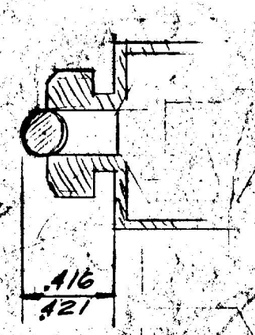
COLE-HERSEE CO.

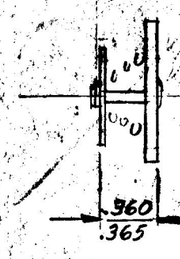
① HOUSING AND BALL SUB-ASSY



TOOL # B-25-11

GAGE # 9088A-1

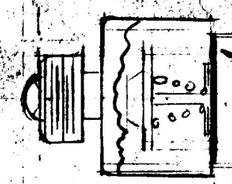
②



CONTROLLED AT (1 TON) HYDR.

TOOL # R-23-5

③



SIZE WITH GASKET IN PLACE ON TON HYDR. 2000 LBS. PRESSURE

TOOL # 5-24-4

— NOTES —

① SIZING OPERATION -(SKETCH 3) IS CONTROLLING INFLUENCE TO INSURE ACCURATE CONTACT POSITION AND "WASHES" OUT MFG. TOLERANCES OF MOST COMPONENTS.

[illegible]

③ AT EACH PRODUCTION RUN PILOT LOTS SHOULD BE SIZED, FINAL CLOSED AND TESTED TO ASSURE COMPLIANCE WITH CONTACT TOLERANCE — ADJUSTMENTS TO HYDRAULIC PRESSURE AND SIZING TOOL MAY BE AT TIMES ADVISABLE.

④ FINAL CLOSING TOOL SHOULD BE SET AT 2000 LBS AND SHOULD RESULT IN APPROX. 80% GOOD AND 20% "NO LITE" — THOSE IN CATEGORY OF "NO LITE" CAN THEN BE RESTRUCK AT 3500 LBS.

⑤ CHECK ALL PARTS AND SUB-ASSEMBLIES TO DWGS. AVAILABLE BEFORE ASSY OPERATIONS, SEE DWG NO'S LISTED ON THIS SHEET.

— OPERATIONS —

1- ASSEMBLE 9088-2 BALL TO 9088A-1 HOUSING & SIZE AND TRAY. SEE SKETCH #1
TOOL # B-25-11 GAGE # 9088A1 .416-.421

2- ASSEMBLE 9146-103 CONTACT ASSY. - # 9146-9 EYELET, 9146-8 CONTACT AND TRAY
HYDR. (1 TON) - SEE SKETCH #2
TOOL # ____

3- ASSEMBLE # 97050 - Ⓐ OIL SEAL TO # 9088A-3 SHAFT
O-H-J PRESS
TOOL # B-25-17

4- ASSEMBLE 9088A-101 OIL SEAL & SHAFT ASSY # 9088A-25 CUP # 88526 WASHER INSULATOR AND CONTACT ASSY AND 9162-16 GASKET AND TRAY.

5- SIZE ABOVE ASSY
HYDR. (6 TONS)
TOOL # 5-24-4 AND TRAY

6- ASSEMBLE # 9088A-26 SPRING # 9133-101 TERM. INSULATOR ASSY TO ABOVE ASSY AND CLOSE ____
HYDR. (6 TONS) TOOL # K-24-14

7- CIRCUIT TEST
FIXTURE # ____

9242

DWG #	QUA
9088A-101	1
9133-101	1
9146-103	1
9242-101	1
9242-102	1
9088A-1	1
9088-2	1
88526	1
9088A-25	1
9162-16	1
9088A-3	1
97050 Ⓐ	1
9088-19	1
9146-8	1
9146-9	1
88525	1
9088-20	1
9146-10	1
88525	1

LET	WAS	DATE	BY	LET	WAS	DATE	BY
				A	9088A-24 13437	5-1-63	S

MATERIAL

FINISH

TOLERANCES FRACTIONAL ± DECIMAL ±

DRAWN | CHECKED ✓ | APPR'V'D | SCALE | USED ON

DATE DRAWN 2-4-60

COLE-HERSEE COMPANY
BOSTON 27, MASS., U.S.A.

DATE ISSUED

NAME ASSEMBLY PROCEDURES

PART NO. 9242

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