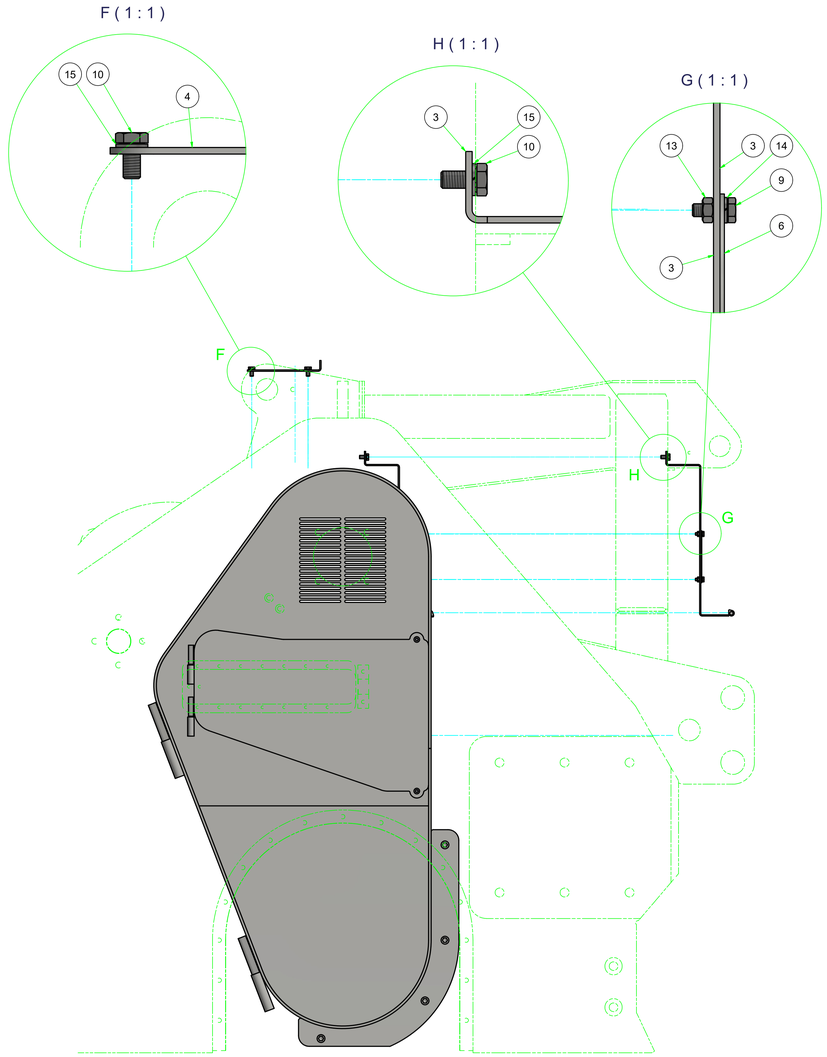
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Maßstab scale 1 : 5	Gewicht: weight	Hierzu gehört Stückliste	to this belongs part list
	Datum / Name		
	Gezeichnet	cladding	
	Kontrolliert		
	Norm		
	Spezialmaschinen Stehr	Vek-4100	1 / A0

Revision





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Maßstab scale	Gewicht: weight	Hierzu gehört Stückliste to this belongs part list	
1 : 5			
	Datum	Name	
Gezeichnet			cladding
Kontrolliert			
Norm			
Spezialmaschinen Stehr			Vek-4100 2 A0
Status Änderungen	Datum	Name	

Revision

Parts list cladding Vek 4100

Item	No.	Description	Drawing number	Article No.
1	1	Cover L	Vek - 4720	ST 60000141
2	1	Cover R	Vek - 4730	ST 60000142
3	1	Sheet front R	Vek - 4005	ST 60000146
4	1	Sheet rear	Vek - 4406	ST 60000144
5	1	Sheet front L	Vek - 4004	ST 60000145
6	4	Cover	Vek - 4707	ST 60000147
7	2	Cover	Vek - 4010	ST 60000143
8	8	Hinge		SD KO12BEW80
9	8	Hexagon screw		SD 9330616109
10	10	Hexagon screw		SD 9330616109
11	4	Cap screw		SD 9120812109
12	8	Cap screw		SD 9121235109
13	8	Hexagon nut		SD 93406109
14	8	Spring ring		SD 12806A
15	10	Spring ring		SD 12808A