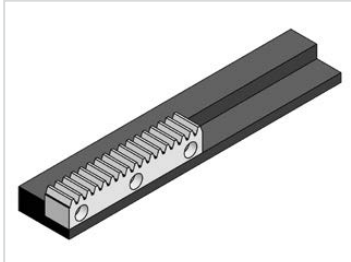


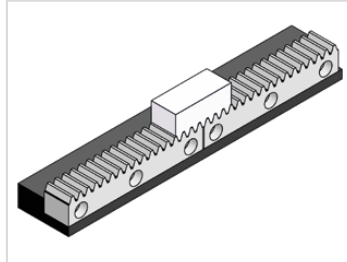
### 3.1 Installation

#### Gear rack fitting instructions / lubrication

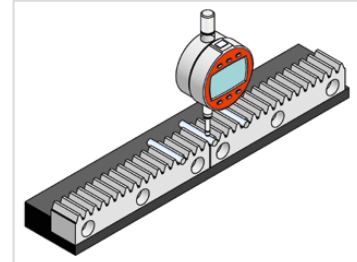
Gear racks can be assembled in any lengths.  
When assembling the spacing between two gear racks must be pitch precise.  
Dowels may be needed for gear racks shorter than 1m.



- Aligning the first gear rack
- Tighten the screws with a torque wrench.
- The torque depends on the friction condition and strength class of the screws.
- For soft or induction hardened gear racks use screws with a strength class of 10.9. For case and through hardened gear racks use strength class 12.9.



- Align the next gear rack with a mounting plate.
- Screw the gear rack on.



- Using a measuring roller check the height deviation at the transition point and if necessary change the position of one gear rack.
- Check that the gear racks are parallel to each other.
- Finally, insert the pins if necessary.

#### Lubrication - instructions for use

Adequate lubrication using a lubricant adapted to the operating conditions is required to maintain the functionality of the rack drive. Lubrication protects from wear and corrosion and reduces friction.

Apart from the initial lubrication during assembly, the machine must be lubricated regularly during operation.

Normally electrically-driven lubrication cartridges are used for lubrication. Lubrication greases NLGI 00 to NLGI 0 are applied to the drive pinion or the gear rack with a felt pinion.

A typical lubricant is Klüber Microlube GB 0.

Too little lubrication shortens the service life of the drive system. Therefore, always ensure that the machine is lubricated adequately.

The detailed version of our mounting instruction is available under [www.schneeberger.com/downloads](http://www.schneeberger.com/downloads).

