**ASSEMBLY NOTES:**

- **USE PARKER O-LUBE ON ALL O-RINGS AND MATING SURFACES UNLESS OTHERWISE NOTED.**
- **USE PERMABOND LM113 OR LOCTITE 222.**
- **USE LUBRIPLATE LOW-TEMP GREASE.**
- **USE PERMABOND LH011 OR LOCTITE 592.**
- **INSTALL SENSOR WITH POTTED SIDE TOWARDS WATERWAY.**
- **TORQUE SET SCREWS 14 TO 17 IN-LBS.**
- **ALIGN TIMING DIMPLE ON BOTH JOINTS PRIOR TO INSTALLING POSITION SENSORS. ADJUST SENSOR OUTPUT TO 2.50 ± 0.01 V.**
- **ASSEMBLE WITH ROUNDED EDGES OF RETAINING RING TOWARDS WASHERS.**
- **USE PERMABOND HH120 OR LOCTITE 277.**
- **ASSEMBLE ROUNDED EDGES OF RETAINING RING TOWARDS WATERWAY.**
- **ALIGN TIMING MARK TO THE FLAT ON THE SHAFT.**
- **ALIGN THE FLAT ON THE SHAFT TOWARDS THE SLOT ON ITEM 3 AFTER THE TIMING MARKS ARE ALIGNED.**
- **ASSEMBLE WITH LABEL SIDE POINTING UP AS SHOWN.**
- **THROUGHLY COAT SOCKETS FOR FEEDBACK SHAFTS WITH NEVER SEEZ MARINERS CHOICE.**
- **AS SPECIFIED.**

**ASSEMBLY NUMBER ANGLE OF ROTATION STOP LOCATIONS**

<table>
<thead>
<tr>
<th>ASSEMBLY NUMBER</th>
<th>ANGLE OF ROTATION</th>
<th>STOP LOCATIONS</th>
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<tbody>
<tr>
<td>33512100</td>
<td>±45°</td>
<td>PT1, PT5</td>
</tr>
<tr>
<td>33512200</td>
<td>±45°</td>
<td>PT1, PT5</td>
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<td>ALL OTHER LOCATIONS</td>
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**TECHNICAL SERVICE PARTS**

**STYLE 3351**

**PRODUCT TUCKAWAY RHINO W/SENSORS**

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**SHORT GEARBOX ADAPTER ORIENTATION**

**LONG GEARBOX ADAPTER ORIENTATION**

**ASSEMBLY NOTES:**
- Use Parker O-Lube on all O-rings and mating surfaces unless otherwise noted.
- Use Permabond LM113 or Loctite 222.
- Use LubePlate Low-Temp Grease.
- Use Permabond LH050 or Loctite 592.
- Install sensor with potted side toward waterway.
- Torque set screws 14 to 17 in-lbs.
- Align timing dimple on both joint's prior to installing position sensors. Adjust sensor output to 2.50 ± 0.01 V.
- Assemble with rounded edges of retaining ring towards washers.
- Use Permabond H1120 or Loctite 277.
- Assemble rounded edges of retaining ring towards waterway.
- Align timing mark to the flat on the shaft.
- Align the flat on the shaft towards the slot on item 3 after the timing marks are aligned.
- Assemble with label side pointing up as shown.
- Thoroughly coat sockets for feedback shafts with Never Seez Mariners choice.
- As specified.

**TECHNICAL SERVICE PARTS**

**STYLE 3351**

**PRODUCT TUCKAWAY RHINO W/SENSORS**

**ELEVATION STOP (ITEM 21) LOCATIONS**

**ASSEMBLY NUMBER** | **ANGLE OF ROTATION** | **STOP LOCATIONS**
--- | --- | ---
33512100 | 45° | PT A, PT C
33512200 | 45° | PT A, PT C
ALL OTHER LOCATIONS (ITEM 20)
PHONE: 330.264.5678 or 800.228.1161 I FAX: 330.264.2944 or 800.531.7335 | www.akronbrass.com

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ASSEMBLY NOTES:
- USE PARKER O-LUBE ON ALL O-RINGS AND MATING SURFACES UNLESS OTHERWISE NOTED.
- USE PERMABOND LM113 OR LOCTITE 222.
- USE LUBRPLATE LOW-TEMP GREASE.
- USE PERMABOND LH050 OR LOCTITE 592.
- INSTALL SENSOR WITH POTTED SIDE TOWARDS WATERWAY.
- TORQUE SET SCREWS 14 TO 17 IN-LBS.
- ALIGN TIMING Dimple ON BOTH JOINTS PRIOR TO INSTALLING POSITION SENSORS. ADJUST SENSOR OUTPUT TO 2.50 ± 0.01 V.
- ASSEMBLE WITH ROUNDED EDGES OF RETAINING RING TOWARDS WASHERS.
- USE PERMABOND HH120 OR LOCTITE 277.
- ASSEMBLE ROUNDED EDGES OF RETAINING RING TOWARDS WATERWAY.
- ALIGN TIMING MARK TO THE FLAT ON THE SHAFT.
- ALIGN THE FLAT ON THE SHAFT TOWARDS THE SLOT ON ITEM 3 AFTER THE TIMING MARKS ARE ALIGNED.
- ASSEMBLE WITH LABEL SIDE POINTING UP AS SHOWN.
- THROUGHLY COAT SOCKETS FOR FEEDBACK SHAFTS WITH NEVER SEEZ MARINERS CHOICE.
- AS SPECIFIED.

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**Find Part List Sheet: 33512100**

**Chg. Date 04-03-14**

**Parts List Sheet: 122584**