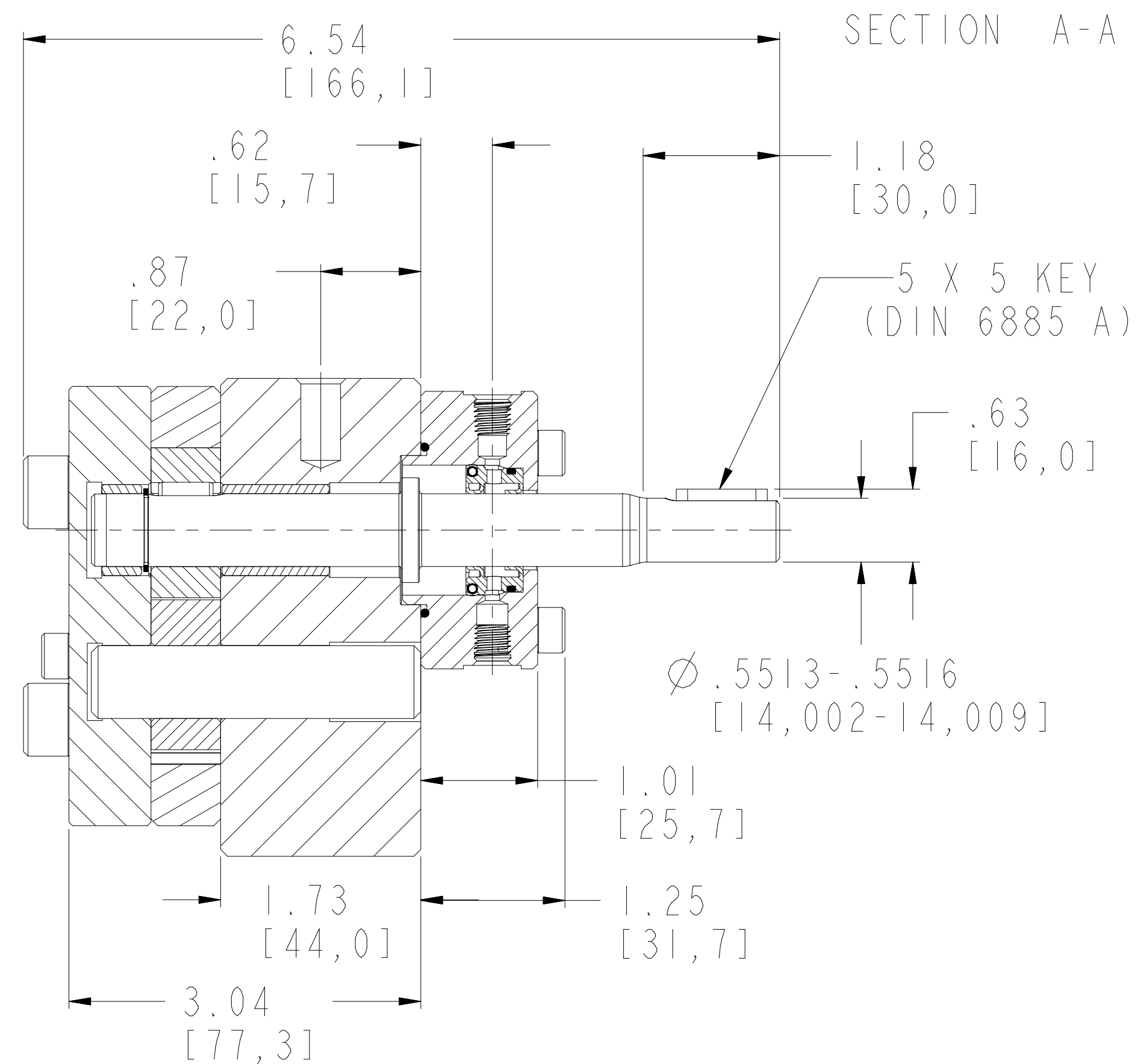
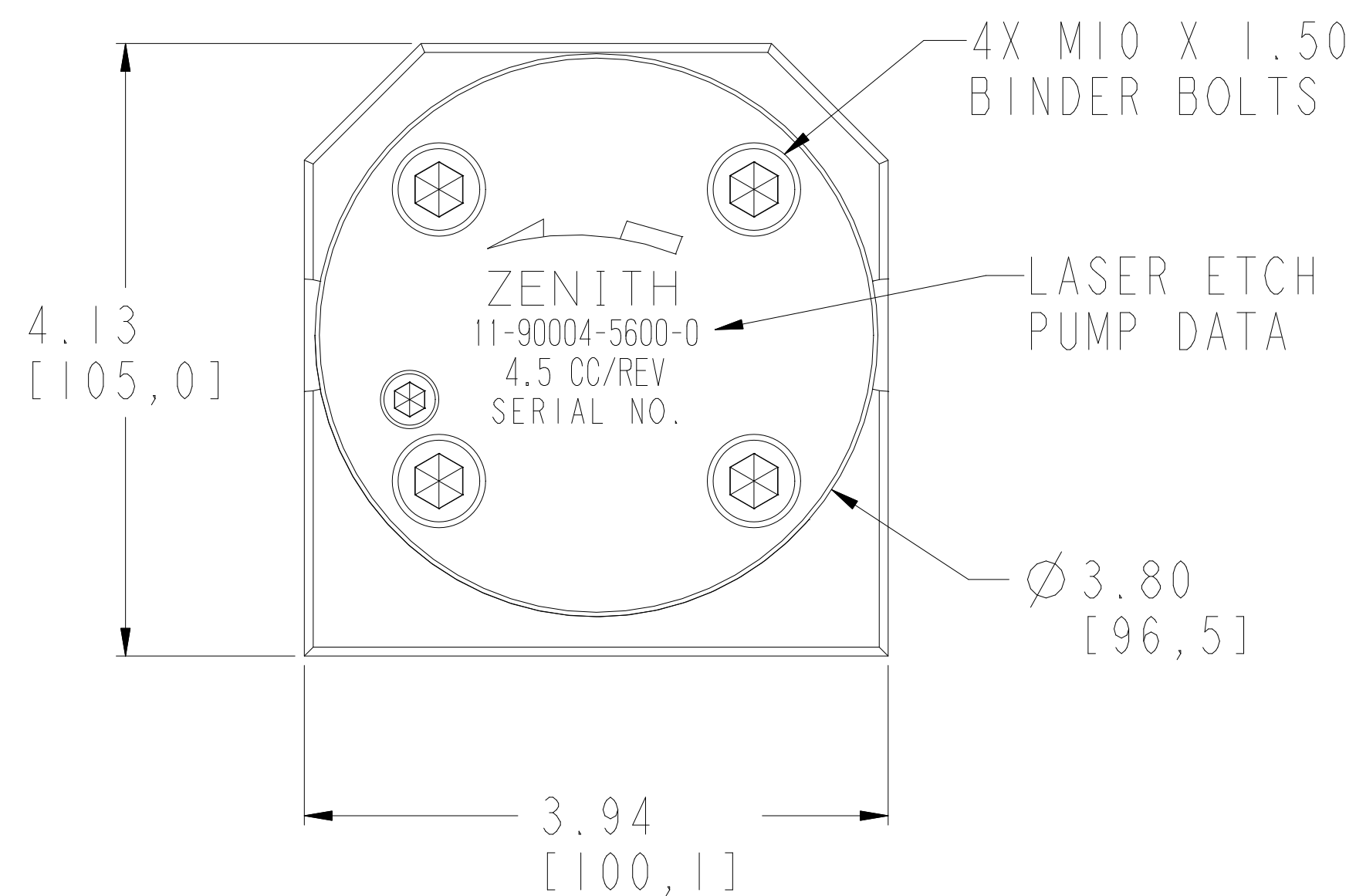
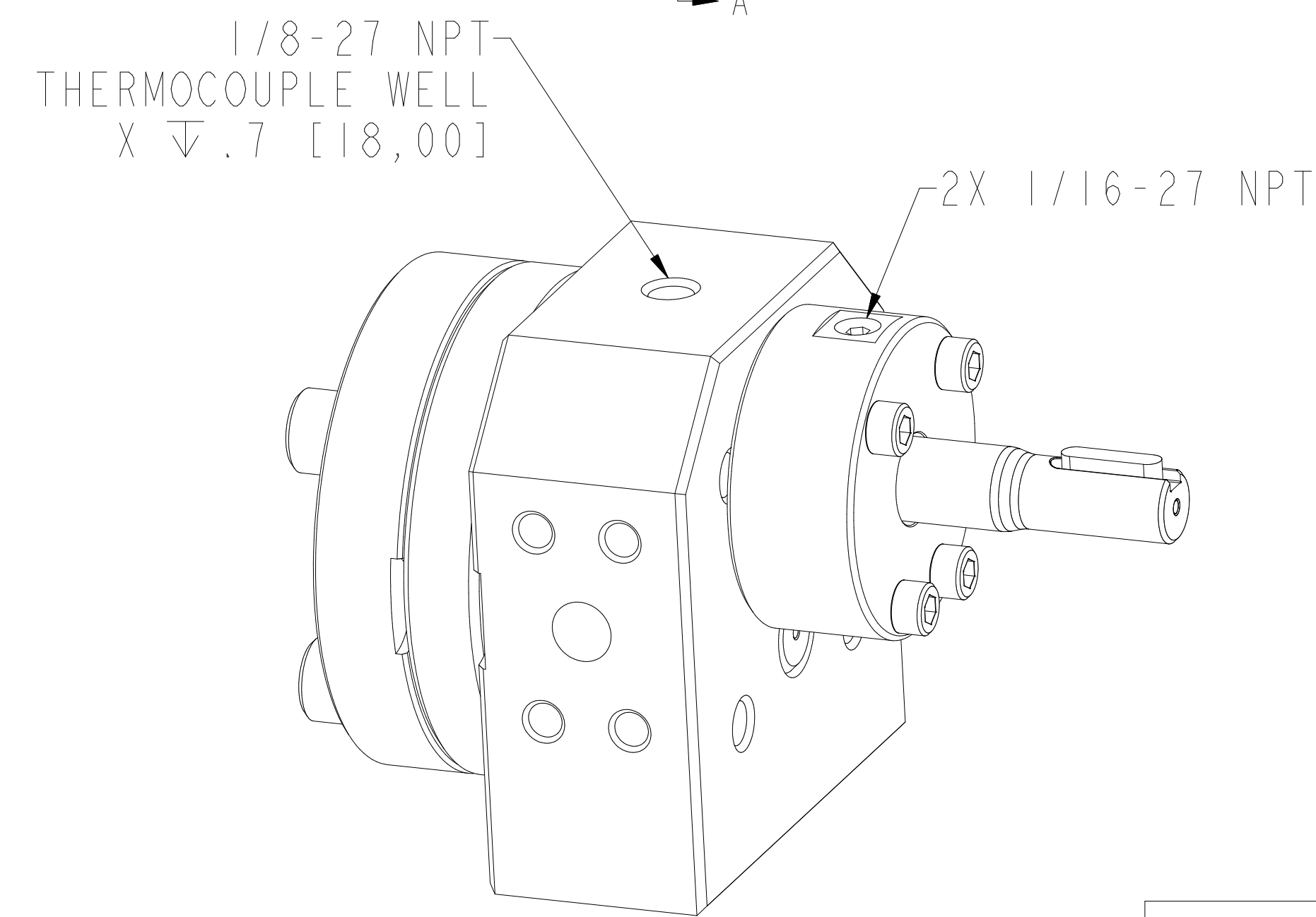
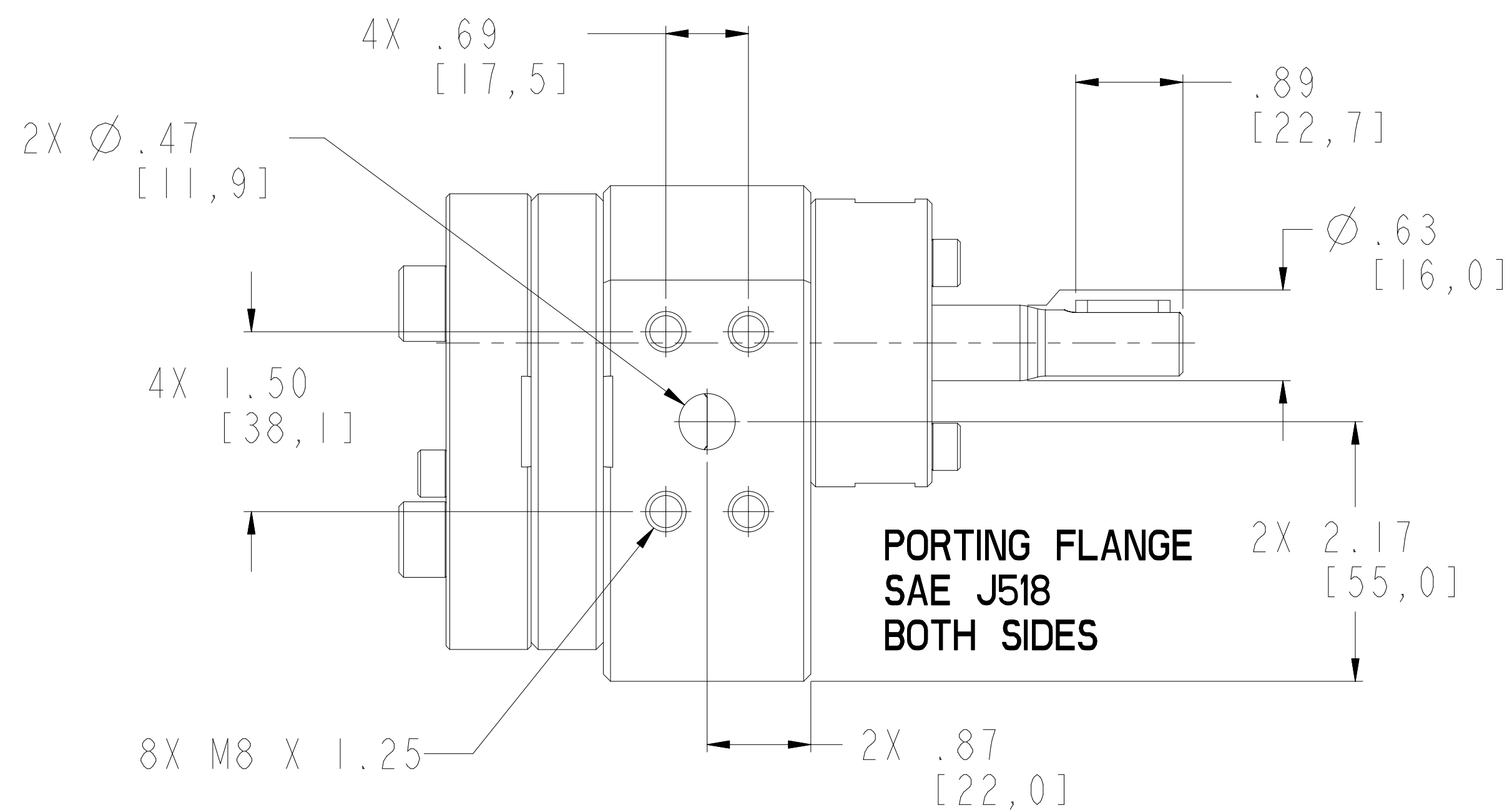
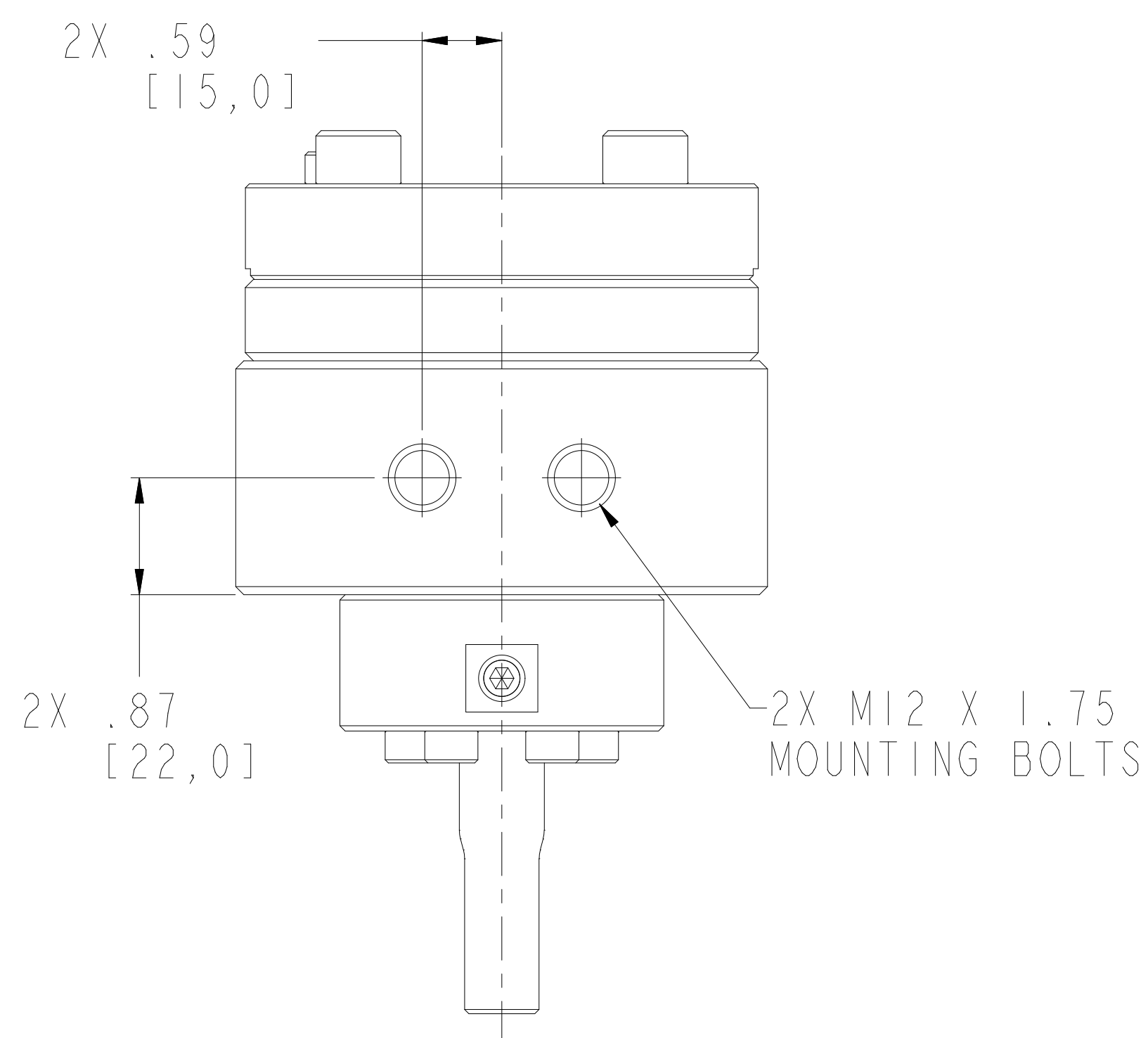
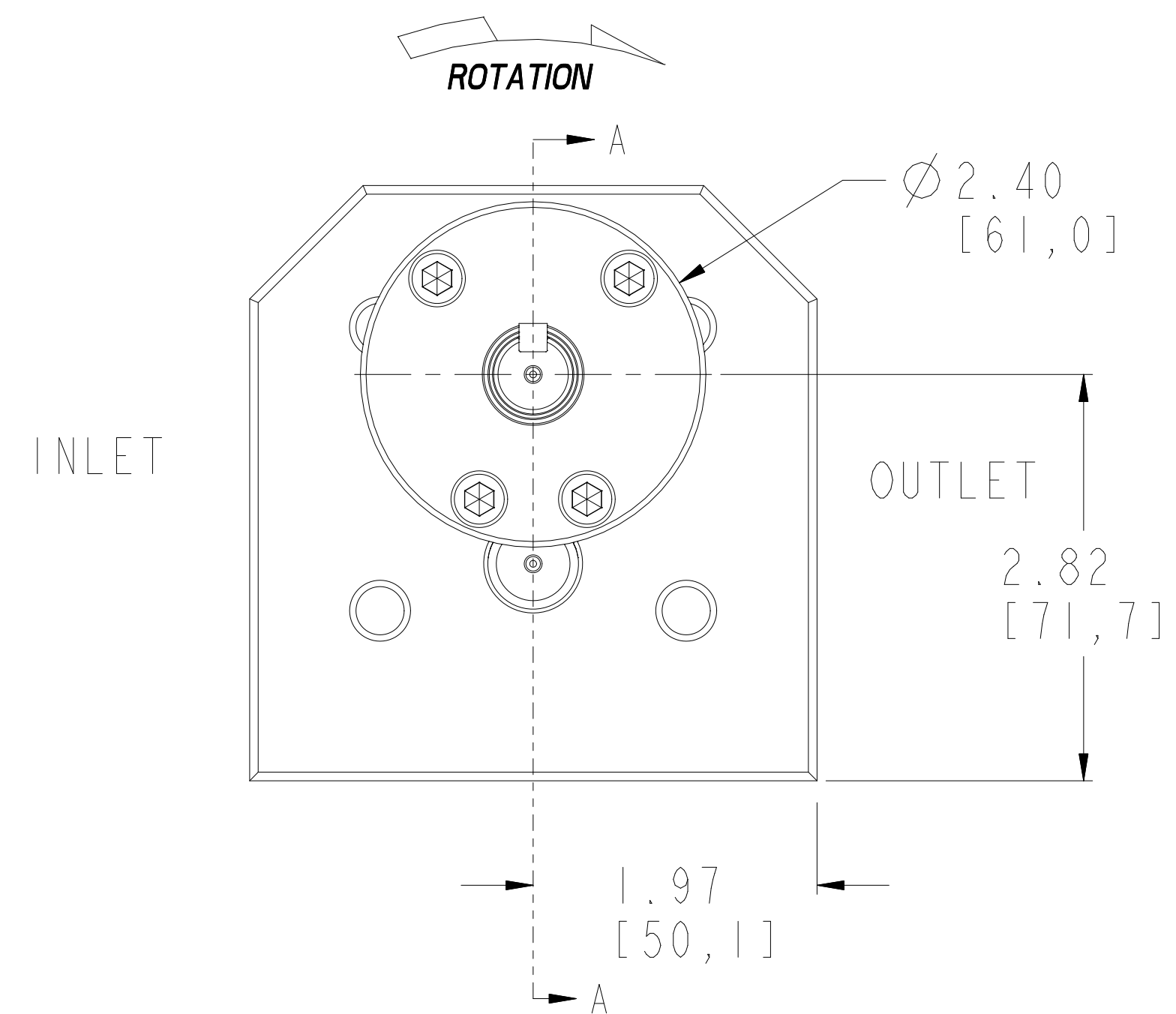


TORQUE SPECIFICATIONS:

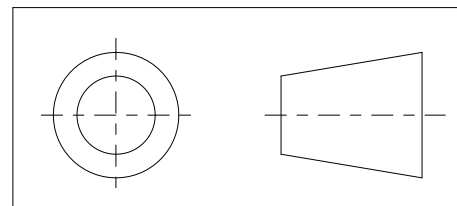
1. TIGHTEN 10MM BINDER BOLTS TO:
684 in-lb NON-LUBRICATED; 519 in-lb LUBRICATED
2. TIGHTEN 6MM BOLTS TO:
142 in-lb NON-LUBRICATED; 108 in-lb LUBRICATED
3. TIGHTEN 8MM BOLTS TO:
345 in-lb NON-LUBRICATED; 262 in-lb LUBRICATED



REVISIONS			
LTR	DESCRIPTION	DATE	ECN NO.
D	CHANGED MAT'LS FROM D2 TO M2, M4 & CPM-M4; WAS 18-76504-0165-1; CORRECTED TORQUE SPECS	2.27.2004	085-2004



INTERPRET PER ASME-Y14.5M 1994



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		<p>CHECKED</p>	
<p>MATERIAL</p> <p>SEE BILL OF MATERIAL ON SHEET 2 OF 2</p>	<p>PRO/ENGINEER DRAWING</p>	<p>MODEL NUMBER = 119000456000 DRAWING = 119000456000</p>	<p>H-9000 4.5 CC/REV RAN-600 4.5 CC/REV</p>
		<p>SIZE D</p>	<p>SCALE 1:1 SHEET 1 OF 2</p>

ITEM No.	PART NUMBER	PART NAME	MATERIAL	QTY
	119000906000	H-9000 9.0 CC/REV RAN-600		1
2	157956801291	SHAFT, DRIVE	CPM-M4	1
16	181831800142	RING - RETAINING	PH 15-7 MO	1
3	156925100741	PLATE, GEAR	M2	1
4	185600800151	KEY, ROUND	FREE CUTTING STEEL	1
5	152523000081	GEAR, DRIVING	CPM-M4 OR EQUIV.	1
6	152513000081	GEAR, DRIVEN	CPM-M4 OR EQUIV.	1
7	146915100442	ASSEMBLY, REAR PLATE		1
33	156915100564	PLATE, REAR	M2	1
34	150451603002	BEARING, SLEEVE	M4	1
8	146945200492	ASSEMBLY, FRONT PLATE		1
31	156945200624	PLATE, FRONT	M2	1
32	150451602994	BEARING, SLEEVE	M4	1
9	150115600771	ARBOR	CPM-M4	1
10	151609100571	DOWEL, HOLLOW	M2	2
11	155401900413	HOUSING, LIPSEAL	440C	1
12	147900400022	SUB-ASSEMBLY, ASSY INSTRUCTION	SEE BILL OF MATERIALS	1
41	150013100652	SEAL ASSEMBLY TOOL	ACETAL COPOLYMER	1
13	187900401341	TANDEM LIP SEAL	CARB. FIBER FILLED PTFE	1
21	187650401891_INV	O-RING	EPDM	1
14	187860610352	SHCS M6XI X 35MM ALLOY 12.9		4
15	185600800051	KEY, SQUARE	STEEL 50-1 K	1
17	187860610602	SHCS M6XI X 60MM ALLOY 12.9		1
18	187861010902	SHCS M10XI.5 X 90 MM ALLOY 12.9		4
19	187300000071	PLUG, DRYSEAL TYPE	AUSTENITIC SS	2

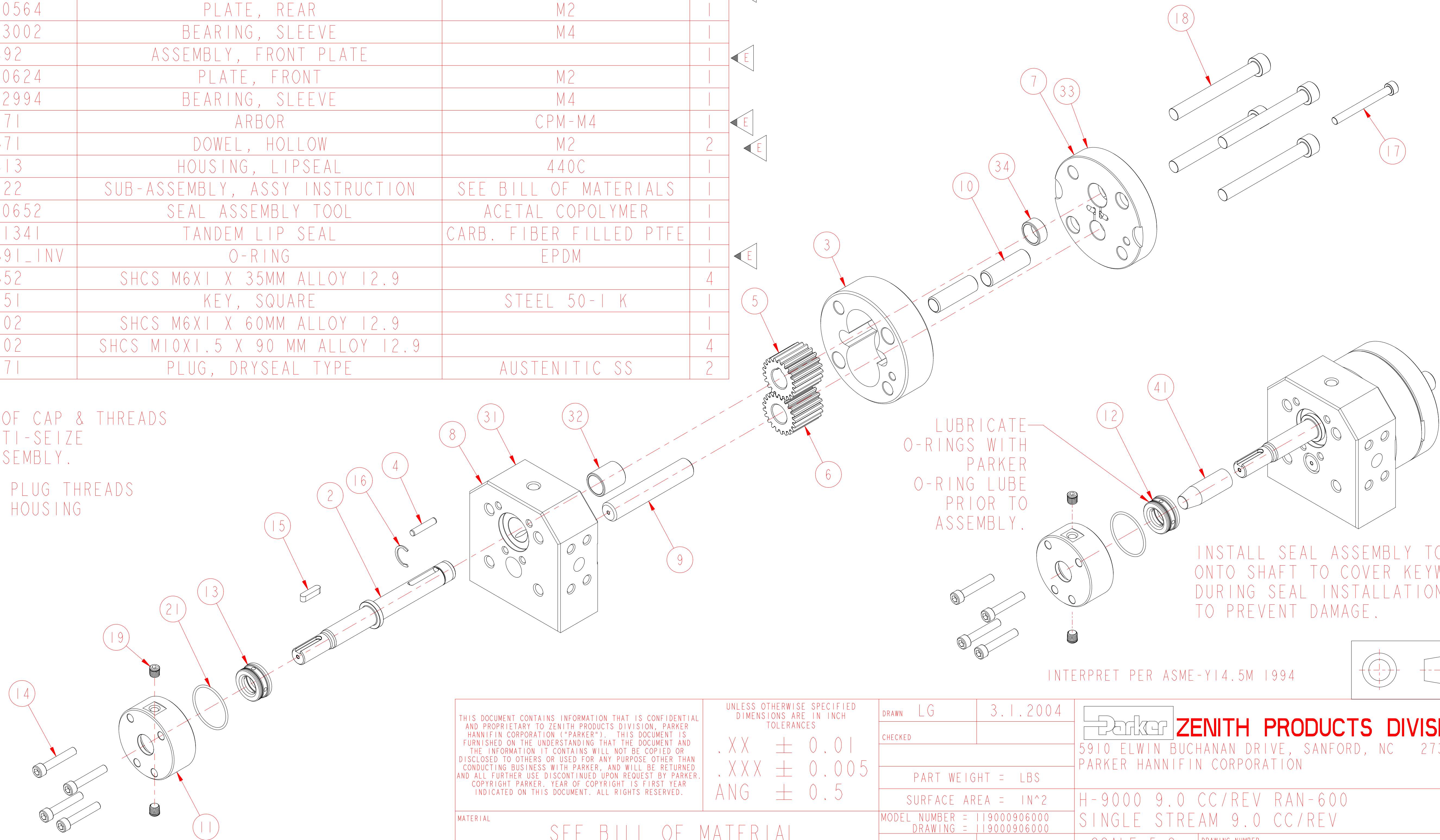
REVISIONS			
LTR	DESCRIPTION	DATE	ECN NO.
E	CHANGED D2 MAT'LS TO M2, M4, & CPM-M4; CORRECTED TORQUE SPECS; WAS 18-76504-0165-1	3.1.2004	085-2004

LUBRICATE UNDERSIDE OF CAP & THREADS ON FASTENERS WITH ANTI-SEIZE COMPOUND PRIOR TO ASSEMBLY.

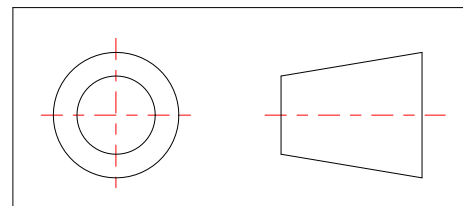
APPLY TEFLON TAPE TO PLUG THREADS WHEN ASSEMBLING INTO HOUSING TO PREVENT LEAKAGE.

LUBRICATE O-RINGS WITH PARKER O-RING LUBE PRIOR TO ASSEMBLY.

INSTALL SEAL ASSEMBLY TOOL ONTO SHAFT TO COVER KEYWAY DURING SEAL INSTALLATION, TO PREVENT DAMAGE.



INTERPRET PER ASME-Y14.5M 1994



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	MATERIAL SEE BILL OF MATERIAL ON SHEET 2 OF 2	MODEL NUMBER = 119000906000 DRAWING = 119000906000	
		PRO/ENGINEER DRAWING SIZE D	DRAWING NUMBER 11-90009-0600-0