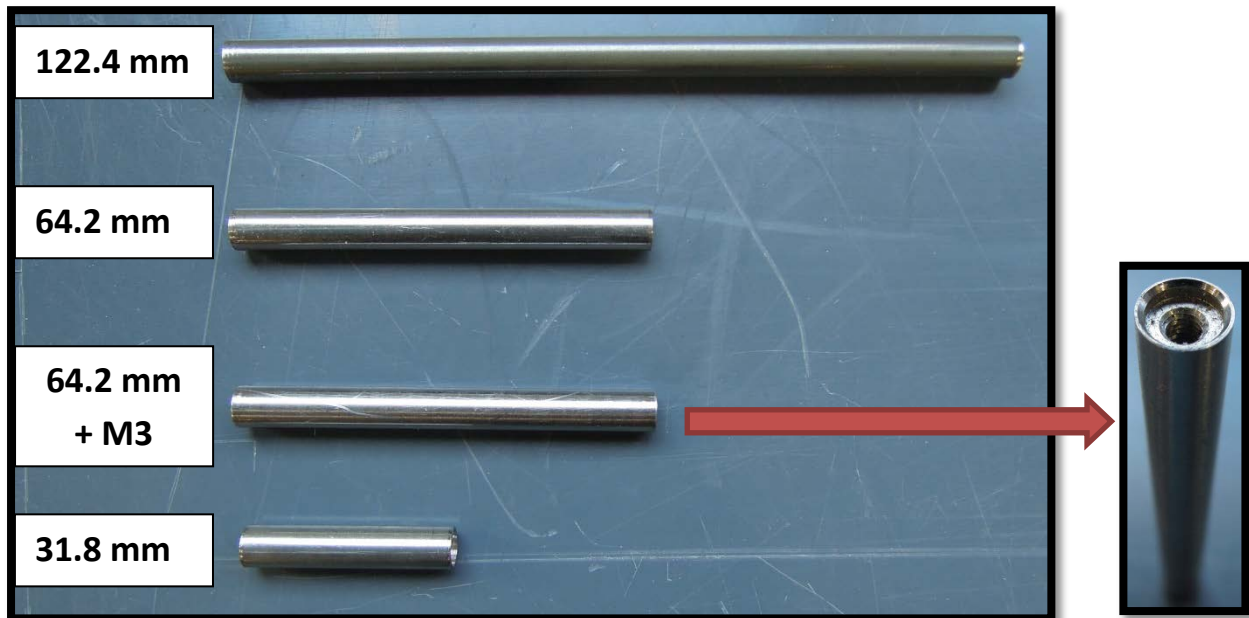


Preparing of collar packs

For execution of the collar pack assembly various parts are required:



Rivets:	Length for machining	Quantity
Instrumented collar pack	122.4 mm	4
Collar Pack A	64.2 mm	28
Collar Pack B	31.8 mm	4
Collar Pack C	31.8 mm	8
Collar Pack D	64.2 mm	76
Collar Pack A with threaded rivets	64.2 mm + M4	4

Collars:	Quantity
Collar type D	422 pieces
Collar type E	180 pieces
Collar type F	592 pieces
Collar type F (with groove)	16 pieces
Collar type D (with equipped gauges)	6 pieces

Collar pack assembly

☐ Check if all required parts are available

For one entire collared coil it requires:

Collar Pack A	16 pieces
Collar Pack B	2 pieces
Collar Pack C	4 pieces
Collar Pack D	38 pieces
Collar Pack A with threaded rods	2 pieces
Instrumented collar Pack	2 pieces



Use the collaring mould to stack the collars into place.



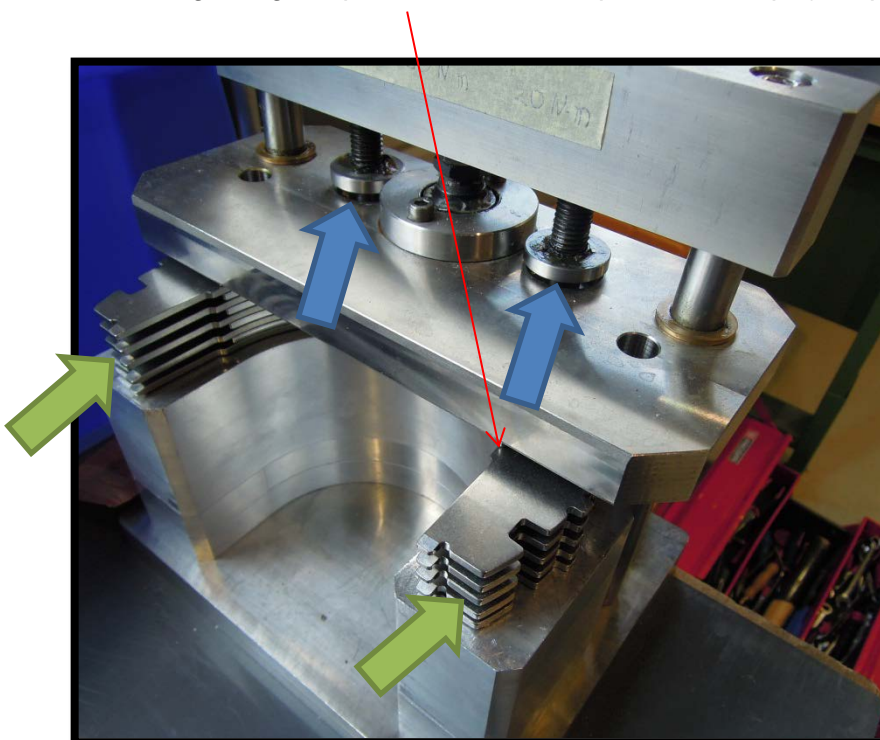
Start always with a small collar type F (For pack C start with the machined one) with the witness on the right side (see circle).

Stack all collars and insert the assembly pin. After that the rivet can be inserted by pushing the rivets in and removing the assembly pin at the same time.

For the numbers of collars and the correct stacking use the relevant drawings.

After stacking do the joint with the rivets:

For that apply the pack with the rivets in the manual handling press. It's important to apply at the beginning the pack with the small part on the top. (see picture)



1. Push the pack in direction to the press (green arrows)
2. let the screws down till they are in contact (blue arrows)
3. Do the same with the middle screw and tighten it with 30 Nm torque.
4. Now press the rivets with 25Nm torque
5. Release the pressure, turn the pack and do it again.