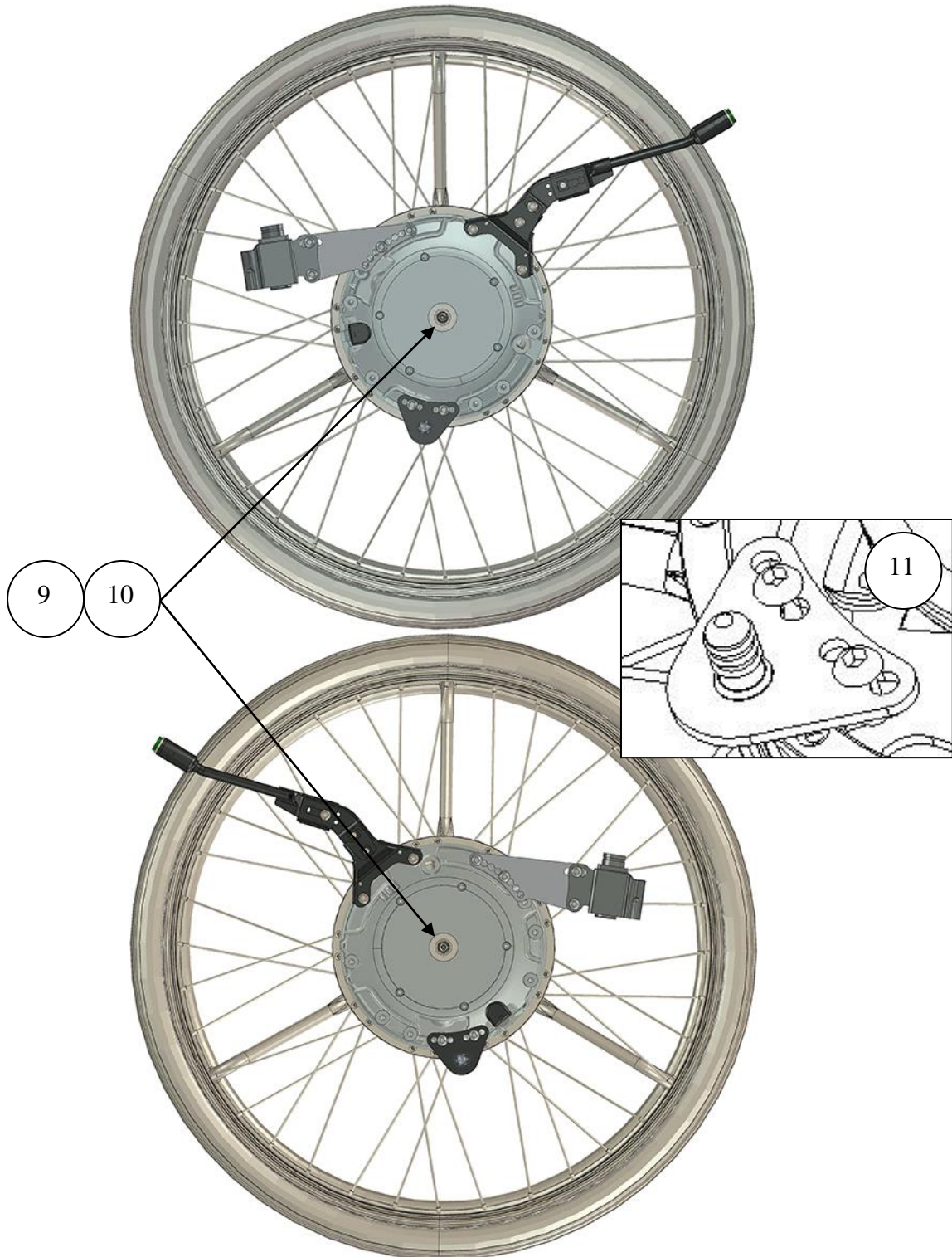
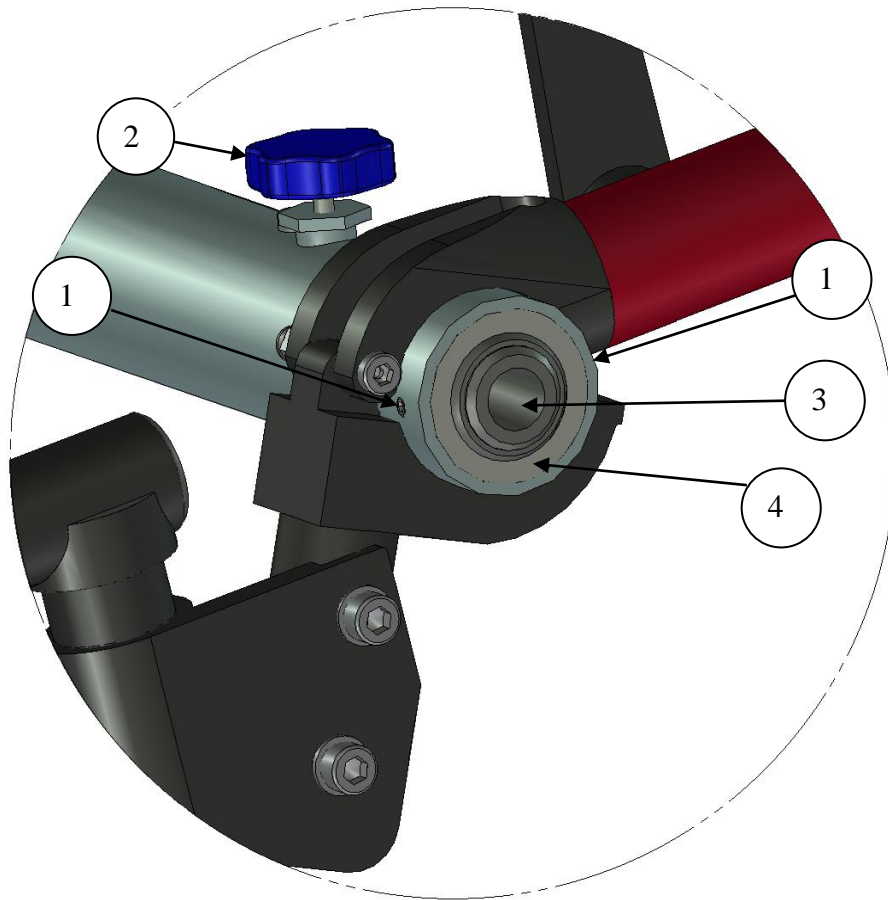


**Assembly instructions for Küschall K-Serie, K-Serie G3  
with Vario-Ax rear axle  
MEM6179P and MEM6180P**

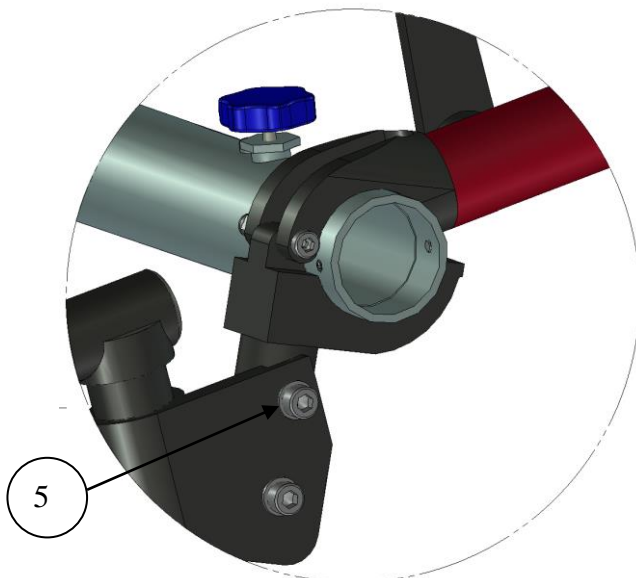
1. Remove the wheels.



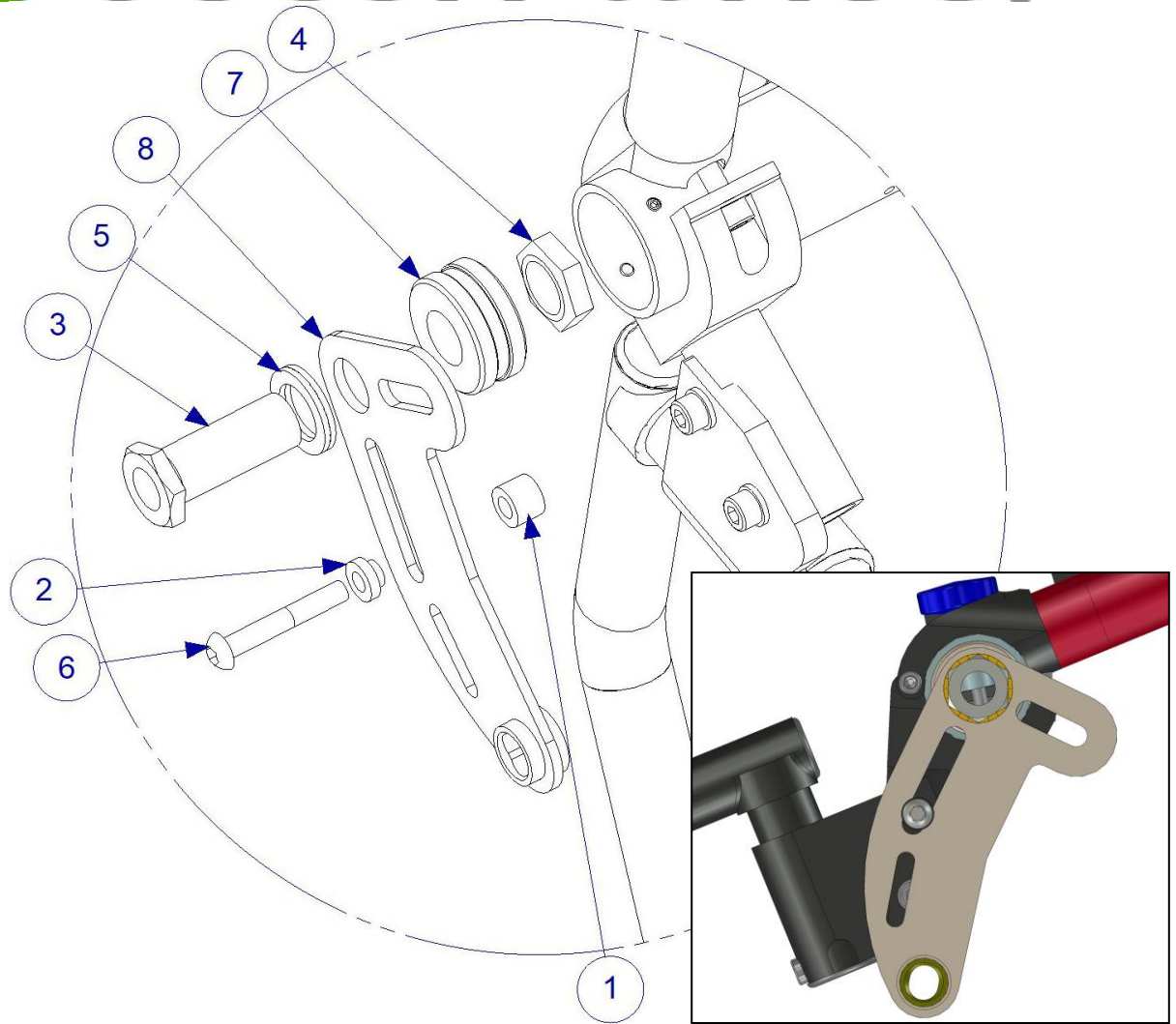
2. Check the correct placement for the eMove with axle  $\varnothing 12,7 \times 51$  with Part number: XOE-2530E-C0 and Spacers with Part number: XOC-25383-00 and Stop pins are assembled with Part Numbers: 320003.



3. Place the wheelchair on the side. Loosen the stop screws (1) that holds the bearing (4) for the hub sleeve (3). Loosen the adjustment screw (2) for the hub sleeve. Now can you remove parts (3 and 4). See the picture on top.



4. Now the most important with having the wheelchair on its side. Because when you assemble the bracket, you have to replace the screw (5) that holds the anti-tip device. Carefully remove this screw (5), because its placed into a spacer inside the tube. This spacer rely wants to move.



5. Assembly parts 3,4,5,7 and 8 together and when the rest of the parts. Do not forget to fasten the stop screws on the rear axle tube.

Parts pair mounting set for (right side):

Item No.	Part Number	Qty	Description
1	100 400 039	1	Spacer
2	100 400 020	1	Spacer
3	HW069	1	Sleeve M16x1/12,7
4	XSM16M	1	Nut M16X1 Low
5	405239	1	Nordlock Washer
6	XSM6X40	1	Screw Round M6 x 40
7	100 400 057	1	Spacer
8	310022	1	Bracket
9	XOC-25383-00	1	Spacer 12,7
10	93440-120520	1	Circlip
11	320003	1	Stop Pin

**Note!** If you only order the mounting set, the axle, axle spacer and the circlip **are not included**, for replacement see the service manual

6. Assemble the back placed battery bag.

**Åtdragningsmoment / Tightening torque**

Metrisk grovgångor, stål.  
Metric coarse threads, steel.

<i><b>Gänga / Thread</b></i>	<i><b>Åtdragningsmoment / Tightening torque</b></i>
M3	1,2 Nm
M4	3 Nm
M5	6 Nm
M6	10 Nm
M8	25 Nm
M10	50 Nm
M12	85 Nm

Navhylsor.  
Hubsleevers.

<i><b>Gänga / Thread</b></i>	<i><b>Åtdragningsmoment / Tightening torque</b></i>
M16x1	30 Nm
M18x1	40 Nm