

**CALIBRE**  
**625**  
**17.5 T1 PC 17 Jewels**

<p>∅ 17.50 mm</p>	
<p>Height</p>	<p>2.50 mm</p>
<p>Power-reserve Jewel number Frequency Angle of lift of balance Thread diameter of winding stem</p>	<p>41 h 17 21'600 A/h 52° 0.90 mm</p>



modernisation of production methods compels us to hold a constantly changing conception of our calibres. The stability of the new machines allows manufacture of parts never possible to realise previously, though not without imposing new limits which lead us to transform existing movements. In this way, calibre 625 replaces calibre 620. It is a new movement whose parts are not interchangeable with the former one. Alone the exterior dimensions remain unchanged. As far as technical performance is concerned, this has been improved to a marked extent by increase of the frequency and maximalisation of the organs.

## ASSEMBLING

Op. No.	Order of operations	Part No.	Fixing device	Lubrication		Remarks
				point	code	
1.0. WHEEL TRAIN						
1.1.	escape wheel	1305				
1.2.	fourth wheel	1243				
1.3.	third wheel	1240				
1.4.	barrel	1200		bearings drum + cover	1.00	the spring is self-lubricated
1.5.	center wheel	1216				
1.6.	3/4 plate bridge	1002	3 screws 2385			see 1.6.0.
1.7.	check end-shakes					0,02 to 0,05 mm
2.0. LUBRICATION						
2.1.	escape wheel			lower jewel	1.02	
2.2.	fourth wheel			lower jewel	1.02	
2.3.	third wheel			lower jewel	1.07	
2.4.	barrel			lower pivot	1.00	
2.5.	center wheel			lower jewel	1.07	
2.6.	escape wheel			upper jewel	1.02	
2.7.	fourth wheel			upper jewel	1.02	
2.8.	third wheel			upper jewel	1.07	
2.9.	barrel			upper pivot	1.00	
2.10.	center wheel			upper jewel	1.07	
3.0. MECHANISM						
3.1.	cannon pinion	1218		center pinion stem	1.07	see 7.1.0.
3.2.	winding pinion	1108		Breguet	1.00	
3.3.	clutch wheel	1107				
3.4.	winding stem	1106	pressure lever	square + pivot	1.00	
3.5.	setting lever	1109		function	1.00	
3.6.	yoke	1111				
3.7.	setting wheel	1113		pivoting	1.00	bevel, underneath
3.8.	minute wheel	1246		pivoting	1.00	
3.9.	yoke apring	1112		active-point	1.00	
3.10.	setting lever spring	1110	2 screws 2385	notches	1.00	
3.11.	incabloc in-setting and cap jewel for balance, lower	1341 1342		cap jewel	1.00	
4.0. WINDING WHEEL UPPER						
4.1.	crown wheel	1101				
4.2.	crown wheel core	1102	1 screw 2559	exterior	1.00	
4.3.	click	1104	1 screw 2559			
4.4.	click spring	1105				
4.5.	ratchet wheel	1100	1 screw 2216			
5.0. ESCAPEMENT						
5.1.	pallet fork	1316		pallets	1.06	
5.2.	pallet cock	1005	2 screws 2187			
5.3.	check end-shakes					0,01 to 0,03 mm
6.0. ADJUSTMENT						
6.1.	regulator assembly					see 6.1.0.
6.2.	incabloc in-setting and cap jewel for balance, upper	1341 1343		cap jewel	1.02	
6.3.	fix balance to balance cock		1 screw 2595			see 6.3.0.
6.4.	balance cock mounted		1 screw 2385			
6.5.	check end-shakes					0,01 to 0,03 mm
6.6.	hairspring-setting					
7.0. EXTERIOR						
7.1.	hour wheel	1231				see 7.1.0.
7.2.	dial					see 7.2.0.
7.3.	hands					
7.4.	casing-up					position of fixing clamps different to that for cal.620

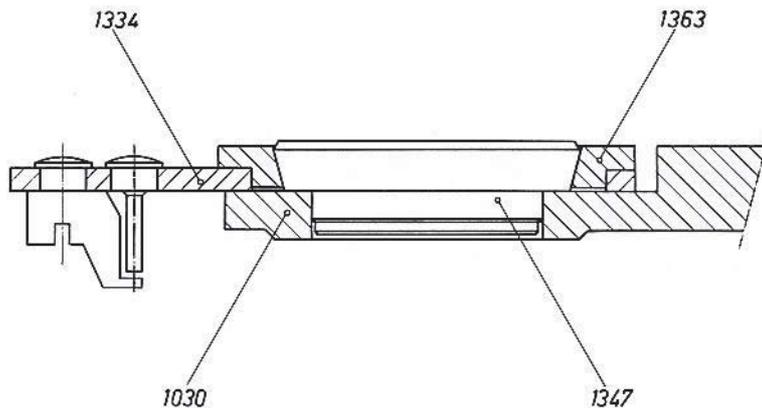
### 1.6.0.

This movement possesses one bridge only which covers both the wheel train and barrel.

Fitting of this part is easily effected; the very low-placed center of gravity of the wheels causes the pinions to be perpendicular to the plate prior to fitting of the bridge.

### 6.1.0. REGULATOR ASSEMBLY

Shocks to which the movements are submitted sometimes result in displacement of the regulator. The fixing principle adopted for the regulator assembly in this caliber has the advantage of increasing the contact surfaces, producing a lateral grip as well as a new vertical grip. Friction thus being increased, the risks of accidental displacement of the regulator are considerably reduced.

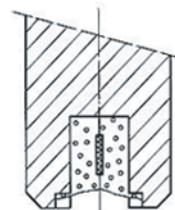
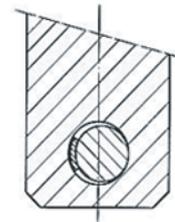


### 6.3.0. PINNING-UP TO THE STUD

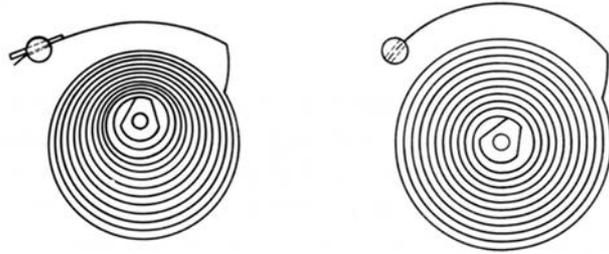
The modern method which consists in fixing the hairspring to the stud by glueing provides two major advantages as far as quality of adjustment is concerned:

A blade fixed by means of a pin is deformed in its section; obliged to follow the curve of the hole, it no longer offers the initial physical conditions at the point where imbedded.

The glueing process, on the contrary fixes the hairspring with care and constitutes an ideal setting point.



The blade of the hairspring is not subjected to any mechanical coercion during the glueing operation. Having thus retained its natural position, the hairspring maintains both its flat and centering without any correction being necessary.



H0



H1



H2

**7.1.0.**

Indication of the hand-fitting height is found on the hour wheel; circular grooves are made on its top, and the number of these grooves designates the respective hand-fitting height.

**7.2.0.**

The dial holders consist of pieces of plastic driven onto the dial feet. Their special shape produces a grip when the feet are inserted in the holes of the plate.

