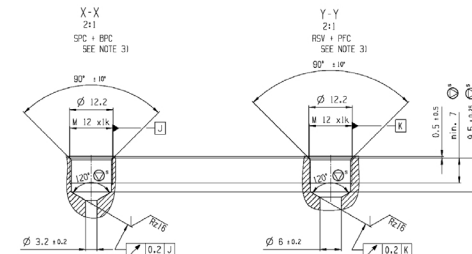
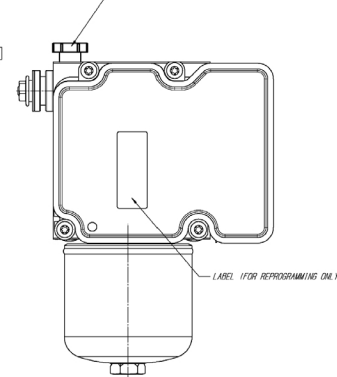
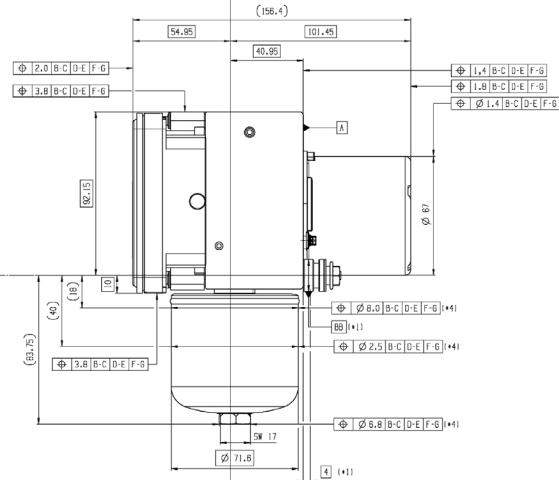
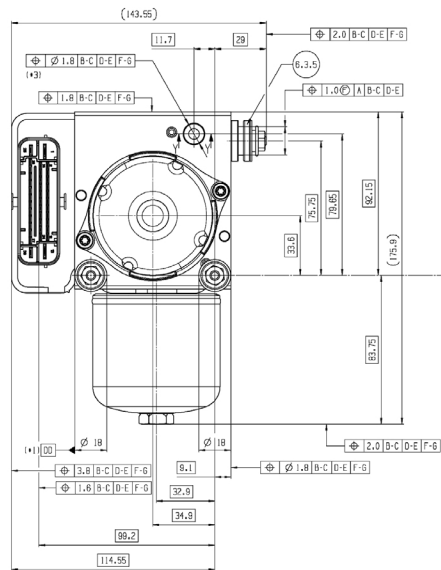
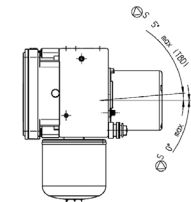
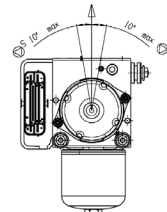
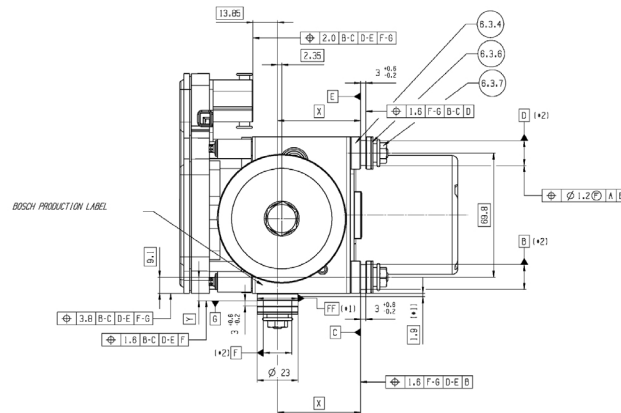
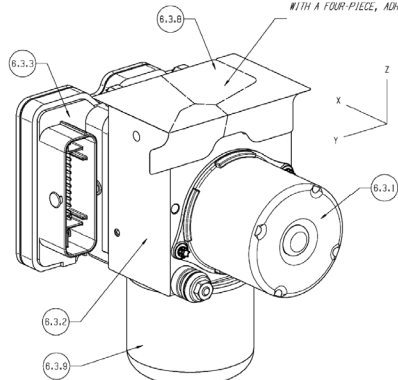


Ⓢ NOT FILLED HYDRAULIC UNITS ARE DELIVERED WITH A FOUR-PIECE, ADHESIVE COVER TAPE.



THE QUALITY OF THE BORES AND THREADS
IS ENSURED BY THE TOOL GEOMETRY.

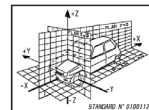
DEFINITIONS

FREE STATE

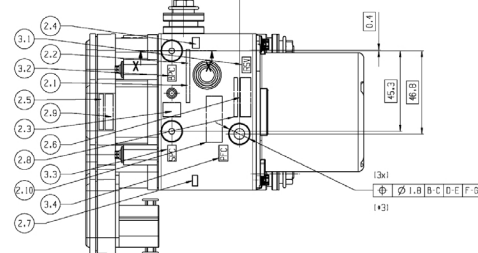
DELIVERY STATUS OF THE HYDRAULIC UNIT: ISOLATORS ARE NOT COMPRESSED.

CONSTRAINED STATE

HYDRAULIC UNIT IS MOUNTED IN THE BRACKET AND ALL ISOLATORS ARE SCREWED WITH THE DEFINED TORQUE (SEE NOTA 1.11).



- *1 MEASUREMENT POSITION FOR FREE STATE (FOR DETERMINATION OF REFERENCE ID, OD, FF).
THE DATUM B IS A PLANE ESTABLISHED 4MM FROM DATUM A. SAME IS VALID FOR DATUM DD. DATUM FF
IS A PLANE ESTABLISHED 1,9MM FROM THE SIDE PIN PLANE. I
- *2 THE REFERENCE CAN NOT BE MEASURED BY BODY AT THE ASSEMBLED HYDRAULIC UNIT WITH
THE 3-D MEASURING MACHINE. A SUFFICIENT TOUCHING OF THE INNER DIAMETER OF THE ISOLATOR IS
NOT POSSIBLE DUE TO THE MOTOR I
- *3 MEASURED ON THREAD
- *4 POSITIONAL TOLERANCE 0,6MM IS VALID FOR A DISTANCE OF 0-10MM FROM REFERENCE B-D
POSITIONAL TOLERANCE 0,9MM IS VALID FOR A DISTANCE OF 10-40MM FROM REFERENCE B-D
POSITIONAL TOLERANCE 0,6MM IS VALID FOR A DISTANCE OF 40-83,75MM FROM REFERENCE B-D I



	DELIVERY STATE	VALUES FOR TIGHTENED ISOLATORS (mm)
BRACKET SHEET METAL THICKNESS		2,5
X	48,75	45,35
Y	13,3	12,2

HYPOTHESIS FOR REDUCTION OF DEGREES OF FREEDOM

REFERENCE	Tx	Ty	Tz	Rx	Ry	Rz
B-C	X	X	X			
D-E				X		X
F-G					X	

REFERENCE POINT B-C, D-E, F-G
ARE CREATED BY SHORT AXIS (B,D,F) AND PLANE (C,E,G)

[illegible]