RONDA

Technical Instructions   4002.B

Specification

12 ½'''

Dimensions and battery

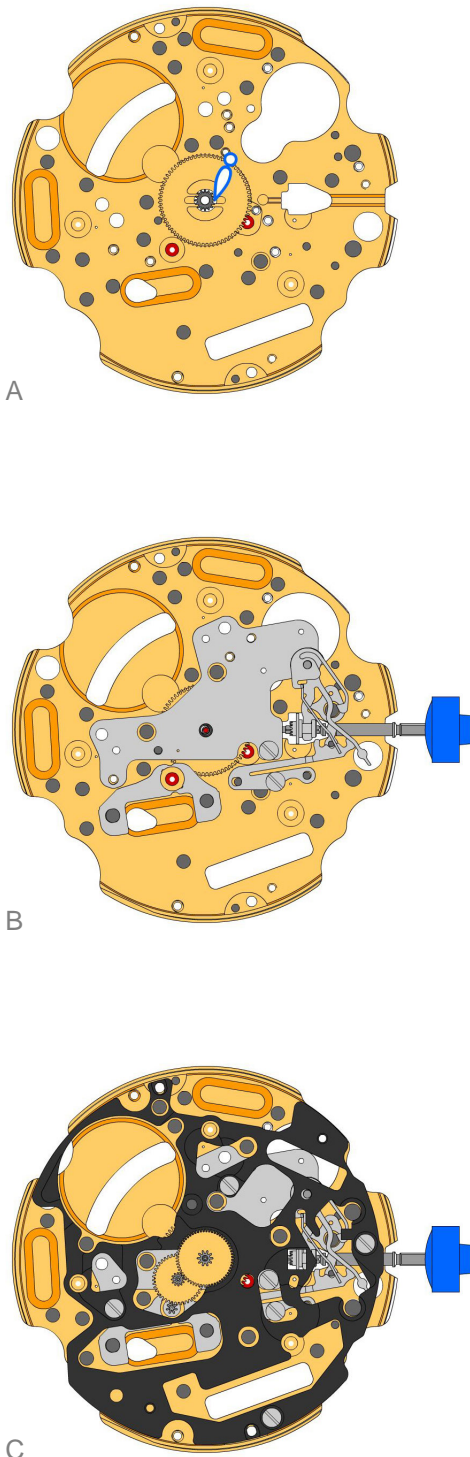|	
ø Total	28.60 mm
ø Case fitting	28.00 mm
Movement height	4.40 mm
Movement rest	0.60 mm
Height of stem	1.90 mm
Stem: Thread / Distance	0.90 mm / 0.90 mm
Battery / Autonomy	Nr. 395 / 48 Months

Performances

Torque T	Minute hand: 6 µNm
Operating temperature	0°C - 50°C
Res. against magn. fields	18.8 Oe = 1500 A/m
Resistance against shock	NIHS 91 - 10

Functions

Position I (crown)	Neutral
Position II (crown)	Setting the date (quick mode)
Position III (crown)	Setting Time

CE

RONDA

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Assembling

A

B

C

| No.	Part	Name	Notes
1.	2000.577.G	Main plate	
2.	3305.314.CO	Cannon pinion with driver (Aig 2)	Moebius 8200 greace must be placed between the steel tube and the brass wheel. The steel tube must be placed into the center hole of the main plate.
3.	2030.019.CO	Centre bridge	Use one screw 4000.250 to fix the center bridge.
4.	3001.041	Sliding pinion	The sliding ponion must be holded using a tweezers, untill the stem is inserted.
5.	3000.177.CO	Handsetting stem	Prior to the insertion of the stem, some greace must be placed on the square part of the stem.
6.	3017.049	Setting lever	The cam on the setting lever must be inserted into the cut out on the stem. (the setting lever must be greaced)
7.	3905.049	Setting lever jumper (3 positions)	The setting lever jumper (3 positions) must be tensioned and inserted into the setting lever. Use one screw 4000.250 to fix the setting lever.
8.	4000.250	Screw	
9.	3015.076	Yoke (3 positions)	The yoke must be inserted below, into the cut out of the sliding pinion.
10.	3905.058	Yoke spring	The yoke spring must be positioned on the yoke. The opposite end of the yoke must be positioned around the pillar of setting lever. Use Moebius 8200 to grease the yoke.
11.	3622.039	Stator	
12.	3603.065	Plastic bracket	Use 4 screws 4000.250
13.	4000.250	Screw	
14.	3715.094.RK	Rotor centre	Use an antimagnetic tweezers to place the rotor.
15.	3147.047.CO	Intermediate wheel (chrono)	
16.	3136.170.CO	Second wheel (height 0)	
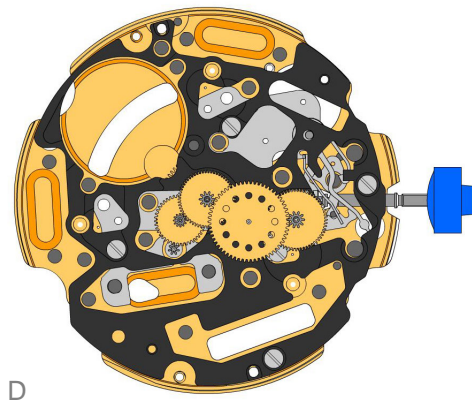
D

17. 3136.148.CO   Second wheel (short)
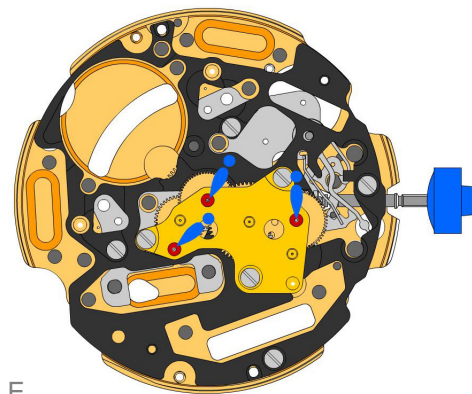
18. 3122.056.CO   Third wheel

19. 2020.164.G   Train wheel bridge

Attention: Prior to the fastening process of the bridge, all pins of the wheels must be visible in the holes in the bridge. Use 3 screws 4000.250.

20. 4000.250   Screw

E

21. 9014.000   Moebius 9014

Use Moebius 9014 on bearing of all rubis

22. 3621.054.RK   Coil (movment)

The wire of the coil (red area) is very sensitiv to mechanical impacts. Hold the coil only ouside the red area.£Fix the coil by 1screw 4000.250.
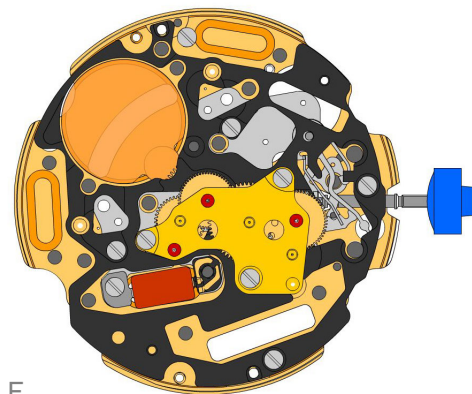
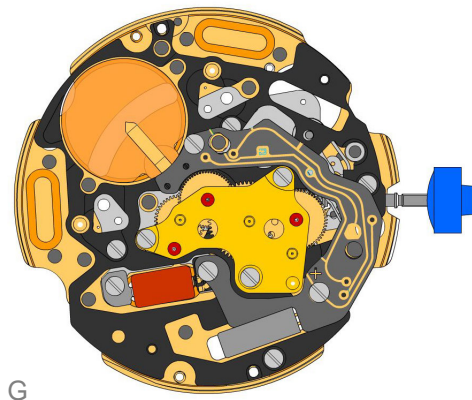**23.** 4000.250   Screw

24. 3503.059   Tube

25. 3603.034   Battery insulator

F

![RONDA logo]

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Assembling

G

26.	4000.248	Screw

27.	3503.068	Tube

28.	3603.076	Circuit insulator

29.	3601.107	Pusher contact spring

Make shure, that the pusher contact spring is placed correctly onto the pillars.
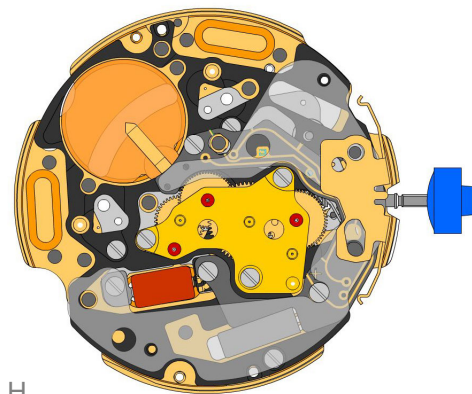
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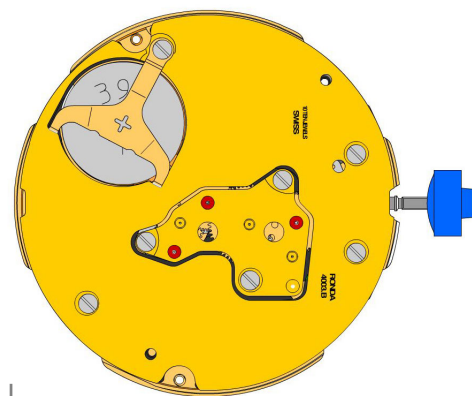| 30.	3600.010	Battery

Use a plastic tweezers to place the battery (to avoid short circuit of battery).
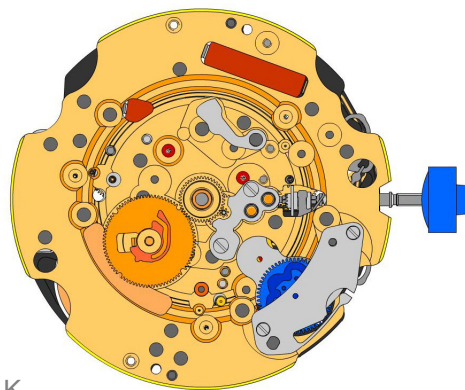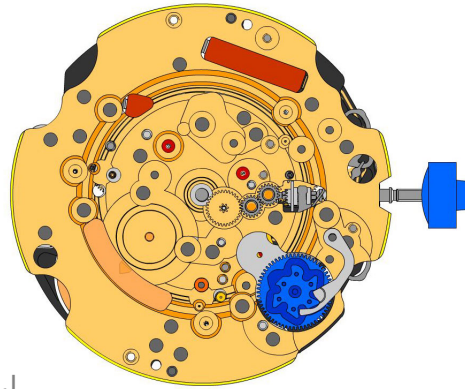
31.	3601.109	Bridle +

Insert the two brackets of the battery bridle under the electronic module cover and fasten the battery bridle by 1 screw 4000.250.

32.	4000.250	Screw

I

Assembling

J

K

33.	2000.577.G	Main plate

34.	9014.000	Moebius 9014
		Use Moebius 9014 on bearing of all rubis

35.	3004.164	Setting wheel
		Use Jismaa 124 or Greace Moebius on both setting wheels.

36.	3007.054.CO	Minute wheel
		Use Moebius 9020

37.	2130.143	Minute train bridge
		Use 2 screws 4000.305

38.	4000.305	Screw

39.	3004.181	Tens indicator driving wheel
		The short tooth of the tens indicator driving wheel must point to the center of the movement.

40.	3500.059	Tens jumper
		Moebius 8200 greace must be placed between the tens jumper and the tens indicator driving wheel.

41.	2130.142	Tens jumper maintaining plate
		Make shure, that the tens indicator driving wheel is not blocked prior to the fastening process. Use 2 screws 4010.306. Place the spring loaded bracket outside of the tens jumper.

42.	4010.306	Screw

43.	3301.285	Hour wheel (Aig 0)
		Use Moebius 9020

44.	3315.016	Hour wheel friction spring
		Must be placed onto the hour wheel

45.	3004.176.CO	Date indicator driving wheel
		Moebius 9020 must be used in the center of this wheel

46.	3500.049	Date jumper
		Moebius 8200 greace must be placed between the date jumper and the date jumper spring

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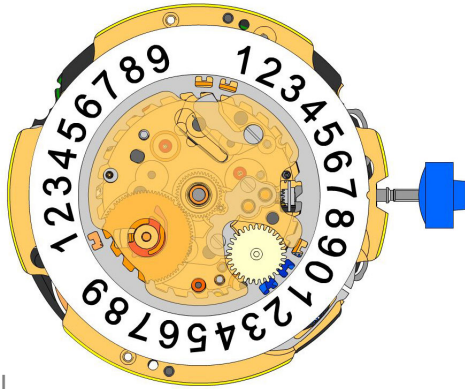
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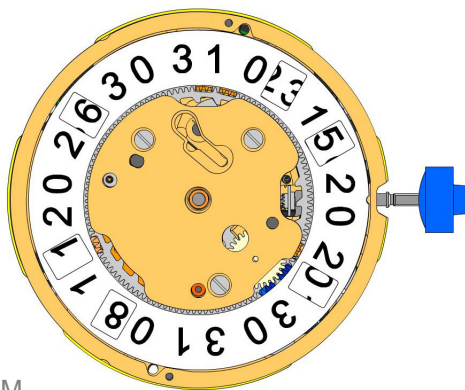
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47. 3504.214.AD   Units indicator
Teaths must be greaced using Moebius 8200. The "half moon" cut out
on the unit indicator must point to the stem (position 3h).

48. 3147.054   Tens intermediate wheel

49. 2130.141   Date indicator maintaining plate
use 1 screw 4000.250

50. 3905.050   Date jumper spring
Insert the spring into the opening of the date indicator maintaining plate

51. 3504.215.AD   Tens indicator (T3/G12)
The "half moon" cut out on the tens indicator must point to the stem
(position 3h).

52. 2130.140   Date mechanism maintaining plate
Assure that the tens intermediate wheel is not blocked, prior to the
fastening process. Use 2 screws 4000.250 to fix the date indicator
maintaining plate

53. 3506.072   Dial support

54. 4000.250   Screw

55. 9010.000   Moebius 8200
Microgliss D5 can be used

56. 9018.000   Jismaa 124
Greace Moebius or Microgliss D5 an be used

57. 9020.000   Moebius 9020

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Voltage of battery

1.50 - 1.55 V

I

395 +

Battery test
Battery must be removed from movement

Consumption (M2) of movem. (Pos. I)

0.75 - 1.3 µA

I

395 +

Supply power from measurement equipment (1,55 V)

Consumption (M2) of movem. (Pos. III)

0.1 - 0.3 µA

III

395 +

Supply power from measurement equipment (1,55 V)
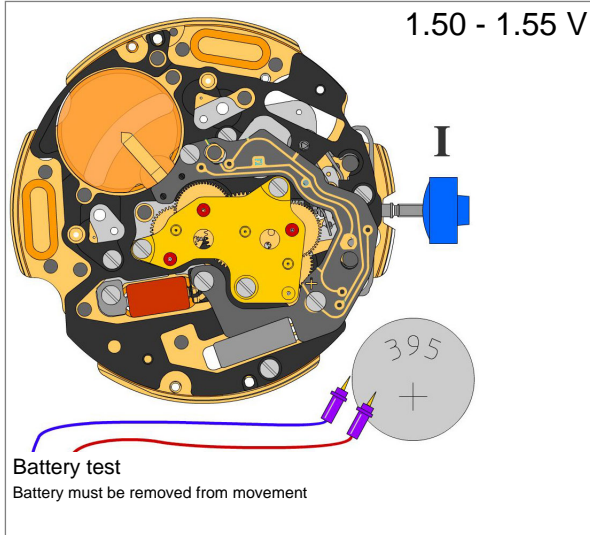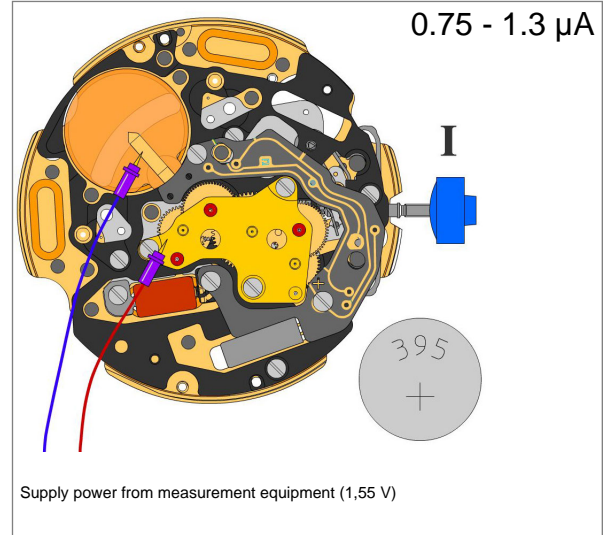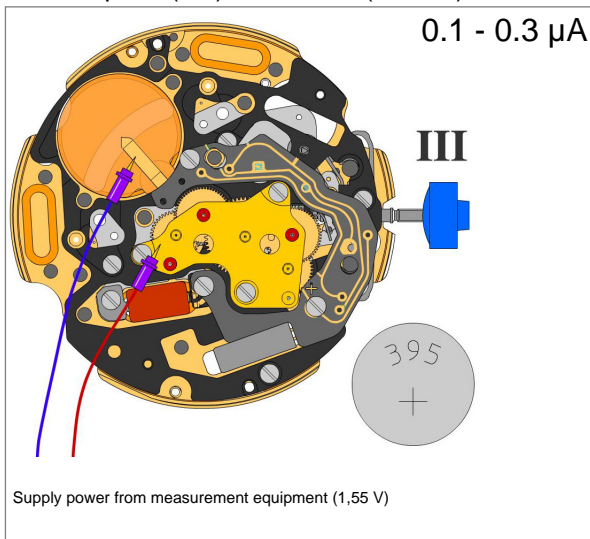
Lowest voltage for movement (M2)

<= 1.3 V

I

395 +

Lower limit for operation of movement
Adjust voltage on the measuring eqipement to 1.55 V. The slowly reduce the
tension untill the movement stops

Accuracy (seconds / month)

-10/+20 s/M

I

395 +

Check for a time of minimal 60 seconds

Resistance of the coil (M2)

2.2 - 2.4 kOhm

I

395 +

Ref. 3621.054.RK
The resistance of the coil can be measured on the electronics (M2) or directly on
the coils (electronic module must be removed).

Coil insulation (M2)

... kOhm

I

395
+

indefinite high

The resistance between each coil and +pole must be measured (electronic module must be removed)

Accelerated test of movement (M1)

1.55 V

I

395
+

8 steps / sec.

To activate this test mode, the corresponding test point must be connected to the -Pole