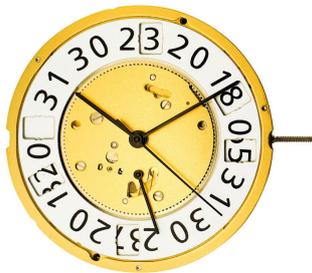


Specification

15'''



Dimensions and battery

∅ Total	34.60 mm
∅ Case fitting	33.80 mm
Movement height	5.60 mm
Movement rest	0.60 mm
Height of stem	3.30 mm
Stem: Thread / Distance	0.90 mm / 1 mm
Battery / Autonomy	Nr. 381 / 48 Months

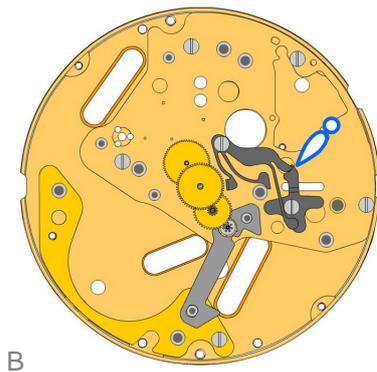
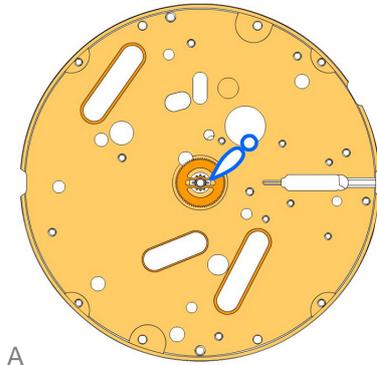
Performances

	Second (M1): typ 10 µNm
Torque T	Minute hand (M1): typ 500 µNm
Res. against magn. fields	18.8 Oe = 1500 A/m
Operating temperature	0°C - 50°C
Resistance against shock	NIHS 91 - 10

functions

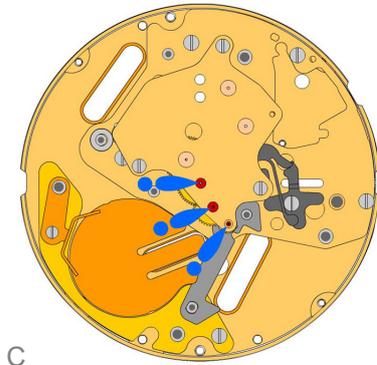
Position I (crown)	Neutral
Position II (crown)	Setting the date (quick mode)
Position III (crown)	Setting the time and retrograde day

Assembling



1. **2000.649.G** **Main Plate**
 Use Moebius 9014 on bearing of all rubis
2. **3305.324** **Cannon pinion with driver (Aig. 1)**
 Moebius 8200 greace must be placed between the steel tube and the wheel. The steel tube must be placed into the center hole of the main plate.
3. **2030.020.CO** **Centre Bridge**
 Use 4 screws 4000.250
4. **4000.250** **Screws**
5. **2130.181** **Use 1 screw 4000.250.**
6. **4000.250** **Screw**
7. **3016.028** **Lever for setting lever**
 "If the stem and the mechanism is already placed on the backside, place the stem into the middle position. Then use 1 screw 4000.326 to fix the lever for setting lever."
8. **4000.326** **Screw**
9. **3016.027** **Stop lever**
 Position the Stop lever under the 'Lever for setting lever' and fix the Stop lever by using 1 screw 4000.326. The reset arm of the Stop lever must be placed according to the picture. Use Moebius 8200 at the contact point of the 2 levers.
10. **4000.326** **Screw**
11. **3622.044** **Stator**
12. **3715.105.RK** **Rotor**
 Use an antimagnetic tweezers to place the rotor.
13. **3147.060.CO** **Intermediate wheel**
14. **3122.062.CO** **Third wheel**
15. **3136.177.CO** **Centre second wheel (Aig. 1)**

Assembling



16. 2020.169.G **Train wheel bridge**
 Attention: Prior to the fastening process of the bridge, all 4 pins of the wheels must be visible in the 4 holes in the bridge. Use 3 screws 4000.250

17. 4000.244 **Screws**

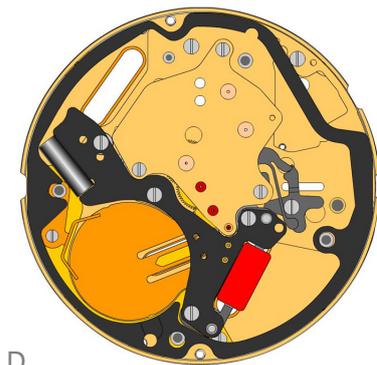
18. 9014.000 **Moebius 9014**

19. 3603.080 **Battery insulator**

20. 3601.120.G **Battery clamp (+)**
 Use 1 screw 4000.248

21. 4000.248 **Screw**

22. 3503.071 **Tube**
 1 pieces



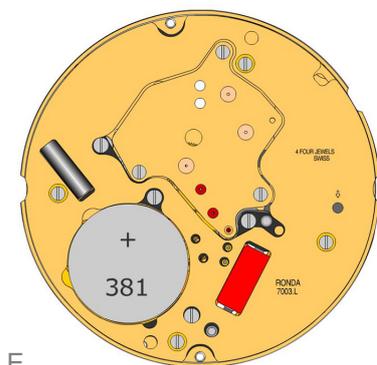
23. 3612.195 **Electronic module**
 The coil is integrated into the electronic module. Use 4 screws 4000.250

24. 4000.250 **Screws**

25. 3603.081 **Spacer**

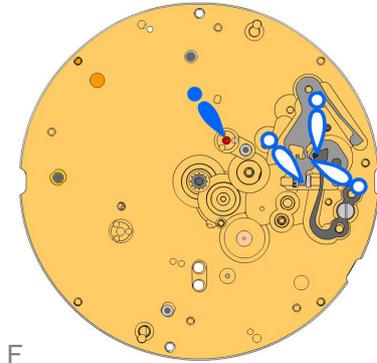
26. 2130.182.G **Electronic module cover**
 Use 4 screws 4000.244

27. 4000.244 **Screws**



28. 3600.032 **Battery**
 use a plastic tweezers to place the battery (to avoid short circuit of battery).

Assembling



29. 2000.649.Gb Main Plate



30. 3017.054.CO Setting lever

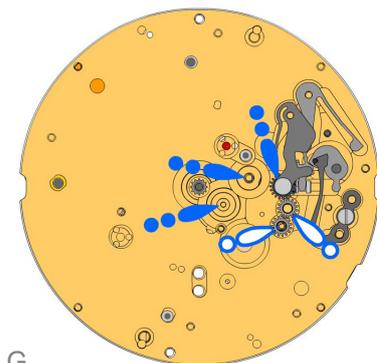


31. 3905.063 Setting lever jumper (3 positions)
 The setting lever jumper must be tensioned and inserted into the setting lever. Use one screw 4000.250. Use Moebius 8200 to grease.

32. 4000.282 Screw



33. 3001.046.FI Sliding pinion



34. 3015.077 Yoke (3 positions)
 The yoke must be inserted into the cut out of the sliding pinion. Tense the spring and connect in the main plate. Use Moebius 8200



35. 3004.200 Corrector setting wheel
 Use Moebius 8200 on both setting wheels.



36. 3015.078.CO Rocking bar (3 positions)
 Moebius 8200 grease must be placed between both levers. oiling wheel with Moebius 9020.



37. 2130.194 Setting mechanism cover
 Use 4 screws 4000.305



38. 4000.305 4 Screws



39. 3000.194.CO Stem
 Prior to the insertion of the stem, some grease must be placed on the square part of the stem.



40. 4000.244 4 Screws



41. 3004.201 Intermediate setting wheel
 Use moebius 9020.



42. 3007.079.CO Minute wheel
 Use moebius 9020.



43. 2130.185 Minute train bridge
 Insert the minute train bridge in the main plate and fix it with 1 screw 4000.278.



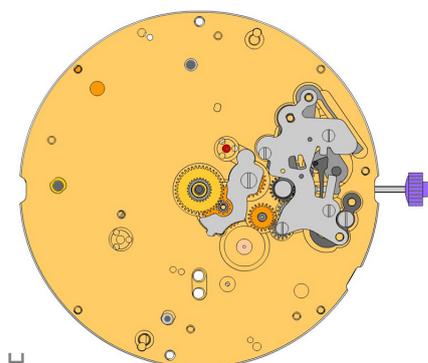
44. 4000.278 Screw



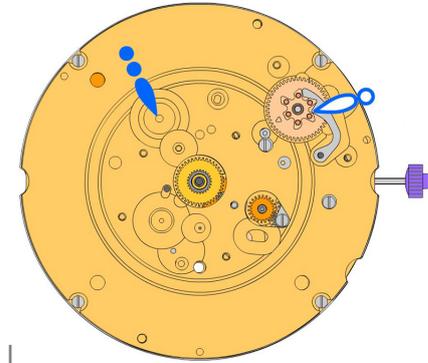
45. 3301.296.CO Hour wheel (Fig. 1)
 Use moebius 9020.



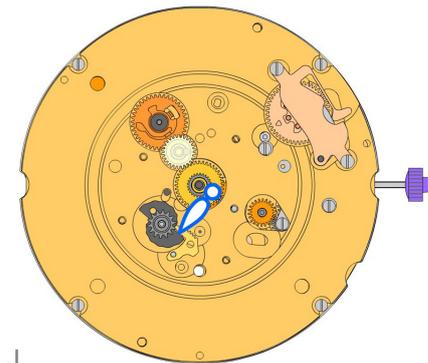
46. 3147.066.CO Date corrector setting wheel



Assembling



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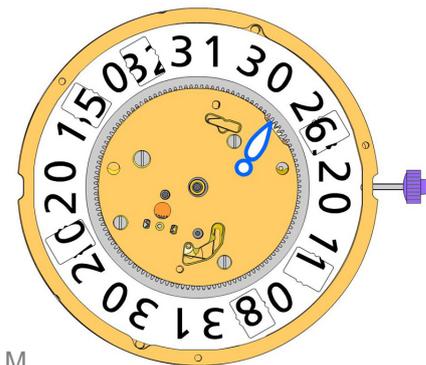
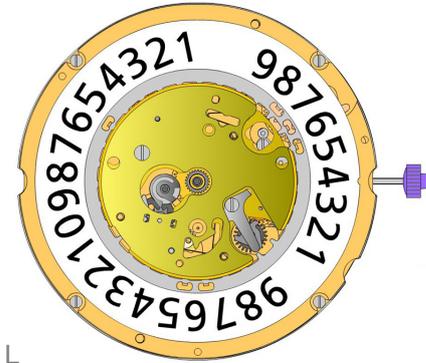
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|-----|-------------|---|
| 47. | 2000.650.G | Main plate retro (6h)
Use 4 screws 4000.248 |
| 48. | 4000.248 | Screw |
| 49. | 3004.209 | Tens indicator driving wheel
The short tooth of the tens indicator driving wheel must point to the center of the movement. |
| 50. | 3500.067 | Tens jumper
Moebius 8200 grease must be placed between the tens jumper and the tens indicator driving wheel. |
| 51. | 2130.187 | Tens jumper maintaining plate
Use 2 screws 4000.279. Place the spring loaded bracket outside of the tens jumper. |
| 52. | 4000.279 | Screw |
| 53. | 3004.208.CO | Date indicator driving wheel
Oil must be placed at the pins before inserting the wheel. |
| 54. | 3147.061 | Intermediate date wheel |
| 55. | 3404.005.CO | Day cam (6h) |
| 56. | 3406.032 | Day rack
Moebius 8200 must be placed between cam and rack. Orientation of the parts like indicated. |
| 57. | 3406.031 | Day rack lever |
| 58. | 3507.059.CO | Date corrector wheel |
| 59. | 2130.188 | Date indicator plate (6h) |
| 60. | 3905.068 | Date corrector spring
Use 1 screw 4000.244. |
| 61. | 3905.066 | Day rack lever spring
The Days rack lever spring must be tensioned and inserted as shown. |
| 62. | 3500.069 | Day jumper
Moebius 8200 grease must be placed between cam and day jumper. |
| 63. | 3500.068 | Date jumper |
| 64. | 3504.229.AF | Units indicator (T3/G12)
Teeths must be greaced using Moebius 8200. The 'half moon' cut out on the unit indicator must point to the stem (position 3h). |

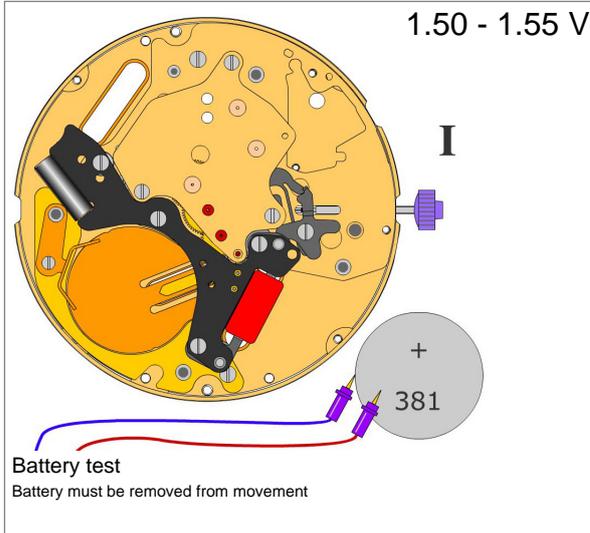
Assembling



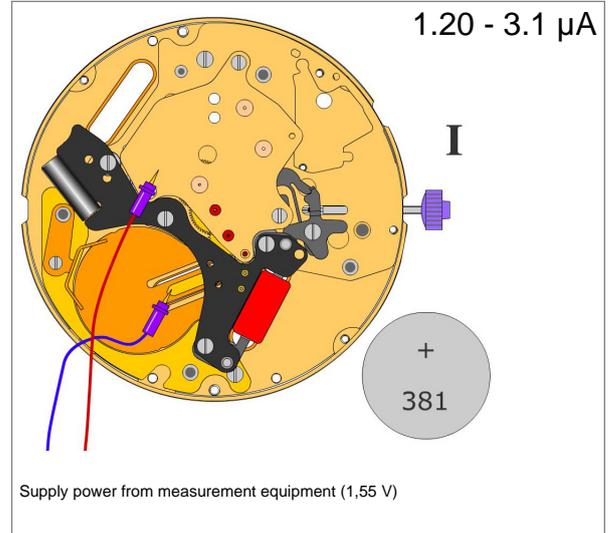
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|-----|-------------|---|--|
| 65. | 2130.189 |  | Date indicator maintaining plate
Use 1 screw 4000.250. |
| 66. | 4000.250 |  | Screw |
| 67. | 3905.064 |  | Date jumper spring
Insert the spring into the opening of the date indicator maintaining plate. |
| 68. | 3907.047 |  | Day finger flange
"Turn the unit indicator forward by 30 days (quick mode). Then pull the stem and adjust the time slowly until the date jump is executed ? after the date jump stop turning the stem immediately! The 'half moon' cut on the units indicator is now again pointing to the stem." |
| 69. | 3004.211 |  | Day finger
"Position the day finger as indicated and turn the day finger until it is in contact with the day cam. By this method the time gap between change of date and change of day indicator can be minimized." |
| 70. | 3004.212 |  | Days driving wheel
"Insert this wheel and assure, its bended down arm is properly inserted into the counterpart on then Day finger. Make sure that during insertion of this wheel, the Day finger is in contact with the day cam. This can be done by slightly turning this wheel (counter clock wise) while inserting." |
| 71. | 3401.082.FI |  | Day indicator pinion |
| 72. | 3147.062 |  | Tens intermediate wheel |
| 73. | 3504.230.AF |  | Tens indicator (T3/G12)
The 'half moon' cut out on the tens indicator must point to the stem (position 3h). |
| 74. | 2130.190.G |  | Date mechanism maintaining plate (6h)
Use 3 screws 4000.320. |
| 75. | 4000.320 |  | Screw |
| 76. | 3506.077.G |  | Dial support |
| 77. | 3506.076.G |  | Intermediate dial support |
| 78. | 9010.000 |  | Moebius 8200
Microgliss D5 can be used |
| 79. | 9014.000 |  | Moebius 9014
Use Moebius 9014 on bearing of all rubis |
| 80. | 9018.000 |  | Jismaa 124
Grease Moebius or Microgliss D5 an be used |
| 81. | 9020.000 |  | Moebius 9020 |

Electrical checking

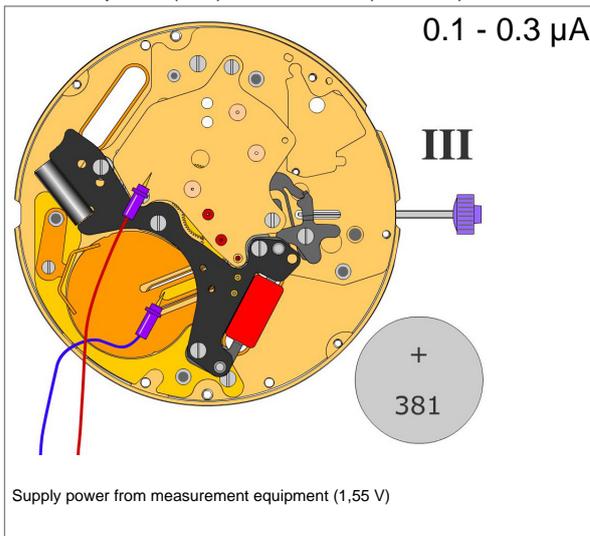
Voltage of battery



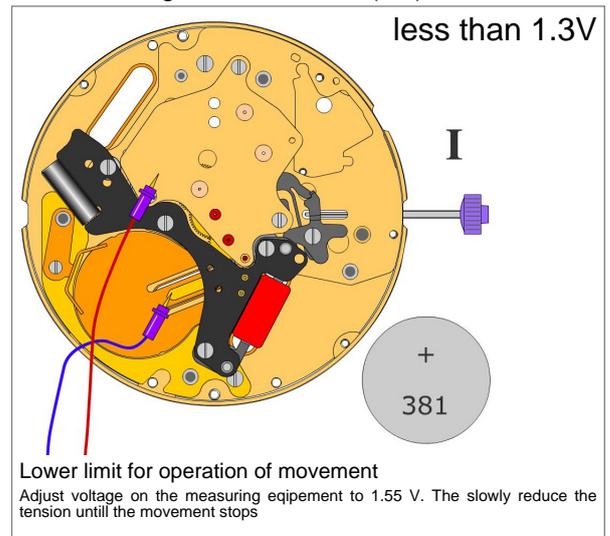
Consumption (M1) of movem. (Pos. I)



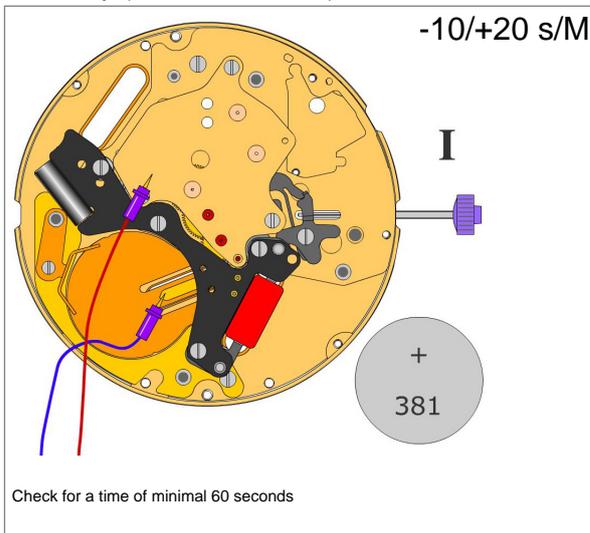
Consumption (M1) of movem. (Pos. III)



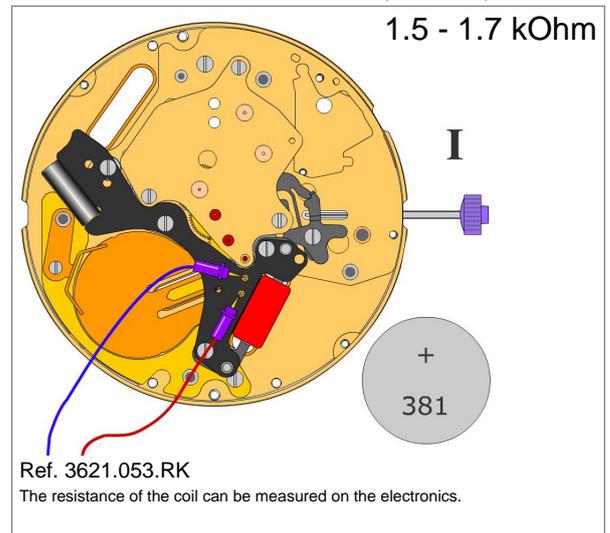
Lowest voltage for movement (M1)



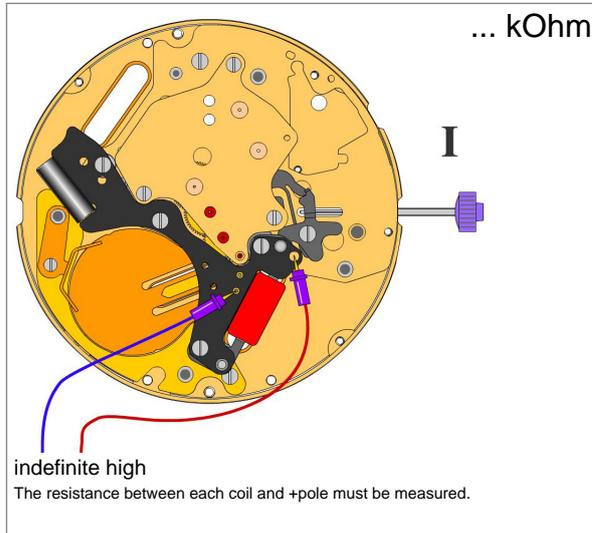
Accuracy (seconds / month)



Resistance of the coil: motor 1 (movem.)



Coil insulation: motor 1 (M1)



Accelerated test of movement (M1)

