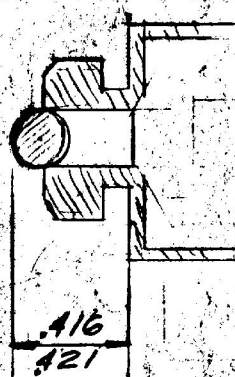


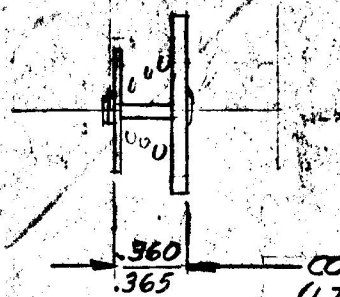
①

HOUSING AND BALL SUB-ASSY



TOOL # B-25-11
GAGE # 9088A-1

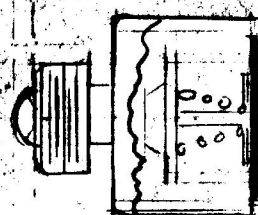
②



CONTROLLED AT
(1 TON) HYDR.

TOOL # R-23-5

③



SIZE WITH GASKET IN
PLACE ON TON HYDR.
2000 LBS. PRESSURE

TOOL # 5-24-4

— NOTES —

① SIZING OPERATION - (SKETCH 3) IS CONTROLLING INFLUENCE TO INSURE ACCURATE CONTACT POSITION AND WASHES OUT MFG. TOLERANCES OF MOST COMPONENTS.

③ AT EACH PRODUCTION RUN PILOT LOTS SHOULD BE SIZED, FINAL CLOSED AND TESTED TO ASSURE COMPLIANCE WITH CONTACT TOLERANCE - ADJUSTMENTS TO HYDRAULIC PRESSURE AND SIZING TOOL MAY BE AT TIMES ADVISABLE.

④ FINAL CLOSING TOOL SHOULD BE SET AT 2000 LBS AND SHOULD RESULT IN APPROX. 80% GOOD AND 20% "NO LITE" - THOSE IN CATEGORY OF "NO LITE" CAN THEN BE RESTRUCK AT 3500 LBS.

⑤ CHECK ALL PARTS AND SUB-ASSEMBLIES TO DWGS. AVAILABLE BEFORE ASSY OPERATIONS, SEE DWG NO'S LISTED ON THIS SHEET.

— OPERATIONS —

9242

1- ASSEMBLE 9088-2 BALL TO 9088A-1 HOUSING & SIZE AND TRAY. SEE SKETCH #1 GAGE #A16-A21
TOOL # B-25-11

DWG #	QTY
9088A-101	1
9133-101	1

2- ASSEMBLE 9146-103 CONTACT ASSY. # 9146-9 EYELET, 9146-8 CONTACT AND TRAY HYDR. (1 TON) - SEE SKETCH #2
TOOL #

9146-103	1
9242-101	1
9242-102	1
9088A-1	1

3- ASSEMBLE # 97050 - ① OIL SEAL TO # 9088A-3 SHAFT # O-N-J PRESS
TOOL # B-25-11

9088B-2	1
BB526	1
9088A-25	1

4- ASSEMBLE 9088A-101 OIL SEAL & SHAFT ASSY # 9088A-25 CUP # BB526 WASHER INSULATOR AND CONTACT ASSY AND 9162-16 GASKET AND TRAY.

9162-16	1
9088A-3	1
97050 ①	1
9088-19	1
9146-8	1

5- SIZE ABOVE ASSY HYDR. (6 TONS)
TOOL # 5-24-4 AND TRAY

9146-9	1
BB525	1
9088-20	1

6- ASSEMBLE # 9088A-26 SPRING # 9133-101 TERM. INSULATOR ASSY TO ABOVE ASSY AND CLOSE

9146-10	1
BB526	1

HYDR. (6 TONS) TOOL # K24-14

7- CIRCUIT TEST

FIXTURE #

LET	WAS	DATE	BY	LET	WAS	DATE	BY	MATERIAL	DRAWN	CHECKED	APPR'D	SCALE	USED ON	DATE DRAWN
										✓				2-4-60
								FINISH	COLE-HERSEE COMPANY					DATE ISSUED
									BOSTON 27, MASS., U.S.A.					
								TOLEPANCES FRACTIONAL ± DECIMAL ±	NAME					PART NO.
				A	9088A-24	13437	5-1-63	3	ASSEMBLY PROCEDURES					9242