

ASSEMBLY INSTRUCTIONS

SUB-ASSEMBLY

1) GEARS & SPLINES: LUBRICATE WITH DOW CORNING MOLYKOTE BR2 PLUS GREASE.

2) BEARINGS: LUBRICATE WITH CHEVRON SR1 GREASE 3) O-RINGS: LUBRICATE WITH O-RING LUBE

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O NG R						REMOVE BURRS AND SHARP EDGES: R.015 MAX MACHINE SURFACE FINISH: 125 RMS OR BETTER
						$.X = \pm .030$ $.XX = \pm .010$ $.XXX = \pm .005$ $.XXXX = \pm .0005$ ANGLE = $\pm 0^{\circ} 30'$
IED.						BLOCK TOLERANCING PER DECIMAL:
FOR G OR LLED						DIMENSIONS ARE IN INCHES DIMENSIONS AND TOLERANCING PER ANSI Y14.5 SURFACE ROUGHNESS PER ANSI Y14.36
) BE						UNLESS OTHERWISE SPECIFIED,

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SCALE 1:1 DO NOT SCALE DRAWING SHEET 1 OF 2

