DATE 1-16-59 SH. 1 OF 2 COMPILED BY	TMC SPECIFICATION NO. S 406	
APPROVED	TITLE: I.P.A. VARIABLE VACUUM CAPACITOR STOP	JOB
	ASSEMBLY PROCEDURE	

NOTE:

On drawing #2-1380, item 1 will be as follows:

TMC DWG. NO.	ITEM NO. 1 PART NO.	MFG. TYPE	TMC PART NO. OF FINISHED PART W/GEAR & NEW SHAFT
2-1380-1	CB-143-1000-3A	UCSL	AM-100
2-1380-2	CB-142-500-7.5A	UCSF	AM-101

1. Rotate shaft of Capacitor (item 1), CCW until shaft and outer sh ll is removed.
2. Disassemble shaft from shell and washers.
3. Replace shaft approximately 4 or 5 turns into Capacitor drive hub.
4. Grip shaft tightly in bench vise.
5. Retract Capacitor body until retaining holes appear.
6. Insert brass screws (item 2) into retaining holes (as shown in detail) to keep hub of capacitor in its extended position.
7. Remove the 3 round head screws that hold the drive hub in its housing.
8. Remove hub and shaft assembly from Capacitor.
9. Remove shaft from hub. (Return shaft & retaining cap to stock)
10. Take new shaft, (item 3), and screw it into the drive hub as shown.
11. Assemble thrustwasher (item 4) onto shaft.
12. Screw nut (item 5) onto shaft until flush with end of shaft. Th n braze nut to shaft as shown.
13. Insert hub and new shaft assembly into the hub housing and replace the three round h ad screws.
14. Turn th shaft CCW until it hits it limit.

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15. Replace outer shell over shaft.

16. Assemble, in order, thrust washer(item4), thrust washer(existing), Bearing washer(existing), thrust washer (existing), thrust wash.(item4)

~~17. Slide new bushing (item 6) over shaft and push it to the limit. Tighten set screw (item 7) into bushing against flat of shaft.~~

17. Slip gear (item 8) over shaft until edge of gear is 1/32" from Capacitor outer shell. Tighten Gear Set screws (item 9) Note-One Setscrew must be on Flat of shaft.

~~. Line up gear pilot hole so it is perperdicular to the flat on the shaft.~~

~~. Tighten gear set screws. (item 9)~~

18. Using a #52 (.063) drill, drill thru pilot hole of gear and continue hole thru.

19. Drive pin (item 10) into hole.