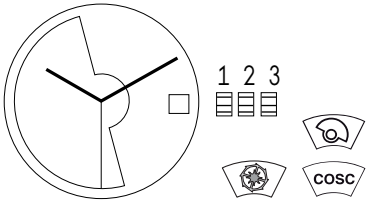


	Technical Guide			TG-19-C-001-E	H
	Made by: selrom	Date: 29.09.2011	3	Modifications: See last page	

# CALIBRE 2500

	Version A	Version B	Version C	Version D
$11\frac{1}{2}'''$ Ø 25,60 mm				
Height on movement	4.10 mm			
Power reserve	44 h		48 h	48 h
Number of rubies	27		27	27
Frequency	4 Hz (28'800 A/h)		3.5 Hz (25'200 A/h)	3.5 Hz (25'200 A/h)
Lift angle	30° / 38°		38°	38°
Versions of Co-Axial	Co-Axial, 2 levels			Co-Axial, 3 levels



Automatic movement, Co-Axial escapement, date, COSC-certified, Omega balance system without index. Hour, minute and second hands in centre.

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## General Information for Calibre 2500

For the following informations, see document «General information for Calibres 1120, 1128, 2007, 2200, 2202, 2300, 2403, 2500, 2610, 2627, 2628:

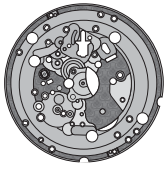
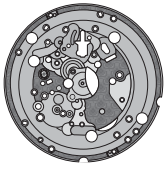
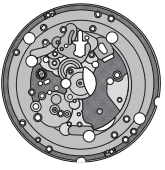

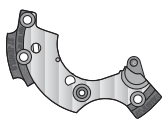
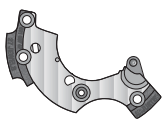
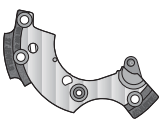
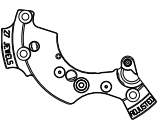




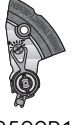


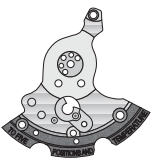
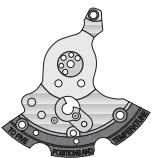
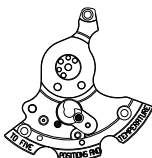



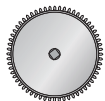
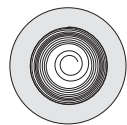
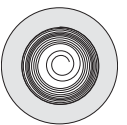
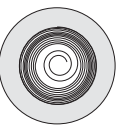








- Date correction
- Complete balance bridge and chronograph bridge
- Instantaneous rate
- Special lubrication
- Lubricants
- Cleaning and epilame-coated procedure
- Components that should not be epilam-treated
- Tightening and untightening torques according to screw thread size
- For more informations, please consult respectives Technical Guides
- Technical modifications on version «B»
- Runners for hand setting and hand setting force
- Mandatory tools
- List of programs of apparatus
- Checks of endshake
- Escapement system installation
- Balance bridge installation
- Disassembling the balance bridge
- Hand fitting height
- Winding stem function
- Technical data
- Adjustment of the rate

### Hand fitting height
























Components marked with an asterisk (\*) are available different versions (color, heigt).



















## Differences between version 2500A, 2500B, 2500C and 2500D

	2500A (4 Hz)	2500B (4 Hz)	2500C (3.5 Hz)	2500D (3.5 Hz)
Main plate	 ref. 72225001002007 Engraved 2500	 ref. 7222500B1002007 Engraved 2500B	 ref. 7222500C1002007 Engraved 2500C	 <b>ref. 7222500D1002007</b> Engraved movement version manufacturing code
Barrel bridge	 ref. 72225001004107	 ref. 7222500B1004107 <b>ref. 7222500B10041N</b>	 ref. 7222500C1004107	 <b>ref. 7222500D1004118</b>
Wheel train bridge	 ref. 72225001004807	 ref. 7222500B1004807		 <b>ref. 7222500D1004807</b>
Balance bridge	 ref. 72225001005824	 ref. 7222500B1005824 <b>ref. 7222500B10058N</b>	 ref. 7222500C1005824	 <b>ref. 7222500D1005818</b>
Automatic device framework jewelled	 ref. 72211201203007	 ref. 7222500B1203007		 <b>ref. 7222500D1203018</b>
Movement barrel complete	 ref. 722112020010	 ref. 7222500B20010	 ref. 722112020010	 <b>ref. 7222500D20010</b>
Mainspring	 ref. 722112020102	 ref. 7222500B20102	 ref. 722112020102	 <b>ref. 7222500D20102</b>
Second wheel	 ref. 722112030027* 96 theeth with 8 arms	 ref. 722112030027* 96 theeth with 8 arms	 ref. 7222500C30027* 105 theeth with 5 arms	
Intermediate escape wheel	 ref. 722250030039 Pinion with 8 leaves	 ref. 7222500B30039 Pinion with 8 leaves	 ref. 7222500C30039 Pinion with 10 leaves Nick on the upper side of the pivot shank.	 <b>ref. 7222500D30039</b> Pinion with 10 leaves Nick on the upper side of the pivot shank.

## Differences between version 2500A, 2500B, 2500C and 2500D

	2500A (4 Hz)	2500B (4 Hz)	2500C (3.5 Hz)	2500D (3.5 Hz)
Co-Axial wheel	 ref. 722250030040 Ø pinion = 1.999 mm	 ref. 7222500B30040 Ø pinion = 1.999 mm	 ref. 7222500C30040 Ø pinion = 2.119 mm	 ref. 7222500D3004019 Ø pinion = 2.119 mm
Pallet fork	 Old shape ref. 722250040010	 Old shape ref. 7222500B40010	 New shape ref. 7222500C40010	
Pallet bridge	 ref. 72225001005707			 ref. 7222500D1005718
Screw for pallet bridge	 ref. 72225003511			 ref. 7222500D3587
Balance complete with stud	 ref. 72225004005021	 ref. 7222500B4005021	 ref. 7222500C4005021	 ref. 7222500D4005021
Diameter	8.54 mm	8.54 mm	8.70 mm	-----
Thickness of balance rim	0.37 mm	0.37 mm	0.45 mm	-----
Pivots	0.08 mm cylindric	0.08 mm cylindric	0.07 mm conical	-----
Incabloc	0.09 mm = Ø pivot hole	0.09 mm = Ø pivot hole	0.08 mm = Ø pivot hole	-----
Rate correction with 1 screw-revolution (On both screws)	57 seconds	57 seconds	86 seconds	-----
Stud support	 ref. 722250040200	 ref. 7222500B40200		-----
Oscillating weight	 ref. 72225002201006			 ref. 7222500D2201018
Stop lever	 ref. 722250056070	 ref. 722112056070	 ref. 7222500C56070	 ref. 7222500D56070









## Differences between version 2500A, 2500B, 2500C and 2500D

	2500A (4 Hz)	2500B (4 Hz)	2500C (3.5 Hz)	2500D (3.5 Hz)
Shock-absorber, balance bridge side	 ref. 722112070530	 ref. 722112070530	 ref. 7222500C70530	 ref. 7222500C70530
shock-absorber, main plate side	 ref. 722112070531	 ref. 722112070531	 ref. 7222500C70531	 ref. 7222500C70531
In setting, balance bridge side	 ref. 722112070640	 ref. 722112070640	 ref. 7222500C70640	 ref. 7222500C70640
In setting, main plate side	 ref. 722112070641	 ref. 722112070641	 ref. 7222500C70641	 ref. 7222500C70641

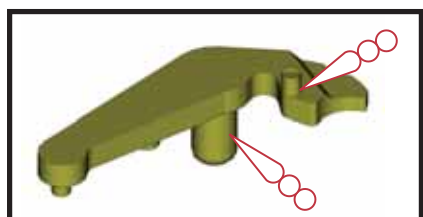
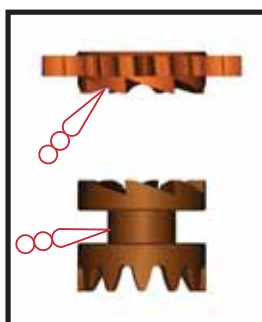
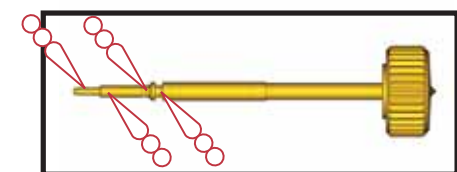



# Fitting stages for calibre 2500 - Assembling of mechanism 1


## 1.0 Parts for assembling

Movement holder	Winding pinion	Sliding pinion	Winding stem	Date corrector operating lever	Setting lever	Yoke	Setting lever jumper	Screw for setting lever jumper
Ref. 506 0117	①	②	③	④	⑤	⑥	⑦	⑧
	Ref. 31120	Ref. 311211	Ref. 5101021	Ref. 53022	Ref. 5108006	Ref. 51050	Ref. 51091	Ref. 3503
								
	-----	-----	-----	-----	-----	-----	-----	-----

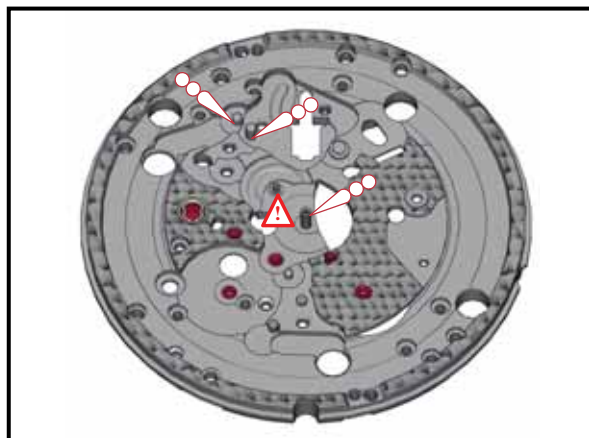
## 2.0 Pre-lubrication



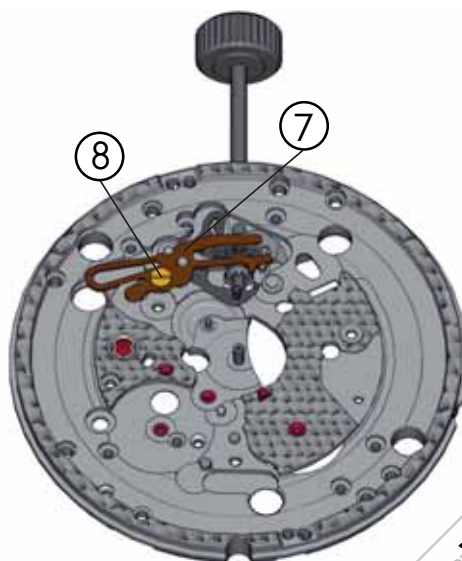
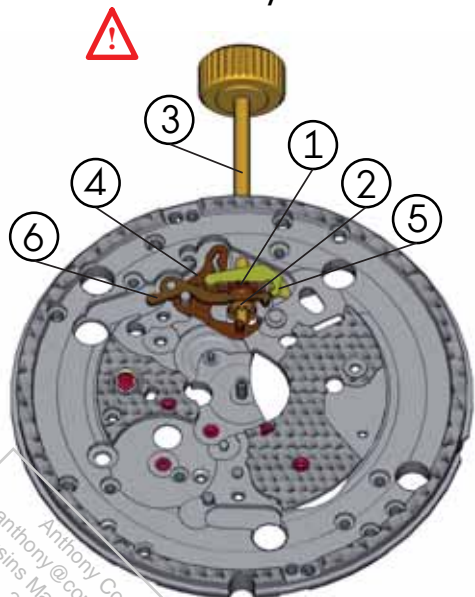
 Moebius SYNT-HP-1300 Sans Colorant

 The removal of the stem must always be in position 1

 Lubrication of centre tube:  
Please refer to [Working Instruction No 40](#)

















## 3.0 Order to assembly



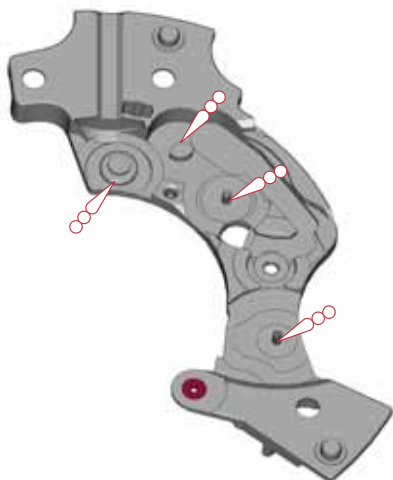
# Fitting stages for calibre 2500 - Pre-assembly of barrel bridge

## 1.0 Parts for assembling

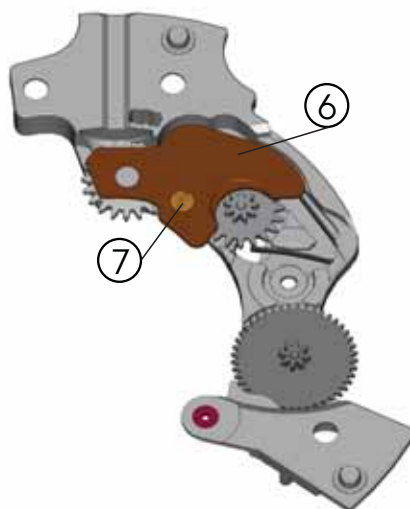
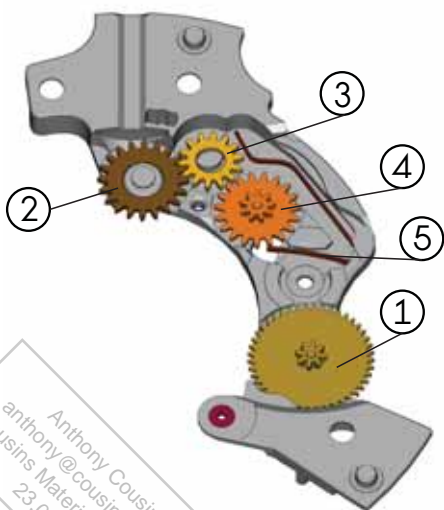
Movement holder	Ratchet wheel driving wheel	Crown wheel	Intermediate crown wheel	Intermediate ratchet wheel	Click	Click plate	Screw for click plate
Ref. 506 0117	①	②	③	④	⑤	⑥	⑦
	Ref. 32033	Ref. 31023	Ref. 31024	Ref. 31021	Ref. 51120	Ref. 81036	Ref. 3509
							
							

## 2.0 Pre-assembly

 Moebius SYNT HP-1300 Sans Colorant

















## 3.0 Order to assembly









# Fitting stages for calibre 2500 - Assembling of mechanism 3

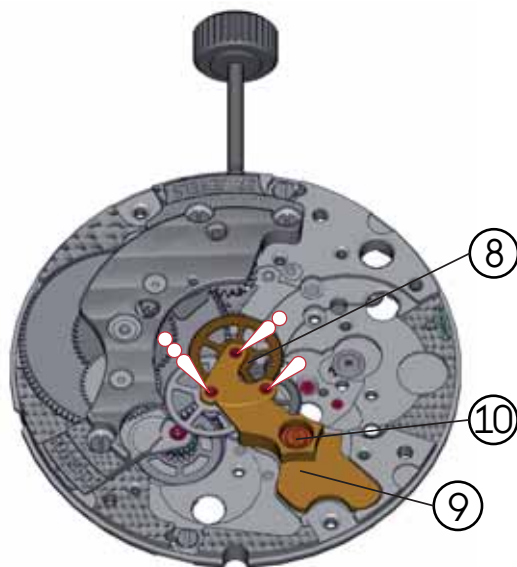
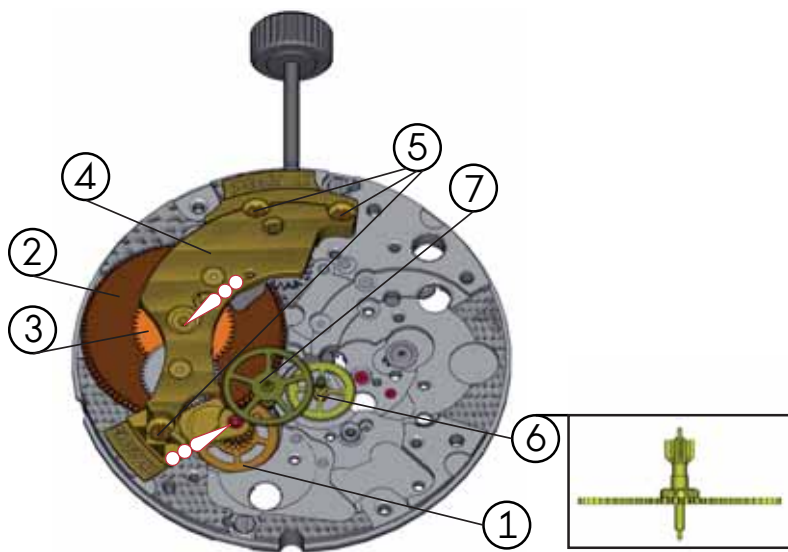
## 1.0 Parts for assembling

Movement holder	Intermediate wheel	Movement barrel complete	Ratchet wheel	Barrel bridge	Screw for barrel bridge	Intermediate escape wheel	Third wheel	Second wheel	Wheel train bridge	Screw for wheel train bridge
Ref. 506 0117	①	②	③	④	⑤	⑥	⑦	⑧	⑨	⑩
	Ref. 30012	Ref. 20010	Ref. 31020	Ref. 1004118	Ref. 3503	Ref. 30039	Ref. 30025	Ref. 30027*	Ref. 1004807	Ref. 3505
										
		-----	-----	-----	⌋				-----	⌋

## 2.0 Order to assembly











-  Moebius SYNT HP-1300 Sans Colorant
-  Moebius SYNT-A-LUBE 9010
-  Moebius SYNT HP-500

**Lubrication of the barrel:**  
 **Lubrication of the second wheel:**  
 Please refer to [Working Instruction No 40](#)



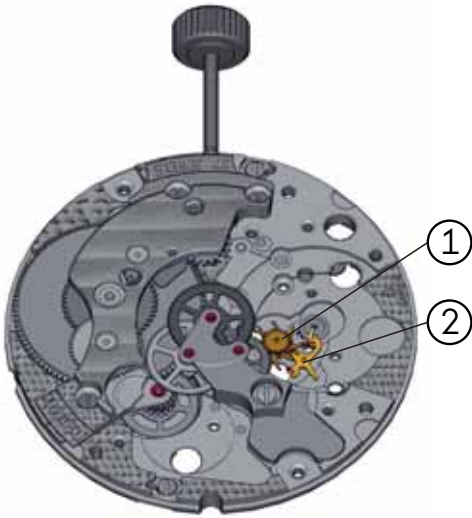
# Fitting stages for calibre 2500 - Assembling of mechanism 4

## 1.0 Parts for assembling

Movement holder	Co-Axial wheel	Pallet fork	Pallet bridge	Screw for Pallet bridge	Balance bridge	Screw for balance bridge	Stop lever
	①	②	③	④ + ⑤	⑥	⑦	⑧
	Ref. 3004019	Ref. 40010	Ref. 1005718	Ref. 3587	Ref. 1005818 + Ref. 4005021	Ref. 3503	Ref. 56070
Ref. 506 0117							
		-----	-----		-----		-----

## 2.0 Order to assembly

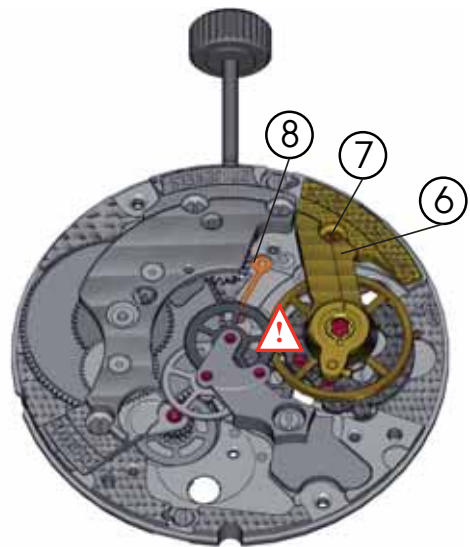
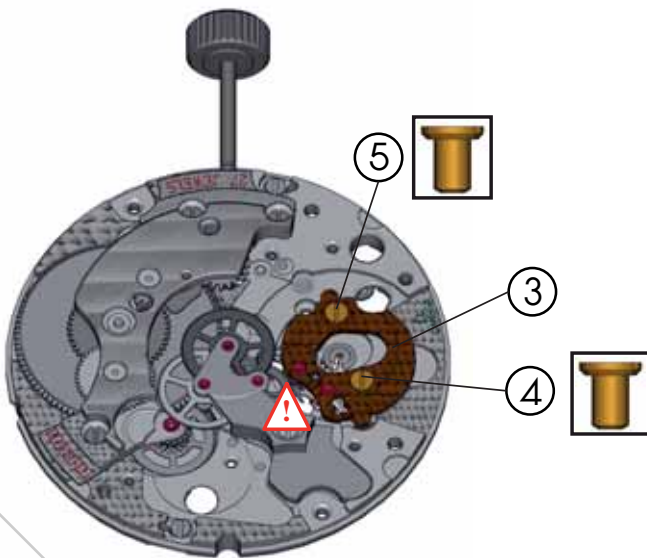
**Lubrication of shock-absorber:**  
**Lubrication of the escapement:**  
 Please refer to [Working Instruction No 40](#)












**⚠ Never touch the inside of the fork**

**Tighten the screw ④ which holds the pallet fork bridge in position.**

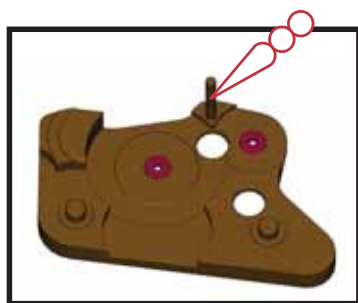
**⚠ Tighten the screw ⑤ which maintains the pallet fork bridge in position.**




1.0 Parts for assembling

Movement holder	Automatic device framework jewelled	Intermediate reduction wheel	Reduction wheel	Reversing wheel	Reverser	Automatic device lower bridge	Screw for automatic device lower bridge	Oscillating weight	Screw for oscillating weight
Ref. 506 0117	①	②	③	④	⑤	⑥	⑦	⑧	⑨
	Ref. 1203018	Ref. 32032	Ref. 32031	Ref. 32037	Ref. 52040	Ref. 1205107	Ref. 3504	Ref. 2201018	Ref. 3507
									
	-----	-----	-----	-----	-----	-----	-----	-----	-----

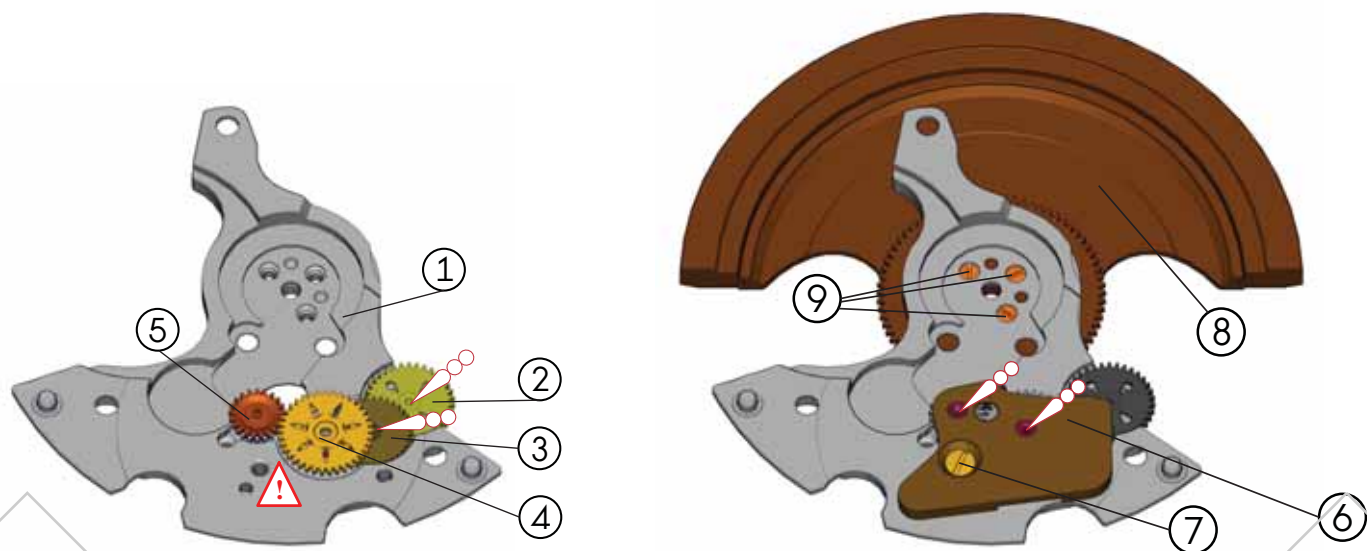
2.0 Pre-lubrication



 Moebius SYNT HP-1300 Sans Colorant

 **Reversing wheel lubrication (32037):**  
Please refer to [Working Instruction No 40](#)

3.0 Order to assembly










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# Fitting stages for calibre 2500 - Assembling of mechanism 6

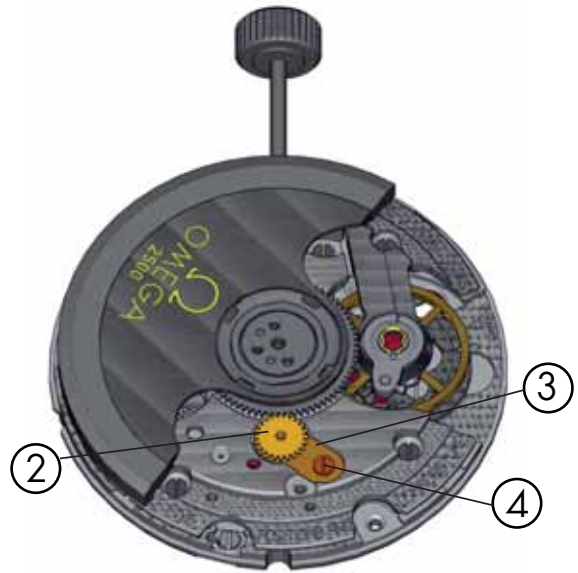
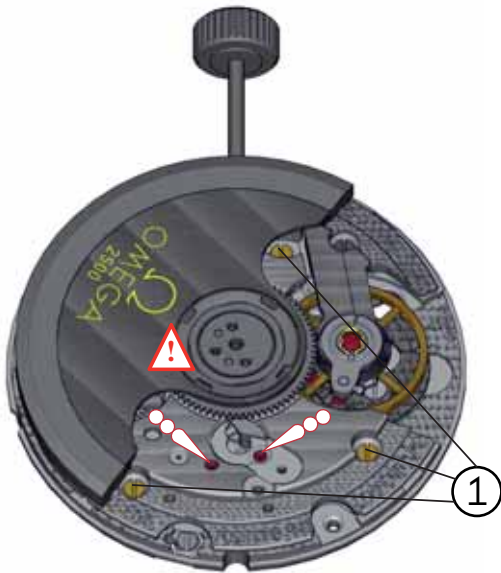
## 1.0 Parts for assembling

Movement holder	Screw for automatic device framework	Auxiliary reverser	Reverser maintaining plate	Screw for reverser maintaining plate
Ref. 506 0117	①	②	③	④
	Ref. 3503	Ref. 52041	Ref. 12124	Ref. 3506
				
			-----	











## 2.0 Order to assembly

 Moebius SYNT HP-1300 Sans Colorant




 **Lubrication of the ball bearing:**  
Please refer to [Working Instruction No 40](#)

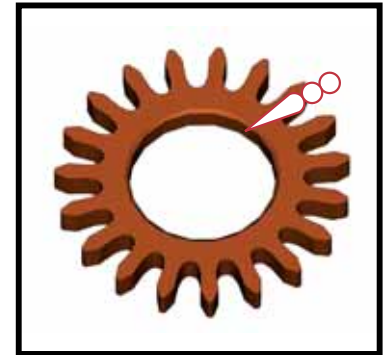
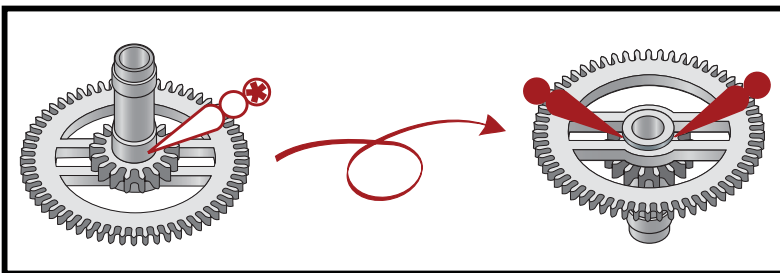
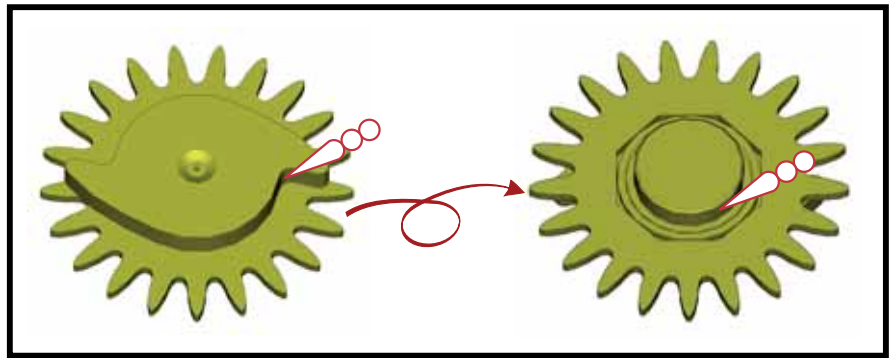
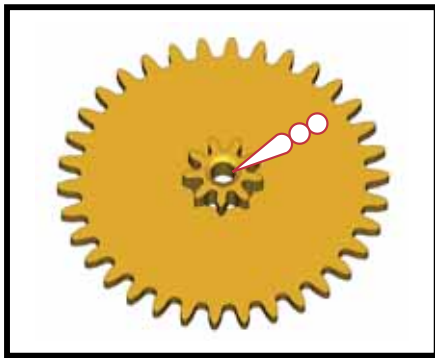


## 1.0 Parts for assembling

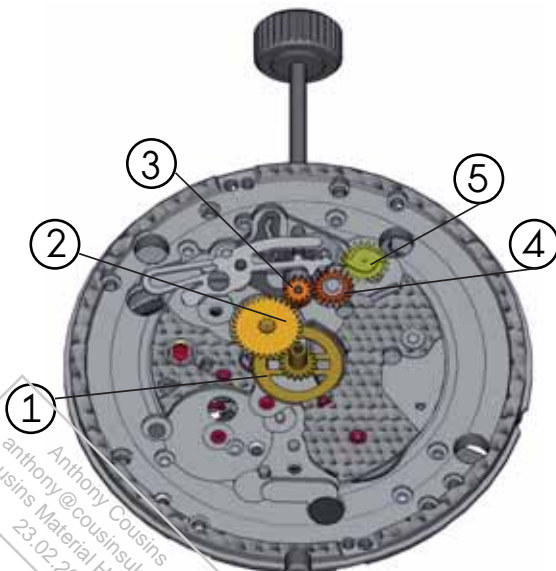
Movement holder	Cannon pinion with driving wheel	Minute wheel	Setting wheel	Intermediate setting wheel	Date corrector
Ref. 506 0117	①	②	③	④	⑤
	Ref. 31083*	Ref. 31041	Ref. 31100	Ref. 31101	Ref. 53200
					
					

## 2.0 Pre-lubrication

-  Moebius 9504
-  Moebius SYNT HP-1300 Sans Colorant
-  Moebius SYNT HP-1300 Sans Colorant



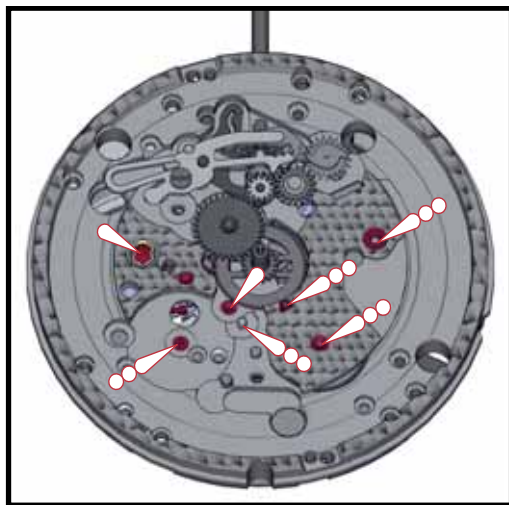
## 3.0 Order to assembly



## 1.0 Parts for assembling

Movement holder	Minute train bridge	Screw for minute train bridge	Date indicator driving wheel	Date indicator	Date jumper	Intermediate date wheel
Ref. 506 0117	①	②	③	④	⑤	⑥
	Ref. 10062	Ref. 3503	Ref. 33020	Ref. 91440***	Ref. 53080	Ref. 33011
	-----			-----	-----	

## 2.0 Pre-lubrication



- Moebius SYNT HP-1300 Sans Colorant
- Moebius SYNT-A-LUBE 9010








## 3.0 Order to assembly



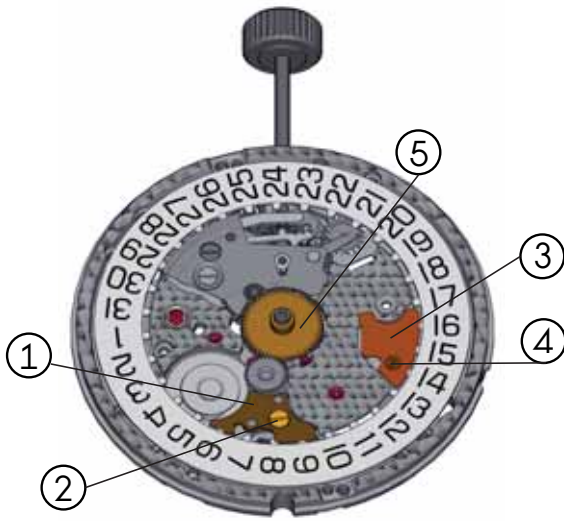
- After assembling of mechanism:
1. Lubricate the date jumper 53080.
  2. Turn the date indicator about ten teeth with the quick date correction.
  3. Lubricate the date jumper 53080 again.
  4. Turn the date indicator about ten teeth with the quick date correction.

# Fitting stages for calibre 2500 - Assembling of mechanism 9



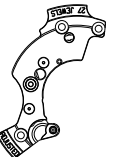




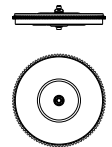

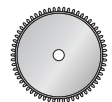




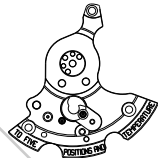

## 1.0 Parts for assembling

Movement holder	Date jumper maintaining plate	Screw for date jumper maintaining plate	Additional indicator maintaining small plate	Screw additional indicator maintaining small plate	Hour wheel
Ref. 506 0117	①	②	③	④	⑤
	Ref. 13111	Ref. 3503	Ref. 53251	Ref. 3508	Ref. 31046***
					
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## 2.0 Order to assembly











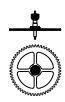

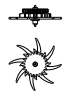







## Spare parts list for Calibre 2500

















Main plate, jewelled, pre-assembled	Version	Reference	Lower automatic bridge	Version	Reference
	2500A	72225001002007		2500A	72211201205107
	2500B	7222500B1002007			
	2500C	7222500C1002007			
	2500D	<b>7222500D1002007</b>			
Barrel bridge, pre-assembled	Version	Reference	Reverser maintaining plate	Version	Reference
	2500A	72225001004107		2500A	722112012124
	2500B	7222500B1004107 <b>7222500B10041N</b>			
	2500C	7222500C1004107			
	2500D	<b>7222500D1004118</b>			
Wheel train bridge, jewelled	Version	Reference	Date jumper maintaining plate	Version	Reference
	2500A	72225001004807		2500A	722112013111
	2500B	7222500B1004807			
	2500C				
	2500D	<b>7222500D1004807</b>			
Pallet bridge, pre-assembled	Version	Reference	Barrel complete	Version	Reference
	2500A	72225001005707		2500A	722112020010
	2500B			7222500B20010	
	2500C			722112020010	
	2500D	<b>7222500D1005718</b>		2500D	<b>7222500D20010</b>
Balance bridge, pre-assembled	Version	Reference	Barrel drum and cover	Version	Reference
	2500A	72225001005824		2500A	722112020030
	2500B	7222500B1005824 <b>7222500B10058N</b>			
	2500C	7222500C1005824			
	2500D	<b>7222500D1005818</b>			
Minute train bridge	Version	Reference	Barrel arbor	Version	Reference
	2500A	722112010062		2500A	722112020060
	2500B				
	2500C				
	2500D				
Dial fastener	Version	Reference	Mainspring	Version	Reference
	2500A	722112010300		2500A	722112020102
	2500B			7222500B20102	
	2500C			722112020102	
	2500D			<b>7222500D20102</b>	
Upper automatic bridge	Version	Reference	Oscillating weight, pre-assembled	Version	Reference
	2500A	72211201203007		2500A	72225002201006
	2500B	7222500B1203007			
	2500C				
	2500D	<b>7222500D1203018</b>		2500D	



## Spare parts list for Calibre 2500
















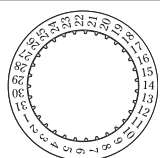
Ball bearing	Version	Reference	Crown wheel	Version	Reference
	2500A	722112022040		2500A	722112031023
	2500B				
	2500C				
	2500D				
Oscillating weight bolt	Version	Reference	Intermediate crown wheel	Version	Reference
	2500A	722112022042		2500A	722112031024
	2500B				
	2500C				
	2500D				
Intermediate wheel	Version	Reference	Minute wheel	Version	Reference
	2500A	722112030012		2500A	722112031041
	2500B				
	2500C				
	2500D				
Third wheel	Version	Reference	Hour wheel	Version	Reference
	2500A	722112030025		2500A	7221120310046***
	2500B				
	2500C				
	2500D				
Second wheel	Version	Reference	Cannon pinion with driving wheel	Version	Reference
	2500A	722112030027*		2500A	722112031083**
	2500B				
	2500C	7222500C30027*			
	2500D				
Intermediate escape wheel	Version	Reference	Setting wheel	Version	Reference
	2500A	722250030039		2500A	722112031100
	2500B	7222500B30039			
	2500C	7222500C30039			
	2500D	7222500D30039			
Co-Axial wheel	Version	Reference	Intermediate setting wheel	Version	Reference
	2500A	722250030040		2500A	722112031101
	2500B	7222500B30040			
	2500C	7222500C30040			
	2500D	7222500D3004019			
Ratchet wheel	Version	Reference	Winding pinion	Version	Reference
	2500A	722112031020		2500A	722112031120
	2500B				
	2500C				
	2500D				
Intermediate ratchet wheel	Version	Reference	Sliding pinion	Version	Reference
	2500A	722112031021		2500A	7221120311211
	2500B				
	2500C				
	2500D				

## Spare parts list for Calibre 2500

Reduction wheel	Version	Reference	Stud support	Version	Reference
	2500A	722112032031		2500A	722250040200
	2500B			2500B	7222500B40200
	2500C			2500C	
	2500D			2500D	
Intermediate reduction wheel	Version	Reference	Winding stem	Version	Reference
	2500A	722112032032		2500A	72211205101021
	2500B			2500B	
	2500C			2500C	
	2500D			2500D	
Ratchet wheel driving wheel	Version	Reference	Yoke	Version	Reference
	2500A	722112032033		2500A	722112051050
	2500B			2500B	
	2500C			2500C	
	2500D			2500D	
Reversing wheel	Version	Reference	Setting lever	Version	Reference
	2500A	722112032037		2500A	72211205108006
	2500B			2500B	
	2500C			2500C	
	2500D			2500D	
Intermediate date wheel	Version	Reference	Combined setting lever jumper	Version	Reference
	2500A	722112033011		2500A	722112051091
	2500B			2500B	
	2500C			2500C	
	2500D			2500D	
Date indicator driving wheel	Version	Reference	Click	Version	Reference
	2500A	722112033020		2500A	722112051120
	2500B			2500B	
	2500C			2500C	
	2500D			2500D	
Pallet fork	Version	Reference	Reverser	Version	Reference
	2500A	722250040010		2500A	722112052040
	2500B	7222500B40010		2500B	
	2500C	7222500C40010		2500C	
	2500D			2500D	
Balance complete with stud	Version	Reference	Auxiliary reverser	Version	Reference
	2500A	72225004005021		2500A	722112052041
	2500B	7222500B4005021		2500B	
	2500C	7222500C4005021		2500C	
	2500D	<b>7222500D4005021</b>		2500D	



## Spare parts list for Calibre 2500

Date corrector operating lever	Version	Reference	In setting, main plate	Version	Reference
	2500A	722112053022		2500A	722112070641
	2500B				
	2500C				
	2500D				
Date jumper	Version	Reference	Cap jewels, balance bridge side	Version	Reference
	2500A	722112053080		2500A	722112070900
	2500B				
	2500C				
	2500D				
Date jumper	Version	Reference	Cap jewels, main plate side	Version	Reference
	2500A	722112053200		2500A	722112070901
	2500B				
	2500C				
	2500D				
Additional indicator maintaining small plate	Version	Reference	Shock-absorber spring, balance bridge side	Version	Reference
	2500A	722112053251		2500A	722112078004
	2500B				
	2500C				
	2500D				
Stop lever	Version	Reference	Shock-absorber spring, main plate side	Version	Reference
	2500A	722250056070		2500A	722112078005
	2500B				
	2500C	7222500B56070			
	2500D	7222500D56070			
Shock-absorber, balance bridge side	Version	Reference	Centre tube	Version	Reference
	2500A	722112070530		2500A	722112080400
	2500B				
	2500C	7222500C70530			
	2500D				
Shock-absorber, main plate side	Version	Reference	Click plate	Version	Reference
	2500A	722112070531		2500A	722112081036
	2500B				
	2500C	7222500C70531			
	2500D				
In setting, balance bridge side	Version	Reference	Date indicator	Version	Reference
	2500A	722112070640		2500A	722250091440***
	2500B				
	2500C	7222500C70641			
	2500D				





\* Only working winding stem! For the correct reference, use the Extranet with the reference of the watch.





## Spare parts list for Calibre 2500

Screw for barrel bridge	Version	Reference	Screw for reverser maintaining plate	Version	Reference
▼	2500A	72211203503	▼	2500A	72211203506
	2500B				
	2500C				
	2500D				
Screw for setting lever jumper	Version	Reference	Screw for ball bearing	Version	Reference
▼	2500A	72211203503	▼	2500A	72211203507
	2500B				
	2500C				
	2500D				
Screw for date jumper maintaining plate	Version	Reference	Screw for additional indicator maintaining small plate	Version	Reference
▼	2500A	72211203503	▼	2500A	72211203508
	2500B				
	2500C				
	2500D				
Screw for balance bridge	Version	Reference	Screw for click plate	Version	Reference
▼	2500A	72211203503	▼	2500A	72211203509
	2500B				
	2500C				
	2500D				
Screw for minute train bridge	Version	Reference	Screw for stud	Version	Reference
▼	2500A	72211203503	▼	2500A	72225003512
	2500B				
	2500C				
	2500D				
Screw for automatic device framework	Version	Reference	Screw for pallet bridge	Version	Reference
▼	2500A	72211203503	▼	2500A	72225003511
	2500B				
	2500C				
	2500D				
Screw for automatic device lower bridge	Version	Reference			
▼	2500A	72211203504			
	2500B				
	2500C				
	2500D				
Screw for pallet fork bridge	Version	Reference			
▼	2500A	72211203504			
	2500B				
	2500C				
	2500D				

## Modifications of Technical Guide for Calibre 2500

Technical Guide versions			
Date of first edition:	01.07.1999	Version A	Made by:  Selrom  Rendav  Selrom
Date of second edition:	01.05.2001	Version B	
Date of third edition:	07.07.2004	Version C	
Date of fourth edition:	27.07.2010	Version D	
Date of fifth edition:	13.10.2010	Version E	
Date of sixth edition:	04.04.2011	Version F	
Date of seventh edition:	03.05.2011	Version G	
Date of last edition:	29.09.2011	Version H	

Modifications of Technical Guide version G					
Old (version F)			New (version G)		
Stop lever	Version	Reference	Stop lever	Version	Reference
	2500A	722250056070		2500A	722250056070
	2500B			2500B	
	2500C	7222500B56070		2500C	7222500C56070
	2500D	7222500D56070		2500D	7222500D56070
In setting, balance bridge side	Version	Reference	In setting, balance bridge side	Version	Reference
	2500A	722112070640		2500A	722112070640
	2500B			2500B	
	2500C	7222500C70641		2500C	7222500C70640
	2500D			2500D	

Modifications of Technical Guide version H					
Old (version G)			New (version H)		
Wheel train bridge, jewelled	Version	Reference	Wheel train bridge, jewelled	Version	Reference
	2500A	72225001004807		2500A	72225001004807
	2500B	7222500B1004807		2500B	7222500B1004807
	2500C			2500C	
	2500D	7222500D1004818		2500D	7222500D1004807
Co-Axial wheel in LIGA	Version	Reference	Co-Axial wheel	Version	Reference
	2500A	722250030040		2500A	722250030040
	2500B	7222500B30040		2500B	7222500B30040
	2500C	7222500C30040		2500C	7222500C30040
	2500D	7222500D3004019		2500D	7222500D3004019
All the components that are mentioned in red.					