TH3 to Carriage Mounting Kit

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709-00654A-B

(For Kit p/n: 518-01377A)

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Revision History

Revision	Date	Author	Comments
A	2/13/2006	M.Herbert	Initial Release
B	11/20/2006	M.Herbert	Update photos and comments

TH3 to Carriage Mounting Kit, Manta
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Procedure

1) Install the sleeve of the adjustable screw set (302-00109) into one of the Vee blocks (252-09539A) using 609 Loctite. Let it dry for at least 12 hours. The sleeve should slide in without having to be pressed in,

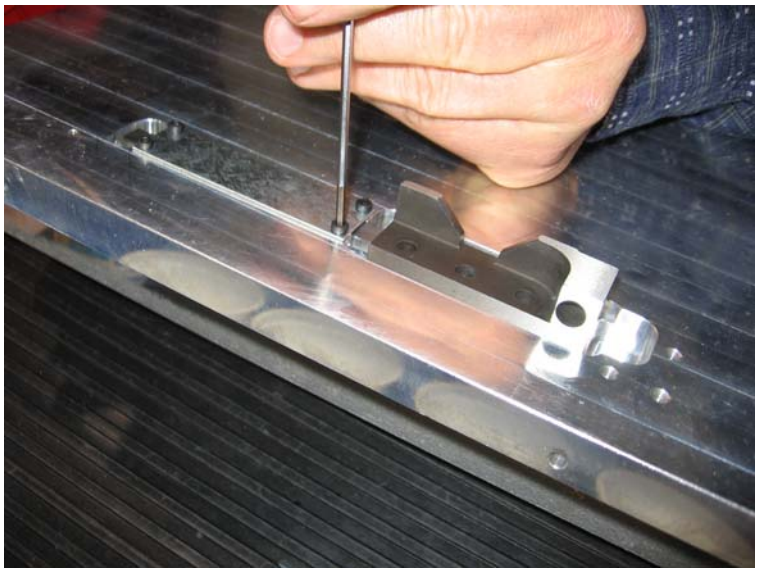


2) Install the lower vee block assembly using M5 X 16 SHCS's and Bellville washers. Do not install the center screw just yet. Make sure the block is pushed tightly into the corner. Install the Tool lead-in (57-9591A) as shown below. Use 425 Loctite. Make sure there is no Loctite on the exposed threads. The Lead-in cone should be positioned on the threads so that the allen key will slide into place. Note: The p/n for the Allen key driver is 90-1211.

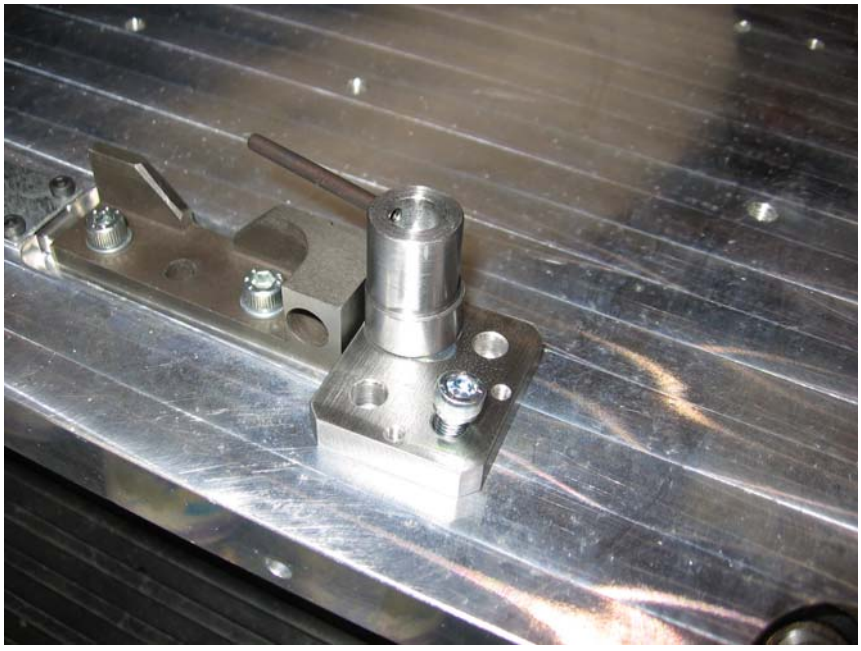




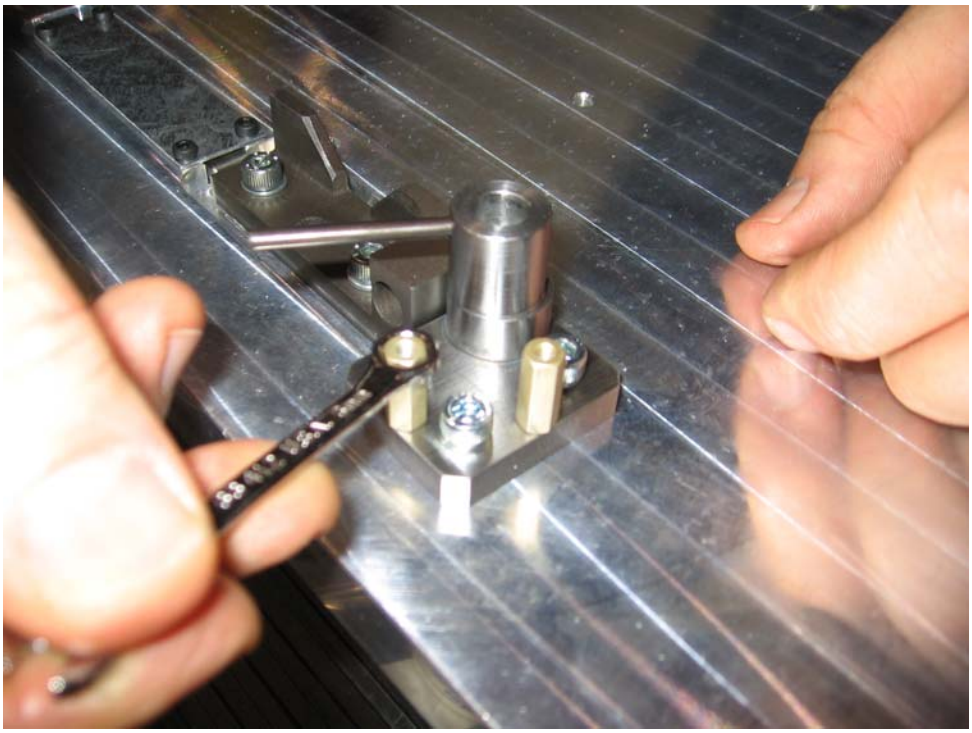
3) Install the upper Vee block(252-09539A). Apply a bit of NSK LR3 grease (89-0006) to the pads, the vee flats and the underside of the block to ensure it slides back and forth freely. Secure the block using only the two outer screws (M5 X 18) for now (The block will have to be adjusted later). Apply some grease to the front vee push rod (252-09934A) and install it in the cut-out. Make sure the curved end of the rod is towards the Vee-Block. Install the Push rod cover plate (252-09935A) using M3 X 8 screws (52-3252).



4) Install the spring pin (52-7308) into the Yaw adjust Cam (252-09598A). Make sure the pin does not extend into the center hole. The eccentric should protrude on the same side as the pin. Grease the bottom of the cam and insert it into the Yaw adjust base (252-09597A) using a M5 X 25 SHCS. Install the yaw adjust base to the carriage using (3) M5 X 16 SHCS's.



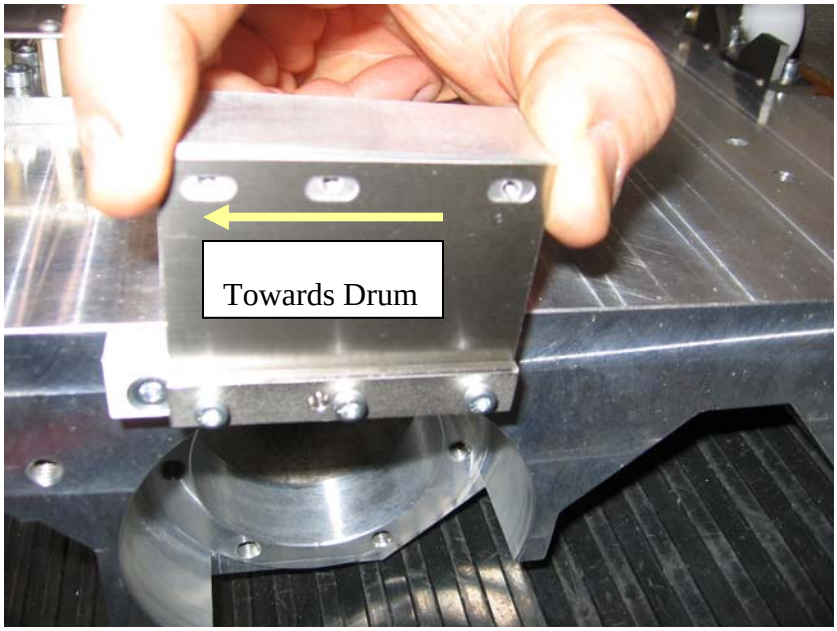
5) Install the standoffs into the Yaw adjust base.



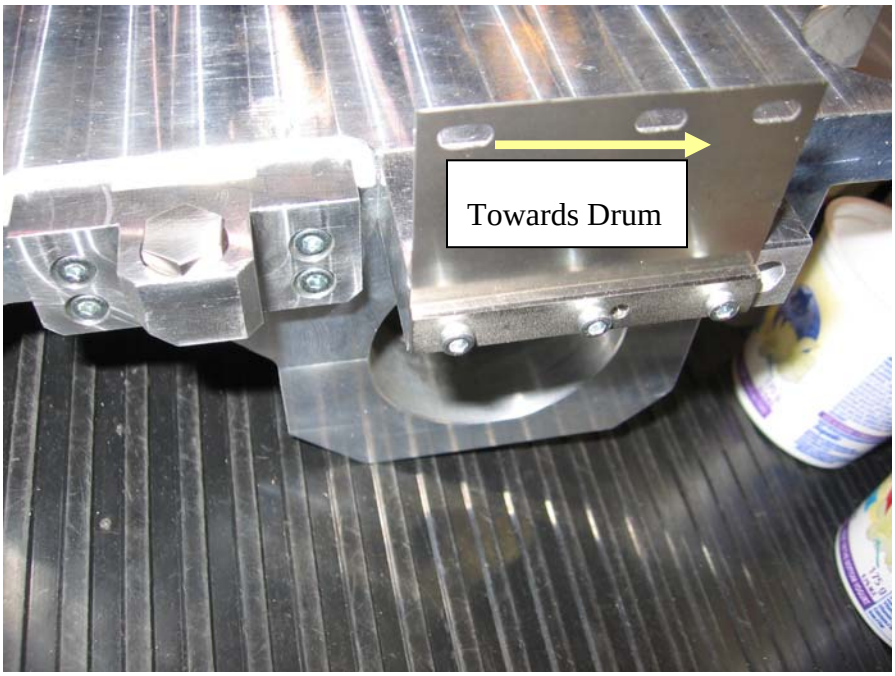
6) Install the 5th point base (252-09538A) onto the carriage using M4 X 14 SHCS's. Push down on the part while tightening the screws so that it sits flat on the ledge. Screw the adjustable 5th point (252-09537A) into the 5th point base. There are six shims (52-4983) that go under the head of the 5th point nut.



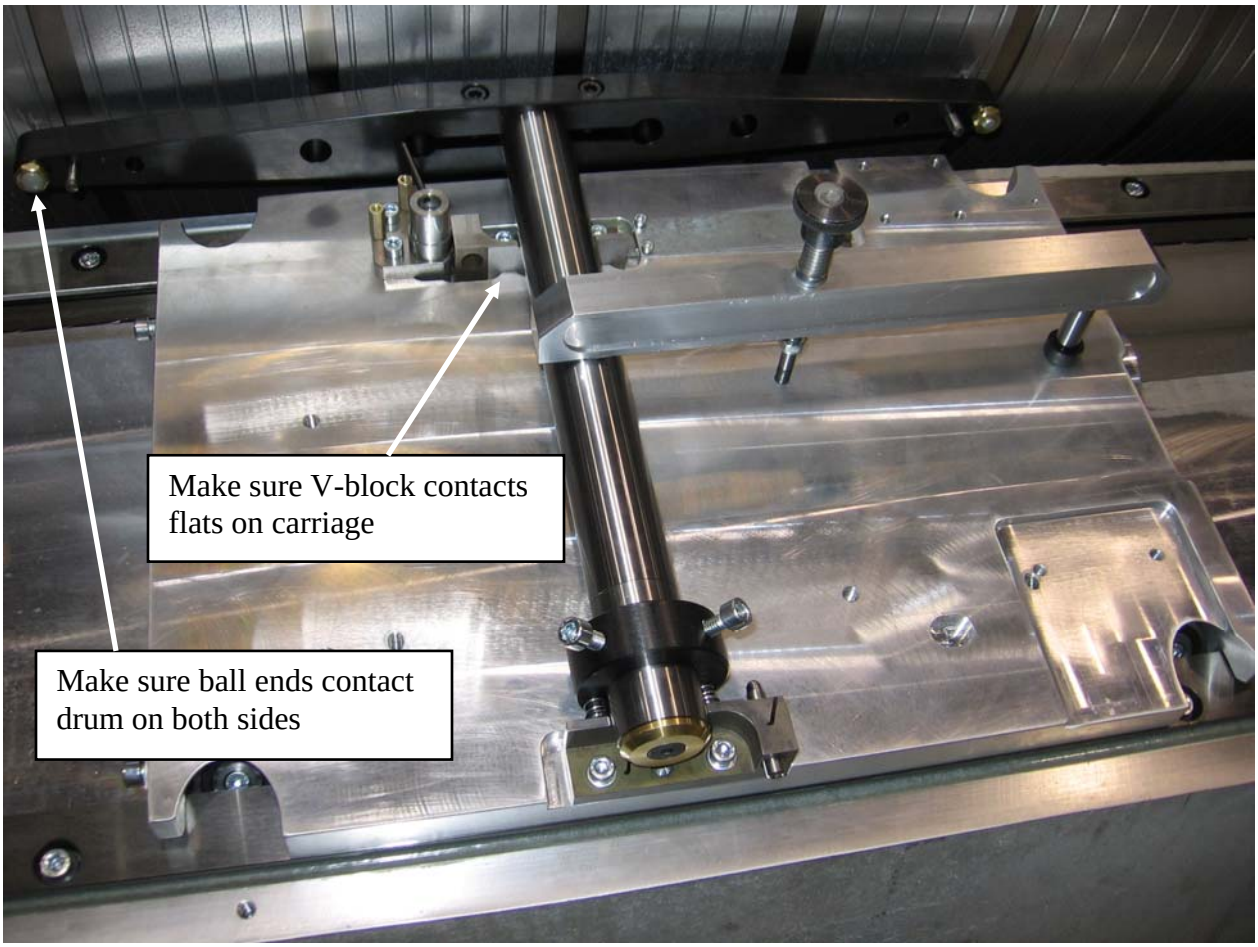
7) Install the Lower home flexure extension block (252-09599A) using M4 X 14 screws, the Flexure (252-09603A), and a Flexure clamping plate (252-09601A) using M3 X 10 screws. Make sure the chamfered edge of the extension block is towards the flexure plate.

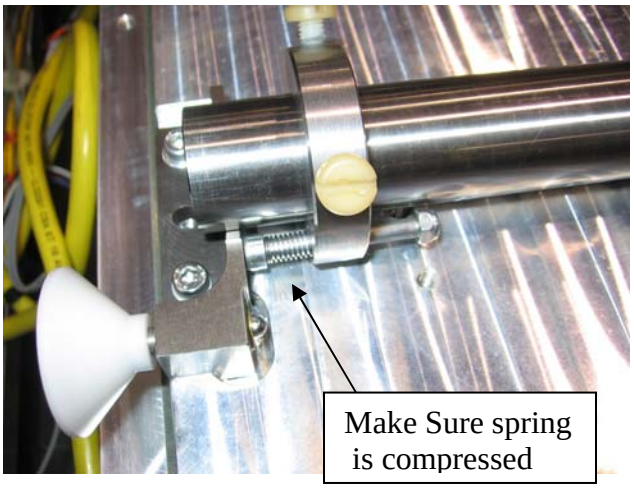


8) Install the lower away flexure extension block (252-09596A) using M4 X 14 screws, flexure (252-09603A),and a Flexure clamping plates (252-09601A) using M3 X 10 screws. Make sure the chamfered edges of the extension blocks are towards the flexure plate.

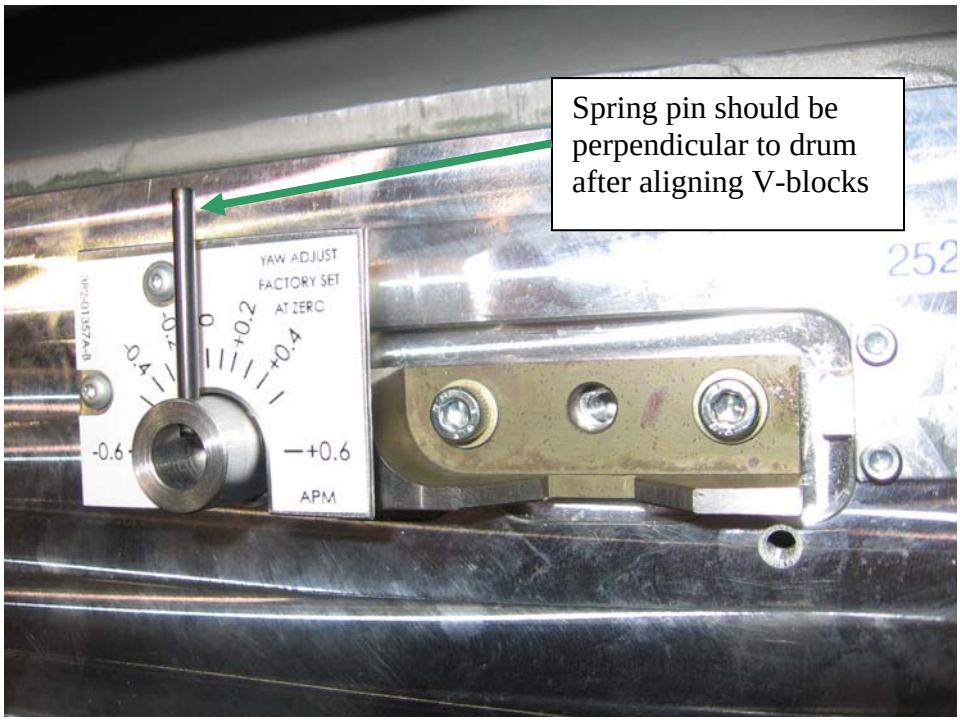


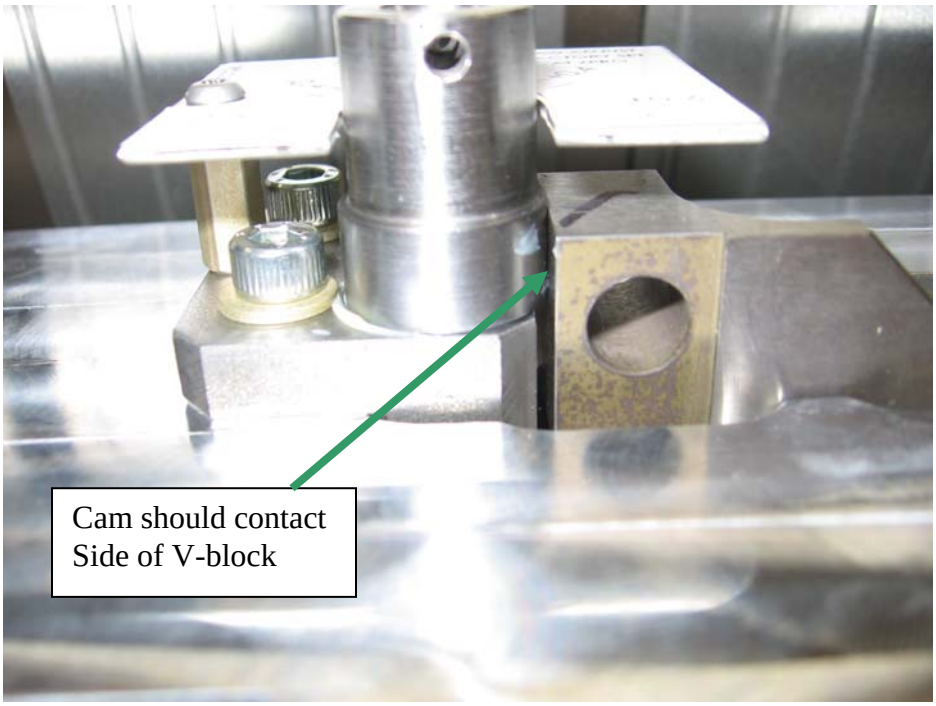
9) Install washer 52-7304 to the carriage using an M4 screw (Spare shims are stored under the washer)
10) Align the Vee blocks to the drum using the Alignment tool. Place the Alignment tool shaft onto the Vee grooves. Make sure the two springs on the shaft are compressed (see lower photo) and that the flats on the alignment tool are sitting on the left side of the Vee blocks. Clamp down the shaft of the jig as shown, “Shift” the front Vee block from side to side until the balls at the ends of the jig come into contact with the drum. Carefully tighten the V-block nearest the drum. Make sure it contacts the flats on the carriage. Apply a green dot to the carriage to show the V’s have been aligned.





11) After aligning the V-Blocks, position the yaw adjust assembly so that the spring pin is perpendicular to the drum. Then slide the assembly towards the V-block so that the cam touches the side of the V-block. Tighten the three screws that hold down the yaw adjust assembly. Apply the Yaw adjust scale sticker (382-01357A) to the Yaw plate. Install the Yaw Plate plate (252-09903A) using two M3 X 8 screws (52-7115).





12) For field installations only, install the home and away tabs as shown. (home tab:252-09870A and away tab:252-09927A)





13) Notes: the Upper home block (252-09600A), Upper away block (252-09602A), two Flexure clamping plates (252-09601A), six M3 X 12 screws, six M3 X 10 screws, may come as a kit supplied with the TH3 head.