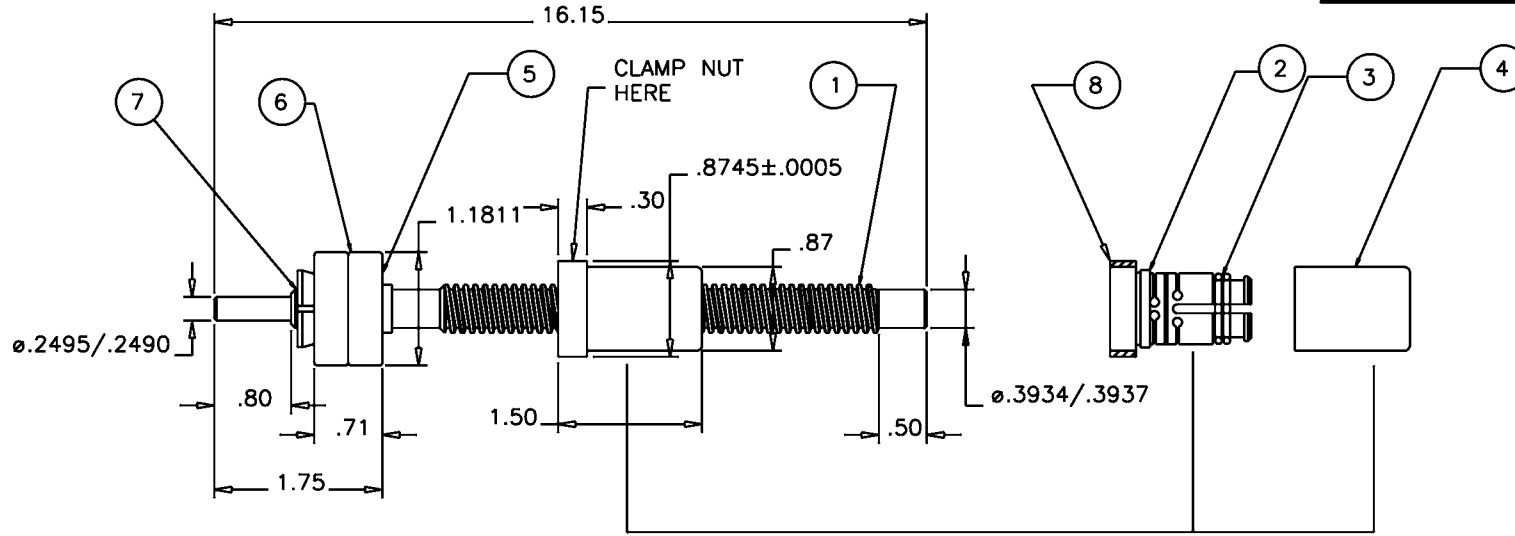


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REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED
A		SEE E.C.R. 00655	1-6-00	T.A.
B		SEE E.C.R. 00657	1-7-00	T.A.
C		SEE E.C.R. 00710	3.21.00	T.A.
D		SEE E.C.R. 00757	5.03.00	T.A.
E		SEE E.C.R. 00764	5.16.00	T.A.
F		SEE E.C.R. 01941	1.23.07	T.A.



NOTES:

1. INSTALL AND PRELOAD BALL BEARINGS AS FOLLOW:
 - A) CLEAN BALL BEARINGS AND THE LEAD SCREW
 - B) INSTALL ITEM 5 ONTO THE SHAFT, INSTALL TWO WASHER ITEM 6 BETWEEN THE BALL BEARINGS.
 - C) USE ITEM 7 TO LOCK AND PRELOAD THE INNER RACE OF THE BALL BEARING,
2. INSTALL SPRING ITEM 3 INTO NUT ITEM 2 AS SHOWN
3. LOCKTITE 262 COVER ITEM 4 INTO NUT ITEM 2.
4. INSTALL THE NUT OVER THE LEAD SCREW AS SHOWN.
5. PRESS FIT OR LOCKTITE (RED) ITEM 8 INTO ITEM 2.
6. NO BRUSHES ON NUT ASSEMBLY.
7. ZERO BACKLASH.
8. BREAKAWAY TORQUE TO BE MEASURED IN VERTICAL POSITION HOLDING NUT BY HAND USING A TORQUE WATCH, AND THE SCREW SHOULD HAVE THE GREASE PER NOTE 9. THE TORQUE TO BE SET BETWEEN 5 OZ. IN. MIN. TO 7 OZ. IN. MAX.
9. APPLY KS-46 LUBRICANT TO LEAD SCREW ITEM 1. THE GREASE IS SUPPLIED BY CUSTOMER.
10. SHIPPING INSTRUCTION: DO NOT SPRAY 5-WAY PENETRANT LUBRICATE ON THE LEAD SCREW ASSY. THE LEAD SCREW SHOULD BE PACKAGED IN THE PLASTIC TUBE WITH PLASTIC CAP.

ITEM	QTY	DRG SIZE	PART NO.	DESCRIPTION	MATERIAL OR NOTE
8	1	C	201731	SPACER	LINTECH
7	1		BH-00	LOCKNUT	W/H
6	1	C	60600	SHIM SET	LINTECH
5	2		200 S ZZ	BALL BEARING, DEEP GROVE	NSK
4	1	C	201468	COVER, NUT	LINTECH
3	2		E1-014B-7 SS	SPRING, EXT.	LEE
2	1	C	201469-06	1/2" DIA NUT, ANTI-BACKLASH	LINTECH
1	1	C	201479-06	LEAD SCREW, 1/2" DIA, .200 L	LINTECH

LIST OF MATERIAL					
UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES		DRAWN	BK	DATE	07-28-99
FRAC. DEC. ANGLES		CHECKED			
1/16" 0.005 1/32"		APPROVED	BK	DATE	07-02-99
BREAK ALL SHARP EDGES		MATERIAL		PART NAME LEAD SCREW ASSY., 1/2" DIA, .200 L, 12.00 T	
MACHINED SURFACE 12.5		FINISH		CODE IDENT	86849
SCALE 1/1				DWG SIZE	C
APPLICATION				DRAWING OR PART NO.	201729

DO NOT SCALE

D
C
F
B
A