POWER TRANSMISSION SOLUTIONS FOR FEED MIXERS
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Comer Industries is a global leader in mechatronic solutions and integrated systems for power transmission, supplied to major manufacturers of agricultural and industrial machinery worldwide.

Founded in 1970 in Reggiolo, Reggio Emilia, Italy, for the manufacturing of gearboxes for agricultural machinery, the company has progressively enlarged its range with complete transmissions also for the industrial and mobile markets, to ensure customers added value and competitive advantages.

Industrial operations are structured in five plants in Italy, specialized by product line, plus two facilities in China (Pinghu) and India (Bangalore).

Comer Industries plants worldwide have been designed following the principles of World Class Manufacturing (WCM), a Japanese work-based integrated production methodology developed in the USA in the 1990s which involves the entire organization, from safety to environment, maintenance, logistics and quality. It targets the elimination of all wastes with the ultimate objective of achieving zero defects, zero accidents, zero breakdowns and zero inventory.
QUALITY MANAGEMENT SYSTEM & CUSTOMER CARE

- **PPAP** (Production Part Approval Process) in compliance with the IATF 16949 automotive requirements
- **SIX SIGMA** culture on the basis of total quality management (TQM) standards
- **FMEA** (failure mode and effects analysis)

MECHATRONICS RESEARCH CENTER

To develop and test advanced product solutions, Comer Industries established its Mechatronics Research Center, (1996), equipped with the latest technologies and experimental tools. Covering an area of 2,100 m², this facility has 1 climate chamber and 16 soundproofed test cells, equipped with cutting-edge devices and simulators to reproduce machine operating environment, thus optimizing product performances and reducing both prototyping lead-time and customer time-to-market for new machines. Its team of application engineers is specialized in acquiring machine performance data, using advanced measuring instruments. Comer Industries can also rely on its Metallographic Laboratory for chemical and materials' analysis.

- **2,100 m² Facility**
- **36,500 Testing hours**
- **16 Test cells**
- **1 Climatic chamber**
- **16 People**

**MAIN TESTS**
- Functional
- Crash test
- Endurance
- Field load data monitoring
- Static overload
- Structural fatigue
KEY STRENGTHS

- Complete systems for power transmission:
  - Rigid and Steering Axles
    > best braking and efficiency performance.
  - Professional Range of Driveshafts and Safety Devices
    > high safety performance
    > ease of maintenance
    > long greasing intervals.
  - Heavy-Duty Speed Change Gears
    > low-noise helical gear transmission featuring gears
    > internal pre-load mechanism enabling gear change and automatic re-engagement
    > electric actuator device to pilot change gear.
  - A-614 POWERSHIFT TRANSMISSION
    > shift underload without tractor PTO stop
    > 30% fuel saving and reduction in mixing time through piloting gearshift from final machine’s panel and using always best gear
    > reduced size of the tractor thanks to high reduction ratio
    > low noise transmission due to helical gear design
    > designed for 10,000 hours life
    > monitoring of input/output speed, pressure and temperature (sensors) to protect unit from wrong utilization of shift gear system.
  - Modular Auger Drives
    > transmission of the vertical and horizontal drive to the augers
    > compact and versatile solutions that can be combined with hydraulic motors.
  - Planetary Wheel Drives
    > compact drives
    > high level of performances
    > robustness
    > easy and economical installation on machines
    > reliability for the application
    > excellent mobility required by vehicle type.

- Wide product range: highly personalized, versatile and cutting-edge transmissions.
- Boosted efficiency and attention to the environment.
- A proven 25 year- track record in the design and manufacturing of power transmissions for feed mixers:
  - From the 90s
    > production of parallel axis speed change gears
    > development of modular auger drives.
  - In the 2000s
    > offer enlarged with axles.
- Strong engineering competences and continuing input towards excellence from R&D.
- Long-time experience in field testing, powering duty cycle machinery and solving customer’ expectations.
SOLUTIONS FOR VERTICAL FEED MIXERS

TRAILED FEED MIXER

N-673J
DP-732A
C-3A
A-613R

VP-6
VP-7
VP-8
VP-9
VP-10

PGA-502
PGA-1002/3
PGA-1202
PGA-1602/3

PGA-1702/3
PGA-2102/3
PGA-2502
PGA-3003/4

PGA-1703
PGA-2103
PGA-2503

PGA-1603
PGA-1703
PGA-2103
PGA-2503

PGA-3400
PGA-4204

MILLING HEAD:
PGA-161
PGA-251
PGA-501

PGA-1603
PGA-3400

F-238
F-328
F-358

S-238
S-328
S-358

SELF-PROPELLED FEED MIXER

A-614A
A-614B

PGA-1703
PGA-2103
PGA-2503

PGA-1702/3 W
PGA-2102/3 W
PGA-2502 W

PGA-3602/3 W

PGR-802 W
PGR-1702/3 W
PGR-2502/3 W

PGR-4802/3 W

PGR-802 W
PGR-1702/3 W
PGR-2502/3 W
PGR-3602/3 W

PGR-4802/3 W
SOLUTIONS FOR HORIZONTAL FEED MIXERS

SELF-PROPELLED
FEED MIXER

PG-1602
PG-2502

PG-161
PG-251
PG-501

PG-802 W
PG-1702/3 W
PG-2502/3 W
PG-3602/3 W

PGR-802 W
PGR-4802/3 W

5970

TRAILED FEED MIXER

PG-702
PG-1002
PG-1602
PG-1802

PG-2502
PG-3002
PG-3503

VP-6
VP-7
VP-8
VP-9
VP-10

EN-60
EN-80
EN-90

SOLUTIONS FOR STATIONARY MACHINES

VP-6
VP-7
VP-8
VP-9
VP-10

EN-60
EN-80
EN-90

PGA-502
PGA-1002/3
PGA-1202
PGA-1602/3

PGA-1702/3
PGA-2102/3
PGA-2502/3
PGA-3003/4

PGA-4203/4
HEAVY-DUTY SPEED CHANGE GEARS

HEAVY-DUTY SPEED CHANGE GEARS
FOR TRAILED VERTICAL FEED MIXERS

N-673J gearbox equips single auger trailed vertical feed mixers (up to 4 m³). The unit is compact, with helical bevel and parallel axis transmission.

The 2-speed change gear DP-732A gearbox is applied on single or double augers trailed vertical feed mixers (up to 10-12 m³ for single auger). The gearbox is available with following options:
- hydraulic actuator for gear shifting
- electric actuator with two positions for gear shifting
- electric actuator with three positions (neutral) for gear shifting
- pump coupling
- optional left output shaft to cutters.

<table>
<thead>
<tr>
<th>Type</th>
<th>Transmission Ratio</th>
<th>Transmissible Power HP</th>
<th>Maximum Torque Nm</th>
<th>Maximum Input Speed rpm</th>
<th>Input</th>
<th>Weight kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>N-673J</td>
<td>10:8:1</td>
<td>75.0</td>
<td>1,032</td>
<td>540</td>
<td>Z</td>
<td>110</td>
</tr>
<tr>
<td></td>
<td>15:6:1</td>
<td>45.0</td>
<td>995</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Type</th>
<th>Transmission Ratio</th>
<th>Transmissible Power HP</th>
<th>Maximum Input Speed rpm</th>
<th>Input</th>
<th>Weight kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>DP-732A</td>
<td>1:1/1.18:1</td>
<td>60.0</td>
<td>540</td>
<td>Y</td>
<td>62</td>
</tr>
</tbody>
</table>
The 2-speed change gear C-3A gearbox equips trailed vertical feed mixers. The unit is available in two versions:
- C-3A standard version (single auger up to 16 m³ and double augers up to 32 m³)
- C-3A reinforced version (single augers up to 18 m³ and double augers up to 38 m³)

The gearbox is available with following options:
- "Easy-Shift" system for shifting gear with preload mechanism inside the unit
- hydraulic actuator with two positions for gear shifting
- electric actuator with two positions for gear shifting
- electric actuator with three positions (neutral) for gear shifting
- pump coupling.

The 2-speed change gear A-613R gearbox with low noise helical gears is applied on double or triple augers trailed vertical feed mixers (from 35 m³ for double augers).

The gearbox is available with following options:
- hydraulic actuator for gear shifting
- electric actuator with two positions for gear shifting
- electric actuator with three positions (neutral) for gear shifting
- high speed pump connection standard
- optional low speed pump connection.
A-614A and A-614B shift underload integrated transmissions are applied respectively on double and triple augers trailed feed mixers (from 30 m³ for double augers).

Transmissions main features are the following:
- complete mechatronic package: 2- or 3-speed helical gears transmission integrated with hydraulic system,
- Electronic Control Unit (ECU) to manage gear shifting
- capacity to shift gear under load without stopping augers rotation
- CAN bus interface to monitor gear position, temperature, in/out speed and pressure
- available in 2-speeds (model A-614A), standard ratio 1:1 / 1.8:1
- available in 3-speeds (model A-614B), standard ratio 1:1 / 1.8:1 / 3.2:1
- optional cooling system.

<table>
<thead>
<tr>
<th>Type</th>
<th>Transmission Ratio i</th>
<th>Transmissible Power HP</th>
<th>Input Speed rpm</th>
<th>Input</th>
<th>Weight kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>A-614A</td>
<td>1:1/1.8:1</td>
<td>250</td>
<td>540/1,000</td>
<td>ISO500-3 TYPE3</td>
<td>255</td>
</tr>
<tr>
<td>A-614B</td>
<td>1:1/1.8:1/3.2:1</td>
<td>250</td>
<td>540/1,000</td>
<td>ISO500-3 TYPE3</td>
<td>325</td>
</tr>
</tbody>
</table>
The **VP driveshaft professional series** is designed to meet the demands of high performance intensive use. VP driveshafts offer enhanced safety and reliability through advanced solutions such as hexalobate profiles and tubes with NITREG treatment, which allows:
- increased wear resistance
- reduced axial thrusts in extension
- extended maintenance intervals.

The new **VP series protection** has passed all Irstea tests with greasing intervals every 250 hours.

The **EN guard** are the following:
- retractable cones for easier attachment/removal of the transmission to the PTO
- quick and easy cone engagement/disengagement for excellent access to transmission grease points
- interchangeable cones on both sides.

### Table of Torque Limiter Safety Device

The **torque limiter** interrupts the power transmission when the torque exceeds the setting value, by shearing the bolt. Transmission is restored by inserting a new bolt in the device.

### Table of Continuous and Dynamic Torque Values

<table>
<thead>
<tr>
<th>Type</th>
<th>Power HP</th>
<th>Continuous Torque</th>
<th>Maximum Dynamic Torque</th>
<th>Speed rpm</th>
<th>ASAE Category</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Nm</td>
<td>in-lb</td>
<td>Nm</td>
<td>in-lb</td>
</tr>
<tr>
<td>VP-6</td>
<td>54</td>
<td>707</td>
<td>6,257</td>
<td>1,350</td>
<td>11,949</td>
</tr>
<tr>
<td>VP-7</td>
<td>69</td>
<td>901</td>
<td>7,977</td>
<td>1,580</td>
<td>13,685</td>
</tr>
<tr>
<td>VP-8</td>
<td>90</td>
<td>1,166</td>
<td>10,323</td>
<td>2,100</td>
<td>18,587</td>
</tr>
<tr>
<td>VP-9</td>
<td>110</td>
<td>1,431</td>
<td>12,670</td>
<td>2,430</td>
<td>21,508</td>
</tr>
<tr>
<td>VP-10</td>
<td>132</td>
<td>1,714</td>
<td>15,172</td>
<td>2,930</td>
<td>25,933</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Type</th>
<th>Power HP</th>
<th>Nm</th>
<th>in-lb</th>
<th>Nm</th>
<th>in-lb</th>
<th>Speed rpm</th>
<th>ASAE Category</th>
</tr>
</thead>
<tbody>
<tr>
<td>EN-60</td>
<td>68</td>
<td>880</td>
<td>7,790</td>
<td>1,510</td>
<td>13,360</td>
<td>540</td>
<td>5, 4</td>
</tr>
<tr>
<td>EN-80</td>
<td>100</td>
<td>1,300</td>
<td>11,500</td>
<td>2,390</td>
<td>21,150</td>
<td>540</td>
<td>6, 5</td>
</tr>
<tr>
<td>EN-90</td>
<td>120</td>
<td>1,560</td>
<td>13,800</td>
<td>2,900</td>
<td>25,700</td>
<td>540</td>
<td>7, 6</td>
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</table>

<table>
<thead>
<tr>
<th>Type</th>
<th>B mm</th>
<th>C mm</th>
<th>D mm</th>
<th>Nm</th>
<th>in-lb</th>
</tr>
</thead>
<tbody>
<tr>
<td>60</td>
<td>162</td>
<td>137</td>
<td>22</td>
<td>2,500</td>
<td>22,100</td>
</tr>
<tr>
<td>80</td>
<td>162</td>
<td>146</td>
<td>22</td>
<td>3,000</td>
<td>30,900</td>
</tr>
<tr>
<td>90</td>
<td>162</td>
<td>152</td>
<td>22</td>
<td>4,000</td>
<td>35,400</td>
</tr>
</tbody>
</table>
**MODULAR AUGER DRIVES**

Comer Industries’ modular auger drives are designed to suit feed mixers up to 52 m³ (1,836 cubic-ft). This product range is large and extremely versatile because of its modularity that features high power density and reliability. One out of two feed mixers currently in the field are equipped with Comer Industries’ modular auger drives. Comer Industries is an undisputed market leader thanks to its continuous investment in new product technology and an unparalleled value it can offer to its customers.

**PGA MODULAR AUGER DRIVES**

FOR TRAILED VERTICAL FEED MIXERS AND STATIONARY MACHINES (BIOGAS, OTHER APPLICATIONS)

(*) First number refers to second stage. Second number refers to third stage.

**PGA MODULAR AUGER DRIVES**

FOR SELF-PROPELLED VERTICAL FEED MIXERS AND STATIONARY MACHINES (BIOGAS, OTHER APPLICATIONS)

(*) Motor predispositions SAE C / SAE D, IEC, NEMA and others.
**PG Modular Auger Drives**

*For Trailed Horizontal Feed Mixers*

<table>
<thead>
<tr>
<th>Size</th>
<th>Transmission Ratio (*)</th>
<th>Output Type</th>
<th>D1</th>
<th>D2</th>
<th>D3</th>
<th>N</th>
<th>L</th>
<th>S6</th>
</tr>
</thead>
<tbody>
<tr>
<td>PG-702</td>
<td>16.2</td>
<td>B</td>
<td>200 F7</td>
<td>250</td>
<td>Ø15 x N*12</td>
<td>646.5</td>
<td>70x64 DIN5482</td>
<td></td>
</tr>
<tr>
<td>PG-1002</td>
<td>16.3</td>
<td>B</td>
<td>230 F7</td>
<td>285</td>
<td>Ø17 x N*10</td>
<td>627.5</td>
<td>60x74 DIN5482</td>
<td></td>
</tr>
<tr>
<td>PG-1602</td>
<td>13.4-33.6</td>
<td>B</td>
<td>230 F7</td>
<td>295</td>
<td>Ø17 x N*10</td>
<td>693</td>
<td>100x94 DIN5482</td>
<td></td>
</tr>
<tr>
<td>PG-1802</td>
<td>15.7-29.9</td>
<td>B</td>
<td>230 F7</td>
<td>295</td>
<td>Ø17 x N*10</td>
<td>714</td>
<td>100x94 DIN5482</td>
<td></td>
</tr>
<tr>
<td>PG-2502</td>
<td>14.6-20-36.2</td>
<td>A</td>
<td>245 F7</td>
<td>340</td>
<td>Ø17 x N*15</td>
<td>785</td>
<td>100x94 DIN5482</td>
<td></td>
</tr>
<tr>
<td>PG-3002</td>
<td>45.3</td>
<td>C</td>
<td>102 H7</td>
<td>340</td>
<td>Ø17 x N*15</td>
<td>595</td>
<td>100x94 DIN5482</td>
<td></td>
</tr>
<tr>
<td>PG-3503</td>
<td>53.7</td>
<td>C</td>
<td>122 H7</td>
<td>340</td>
<td>Ø17 x N*15</td>
<td>680</td>
<td>120x225 DIN5482</td>
<td></td>
</tr>
</tbody>
</table>

(*) Suggested ratios. Other ratios available on request.

*For Self-Propelled Horizontal Feed Mixers*

<table>
<thead>
<tr>
<th>Size</th>
<th>Transmission Ratio (*)</th>
<th>Output Type</th>
<th>D1</th>
<th>D2</th>
<th>D3</th>
<th>D4</th>
<th>N</th>
<th>E (*)</th>
</tr>
</thead>
<tbody>
<tr>
<td>PG-1602</td>
<td>22.14-33.6</td>
<td>40x74 DIN5482</td>
<td>275 F7</td>
<td>275 F7</td>
<td>314</td>
<td>Ø15 x N*18</td>
<td>SAC E / SAC C</td>
<td></td>
</tr>
<tr>
<td>PG-2502</td>
<td>20.38.2</td>
<td>100x94 DIN5482</td>
<td>245 F7</td>
<td>340 F7</td>
<td>370</td>
<td>Ø17 x N*15</td>
<td>SAC E / SAC C</td>
<td></td>
</tr>
</tbody>
</table>

(*) Suggested ratios. Other ratios available on request.

(**) Others available on request.

**PG Modular Drives for Milling Head on Self-Propelled Feed Mixers**

<table>
<thead>
<tr>
<th>Size</th>
<th>Transmission Ratio (*)</th>
<th>D1</th>
<th>D2</th>
<th>D3</th>
<th>D4</th>
<th>N</th>
<th>E (*)</th>
</tr>
</thead>
<tbody>
<tr>
<td>PG-161</td>
<td>3.65-2.40-5.80</td>
<td>40x36 DIN5482</td>
<td>110 F7</td>
<td>165</td>
<td>Ø10.5 x N*8</td>
<td>SAC A / SAC B / SAC BB / CMTS</td>
<td></td>
</tr>
<tr>
<td>PG-251</td>
<td>4.15-2.17-6.90</td>
<td>58x33 DIN5482</td>
<td>150 F7</td>
<td>195</td>
<td>Ø13 x N*10</td>
<td>SAC A / SAC B / SAC BB / CMTS</td>
<td></td>
</tr>
<tr>
<td>PG-301</td>
<td>4.15-2.17-6.90</td>
<td>58x33 DIN5482</td>
<td>150 F7</td>
<td>195</td>
<td>Ø13 x N*10</td>
<td>SAC A / SAC B / SAC BB / CMTS</td>
<td></td>
</tr>
</tbody>
</table>

(*) Suggested ratios. Other ratios available on request.

(**) Others available on request.
Comer Industries axles are suitable for self-propelled feed mixers up to 24 m³. With their steering and rigid versions, these axles fit both 2-Wheel-Steer and 4-Wheel-Steer vehicles and, thanks to their modularity, they easily meet market demand in terms of brake options, reduction ratios and differential types. For 2-Wheel-Drive vehicles, the hydraulic motor can be directly mounted on axle input. For 4-Wheel-Drive vehicles, the axle can be equipped with double speed gearbox S-528 series to manage different speeds for transfer as well as for work mode. The gearbox can be provided with the 4-Wheel-Drive disconnection option which allows the user to disengage the transmission between front and rear axles in transfer mode.

**RIGID AXLES**

For self-propelled vertical feed mixers.

### Type | Maximum Dynamic Load (kN) | Maximum Output Torque (Nm) | BCD (Bolt Circle Diameter) (mm) | Reduction Ratio at Wheels | Total Reduction Ratio | Track-Dimension A (mm) | Service Brake Type |
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>F-220</td>
<td>8.300 (*)</td>
<td>3,400</td>
<td>275/355</td>
<td>6.1</td>
<td>from 13.4-1 to 24.1</td>
<td>770</td>
<td>Oil immersed Brake Disc</td>
</tr>
<tr>
<td>F-225</td>
<td>10,000 (*)</td>
<td>4,000</td>
<td>338</td>
<td>6.4-1</td>
<td>from 13.7-2 to 28.1</td>
<td>800</td>
<td>Oil immersed Brake Disc</td>
</tr>
<tr>
<td>F-325</td>
<td>15,000 (*)</td>
<td>6,000</td>
<td>335/425</td>
<td>6.4-1</td>
<td>from 15.7-1 to 29.1</td>
<td>850</td>
<td>Oil immersed Brake Disc</td>
</tr>
</tbody>
</table>

(*) The dynamic load values refer to pivoting axles.
PLANEYR W PLANETARY WHEEL DRIVE SERIES
FOR SELF-PROPELLED FEED MIXERS

Comer Industries’ planetary wheel drive PGR W series, available with either two or three stages of reduction, can deliver maximum torque between 10,000 Nm and 48,000 Nm and can be used on most self-propelled feed mixers available to the market.

The compact design of the PGR W series allows seamless integration on agricultural applications, such as feed mixers, at a competitive price. Comer Industries’ drives deliver enhanced performance in line with the reliability, travel speed and desired mobility necessary to succeed in these applications.

By incorporating a disconnect feature, offered as a product option for the PGR W series, Comer Industries’ planetary wheel drives allow a vehicle to be towed in case of failure within the hydraulic system.

Additionally, these drives can readily accept a SAE flange hydraulic motor, as well as cartridge style motors.

### Table: PGR W PLANETARY WHEEL DRIVE SERIES

<table>
<thead>
<tr>
<th>Size</th>
<th>Transmission Ratio</th>
<th>Maximum Torque Nm</th>
<th>Braking Torque Nm</th>
<th>Maximum Input Speed rpm</th>
<th>Minimum Opening Pressure bar</th>
<th>Weight kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>PGR-402 W 30-64</td>
<td>10,000</td>
<td>150-300</td>
<td>3,500</td>
<td>15-20</td>
<td>68</td>
<td></td>
</tr>
<tr>
<td>PGR-402-2 W 16-61</td>
<td>18,000</td>
<td>320-400</td>
<td>3,900</td>
<td>15-20</td>
<td>68</td>
<td></td>
</tr>
<tr>
<td>PGR-402-3 W 16-61</td>
<td>25,000</td>
<td>250-400</td>
<td>3,500</td>
<td>15-20</td>
<td>120</td>
<td></td>
</tr>
<tr>
<td>PGR-402-2 W 16-61</td>
<td>35,000</td>
<td>250-600</td>
<td>3,500</td>
<td>15-20</td>
<td>140</td>
<td></td>
</tr>
<tr>
<td>PGR-402-3 W 16-61</td>
<td>48,000</td>
<td>250-800</td>
<td>3,900</td>
<td>15-20</td>
<td>170</td>
<td></td>
</tr>
</tbody>
</table>

(*) Dimensions may change according to the selected hydraulic motors.

(*) Braking torque may change according to the selected hydraulic motors.

### Table: 5970 RIGID AXLE

<table>
<thead>
<tr>
<th>Type</th>
<th>Maximum Dynamic Load daN</th>
<th>Maximum Output Torque daNm</th>
</tr>
</thead>
<tbody>
<tr>
<td>5970</td>
<td>15,000</td>
<td>3,000</td>
</tr>
</tbody>
</table>

### Table: PLANETARY WHEEL DRIVE SERIES

<table>
<thead>
<tr>
<th>Type</th>
<th>Reduction Ratio at Differential</th>
<th>Reduction Ratio at Wheels</th>
<th>Total Reduction Ratio</th>
</tr>
</thead>
</table>

### Table: Drum Brake Type

<table>
<thead>
<tr>
<th>Type</th>
<th>Track-Dimension A mm</th>
<th>Service Brake Type</th>
</tr>
</thead>
<tbody>
<tr>
<td>5970</td>
<td>M1 1,800-2,000</td>
<td>Drum Brake 400x80</td>
</tr>
<tr>
<td></td>
<td>M2 1,781-2,000</td>
<td>Disc Brake Ø380 with Caliper</td>
</tr>
</tbody>
</table>

(*) Dimensions may change according to the selected hydraulic motors.
GLOBAL PRESENCE - SALES

Comer Industries operates in the main world markets with its own sales organization and it is present in major foreign countries with its own sales subsidiaries in the United States, Brazil, China, India, Germany, France and the United Kingdom.

In countries where there are no own branches, product distribution is carried out through an international network of distributors and agents. In Italy a direct sales network is operating.