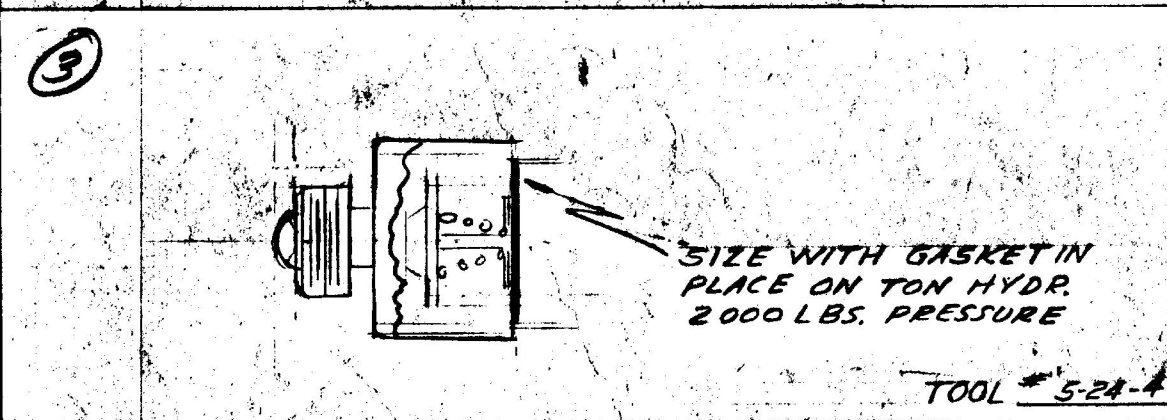
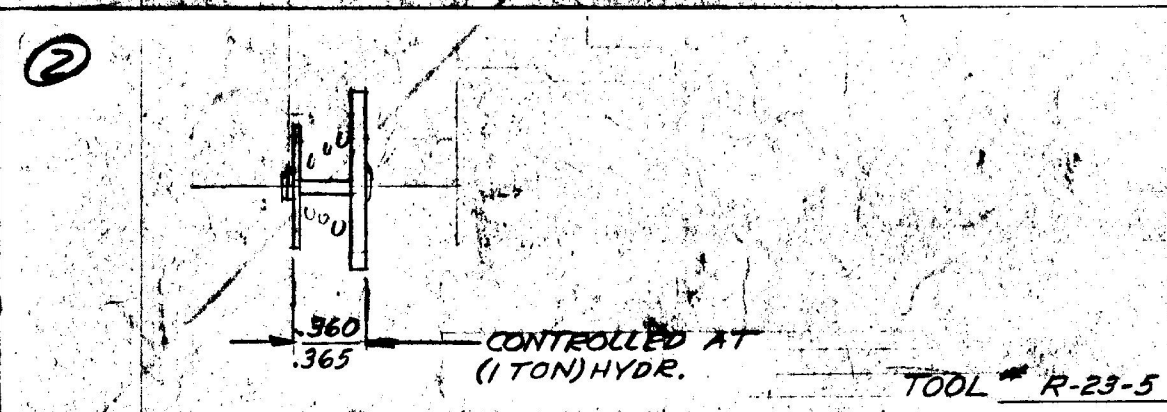
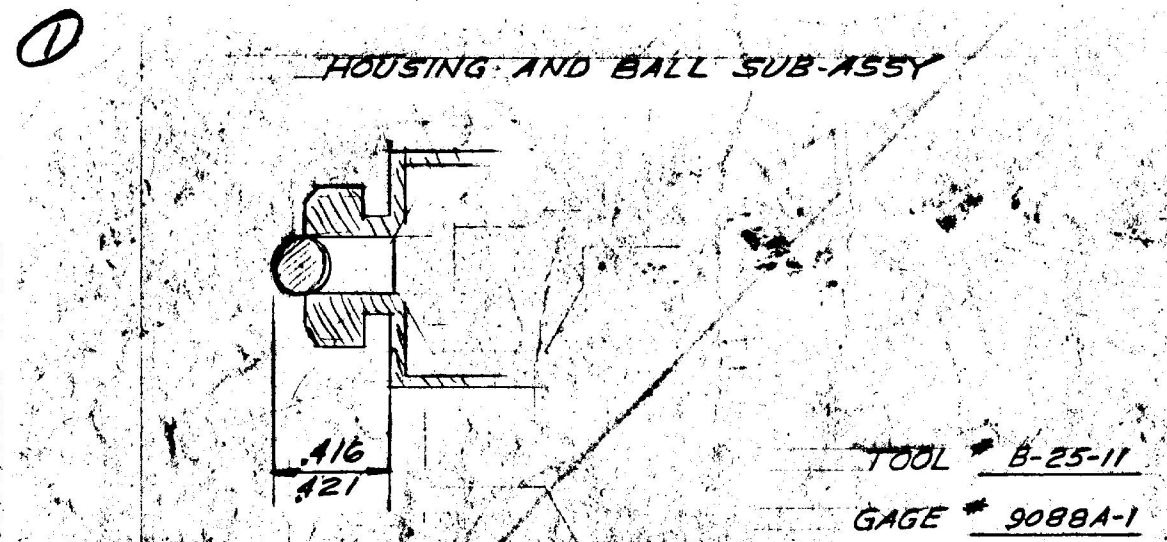




— NOTES —

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

② 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.

③ 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.

④ 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	DWG #	9088A-101
TOOL # B-25-11		9133-101
2- ASSEMBLE 9146-103 CONTACT ASSY. # 9146-9 EYELET, 9146-8 CONTACT AND TRAY. HYDR. (1 TON) SEE SKETCH #2		9146-103
TOOL #		9242-101
		9242-102
3- ASSEMBLE # 97050 - ① OIL SEAL TO # 9088A-3 SHAFT # O-N-J PRESS		9088A-1
TOOL # B-25-11		9088-2
		88526
		9088A-25
4- ASSEMBLE 9088A-101 OIL SEAL & SHAFT ASSY # 9088A-25 CUP # 88526 WASHER INSULATOR AND CONTACT ASSY AND 9162-16 GASKET AND TRAY.		9162-16
		9088A-3
		97050 ①
		9088-19
		9146-8
5- SIZE ABOVE ASSY HYDR. (6 TONS) TOOL # 5-24-4 AND TRAY		9146-9
		88525
		9088-20
6- ASSEMBLE # 9088A-26 SPRING # 9133-101 TERM. INSULATOR ASSY TO ABOVE ASSY AND CLOSE HYDR. (6 TONS) TOOL # K24-14		9146-10
		88526
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						DATE ISSUED
								TOLEANCES						PART NO.
								FRACTIONAL ±						9242
								DECIMAL ±						

COLE-HERSEE COMPANY
BOSTON 27, MASS., U.S.A.

ASSEMBLY PROCEDURES