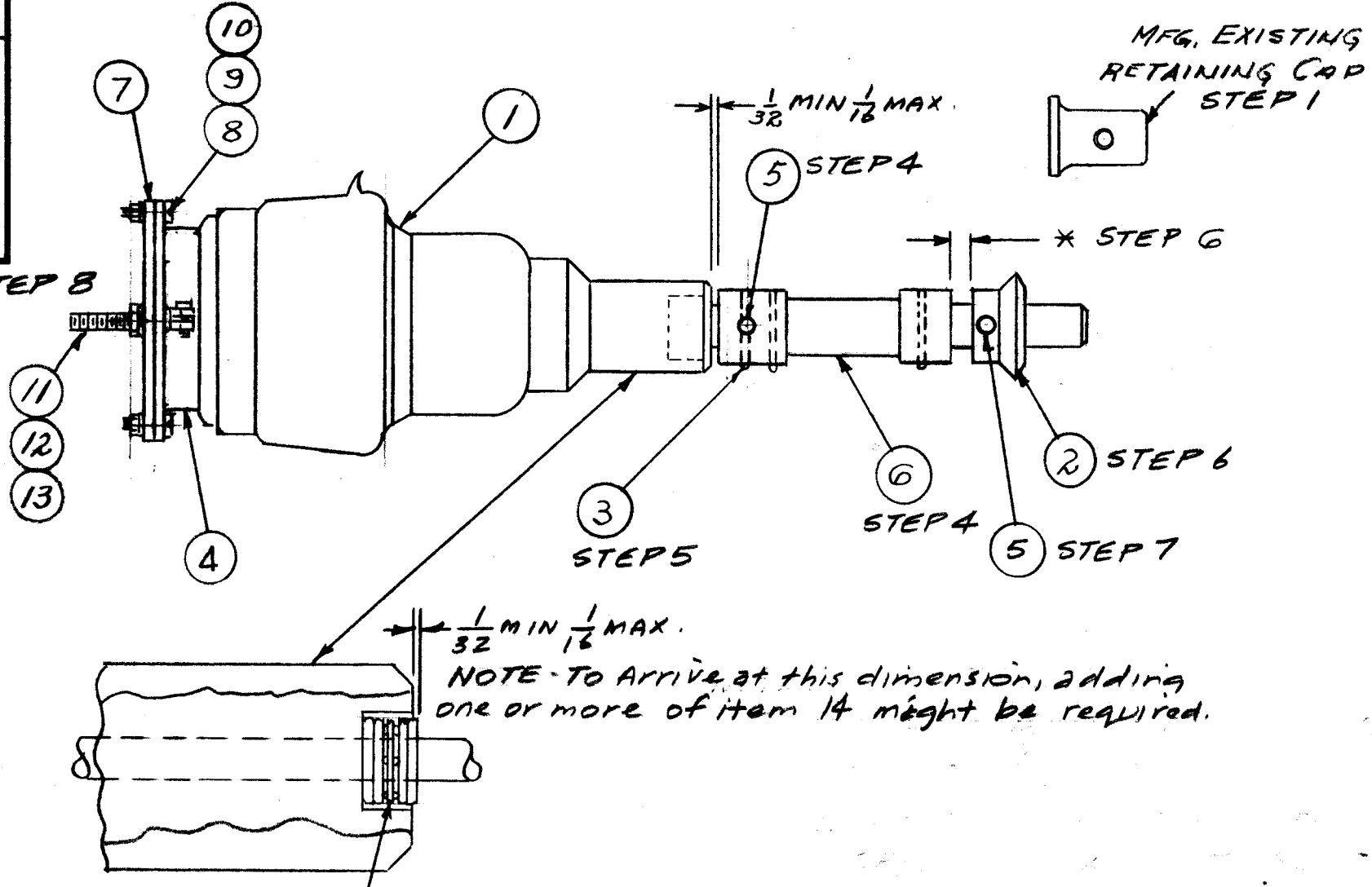


A-1692



MFG. EXISTING  
RETAINING CAP  
STEP 1

BEARING WASHER  
IN MIDDLE,  
2 FLAT WASHERS  
ON EACH SIDE  
(STEP 3)

**PROCEDURE**

1. REMOVE & STOCK RETAINING CAP.
  2. ROTATE SHAFT CCW TO LIMIT.
  3. BE SURE WASHERS ARE PLACED ON SHAFT IN ORDER SHOWN.
  4. PLACE SHAFT ASS'Y, ITEM 6, ON CAPACITOR SHAFT IN POSITION SHOWN, TIGHTEN SET SCREW, ITEM 5, (NOTE: SET SCREW MUST BE ON FLAT OF CAPACITOR SHAFT).
  5. DRILL THROUGH SHAFT ASS'Y PILOT HOLE WITH #52 DRILL, PIN THROUGH WITH ITEM 3.
  - \* 6. ASSEMBLE GEAR, ITEM 2, IN POSITION SHOWN
  7. TIGHTEN SET SCREWS, ITEMS 5, ON GEAR.
  8. ASSEMBLE ITEMS 4, 7, 8, 9, 10, 11, 12, 13
- \* THIS DIMENSION TO BE ESTABLISHED ON ASSEMBLY & INSTALLATION INTO UNIT.

X	14	WA-133-5	WASHER, THRUST (IF REQUIRED)
	1	13	NTH2520BNI4 NUT, HEX.
	1	12	LWS25MRN LOCKWASHER, SPLIT
	1	11	SCFS2520BNI6 SCREW, MACHINE, FL. HD.
	6	10	NTH0832BN02 NUT, HEX
	6	9	LWE08MRN LOCKWASHER, EXT.
	6	8	SCBS0832BNG SCREW MACHINE
	1	7	MS-1596 PLATE, TOP, CAP.
	1	6	PM-524 SHAFT ASS'Y
	3	5	AN565D8H4 SET SCREW
	1	4	PO-185-3 FLANGE, VAC. CAP (FIXED)
	1	3	PN59-062-16 PIN, SPRING
	1	2	GR-141-2 GEAR, BEVEL
	1	1	CB-146 CAPACITOR, VAR. VAC. 15-1200uufd

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
CP		THE TECHNICAL MATERIEL CORP.	
STOCK SIZE		MAMARONECK, NEW YORK	
MATERIAL		AM-102 ASS'Y	
		CAPACITOR, VAR., VAC., W/GEAR	
		ALLC	JDE
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN
			CHECKED
			FINAL APPROVAL
			A-1692
FINISH & SPEC. NO.		ELEC. DES. APP	MECH. DES. APP

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES							
SCALE: <i>1/16</i>							
DEC. DIM. ±							
FRAC. DIM. ±							
ANGULAR DIM. ±							

1	AM-102	AX-137			
REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE	USED ON