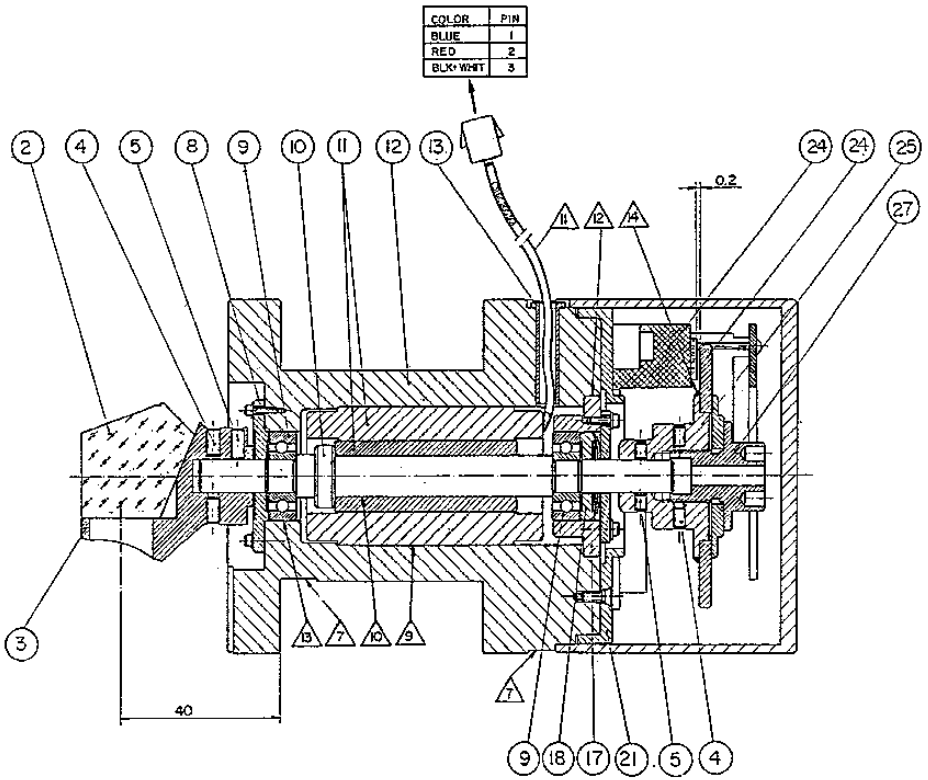
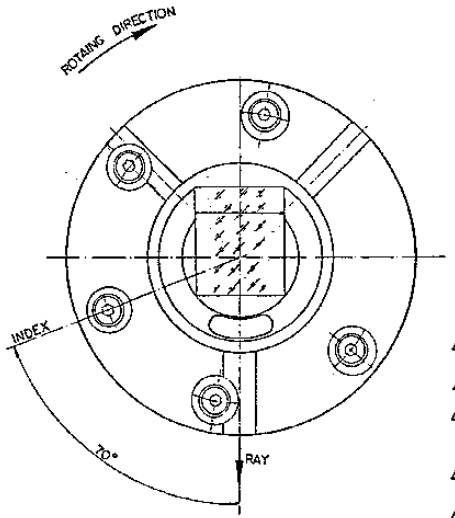




Installation Procedure

1) APPLY EPOXY PATCH KIT 907 BLUE DEXTER TO GLUE PENTA PRISMA #2 TO HOLDER #3 AND WAIT FOR 24 HOURS, FOR CURING.
2) BALANCE ASSY USING SCREW #5 AFTER ADJUSTING CONCENTRICITY OF ENCODERS DISK #25 TO 0.001 T.I.R.
3) APPLY LOCTITE 638 TO GLUE BALANCING SCREWS, LET CURE FOR 3 HOURS.
4) SECURE BALANCING SCREWS WITH LOCTITE #638, AND LOCKING SCREW WITH LOCTITE #242.
5) M.T.B.F. - 5000 HOURS AT 25 C.
6) PRELOAD 1.5 0.5 LBS.

△7 MECHANICAL VIBRATION

MEASURE AT TWO POINTS AS INDICATED

7.1) ACCELEROTION MEASURING CONTINUOUS VARIABLE FEQUENCY AT 55HZ 200HZ SHOULD BE LESS THAN 0.08g.

7.2) THE RMS ACCELERATIONS OF THE SPECTRUM BETWEEN 250HZ AND 6.4 KHZ SHOULD BE LESS THAN 0.07g.

8) BALANCE: 0.0001 OZ-INCH-DYNAMIC UNBALANCE.

△9 SPREAD THIN LAYER OF LOCTITE 638 ON INNER DIAMETER OF MOTOR HOUSING. INSERT STATOR INTO MOTOR HOUSING UP TO SHOULDER, LET CURE 3 HOURS.

△10 GLUE PART #10 WITH #11, ROTOR USING LOCTITE #638. LET CURE 3 HOURS AND CLEAN IN NITRASONIC BATH

△11 MOTOR WIRE LENGTH 29MM. +1

△12 SPREAD THIN LAYER OF ARALDITE - EXPOXY ADHESIVE - SLOW SETTING ON #17 OUTER DIA. AND INSERT INTO #12 UP TO SHOULDER, THEN CLEAN THE GL REMNANTS WITH ACETON

△13 SPREAD THIN LAYER OF OIL ON OUTER DIAMETER OF BEARINGS #9.

△14 GLUE PARTS #25 AND #26 WITH UV GLUE - VITRALIT 6102 - TIN (4POINTS EQUALLY DEVIDED).

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