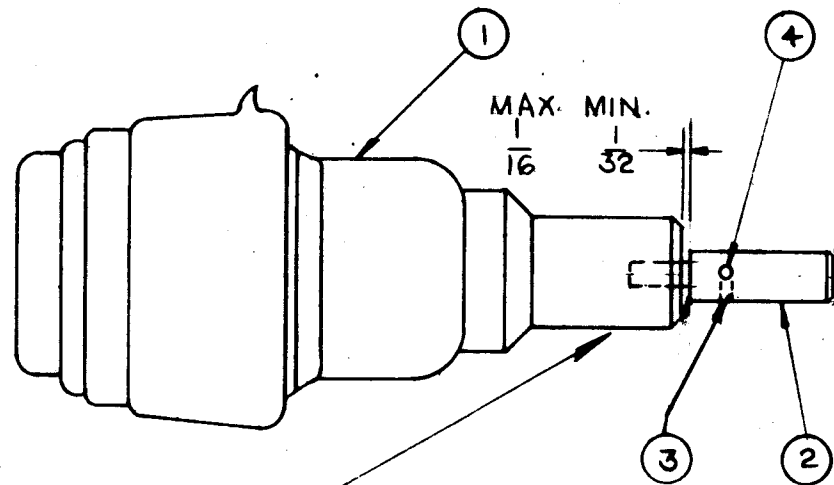
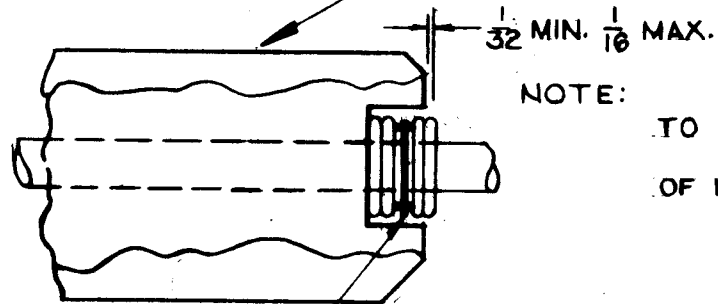
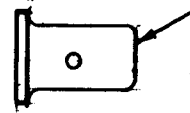


PROCEDURE

1. REMOVE STOCK RETAINING CAP
2. ROTATE SHAFT CCW TO LIMIT.
3. BE SURE WASHERS ARE PLACED ON SHAFT IN ORDER SHOWN.
4. PLACE ADAPTER SHAFT, ITEM 2, ON CAPACITOR SHAFT IN POSITION SHOWN, TIGHTEN SET SCREW ITEM 4, (NOTE: SET SCREW MUST BE ON FLAT OF CAPACITOR SHAFT.)
5. DRILL THROUGH SHAFT ASSEMBLY PILOT HOLE WITH $\frac{3}{32}$ DRILL, PIN THROUGH WITH ITEM 3.



MFG EXISTING RETAINING CAP STEP 1



NOTE:

TO ARRIVE AT THIS DIMENSION, ADDING ONE OR MORE OF ITEM 5 MIGHT BE REQUIRED.

BEARING WASHER IN MIDDLE 2. THRUST WASHERS ON EACH SIDE (STEP 5)

SEE NOTE-

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 5	WA-133-5	WASHER, THRUST (IF REQUIRED)	
1 4	SLHC0632SP3	SET SCREW	
1 3	PN-114-4	PIN	
1 2	PM-628	SHAFT, ADAPTER	
1 1	CB-155	CAPACITOR, VAR, VAC, 15-1200UUF	
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK AM-116 ASSY CAPACITOR VAR, VACUUM			
DRAWN		ENGR	FINAL APPROVAL
AS		RUZZO	DR
TYPE & TEMPER		HEAT TREAT. SPEC.	FINISH & SPEC. NO.
			A-2197 B

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B		ITEM 4 WAS AN565D6K3	3-7-67	17885	L.A.K.		
A	2	ON STEP 5, $\frac{3}{32}$ DRILL WAS $\frac{5}{32}$					
	1	ITEM 3 WAS PN59-062-8	3-25-64	11095	WB	@	

TOLERANCES		SCALE:	
DEC. DIM. \pm		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.	
FRAC. DIM. \pm		REMOVE ALL BURRS AND SHARP EDGES	
ANGULAR DIM. \pm			

REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE
1	GPT-40K	AT-103		10-26-61
USED ON				