TECHNICAL SERVICE PARTS

STYLE 3463

PRODUCT: FIREFOX 2.5" INLET W/POSITION SENSORS

ASSEMBLY NOTES:
- USE PARKER O-LUBE ON ALL O-RINGS AND MATING SURFACES UNLESS OTHERWISE NOTED.
- USE PERMABOND LM113 OR LOCTITE 222.
- USE PRIMER T AND PERMABOND HH120 OR LOCTITE 277.
- USE LOW-TEMP LUBRIPLATE.
- DIMPLE AT ASSEMBLY.
- THOROUGHLY COAT WITH NEVER SEEZ MARINERS CHOICE.
- USE PERMABOND LH050 OR LOCTITE 592.
- USE LOCTITE 290.
- GENERAL DEPICTION SEE BILL OF MATERIAL.
- ALIGN BALL IN HOLE. TIGHTEN PLUG UNTIL TOUCHES BALL. THEN BACK OUT PLUG 1/4-1/2 TURN.
- TORQUE SET SCREWS 14 TO 17 IN-LBS.
- ALIGN TIMING Dimple on BOTH JOINTS PRIOR TO INSTALLING POSITION SENSORS. ADJUST SENSORS OUTPUT TO 2.50 ± 0.01 V.
- ASSEMBLE WITH ROUNDED EDGES OF RETAINING RING TOWARDS WASHERS (ITEM 113).
- ALIGN TIMING MARK TO THE FLAT OF THE SHAFT.
- ALIGN THE TIMING MARK TO THE STOP ON ELEVATION JOINT TO TIGHTEN THE SET SCREWS ON ITEM 122.
- INSTALL SET SCREW FLUSH WITH CASTING OD.

WARRANTY AND DISCLAIMER*: We warrant Akron Brass products for a period of five (5) years after purchase against defects in materials and workmanship. Akron Brass will repair or replace product which fails to satisfy this warranty. Repair or replacement shall be at the discretion of Akron Brass. Products must be promptly returned to Akron Brass for warranty service. We will not be responsible for: wear and tear; any improper installation, use, maintenance or storage; negligence of the owner or user; repair or modification after delivery; failure to follow our instructions or recommendations; or anything else beyond our control. WE MAKE NO WARRANTIES, EXPRESS OR IMPLIED, OTHER THAN THOSE INCLUDED IN THIS WARRANTY STATEMENT, AND WE DISCLAIM ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE. Further, we will not be responsible for any consequential, incidental or indirect damages (including, but not limited to, any loss of profits) from any cause whatsoever. No person has authority to change this warranty. *Unless otherwise provided herein. Akron Brass industrial electronic components & the Severe-Duty Monitor have a one (1) year warranty. Select Akron Brass handline nozzles and valves carry a ten (10) year warranty. Scene Star Lights carry a (6) year warranty. Weldon products have a two (2) year warranty from date of manufacture (excluding consumable components). Select Weldon LED products carry a five (5) year warranty. Honda products have the manufacturers' warranty and Akron Brass disclaims any warranty in respect of those products.

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**ELEVATION STOP (ITEM 43) LOCATIONS**

<table>
<thead>
<tr>
<th>ANGLE OF ROTATION</th>
<th>STOP LOCATIONS</th>
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<tbody>
<tr>
<td>+90°, +45° (STD)</td>
<td>3</td>
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<tr>
<td>+45°, -20°</td>
<td>2</td>
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<tr>
<td><strong>ALL OTHER LOCATIONS (ITEM 44)</strong></td>
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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 Primer T and Permabond H120 or Loctite 277.
- Use low-temp lubricant.
- Dimple at assembly.
- Thoroughly coat with Never Seez Mariners Choice.
- Use Permabond LH050 or Loctite 592.
- Use Loctite 290.
- General depiction see Bill of Material.
- Align ball in hole, tighten until touches ball, then back out plug 1/4-1/2 turn.
- Torque set screws 14 to 17 in-lbs.
- Align timing dimple on both joints prior to installing position sensors. Adjust sensors output to 2.50 ± 0.01 V.
- Assemble with rounded edges of retaining ring towards washers (item 102).
- Align timing mark to the fl at of the shaft.
- Align the timing mark to the stop on elevation joint to tighten the set screws on item 102.
- Install set screw flush with casting off.

**ASSEMBLY NOTES:**
- Use Parker O-Lube on all O-rings and mating surfaces unless otherwise noted.
- Use Permabond LM113 or Loctite 222.
- Use Primer T and Permabond H120 or Loctite 277.
- Use low-temp lubricant.
- Dimple at assembly.
- Thoroughly coat with Never Seez Mariners Choice.
- Use Permabond LH050 or Loctite 592.
- Use Loctite 290.
- General depiction see Bill of Material.
- Align ball in hole, tighten until touches ball, then back out plug 1/4-1/2 turn.
- Torque set screws 14 to 17 in-lbs.
- Align timing dimple on both joints prior to installing position sensors. Adjust sensors output to 2.50 ± 0.01 V.
- Assemble with rounded edges of retaining ring towards washers (item 101).
- Align timing mark to the flat of the shaft.
- Align the timing mark to the stop on elevation joint to tighten the set screws on item 102.
- Install set screw flush with casting off.

**TECHNICAL SERVICE PARTS**

**STYLE 3463**

**PRODUCT FIREFOX 2.5" INLET W/POSITION SENSORS**
Technological Service Parts

**Style: 3463**

**Product: Firefox 2.5" Inlet w/Position Sensors**

**Assembly Notes:**

- Use Parker O-Lube on all O-Rings and mating surfaces unless otherwise noted.
- Use Permanbond LM113 or Loctite 222.
- Use Primer T and Permanbond HH120 or Loctite 277.
- Use Low-Temp Lubriplate.
- Dimple at assembly.
- Thoroughly coat with Never Seez Mariners Choice.
- Use Permanbond LH500 or Loctite 592.
- Use Loctite 290.
- General depiction see Bill of Material.
- Align ball in hole, tighten plug until touches ball, then back out plug 1/4-1/2 turn.
- Torque set screws 14 to 17 in-lbs.
- Align timing dimple on both joints prior to installing position sensors. Adjust sensors output to 2.50 ± 0.01V.
- Assemble with rounded edges of retaining ring towards washers (item 11).
- Align timing mark to the flat of the shaft.
- Align the timing mark to the stop on elevation joint to tighten the set screws on item 103.
- Install set screw flush with casting OD.

**Parts List Sheet:**

- 124124

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**Warranty and Disclaimer:**

We warrant Akron Brass products for a period of five (5) years after purchase against defects in materials or workmanship. Akron Brass will repair or replace product which fails to satisfy this warranty. Repair or replacement shall be at the discretion of Akron Brass. Products must be promptly returned to Akron Brass for warranty service. We will not be responsible for: wear and tear; any improper installation, use, maintenance or storage; negligence of the owner or user; repair or modification after delivery; failure to follow instructions or recommendations; or anything else beyond our control. WE MAKE NO WARRANTIES, EXPRESS OR IMPLIED, OTHER THAN THOSE INCLUDED IN THIS WARRANTY STATEMENT, AND WE DISCLAIM ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE. Further, we will not be responsible for any consequential, incidental or indirect damages (including, but not limited to, any loss of profits) from any cause whatsoever. No person has authority to change this warranty.

*Unless otherwise provided herein, Akron Brass components & the Severe-Duty Monitor have a one (1) year warranty. Select Akron Brass handline nozzles and valves carry a ten (10) year warranty. Scene Star Lights carry a five (5) year warranty. Weldon products have a two (2) year warranty from date of manufacture (excluding consumable components). Select Weldon LED products carry a five (5) year warranty. Honda products have the manufacturers' warranty and Akron Brass disclaims any warranty in respect of those products.*

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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 PRIMER T AND PERMABOND HH120 OR LOCTITE 277."
"USE LOW-TEMP LUBRIPLATE."
"DIMPLE AT ASSEMBLY."
"THOROUGHLY COAT WITH NEVER SEEZ MARINERS CHOICE."
"USE PERMABOND LH050 OR LOCTITE 592."
"USE LOCTITE 290."
"GENERAL DEPICTION SEE BILL OF MATERIAL."
"ALIGN BALL IN HOLE. TIGHTEN PLUG UNTIL TOUCHES BALL. THEN BACK OUT PLUG 1/4-1/2 TURN."
"TORQUE SET SCREWS 14 TO 17 IN-LBS."
"ALIGN TIMING DIMPLE ON BOTH JOINTS PRIOR TO INSTALLING POSITION SENSORS. ADJUST SENSORS OUTPUT TO 2.50 ± 0.01 V."
"ASSEMBLE WITH ROUNDED EDGES OF RETAINING RING TOWARDS WASHERS (ITEM 33)."
"ALIGN TIMING MARK TO THE FLAT OF THE SHAFT."
"ALIGN THE TIMING MARK TO THE STOP ON ELEVATION JOINT TO TIGHTEN THE SET SCREWS ON ITEM 32."
"INSTALL SET SCREW FLUSH WITH CASTING OD."

MOTOR/GEARBOX ASSEMBLY
ELEVATION JOINT

PHONE: 330.264.5678 or 800.228.1161 | FAX: 330.264.2944 or 800.531.7335 | www.akronbrass.com

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<th>Find</th>
<th>Description</th>
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<td>SCREW, SOCKET HEAD CAP 10-24 x 2&quot;</td>
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<td>SCREW, SOCKET HEAD CAP 6-32 x 1-3/8&quot;</td>
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*Quantity of 1 required for 1-1/2" outlet.
*Quantity of 2 required for 2-1/2" outlet.

*** Optional parts for 3" flange. Use with 122441 base only (not shown).