

- ASSEMBLY NOTES:
- △2 USE PERMABOND LM 113 OR LOCTITE 222
 - △3 USE PRIMER T AND PERMABOND #HH-120 OR LOCTITE 277.
 - △4 STAMP LETTER "D" AFTER CALIBRATION
 - △5 DO NOT OVERTIGHTEN
 - △6 USE PERMABOND HH120 OR LOCTITE 277 AFTER CALIBRATION
 - △7 TORQUE TO 35-45 IN-LBS
 - △8 USE LOW-TEMP LUBRIPLATE
 - △9 GREASE BODY FACE (ITEM #12) AND O-RING (ITEM #21) WITH PARKER O-LUBE
 - △10 TIGHTEN CONE POINT SET SCREW BETWEEN TWO BALL BEARINGS UNTIL IT BOTTOMS OUT IN SWIVEL PLUG HOLE (SWIVEL SHOULD BE FIXED). THEN BACK OUT APPROX 1 TURN UNTIL SWIVEL TURNS SMOOTHLY. THEN, STAKE THE FIRST THREAD TO PREVENT SCREW FROM BACKING OUT.
 - △11 CENTER A BALL IN THE LOADING HOLE. SCREW IN SET SCREW UNTIL IT MAKES CONTACT WITH THE BALL. BACK OUT SET SCREW "SLIGHTLY" UNTIL SPINDLE MOVES FREELY.
 - △12 DIMPLE AT ASSEMBLY

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Parts List Sheet:

124204

FIND	ITEM NO.	DESCRIPTION	QTY
1	124202	BAFFLE 760-1000 GPM (2900-3800 LPM)	1
1	124203	BAFFLE 528-760 GPM (2000-2900 LPM)	1
2	768319	SPRING-BAFFLE	1
3	768377	BAFFLE STEM	1
4	120387	SCREW SOCKET HEAD SET 1/4-20 X1/4"	1
12	120054	BODY	1
16	101420	SWIVEL 2 1/2" NH #	1
16	101422	SWIVEL 2 1/2" BSP #	1
16	109525	SWIVEL 3 1/2" NH #	1
17	703017**	BALL BRASS 1/4" DIA FOR 2 1/2" SWIVEL	38
17	703017**	BALL BRASS 1/4" DIA FOR 3 1/2" SWIVEL	39
18	742023	PLUG	1
19	717043	GASKET FOR 2 1/2" SWIVEL	1
19	714023	GASKET FOR 3 1/2" SWIVEL	1
20	119706	PATTERN SLEEVE 5177	1
21	757087	O-RING FOR 3 1/2" SWIVEL 2-149	1
22	757038	O-RING 2-344	1
27	119703	THROAT	1
28	120386	SHAPER STREAM	1
38	757046	O-RING 2-235	1
40	765186	SCREW SOCKET HEAD SET 3/8-24 X 1/2"	1
57	803082	BAND ID STYLE 5176	1
59	768096	SHIM .005 THICK BLUE	1
60	765008	SCREW SOCKET HEAD 1/4 -20 X 3/16"	1
61	757068	O-RING 2-244	1
62	768097	SHIM .010 THICK BROWN	1
63	768098	SHIM .015 THICK PINK	1
102	119498	HOUSING ACTUATOR	1
103	50770028	12V MOTOR ASSEMBLY WITH SPEED CLIP	1
103	50770029	24V MOTOR ASSEMBLY WITH SPEED CLIP	1
103	33560006	12V MOTOR ASSEMBLY WITH DEUTSCH CONNECTOR	1
103	33560008	24V MOTOR ASSEMBLY WITH DEUTSCH CONNECTOR	1
104*	757112	O-RING 2-015	1
105*	785021	WORM	1
106	119500	COLLAR OVERRIDE	1
107*	744341	PIN ROLL.0625 X .375 LG	1

FIND	ITEM NO.	DISCRIPTION	QTY.
108	757293	O-RING 2-118	1
109*	757056	O-RING 2-029	1
110	744288	PIN ROLL 1/8 X 1/2	1
111*	765150	SCREW SOCKET HEAD CAP 6-32 X 1/2"	4
112***	704018	BALL STAINLESS STEEL 3/16"DIA	25
113+	718292	GEAR	1
114	768283	SPRING DETENT	1
116+	770343	SHAFT OVERRIDE	1
117	757330	O-RING 2-119	1
121	767158	SCREW SHOULDER 1/2 DIA X 1-1/4" LG	1
122	727050	KEY SPECIAL	1
124	765028	SCREW SOCKET HEAD CAP 10-24 X 5/8"	2
129	765134	SCREW SOCKET HEAD 5/16-24 X 1/4"	1
130+	51770033	OVERRIDE HUB ASSEMBLY 1.343 STROKE	1
133	119704	HOUSING BALLSCREW	1
136	118253	TUBE GUIDE	1
137	757055	O-RING 2-016	1
138	757282	O-RING 2-127	1
139	757048	O-RING 2-127	1
140+	767136	SCREW FREEWHEELING BALL ASSY	1

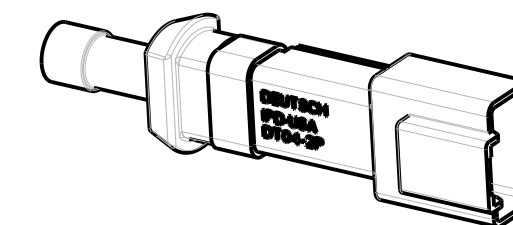
* ITEMS INCLUDED IN MOTOR ASSEMBLY ITEM #103

**KIT OF 50 BALLS:109041

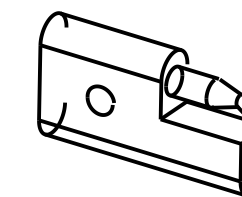
*** KIT OF 50 BALLS: 121874

FOR OTHER THREADS ORDER BY DESCRIPTION AND THREAD SIZE (ODM AND TPI) OR AKRON THREAD CODE

+ INCLUDED IN OVERRIDE HUB ASSEMBLY 51770033



DEUTSCH CONNECTOR



SPEED CLIP CONNECTOR