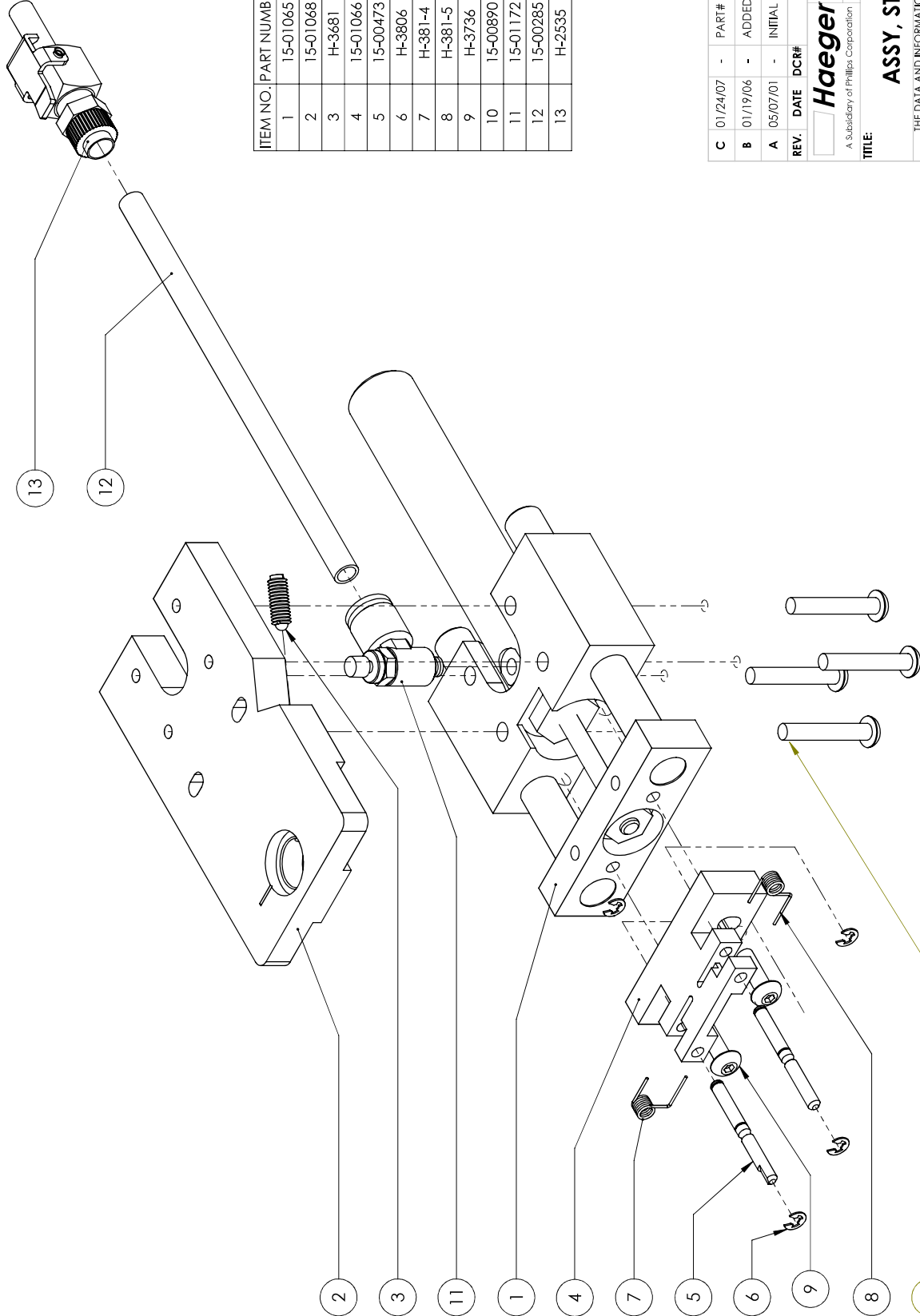


ASSEMBLY NOTES

1. ADJUST JAW BLOCK UP TO SLIDE WITHIN .010 OF MAIN PLATE.
2. TOP LEGS OF JAW SPRINGS TO RIDE IN SLOTS ON TOP OF JAW PLATE.
3. TIGHTEN BALL PLUNGER TO FIT TIGHTLY AGAINST INSTALLED AND LOCKED TUBE CONNECTOR (USE SAMPLE IF NECESSARY)
4. ADJUST FLOW CONTROL ELBOW SO THAT SLIDE MOVES SMOOTHLY AT MEDIUM SPEED
5. INSTALL PART # H-3681 SPRING PLUNGER USING LOCKTITE BRAND # 222MS THREAD LOCKER (PURPLE); USE ONE DROP APPROX AT THE MIDDLE OF THE THREAD



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	15-01065	ASSY, GUIDED AIR CYLINDER	1
2	15-01068	TUBE CONNECTOR PLATE, DUAL GUIDED SHUTTLE	1
3	H-3681	SPRING PLUNGER, M5, STEEL	1
4	15-01066	JAW BLOCK, DUAL GUIDED SHUTTLE	1
5	15-00473	MODIFIED JAW PIN, 1/8, DUAL GUIDED SHUTTLE	2
6	H-3806	SNAP RING, E-STYLE 1/8, BLACK	4
7	H-381-4	SPRING, RIGHT HAND WIND, JAW	1
8	H-381-5	SPRING, LEFT HAND WIND, JAW	1
9	H-3736	BHCS, #8-32 x 1/2"	2
10	15-00890	BHCS, M4 x 0.7 x 25mm, ZINC PLATED	4
11	15-01172	FLOW CONTROL ELBOW, 10-32 X 1/4, METER OUT	1
12	15-00285	24" LONG TUBING, 1/4, BLACK	1
13	H-2535	QUICK DISCONNECT, 1/4"	1

PRINTED BY: _____
DATE: ___ / ___ / ___

C	01/24/07	-	PART # 15-00473 WAS 10-00443
B	01/19/06	-	ADDED NOTE: 5
A	05/07/01	-	INITIAL RELEASE

REV.	DATE	DCR#	DESCRIPTION
Haeger MATERIAL: SEE BOM			
A Subsidiary of Phillips Corporation SCALE: 1:1			

PART NO: 15-01173

ASSY, STUD & SO, DUAL GUIDED SHUTTLE

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REVISION: **C** DWG. NO: 15-01173