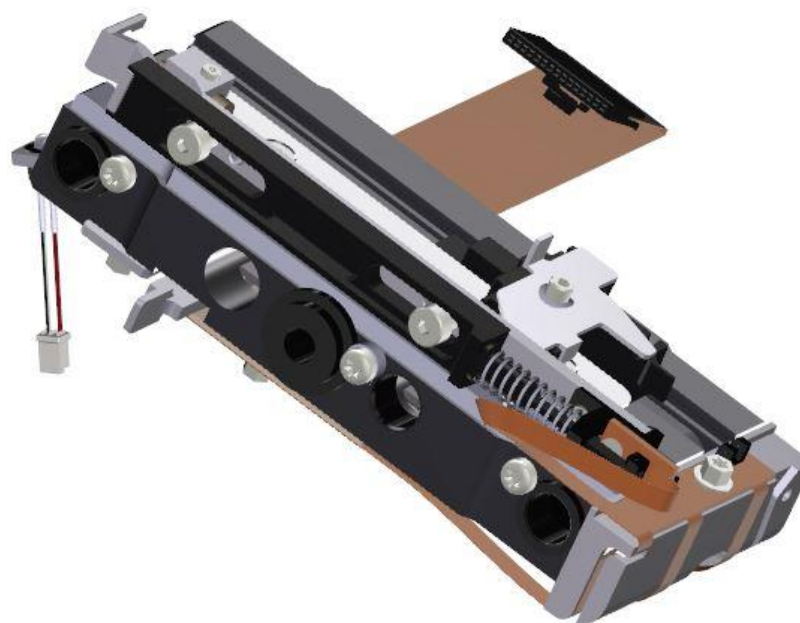


Author: D.Guertin



Verify



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Torque



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ASP Revision 'AA' included the following changes (ECR 9221253):

- OPER 6.10 through 6.15 - Replaced instructions to use new Crease Fixture including images, callouts and instructions.
- Sequenced remaining OPER 6 steps to keep in order.



Verify



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Torque



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OPER
1.0

OPERATION DESCRIPTION
BUSHING INSTALLATION

ITEM	QTY	PART #	DESCRIPTION
1	1	405011225	Needle Carriage Block
2	2	405009623	Bushing
3	2	WAT417303	Set Screw

TOOL #	DESCRIPTION
N/A	Torque Driver (30 in-ozs) with T6 Torx Bit
N/A	5mm Nut Driver

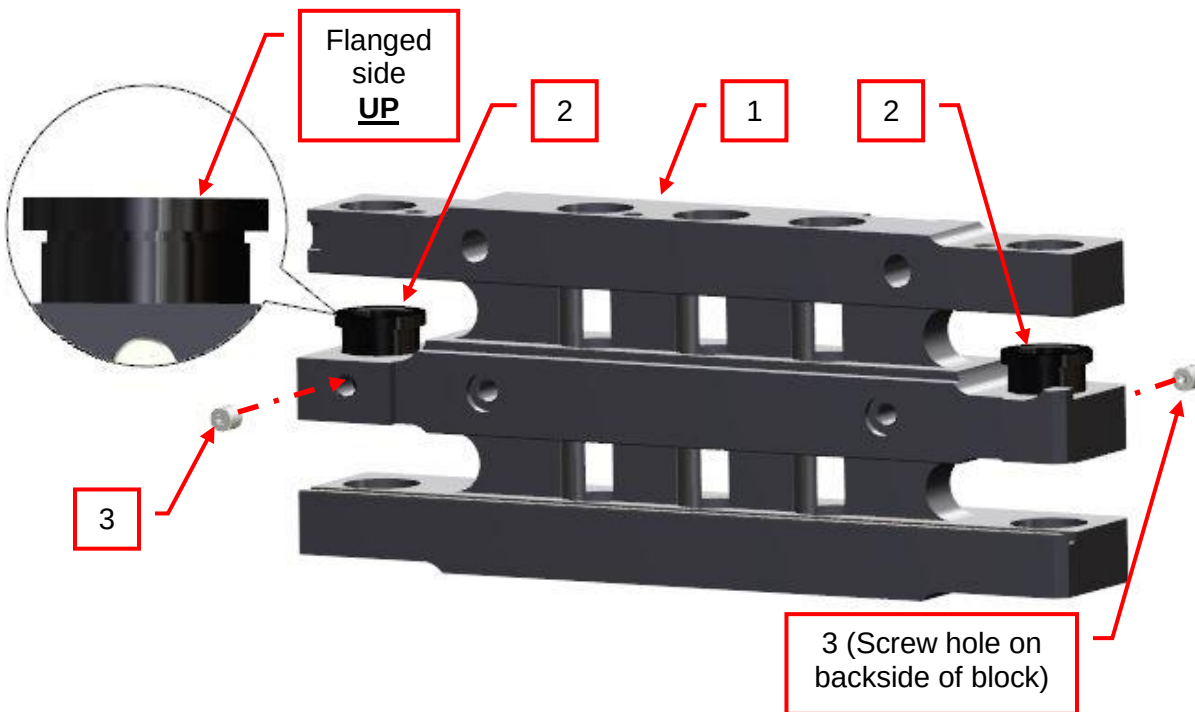
NOTE: If assembling Needle Carriage Drive assembly using Atlas Copco Micro Torque System, follow procedure [735004316](#).

- 1.1 Orient needle carriage block and flanged side of bushings as shown and insert into center hole in needle carriage block on both ends.



- 1.2 Secure each bushing to the block with a set screw applying a torque of 30 in-ozs.

NOTE: Set screw holes are on opposite sides of needle carriage block.



Verify



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Torque



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1.0

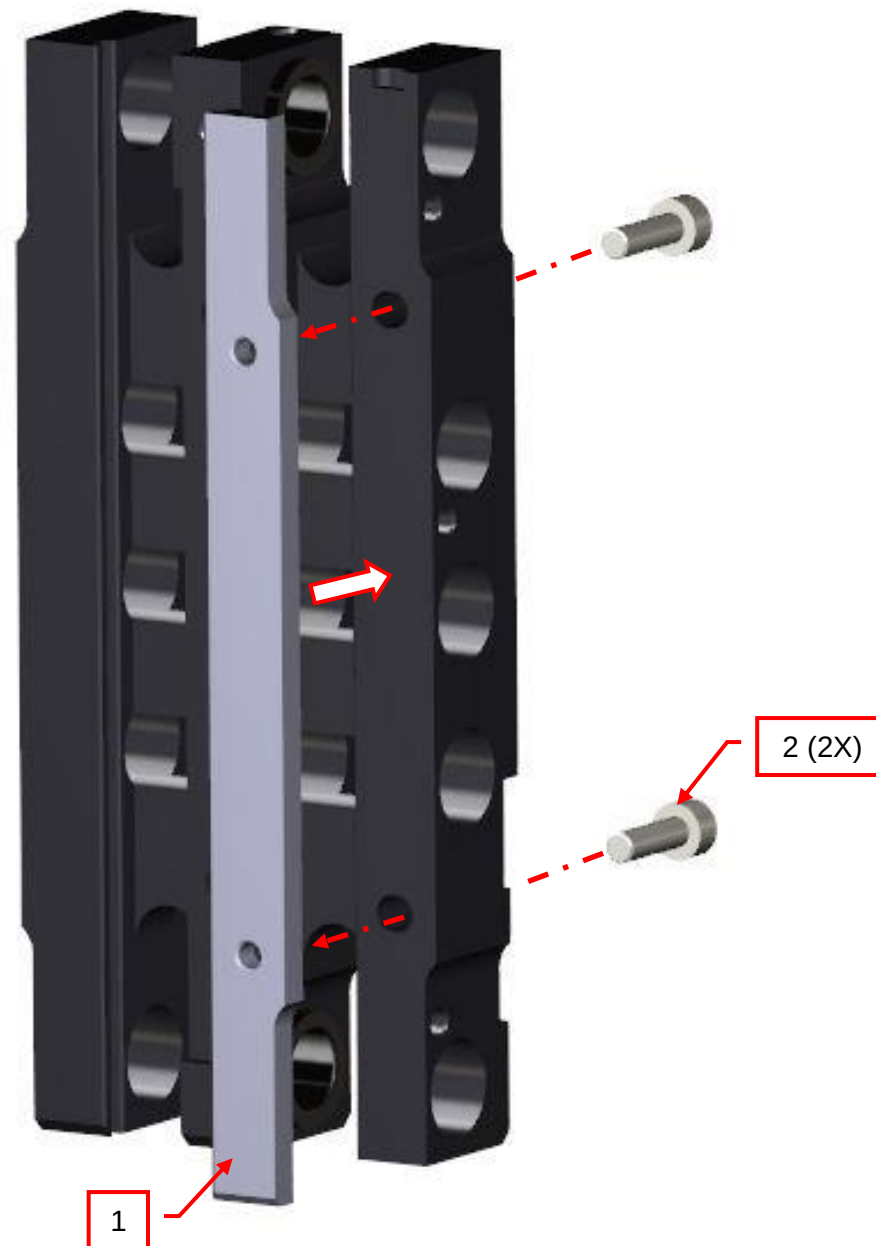
OPERATION DESCRIPTION
BUSHING INSTALLATION

ITEM	QTY	PART #	DESCRIPTION
1	1	405011226	Needle Block Rail Guide
2	2	WAT413310	Screw

TOOL #	DESCRIPTION
N/A	T10 Torx Driver

- 1.3 Orient and attach needle block rail guide to needle carriage block assembly with two screws as shown.

NOTE: Leave screws loose.



Verify



Scan



Torque



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Electrostatic

OPER
2.0

OPERATION DESCRIPTION
STRIPPER BLOCK ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	405011070	Stripper Guide Block
2	1	415001901	Stripper Block Rail
3	1	410001066	Screw

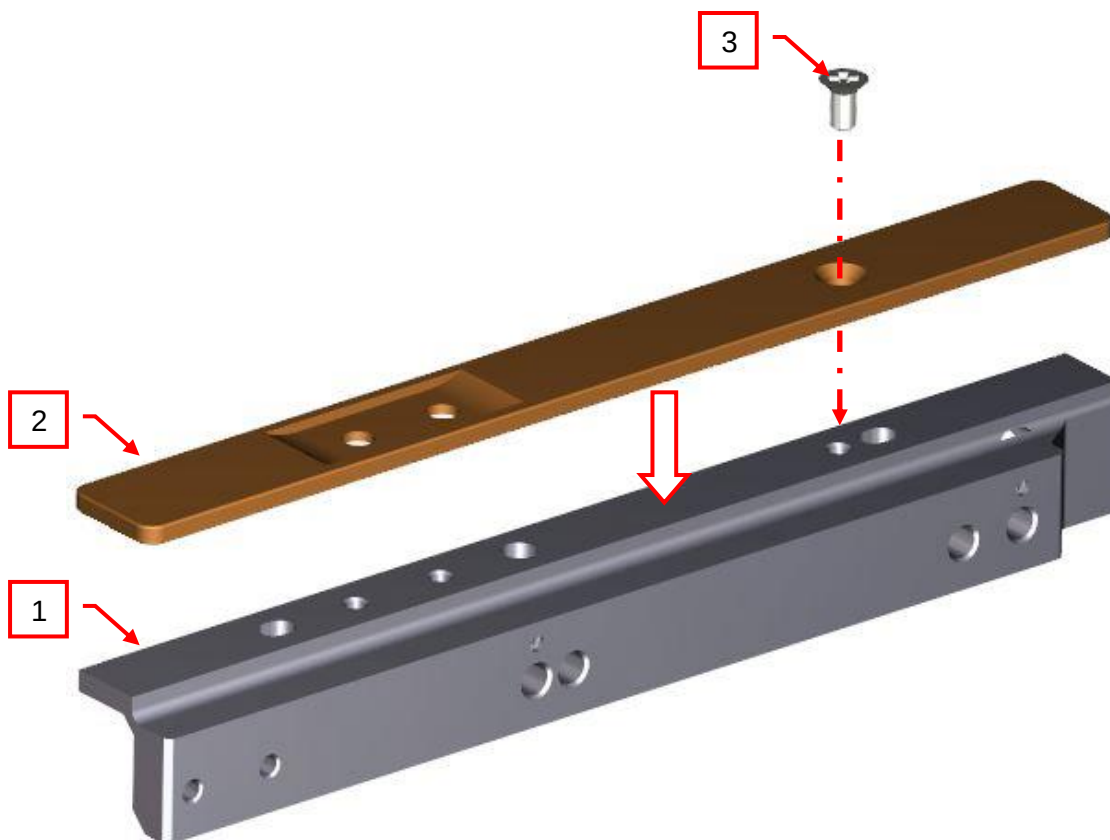
TOOL #	DESCRIPTION
N/A	Torque Driver (41 in-ozs) with Phillips Bit

2.1 Attach stripper block rail to the stripper guide block with a screw.



2.2 Torque screw to 41 in-ozs.

NOTE: Keep stripper guide rail parallel to the stripper block rail.



Verify



Scan



Torque



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OPER
2.0

OPERATION DESCRIPTION
STRIPPER BLOCK ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	N/A	Stripper Block Assembly
2	1	405003380	Belt
3	1	400003719	Belt Clamp
4	2	410005415	Screw

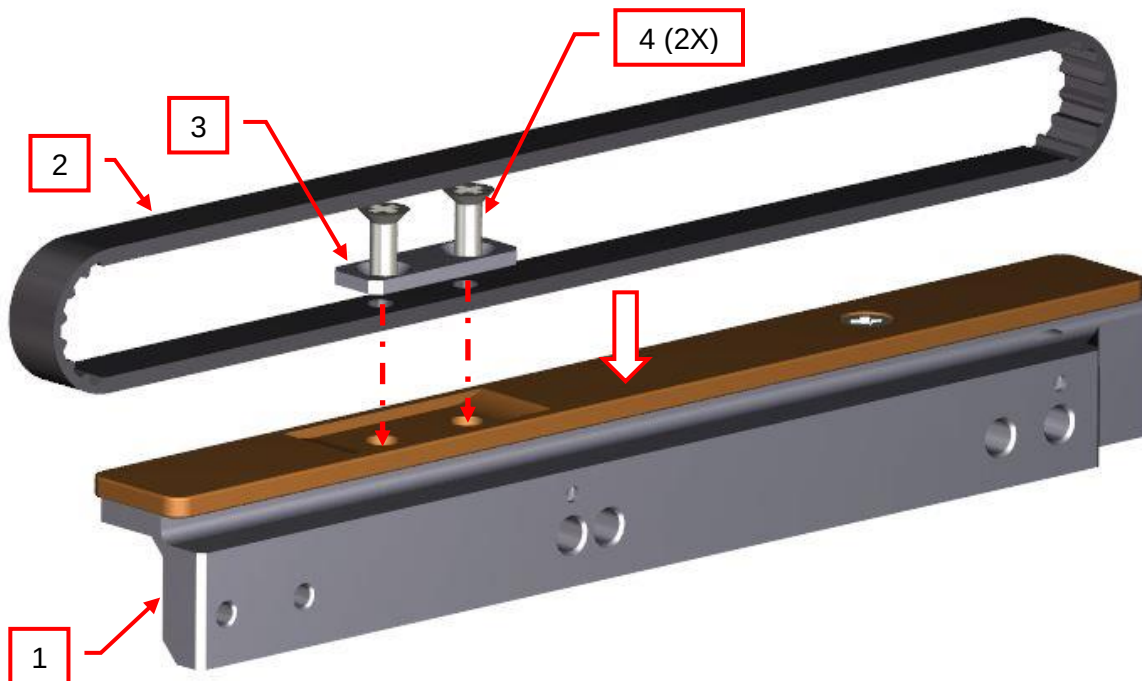
TOOL #	DESCRIPTION
N/A	Torque Driver (41 in-ozs) with Phillips Bit

2.3 Attach belt to stripper block assembly using a belt clamp and two screws.



2.4 Torque screws to 41 in-ozs.

NOTE: Keep stripper block assembly and belt assembly parallel.



Verify



Scan



Torque



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2.0

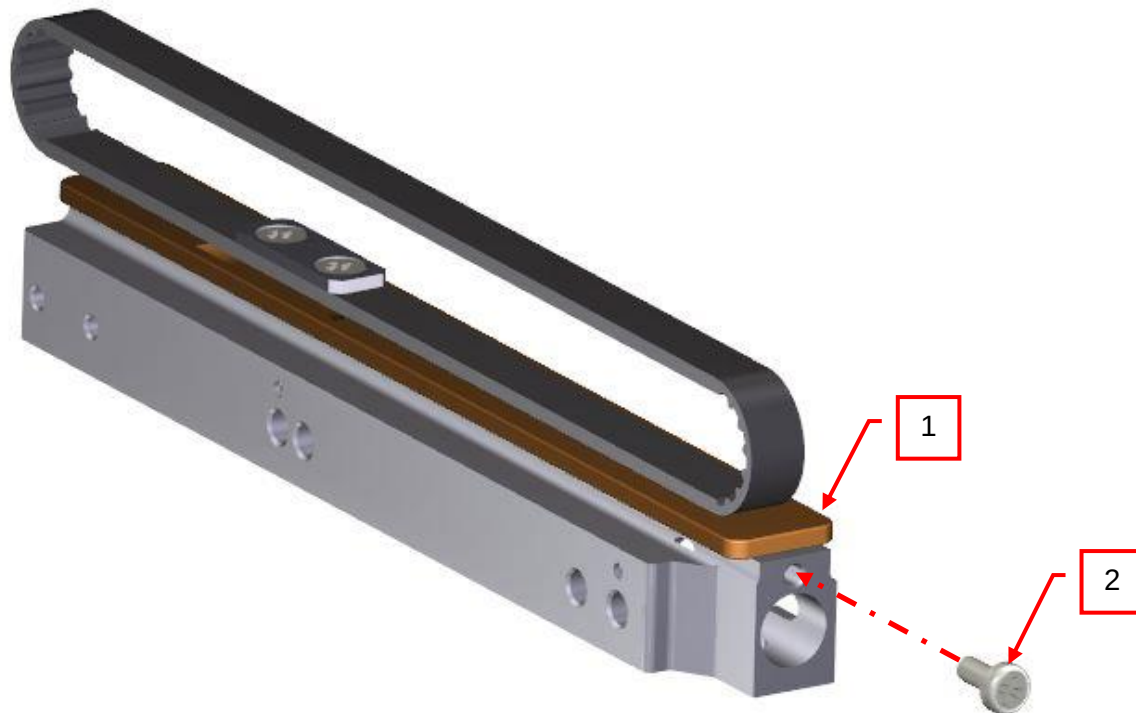
OPERATION DESCRIPTION
STRIPPER BLOCK ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	N/A	Stripper Block Assembly
2	1	410000723	Screw

TOOL #	DESCRIPTION
N/A	Torque Driver (41 in-ozs) with Phillips Bit



2.5 Torque a screw into stripper block assembly where shown to 41 in-ozs.



Verify



Scan



Torque



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OPER
3.0

OPERATION DESCRIPTION
NEEDLE RETAINER ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	415001487	Sample Needle Mounting Base
2	1	400004208	Needle Retainer
3	1	410001302	Curved Spring Washer
4	1	405011152	Shoulder Screw

TOOL #	DESCRIPTION
N/A	Torque Driver (41 in-ozs) with 2mm Hex Bit

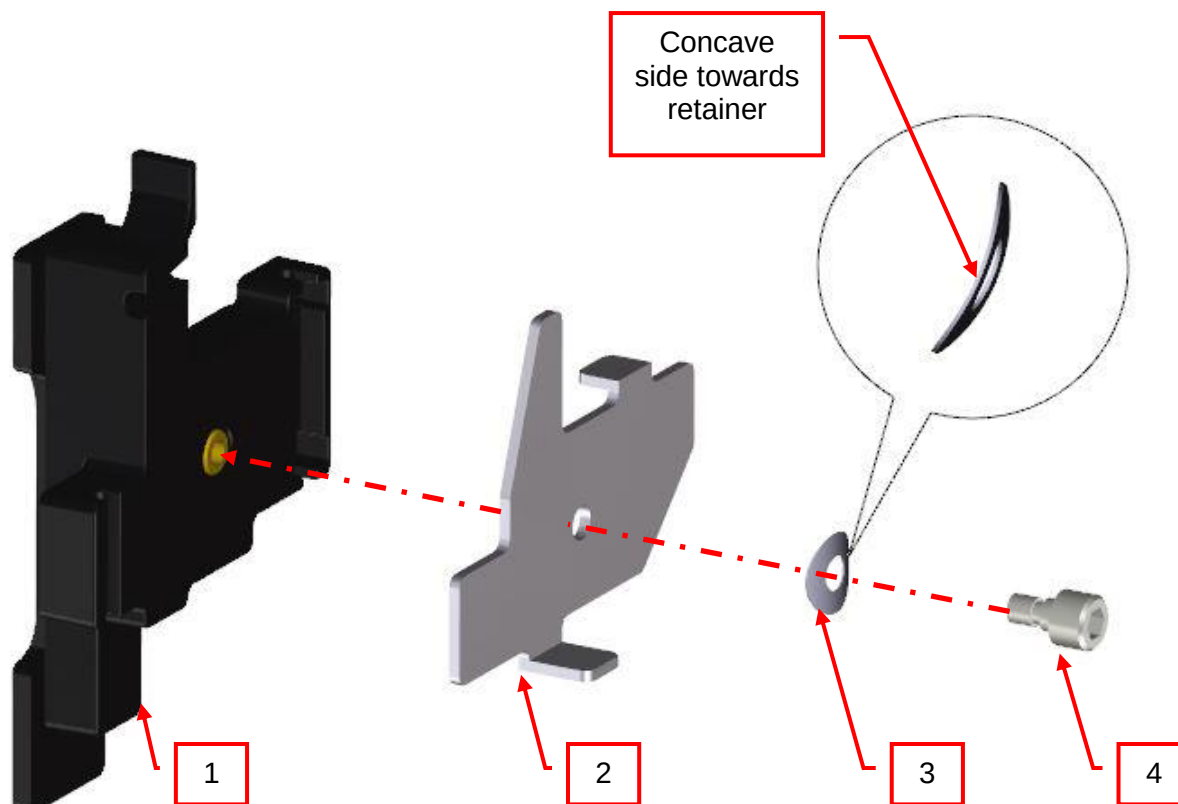
3.1 Attach needle retainer to sample needle mounting base with a curved spring washer and shoulder screw.

NOTE: Ensure curved spring washer is installed concave side towards needle retainer, as shown.



3.2 Torque shoulder screw to 41 in-ozs.

NOTE: Ensure needle retainer turns smoothly after assembly.



Verify



Scan



Torque



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OPER
3.0

OPERATION DESCRIPTION
NEEDLE RETAINER ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	N/A	Needle Retainer Assembly
2	1	405003380	Belt
3	1	400003719	Belt Clamp
4	2	410001500	Screw

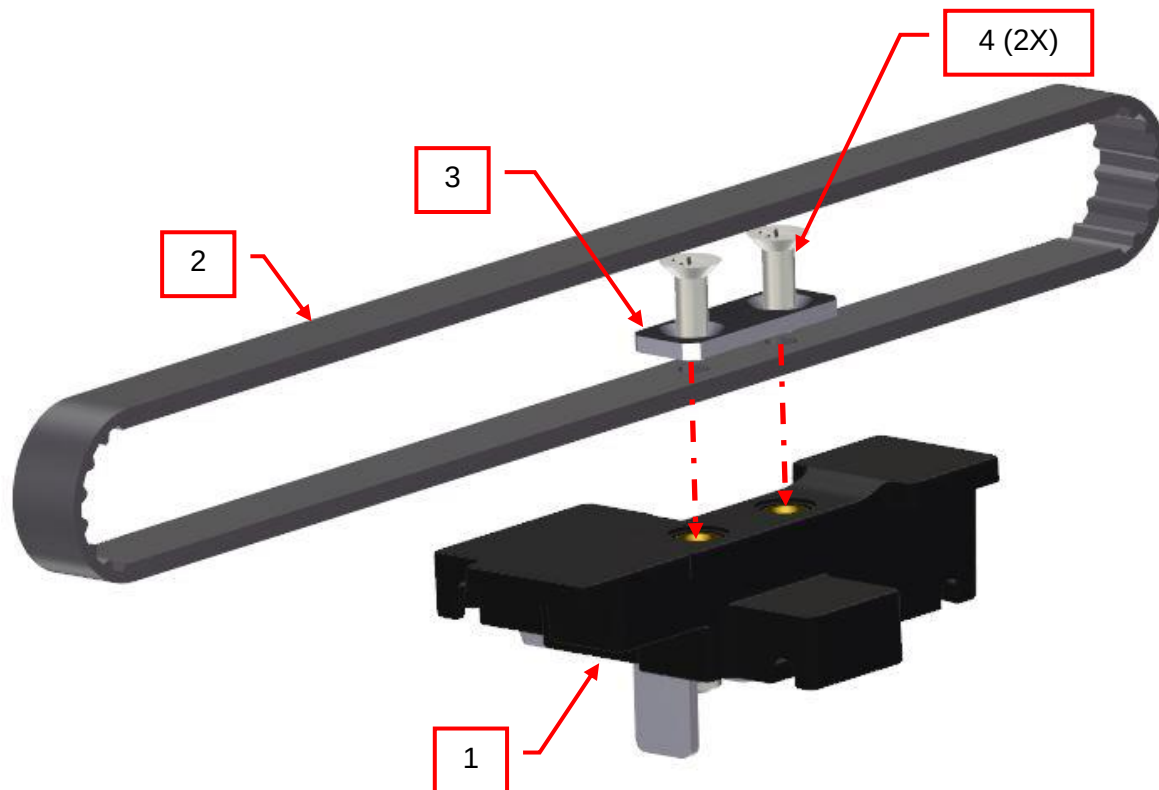
TOOL #	DESCRIPTION
N/A	Torque Driver (41 in-ozs) with Phillips Bit

3.3 Attach belt to needle retainer assembly using a belt clamp and two screws.



3.4 Torque screws to 41 in-ozs.

NOTE: Keep the needle retainer assembly and belt assembly parallel.



Verify



Scan



Torque



Critical Clean



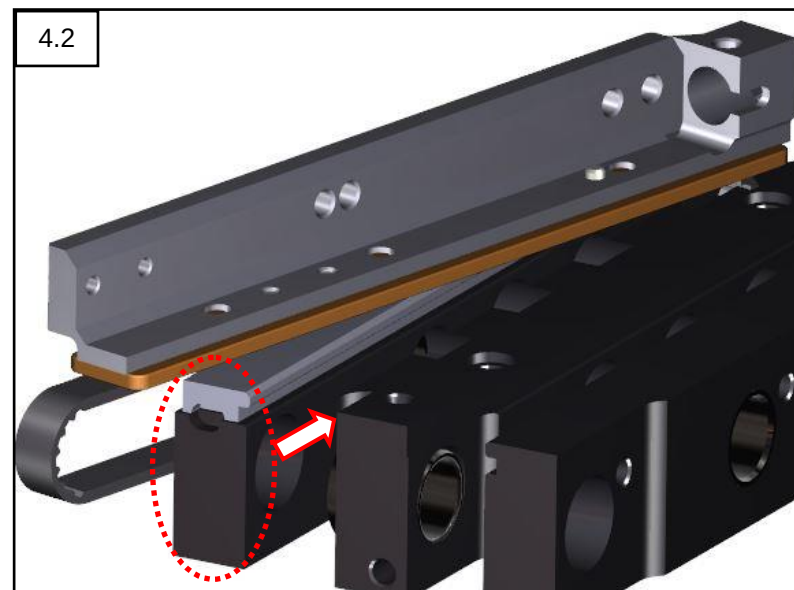
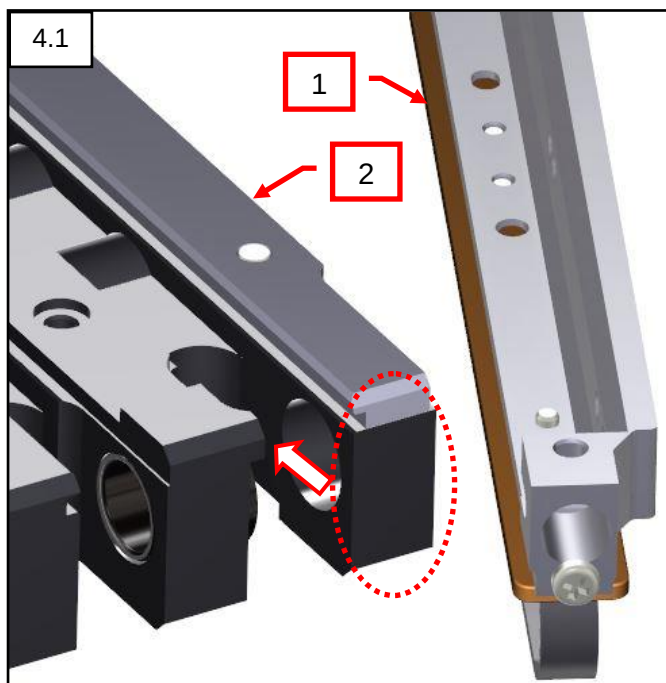
Electrostatic

OPER
4.0

OPERATION DESCRIPTION
BLOCK ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	N/A	Stripper Block Assembly
2	1	N/A	Needle Carriage Block Assembly

- 4.1 On rail guide side of needle carriage block assembly, loop stripper block assembly belt over one end, placing belt into block slot.
- 4.2 Loop belt over other side of needle carriage block assembly.



Verify



Scan



Torque



Critical Clean



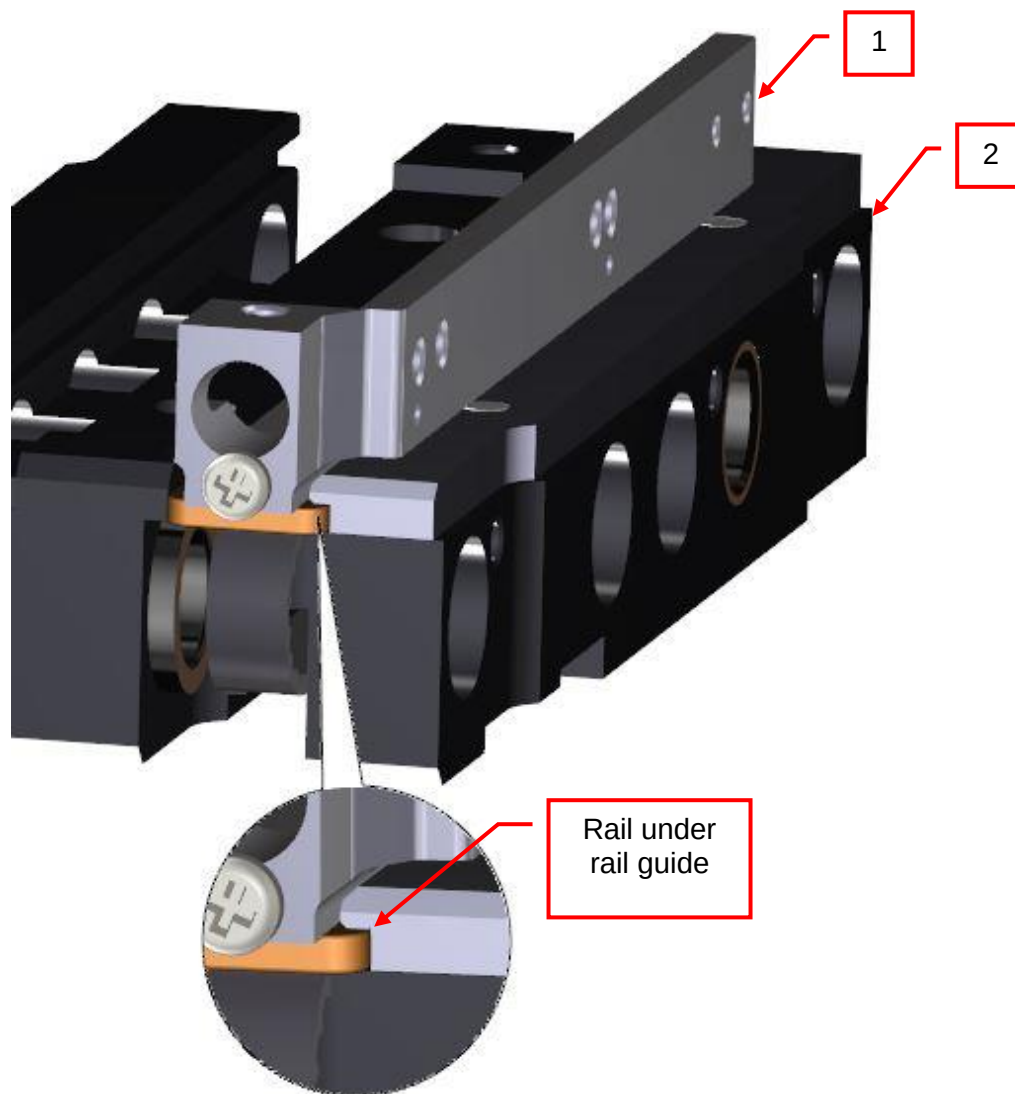
Electrostatic

OPER
4.0

OPERATION DESCRIPTION
BLOCK ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	N/A	Stripper Block Assembly
2	1	N/A	Needle Carriage Block Assembly

- 4.3 Slide stripper block assembly rail under needle carriage block assembly rail guide, as shown.



Verify



Scan



Torque



Critical Clean



Electrostatic

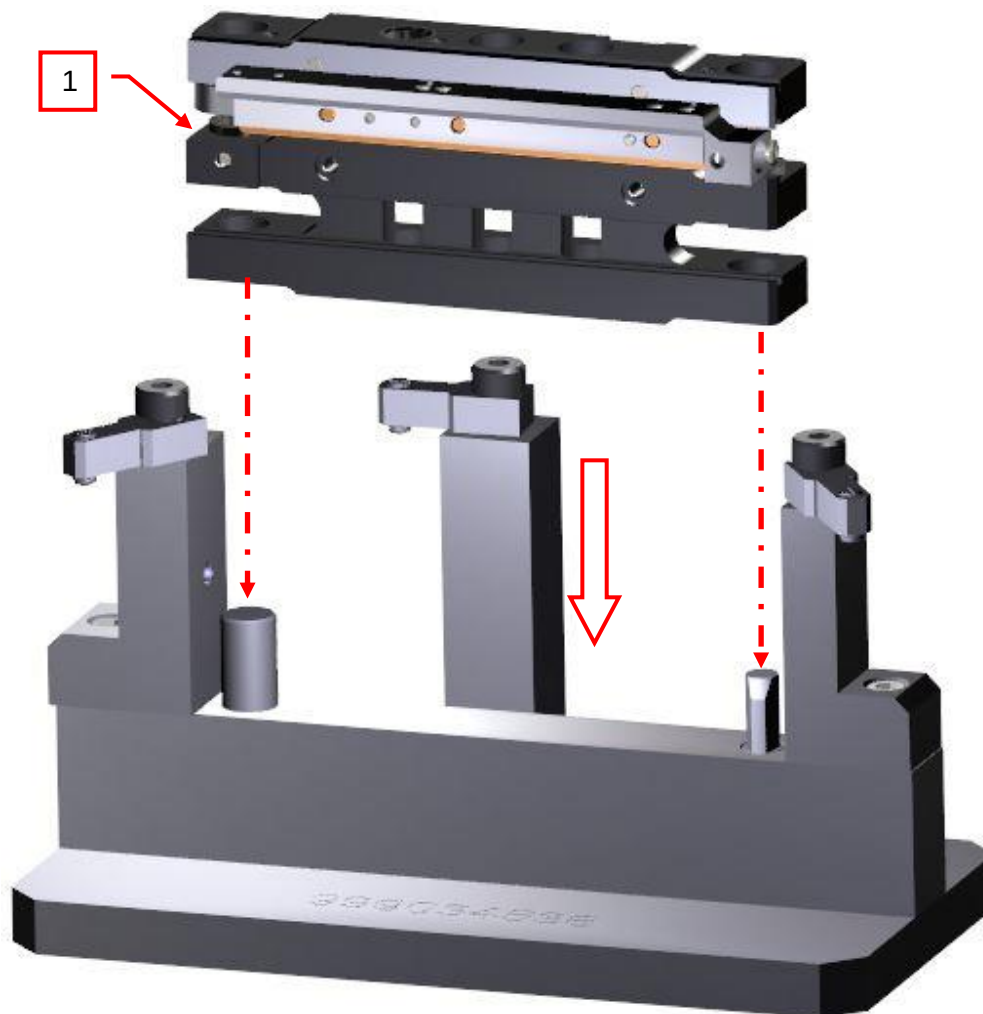
OPER
4.0

OPERATION DESCRIPTION
BLOCK ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	N/A	Needle Carriage Block Assembly with Stripper

TOOL #	DESCRIPTION
999034536	Assembly Clamp Fixture

- 4.4 Rotate arms on clamp fixture to allow assembly to be installed.
- 4.5 Orient and slide the needle carriage block assembly onto pins on clamp fixture, as shown.



Verify



Scan



Torque



Critical Clean



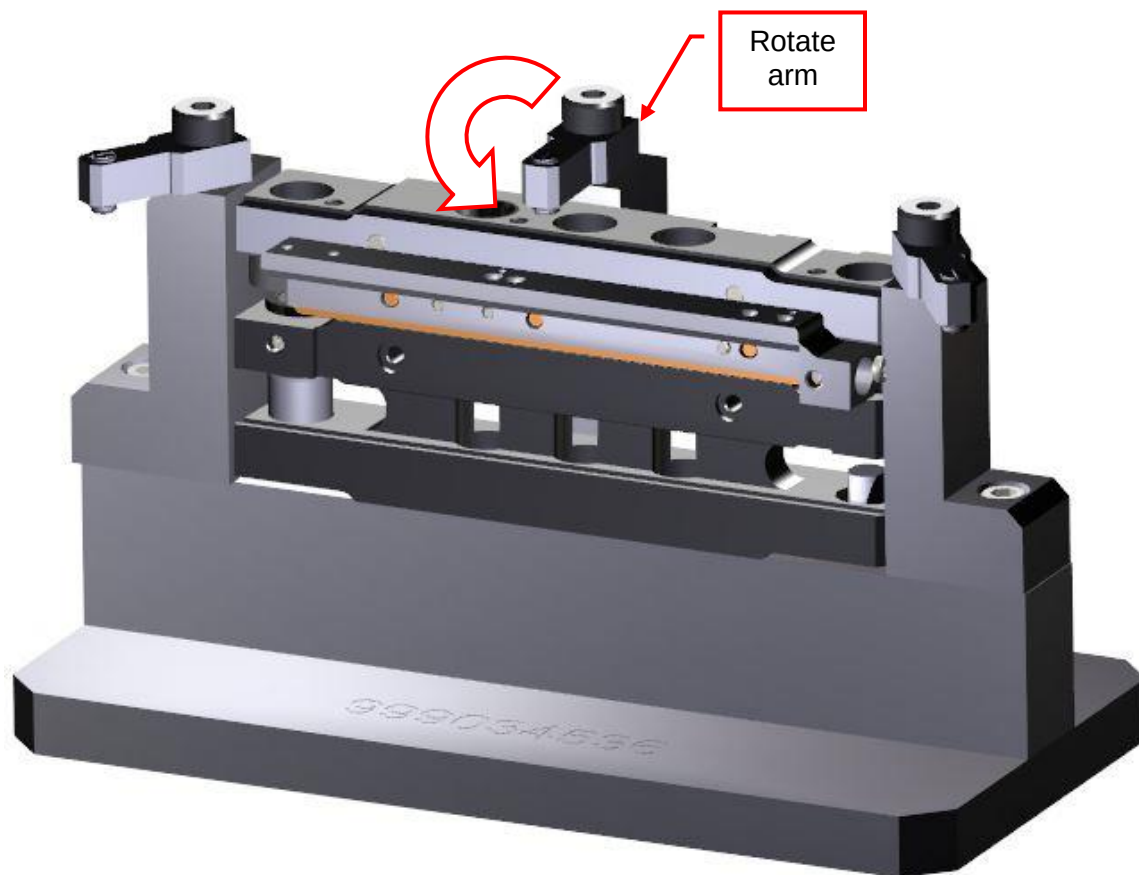
Electrostatic

OPER
4.0

OPERATION DESCRIPTION
BLOCK ASSEMBLY

<u>TOOL #</u>	<u>DESCRIPTION</u>
999034536	Assembly Clamp Fixture

4.6 Rotate clamp fixture center arm to hold needle carriage block assembly.



Verify



Scan



Torque



Critical Clean



Electrostatic

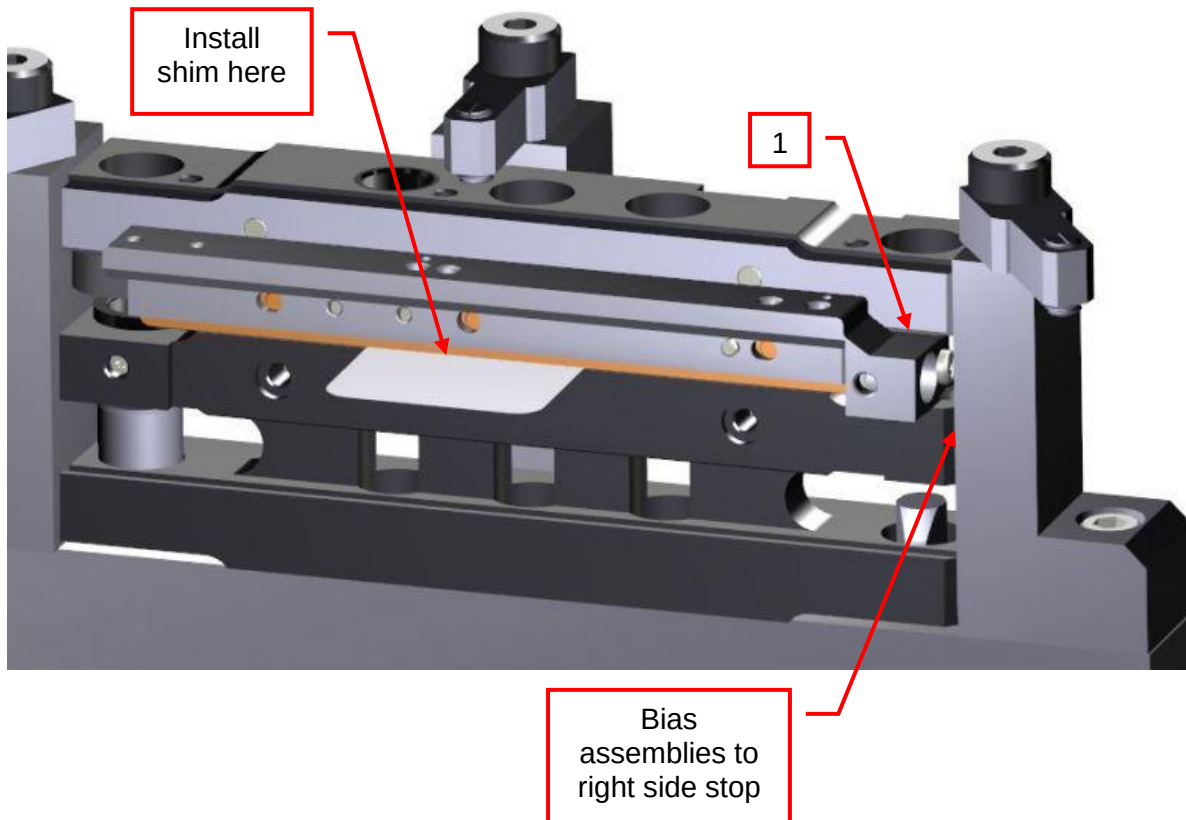
OPER
4.0

OPERATION DESCRIPTION
BLOCK ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	N/A	Stripper Block Assembly

TOOL #	DESCRIPTION
999034536	Assembly Clamp Fixture
999034532	.0015 Shim

- 4.7 Bias needle carriage block assembly and stripper block assembly against right side stop of clamp fixture.
- 4.8 Place .0015 shim between needle carriage block assembly and stripper block assembly, where shown.



Verify



Scan



Torque



Critical Clean



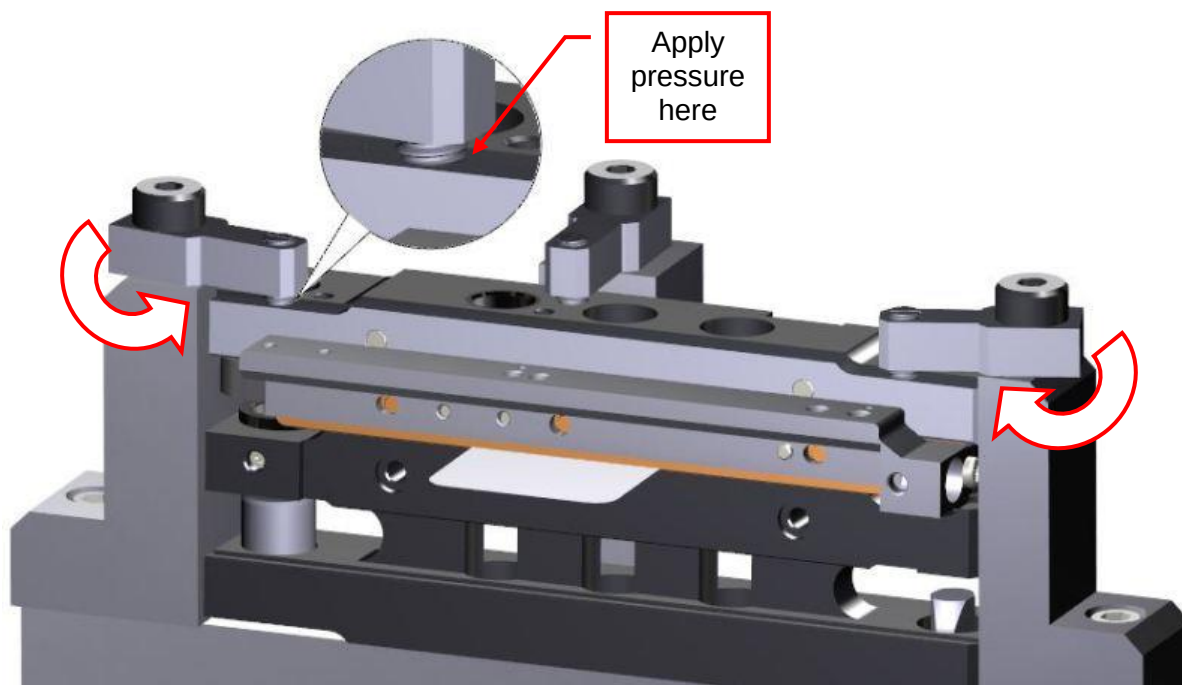
Electrostatic

OPER
4.0

OPERATION DESCRIPTION
BLOCK ASSEMBLY

<u>TOOL #</u>	<u>DESCRIPTION</u>
999034536	Assembly Clamp Fixture
999034532	.0015 Shim

4.9 Rotate clamp fixture outside arms to apply pressure to the stripper block assembly guide block, where shown.



Verify



Scan



Torque



Critical Clean



Electrostatic

OPER
4.0

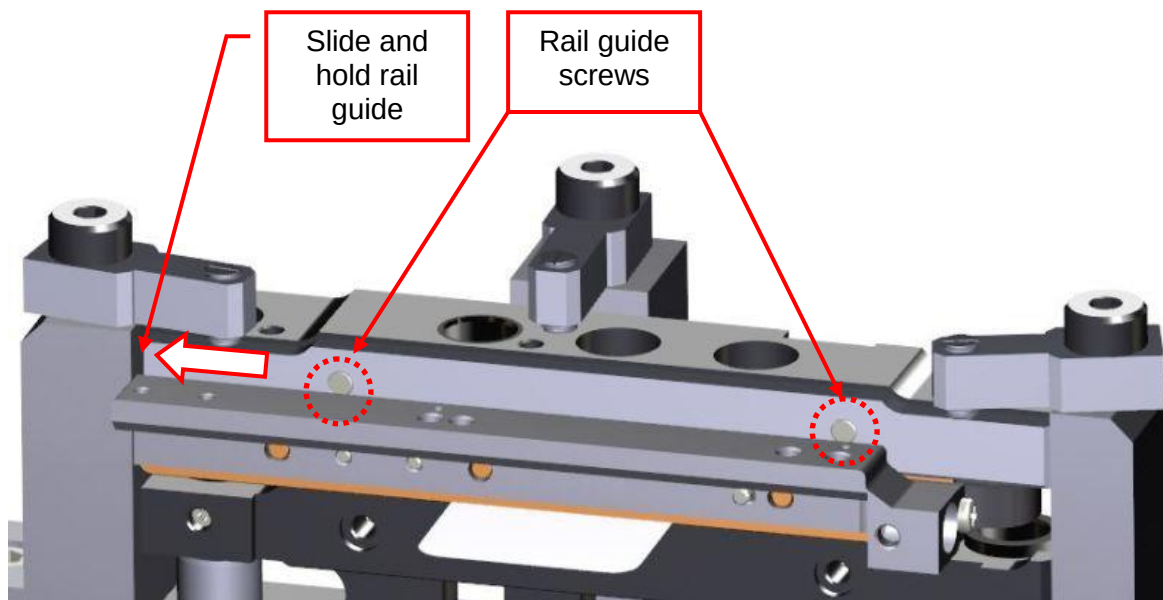
OPERATION DESCRIPTION
BLOCK ASSEMBLY

<u>TOOL #</u>	<u>DESCRIPTION</u>
999034536	Assembly Clamp Fixture
999034532	.0015 Shim

4.10 Slide and hold needle block rail guide to the left of assembly clamp fixture.



4.11 While holding needle block rail guide in position, torque two rail guide screws left loose from Oper 1.3 to 10 in-lbs.



Verify



Scan



Torque



Critical Clean



Electrostatic

OPER
4.0

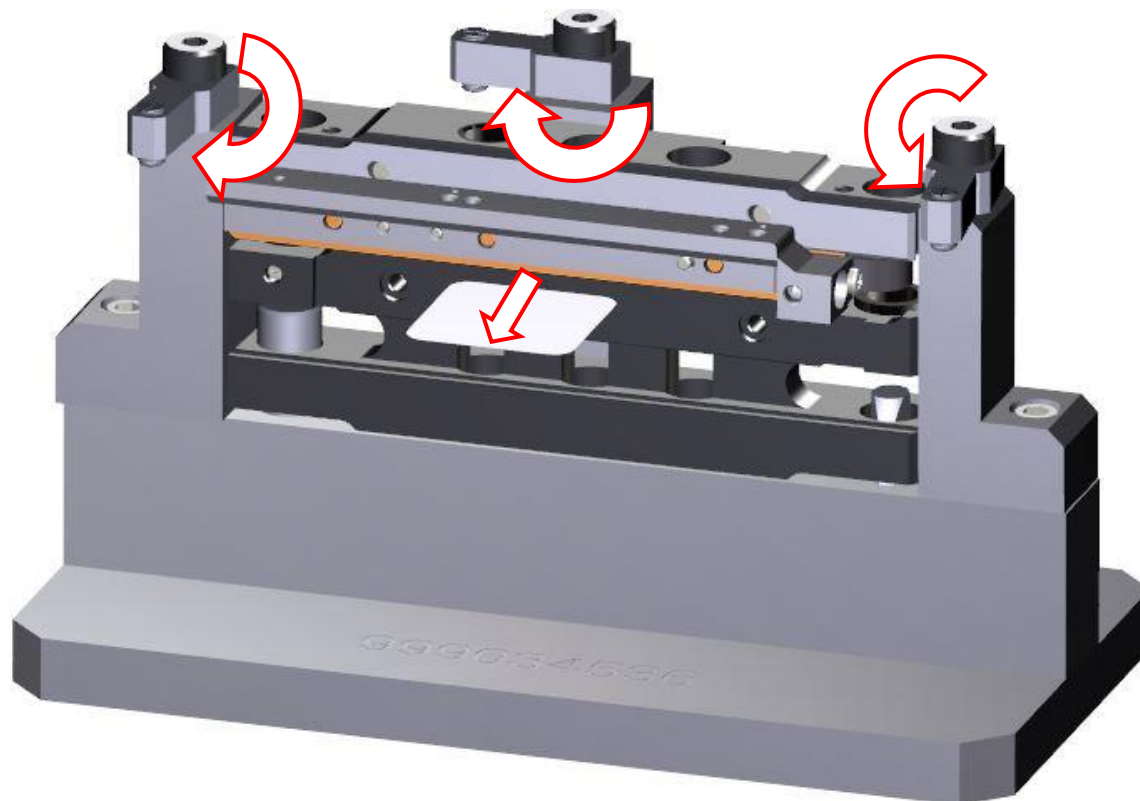
OPERATION DESCRIPTION
BLOCK ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	N/A	Needle Carriage Block Assembly

TOOL #	DESCRIPTION
999034536	Assembly Clamp Fixture
999034532	.0015 Shim

4.12 Remove shim.

4.13 Rotate clamp fixture arms to release pressure on needle carriage block assembly.



Verify



Scan



Torque



Critical Clean



Electrostatic

OPER
4.0

OPERATION DESCRIPTION
BLOCK ASSEMBLY

TOOL #	DESCRIPTION
999034536	Assembly Clamp Fixture

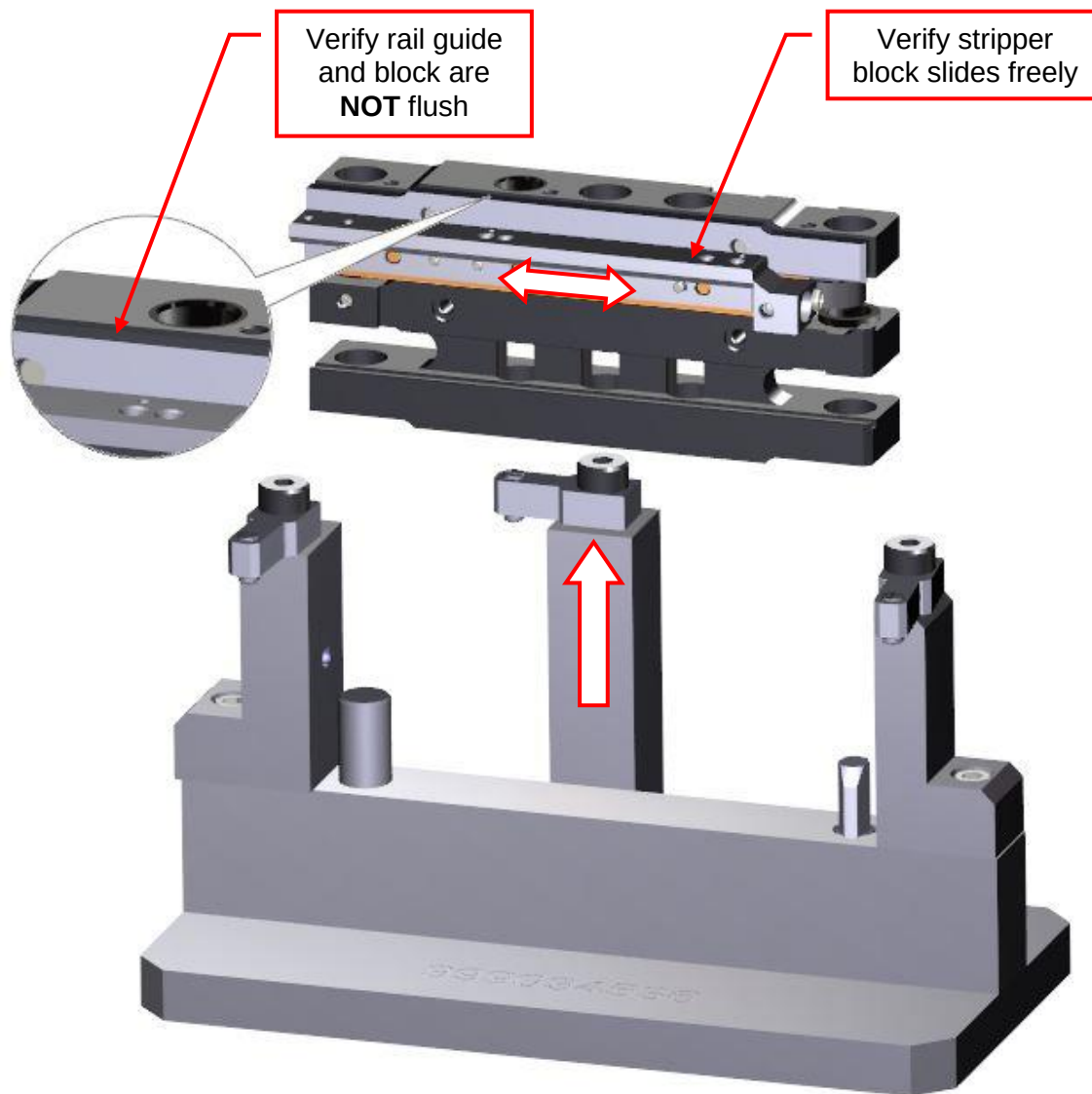
4.14 Remove needle carriage block assembly from clamp fixture.



4.15 Verify stripper block assembly is sliding freely in groove.



4.16 Verify needle block rail guide and needle carriage block assembly are **NOT** flush, where shown.



Verify



Scan



Torque



Critical Clean



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OPER
5.0

OPERATION DESCRIPTION
BELT ASSEMBLY

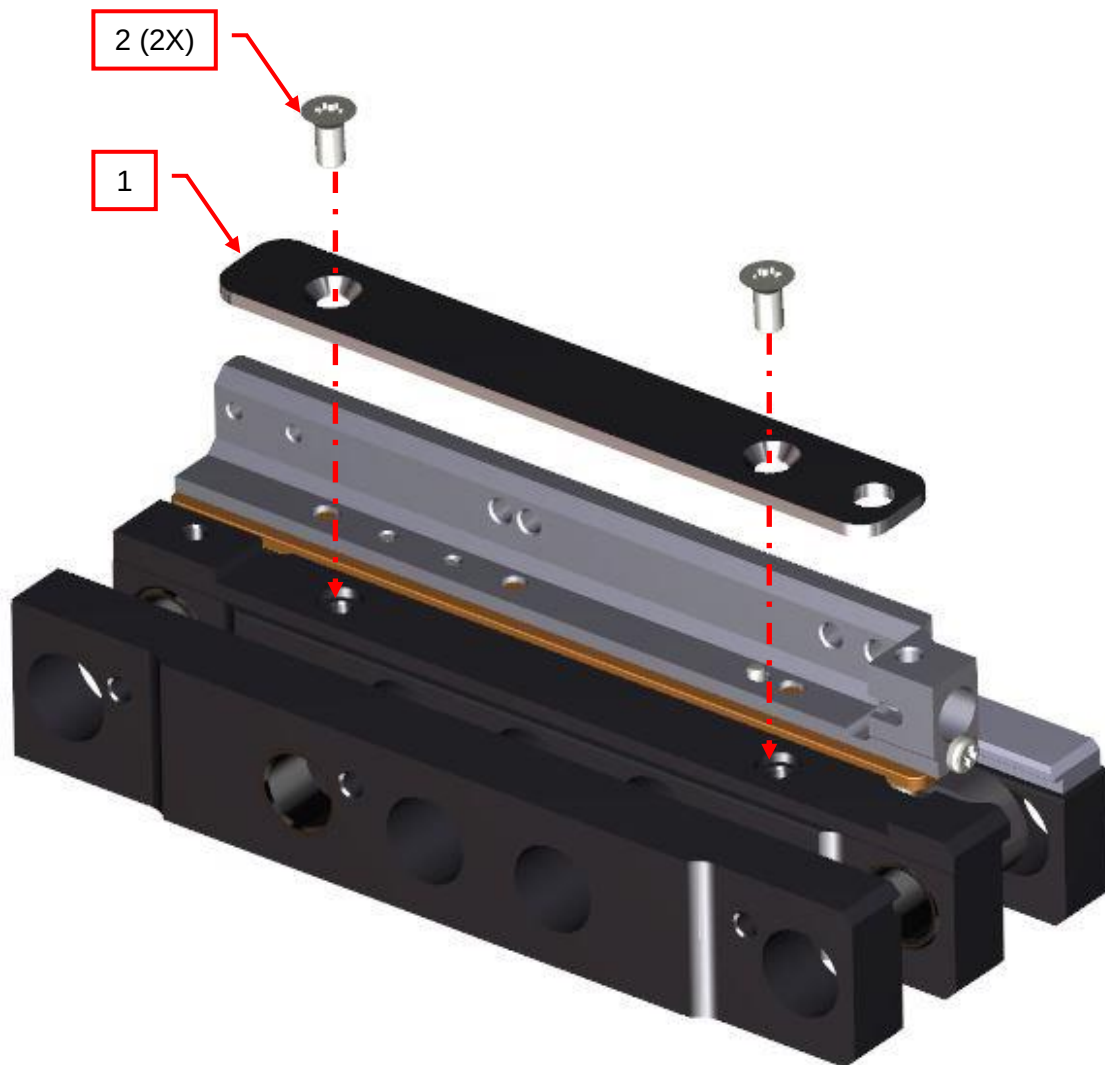
ITEM	QTY	PART #	DESCRIPTION
1	1	405006344	Belt Cover
2	2	WAT414306	M3 Screw

TOOL #	DESCRIPTION
N/A	Torque Driver (10 in-lbs) with T10 Torx Bit

5.1 Orient and attach the belt cover to the needle carriage block assembly with two screws.



5.2 Torque screws to 10 in-lbs.



Verify



Scan



Torque



Critical Clean



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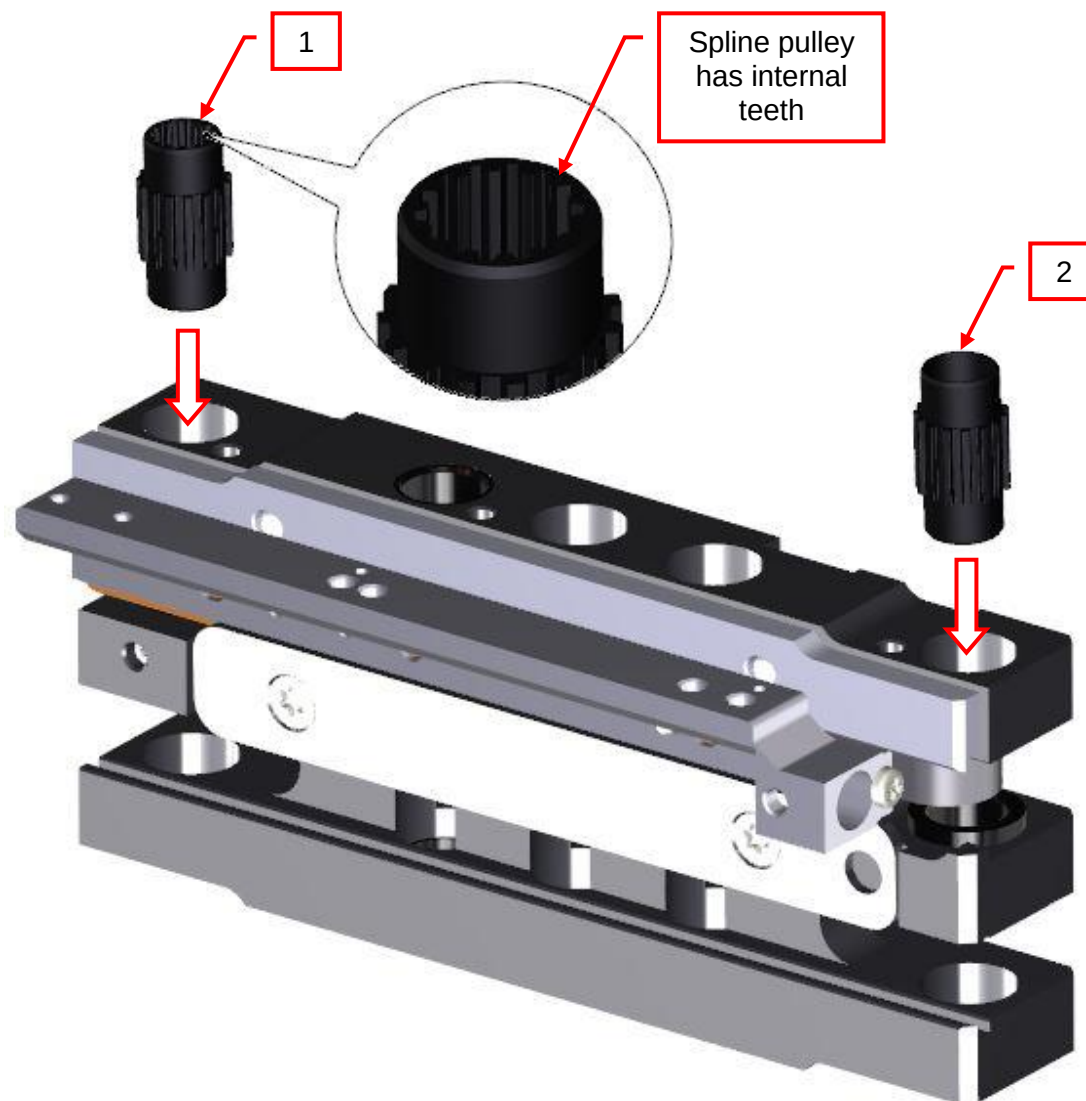
OPER
5.0

OPERATION DESCRIPTION
BELT ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	415001096	Spline Drive Pulley
2	1	415001095	Drive Idler Pulley

5.3 Insert spline drive pulley and driver idler pulley into needle carriage block assembly engaging the stripper belt, where shown.

NOTE: Spline pulley has internal teeth.



Verify



Scan



Torque



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OPER
5.0

OPERATION DESCRIPTION
BELT ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	2	405009623	Bushing
2	2	WAT411306	M3 Screw

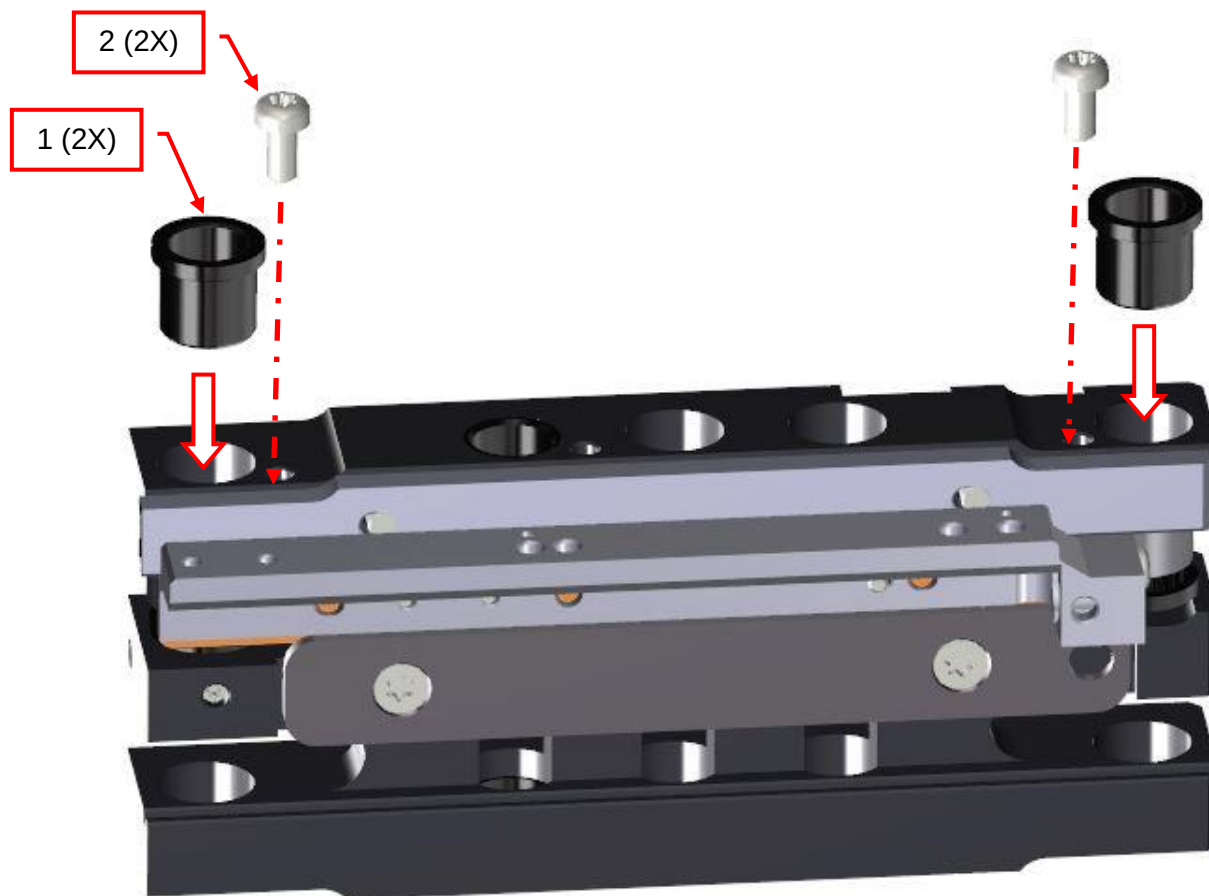
TOOL #	DESCRIPTION
N/A	Torque Driver (41 in-ozs) with T10 Torx Bit

5.4 Insert two bushings into needle carriage block assembly, where shown.

5.5 Secure the bushings with two screws.



5.6 Torque screws to 41 in-ozs.



Verify



Scan



Torque



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OPER
5.0

OPERATION DESCRIPTION
BELT ASSEMBLY

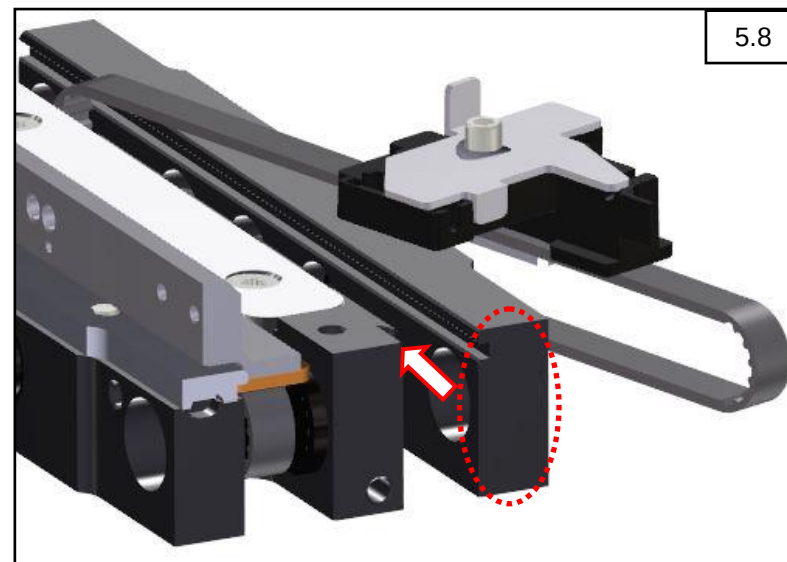
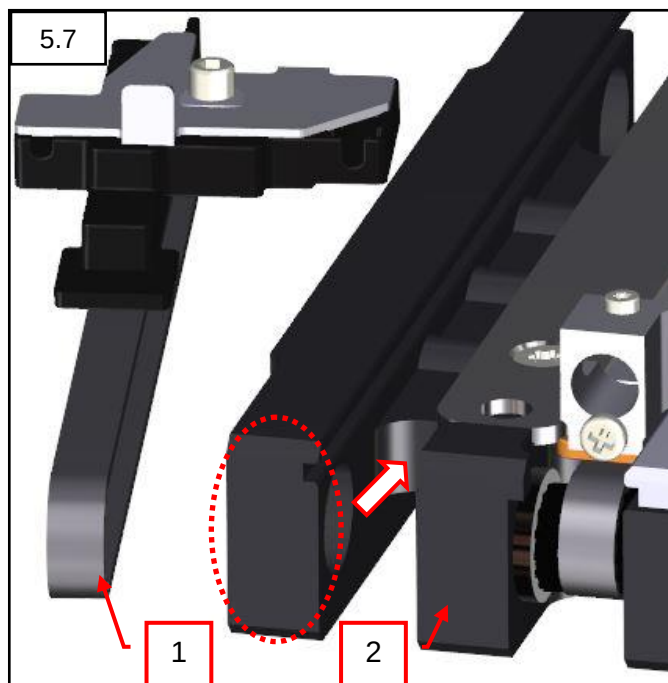
ITEM	QTY	PART #	DESCRIPTION
1	1	N/A	Needle Retainer Assembly
2	1	N/A	Needle Carriage Block Assembly

5.7 Loop needle retainer assembly belt over one end, placing belt into block slot.

5.8 Loop belt over other side of needle carriage block assembly and under belt cover.



5.9 Verify the needle retainer assembly slides freely in block groove.



Verify



Scan



Torque



Critical Clean



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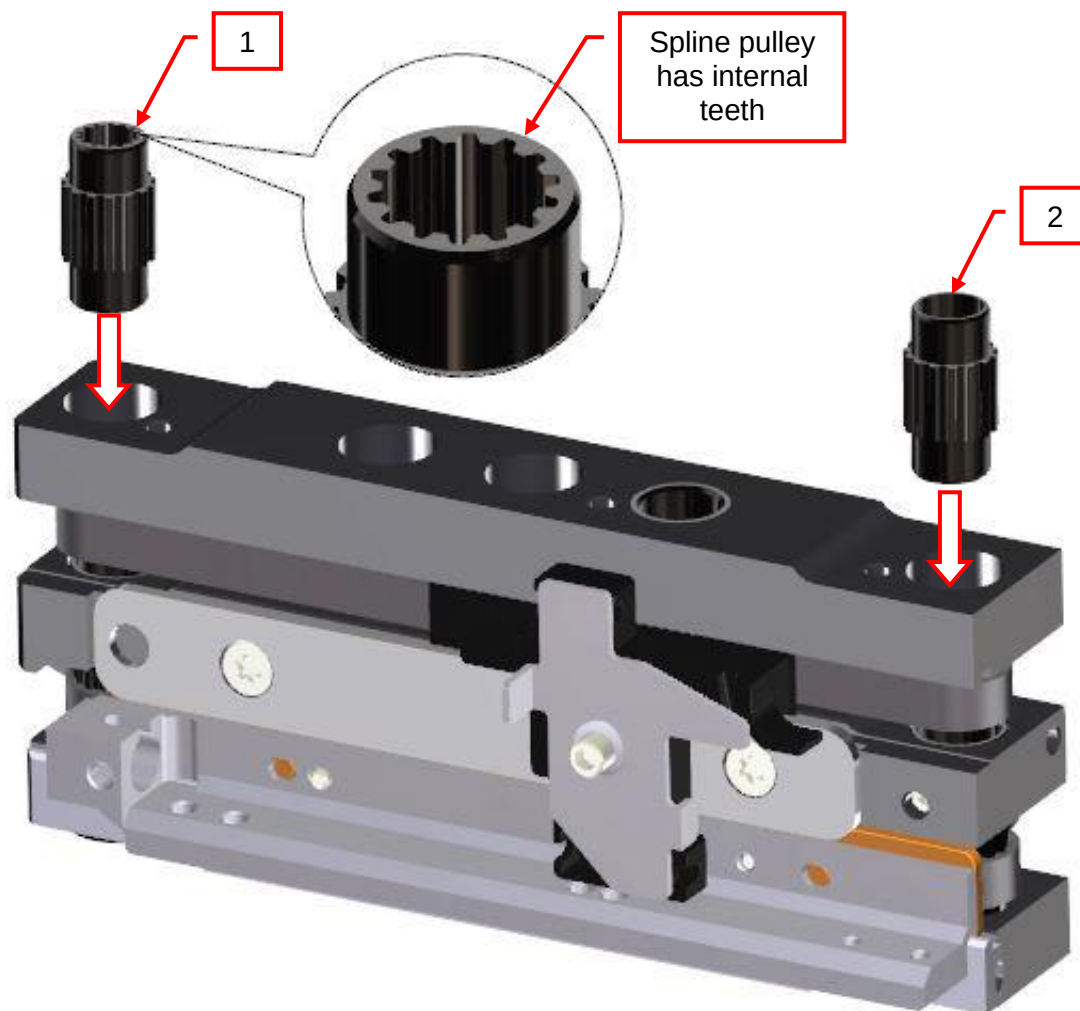
OPER
5.0

OPERATION DESCRIPTION
BELT ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	415001096	Spline Drive Pulley
2	1	415001095	Drive Idler Pulley

5.10 Insert spline drive pulley and driver idler pulley into needle carriage block assembly engaging the needle retainer belt, where shown.

NOTE: Spline pulley has internal teeth.



Verify



Scan



Torque



Critical Clean



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OPER
5.0

OPERATION DESCRIPTION
BELT ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	2	405009623	Bushing
2	2	WAT411306	M3 Screw

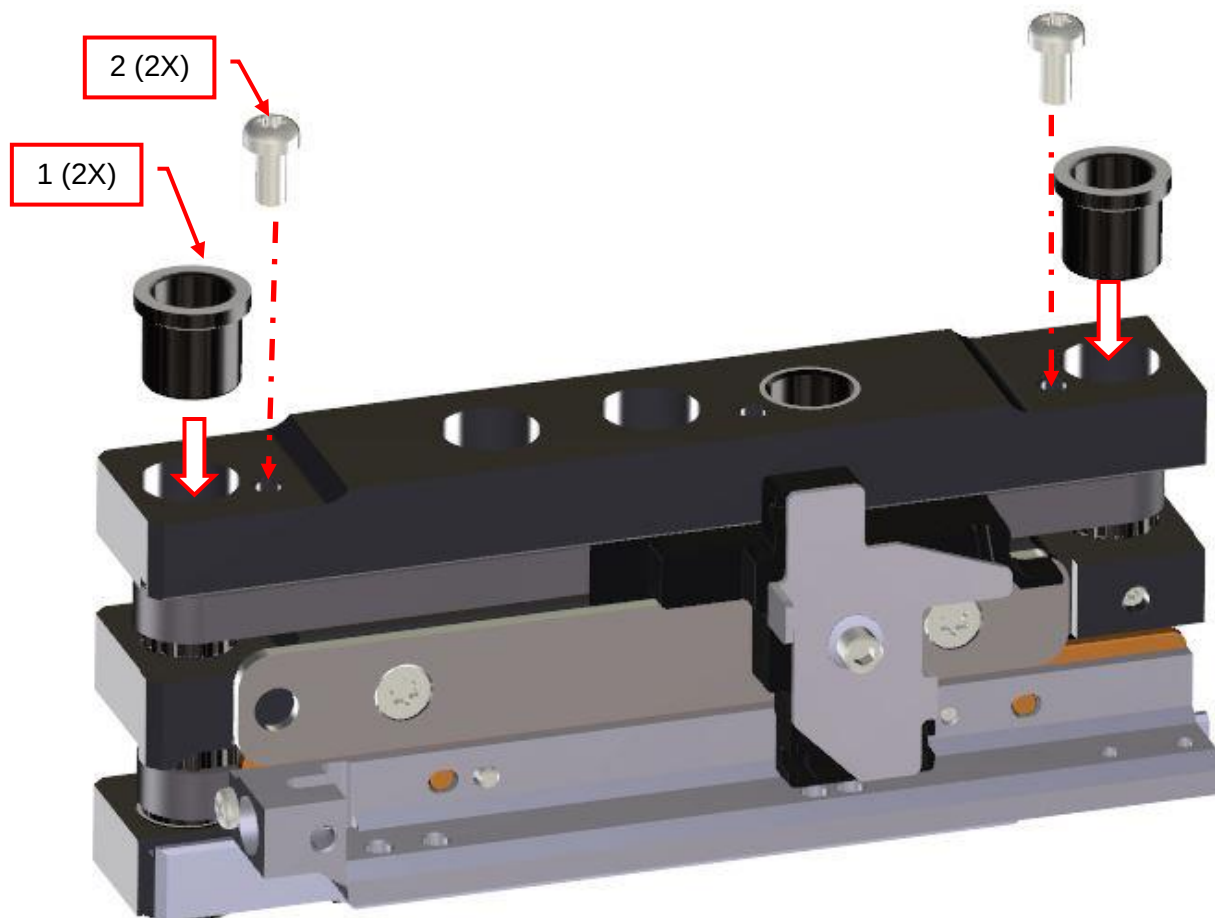
TOOL #	DESCRIPTION
N/A	Torque Driver (41 in-ozs) with T10 Torx Bit

5.11 Insert two bushings into needle carriage block assembly, where shown.

5.12 Secure the bushings with two screws.



5.13 Torque screws to 41 in-ozs.



Verify



Scan



Torque



Critical Clean



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OPER
5.0

OPERATION DESCRIPTION
BELT ASSEMBLY

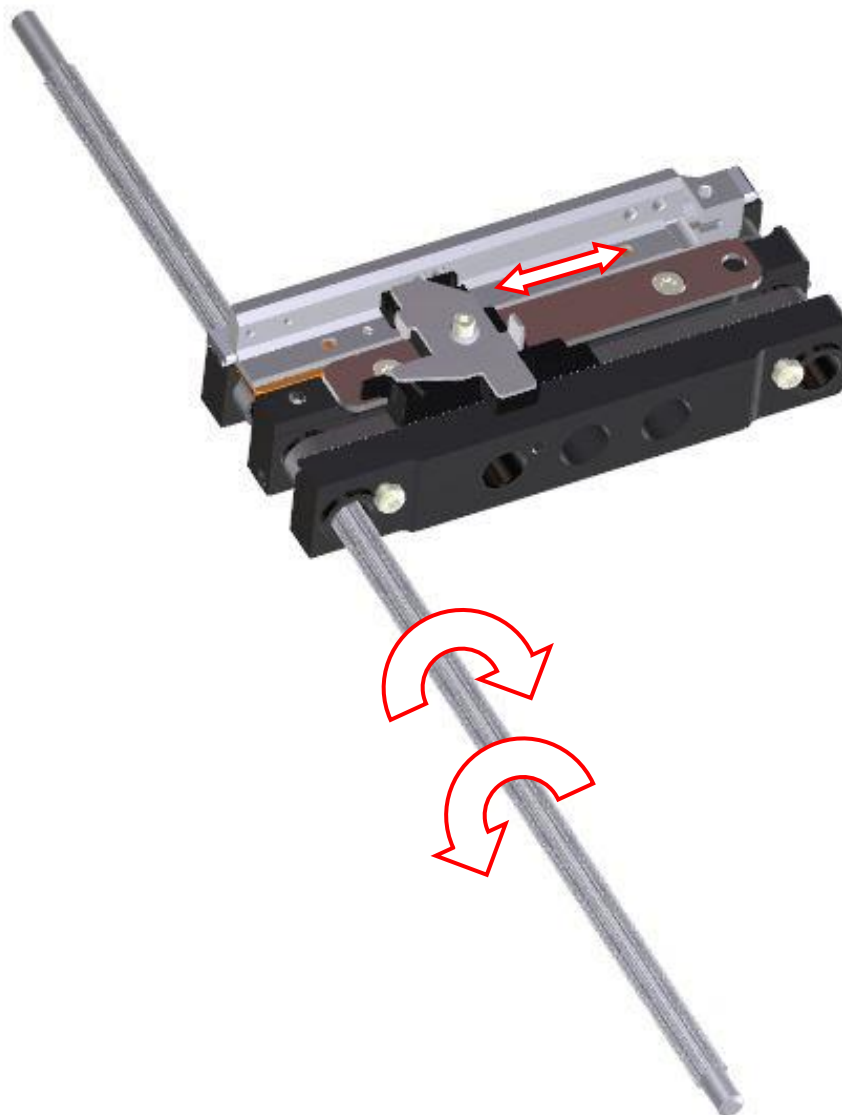
TOOL #	DESCRIPTION
405008773	RZZ Spline Shaft

- 5.14 Insert a spline shaft into needle carriage block assembly spline gear, as shown.



- 5.15 Turn shaft to verify **stripper** belt assembly slide freely in both directions.

- 5.16 Remove shaft from needle carriage block assembly.



Verify



Scan



Torque



Critical Clean



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OPER
5.0

OPERATION DESCRIPTION
BELT ASSEMBLY

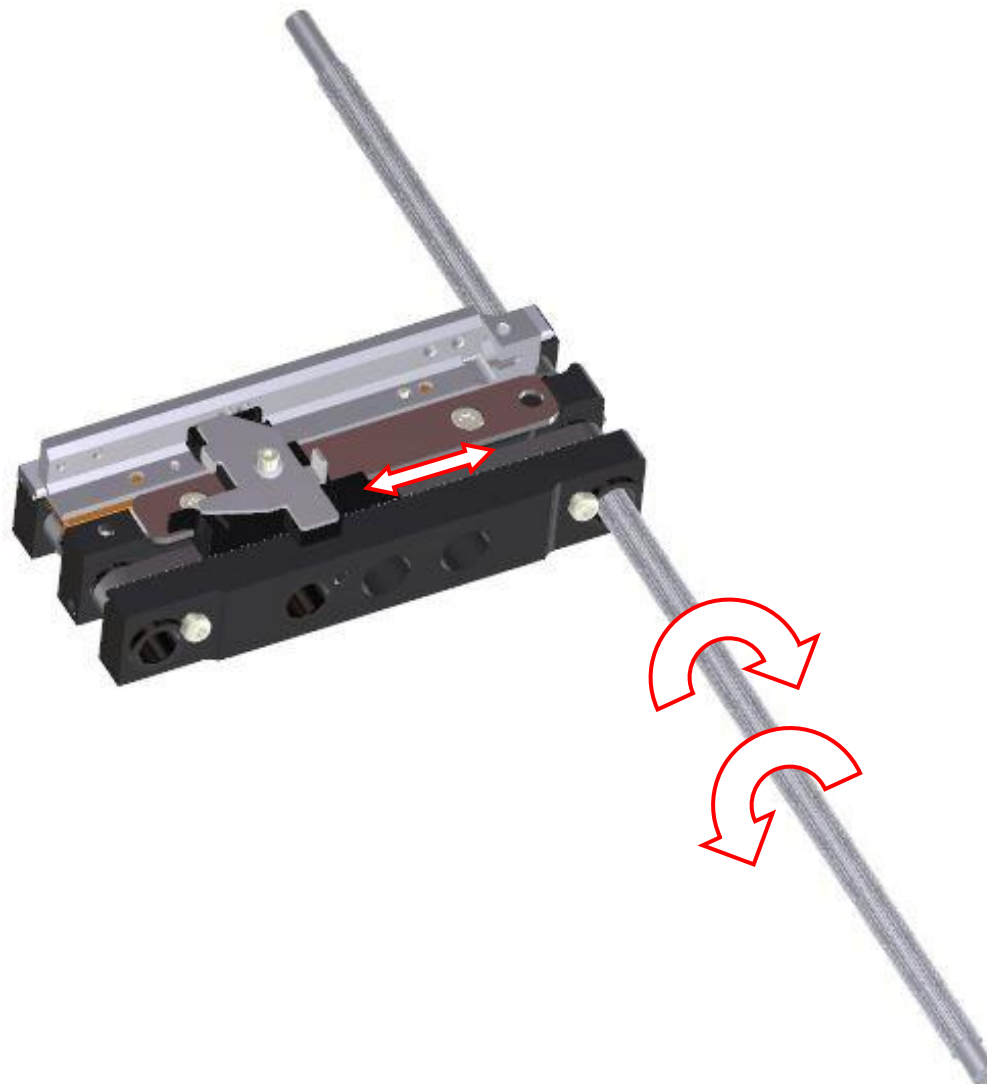
<u>TOOL #</u>	<u>DESCRIPTION</u>
405008773	RZZ Spline Shaft

5.17 Insert spline shaft into other spline gear in needle carriage block assembly, as shown.



5.18 Turn shaft to verify **needle retainer** belt assembly slides freely in both directions.

5.19 Remove shaft from needle carriage block assembly.



Verify



Scan



Torque



Critical Clean



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OPER
6.0

OPERATION DESCRIPTION
FLEX CABLE ASSEMBLY

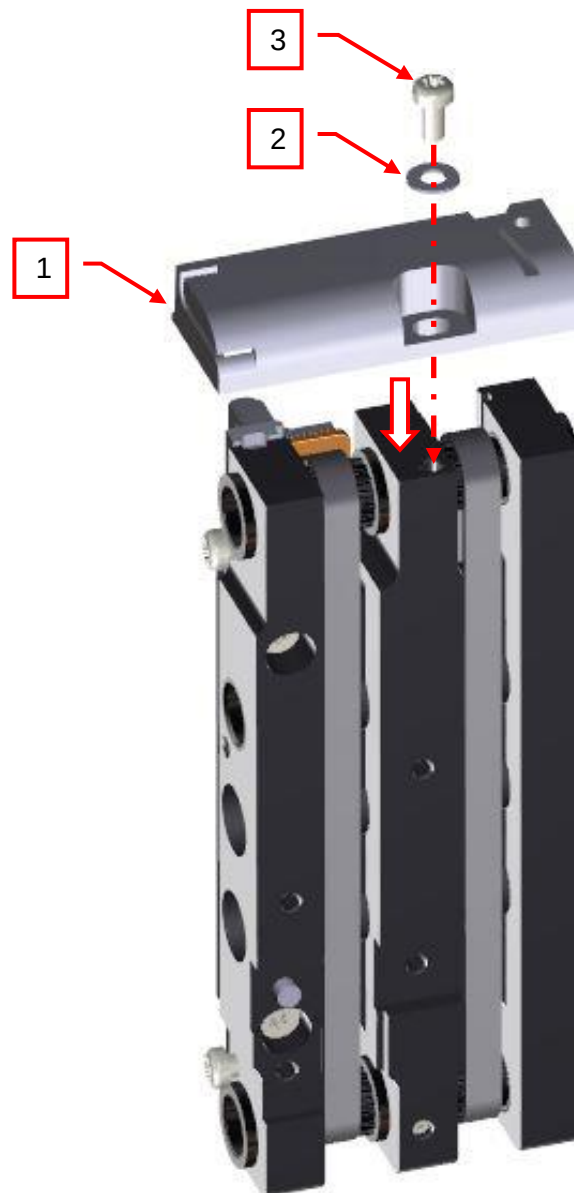
ITEM	QTY	PART #	DESCRIPTION
1	1	415001861	Opto Mounting Plate
2	1	WAT410320	M3 Washer
3	1	WAT411306	M3 Screw

TOOL #	DESCRIPTION
N/A	Torque Driver (5 in-lbs) with T10 Torx Bit

6.1 Attach the opto mounting plate to the needle carriage block assembly with a washer and a screw.



6.2 Torque screw to 5 in-lbs.



Verify



Scan



Torque



Critical Clean



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OPER
6.0

OPERATION DESCRIPTION
FLEX CABLE ASSEMBLY

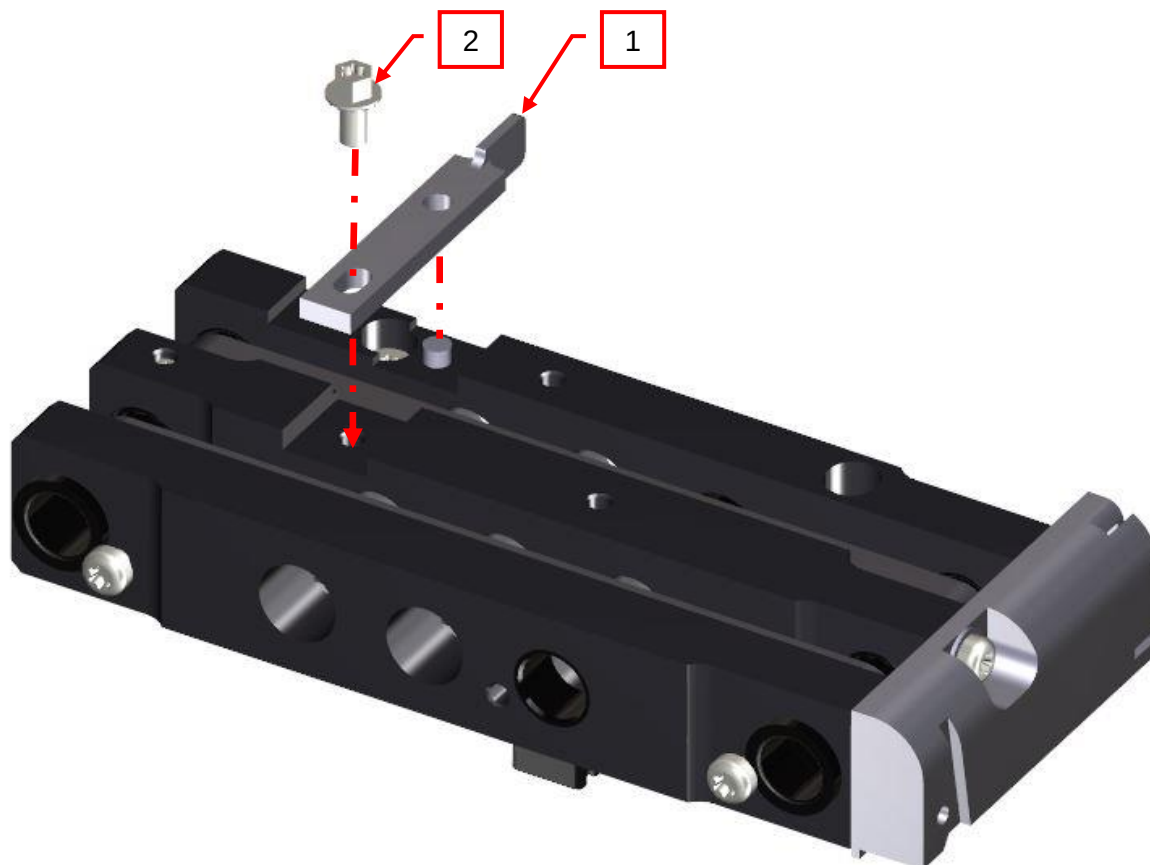
ITEM	QTY	PART #	DESCRIPTION
1	1	405009232	Flag
2	1	WAT271463	M3 Screw

TOOL #	DESCRIPTION
N/A	Torque Driver (10 in-lbs) with T10 Torx Bit
999038336	Horizontal Assembly Fixture (optional)

6.3 Attach the flag to the needle carriage block assembly with a screw.



6.4 Torque screw to 10 in-lbs.



Verify



Scan



Torque



Critical Clean



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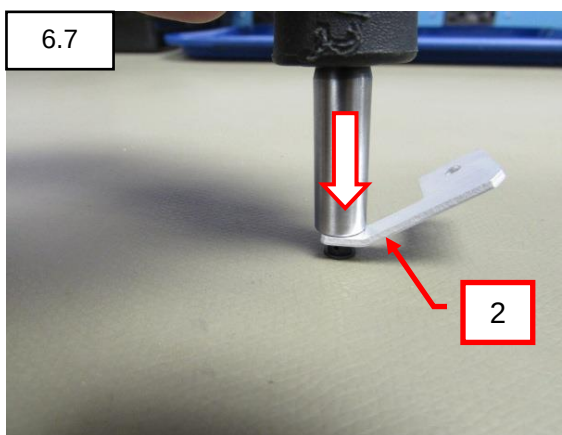
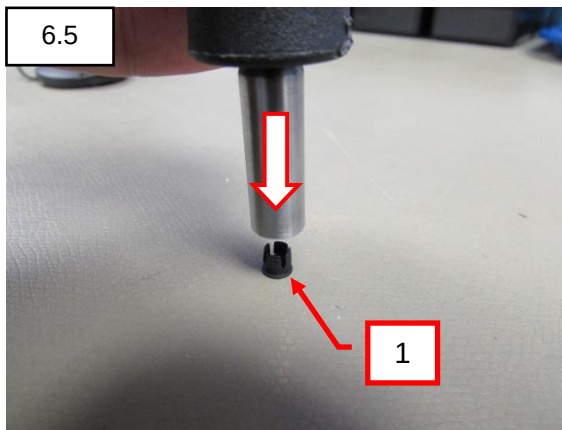
OPER
6.0

OPERATION DESCRIPTION
FLEX CABLE ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	410001142	LED Holder
2	1	400002525	LED Bracket

TOOL #	DESCRIPTION
999039872	Sample Manager LED Bulb Assembly Fixture

- 6.5 Orient LED holder with fins facing **UP** and Insert into assembly tool.
- 6.6 Eject LED holder from tool by pressing top button on tool.
- 6.7 Orient LED holder with hole in LED bracket and press together with assembly tool.



Verify



Scan



Torque



Critical Clean



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OPER
6.0

OPERATION DESCRIPTION
FLEX CABLE ASSEMBLY

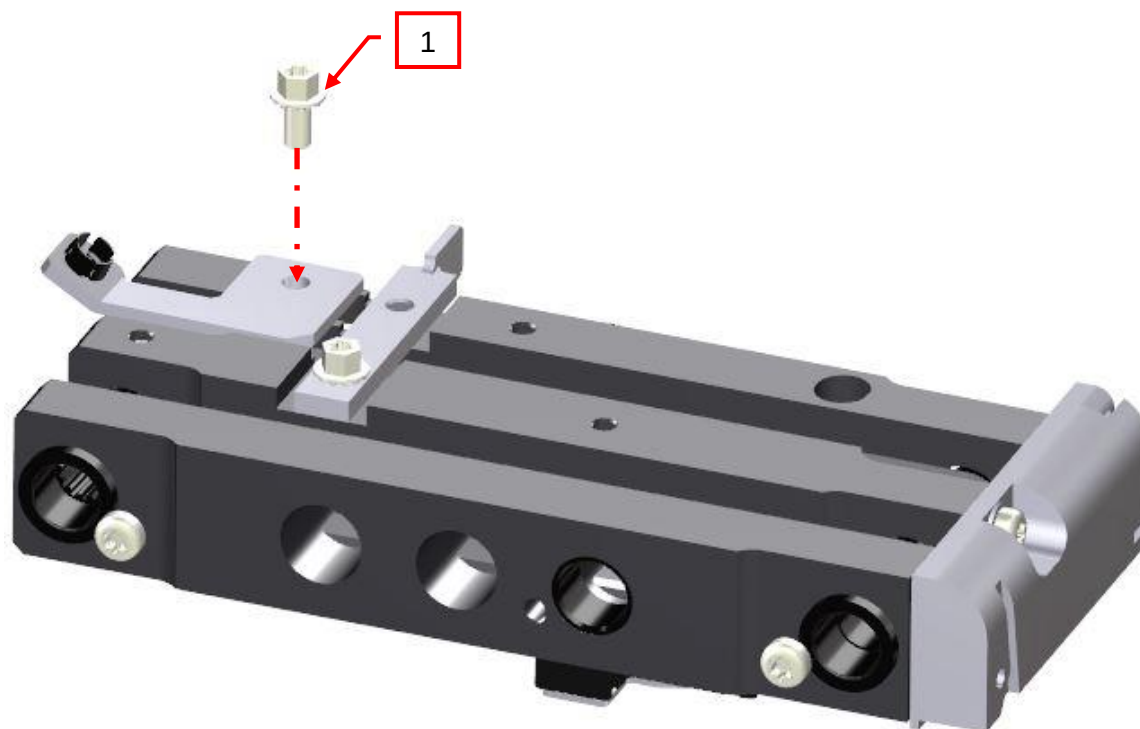
ITEM	QTY	PART #	DESCRIPTION
1	1	WAT271463	M3 Screw

TOOL #	DESCRIPTION
N/A	Torque Driver (10 in-lbs) with T10 Torx Bit
999038336	Horizontal Assembly Fixture (optional)

6.8 Attach the LED bracket assembly to the needle block assembly with a screw.



6.9 Torque screw to 10 in-lbs.



Verify



Scan



Torque



Critical Clean



Electrostatic

OPER
6.0

OPERATION DESCRIPTION
FLEX CABLE ASSEMBLY

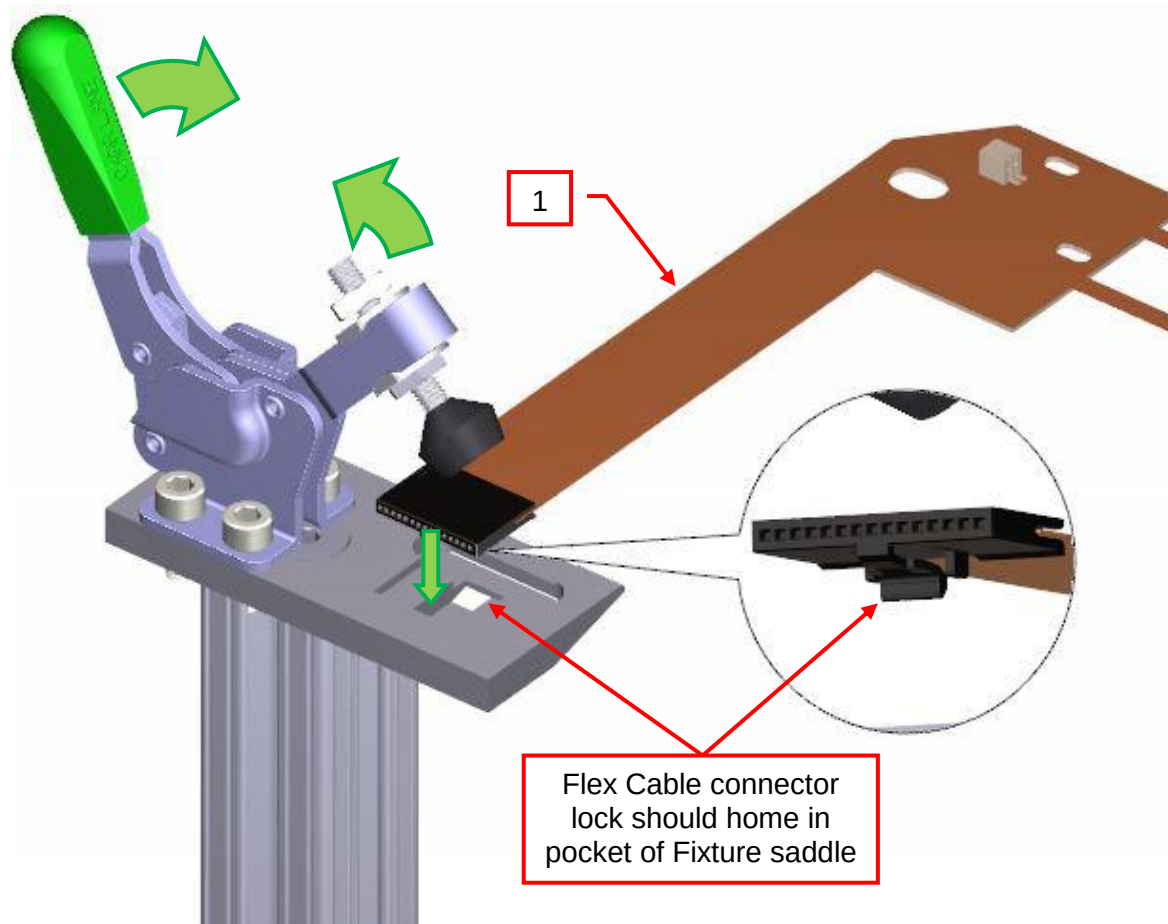
ITEM	QTY	PART #	DESCRIPTION
1	1	210000524	Flex Cable

TOOL #	DESCRIPTION
999034185	Crease Fixture

6.10 Open clamp on Crease Fixture by raising arm.

6.11 Orient Flex Cable connector **down** and place into Fixture saddle.

NOTE: Flex Cable connector lock should home in pocket of Fixture saddle.



Verify



Scan



Torque



Critical Clean



Electrostatic

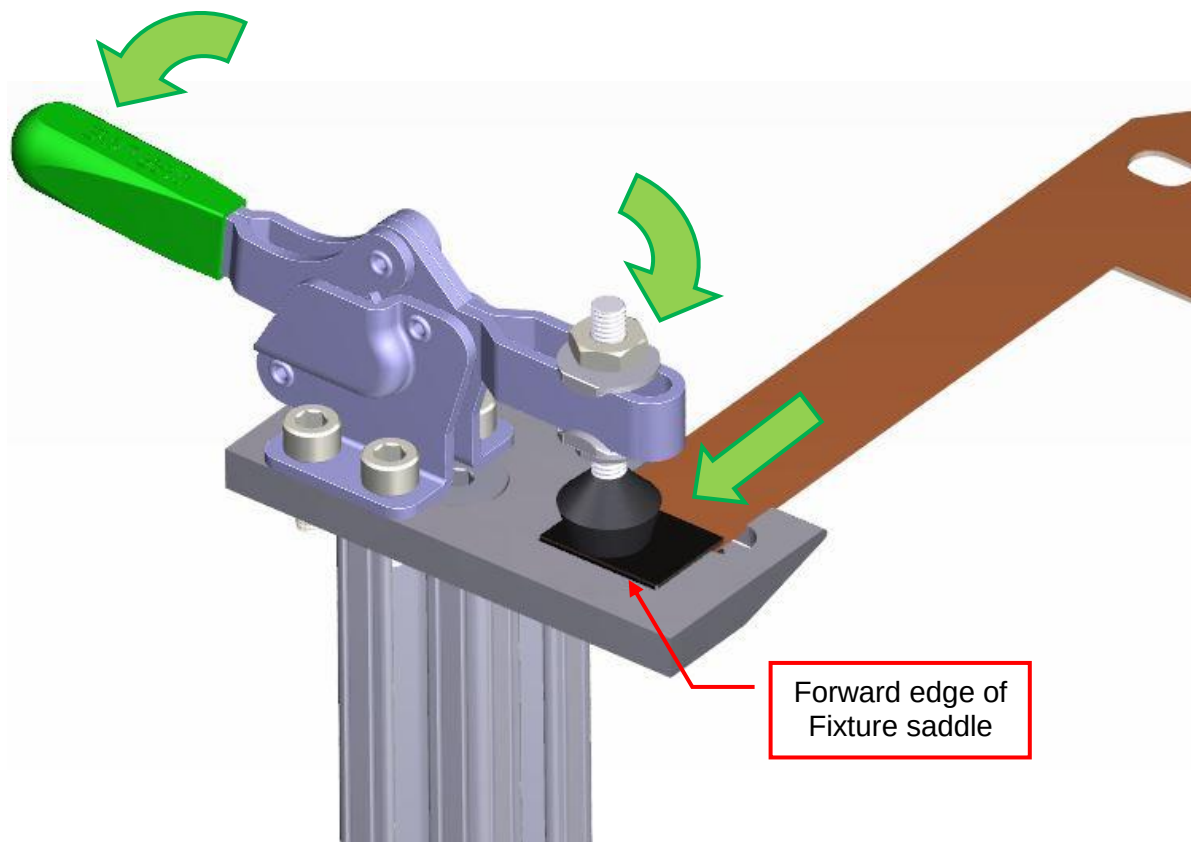
730001259 V 00 Page 31 of 48

OPER
6.0

OPERATION DESCRIPTION
FLEX CABLE ASSEMBLY

TOOL #	DESCRIPTION
999034185	Crease Fixture

- 6.12 Bias Flex Cable connector against forward edge of Fixture saddle.
- 6.13 Close clamp on Crease Fixture by lowering arm.



Verify



Scan



Torque



Critical Clean



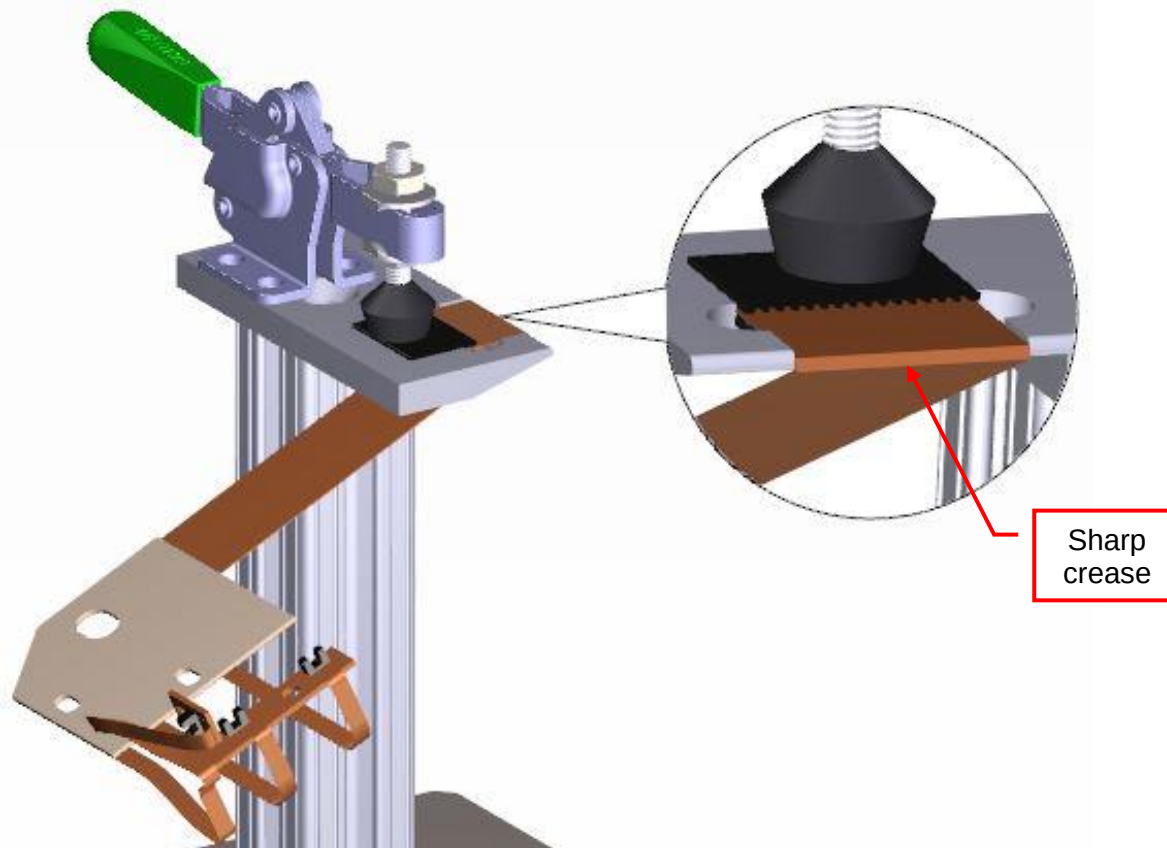
Electrostatic

OPER
6.0

OPERATION DESCRIPTION
FLEX CABLE ASSEMBLY

TOOL #	DESCRIPTION
999034185	Crease Fixture

- 6.14 Use Crease Fixture to put a sharp crease in Flex Cable, as shown.
- 6.15 Open clamp on Crease Fixture by raising arm and remove Flex Cable.



Verify



Scan



Torque



Critical Clean



Electrostatic

OPER
6.0

OPERATION DESCRIPTION
FLEX CABLE ASSEMBLY

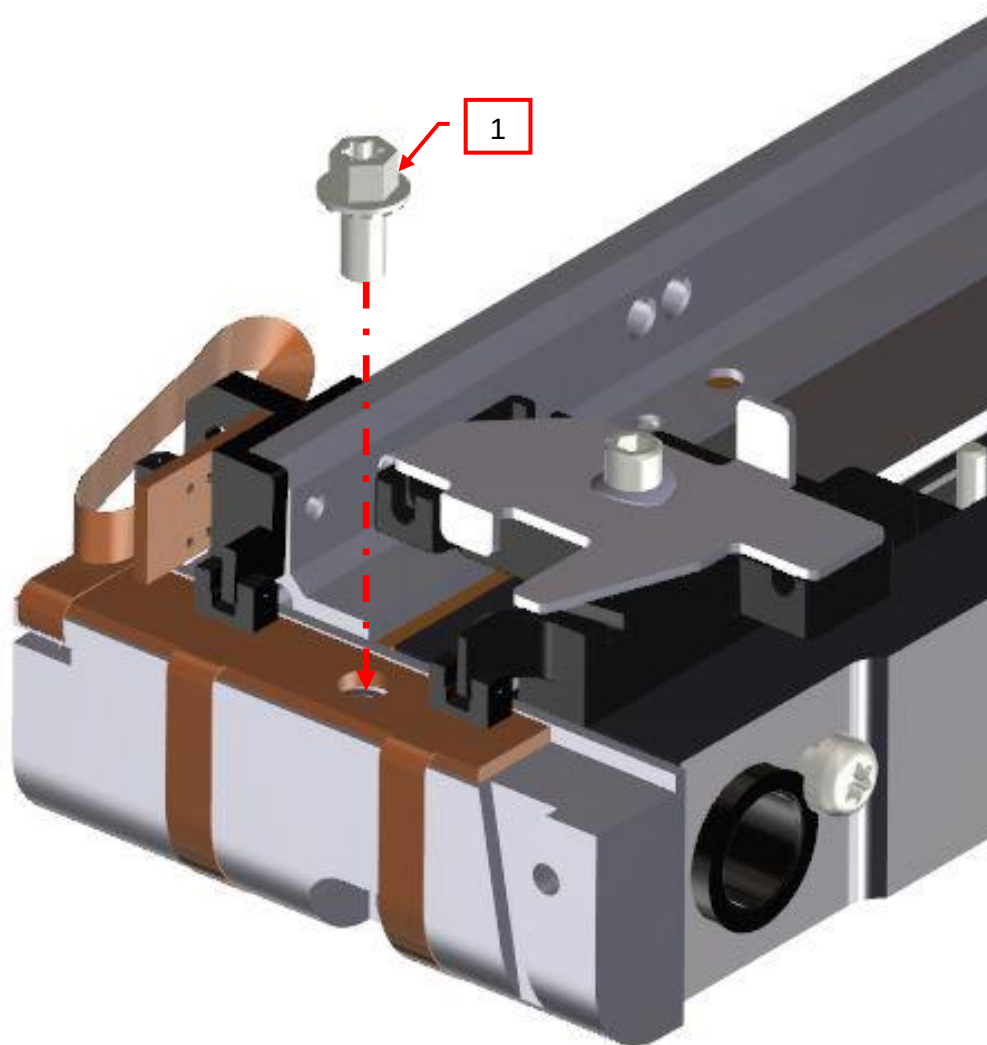
ITEM	QTY	PART #	DESCRIPTION
1	1	WAT271463	M3 Screw

TOOL #	DESCRIPTION
N/A	Torque Driver (36 in-ozs) with T10 Torx Bit

6.16 Route the flex cable over opto mounting plate, as shown.



6.17 Torque screw to 36 in-ozs.



Verify



Scan



Torque



Critical Clean



Electrostatic

OPER
6.0

OPERATION DESCRIPTION
FLEX CABLE ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	2	WAT271463	M3 Screw

TOOL #	DESCRIPTION
N/A	Torque Driver (36 in-ozs) with T10 Torx Bit

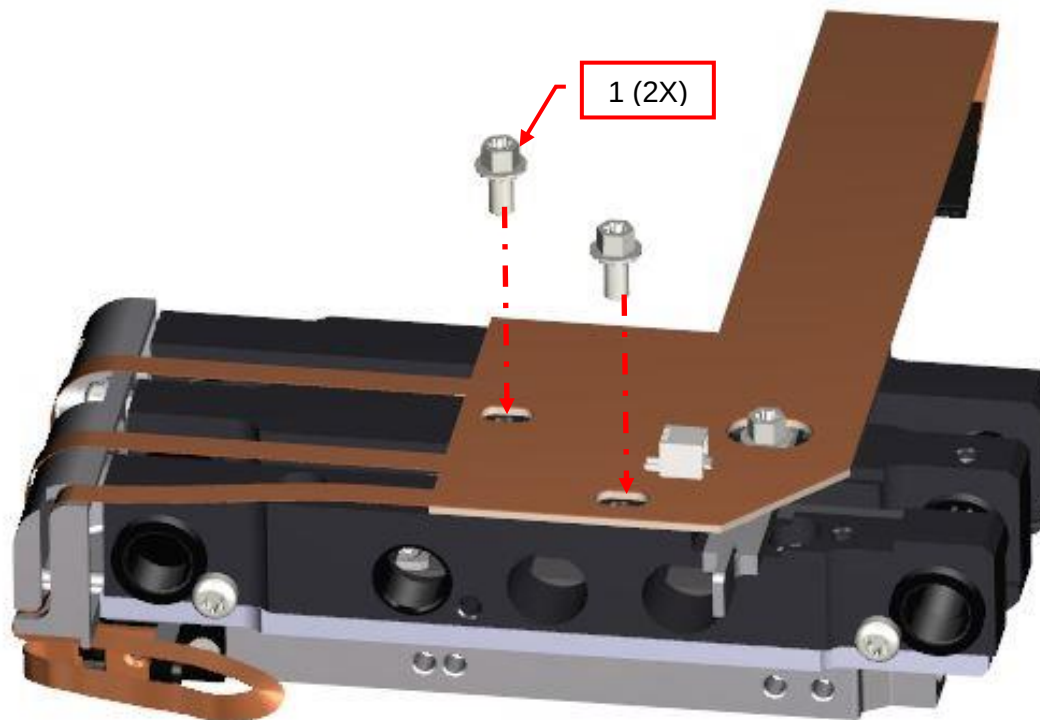
6.18 Attach flex cable to needle carriage block assembly with two screws in slots where shown.



6.19 Torque screws to 36 in-ozs.

NOTE: Do not pull flex cable too tightly.

NOTE: Leave a slight gap between the flex cable and needle carriage block assembly.



Verify



Scan



Torque



Critical Clean



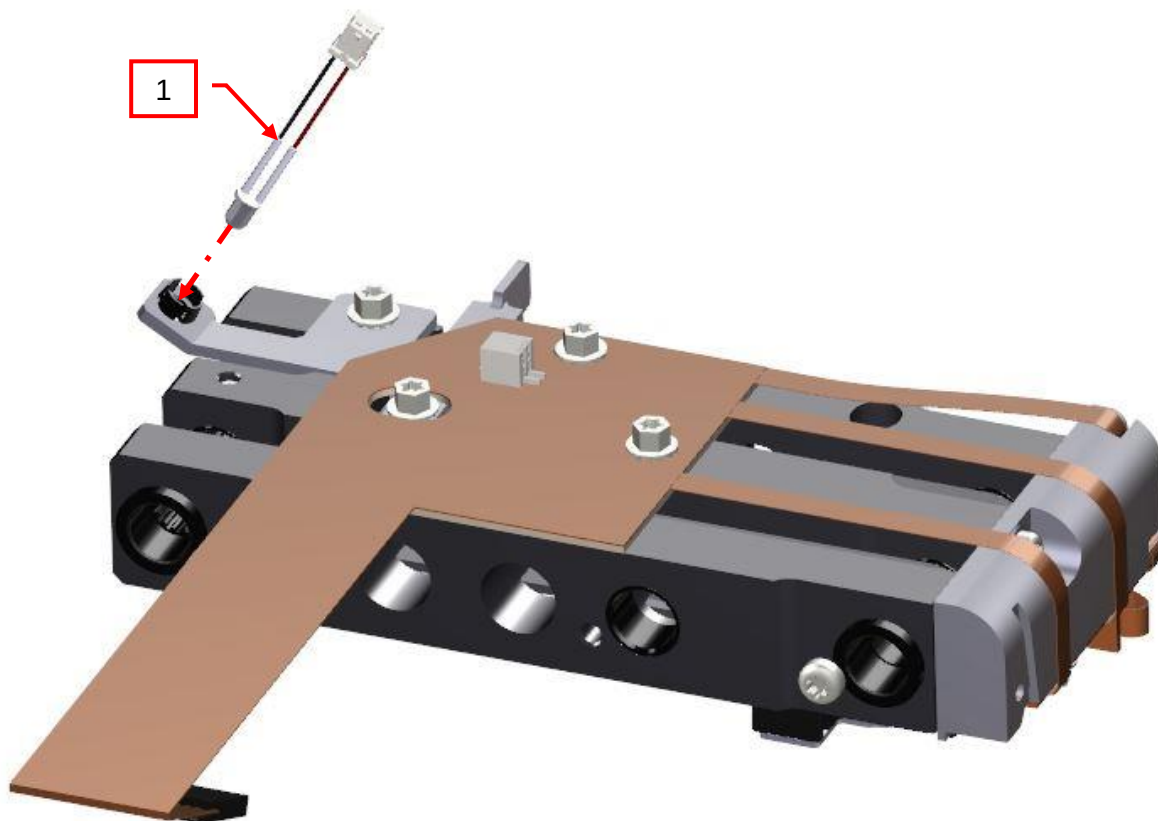
Electrostatic

OPER
6.0

OPERATION DESCRIPTION
FLEX CABLE ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	441000982	LED Cable Assembly

6.20 Insert LED cable assembly into LED bracket assembly.



Verify



Scan



Torque



Critical Clean

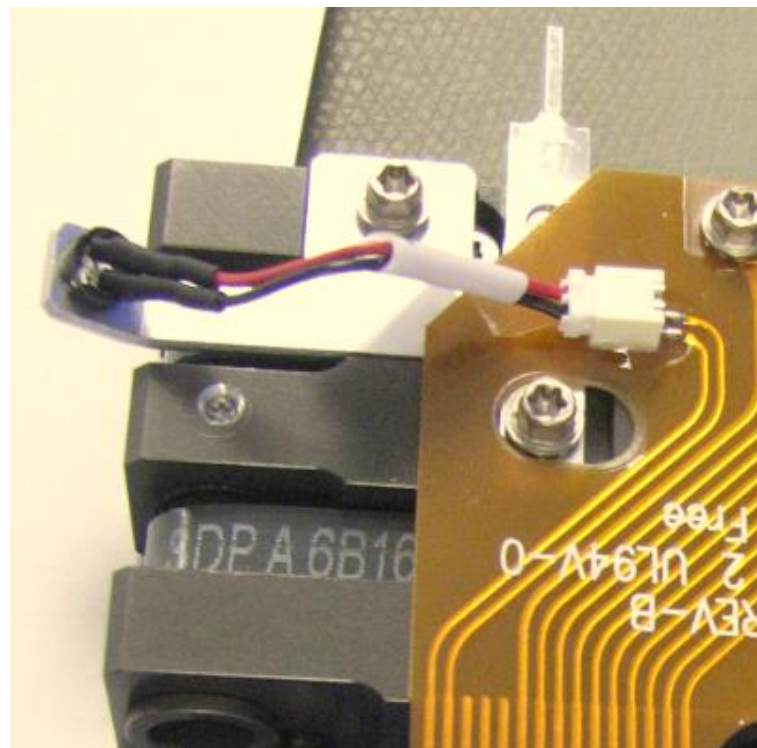


Electrostatic

OPER
6.0

OPERATION DESCRIPTION
FLEX CABLE ASSEMBLY

6.21 Connect lamp cable to flex cable connector, as shown.



Verify



Scan



Torque



Critical Clean



Electrostatic

OPER
6.0

OPERATION DESCRIPTION
FLEX CABLE ASSEMBLY

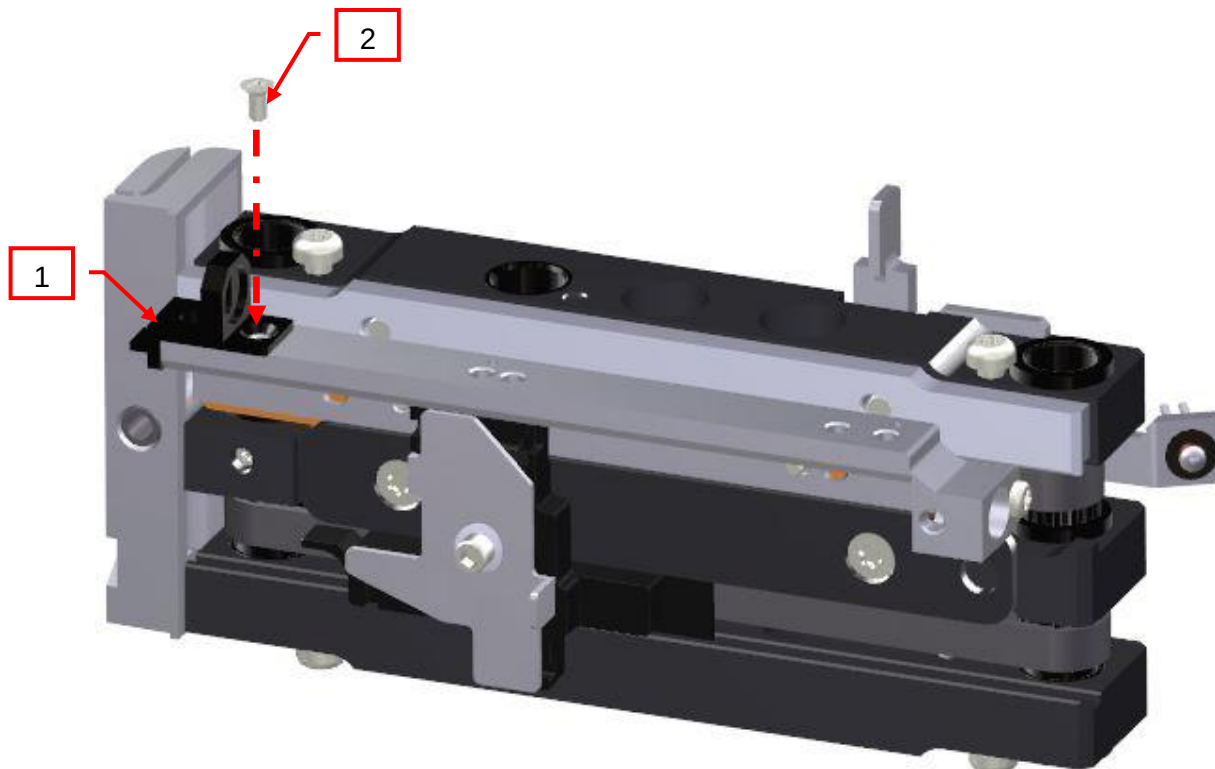
ITEM	QTY	PART #	DESCRIPTION
1	1	405008797	Flag Bracket
2	1	410001066	M2 Screw

TOOL #	DESCRIPTION
N/A	Torque Driver (41 in-ozs) with Phillips Bit
999038335	Vertical Assembly Fixture (optional)

6.22 Attach flag bracket to stripper guide block with a screw.



6.23 Torque screw to 41 in-ozs.



Verify



Scan



Torque



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OPER
6.0

OPERATION DESCRIPTION
FLEX CABLE ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	410001500	M3 Screw

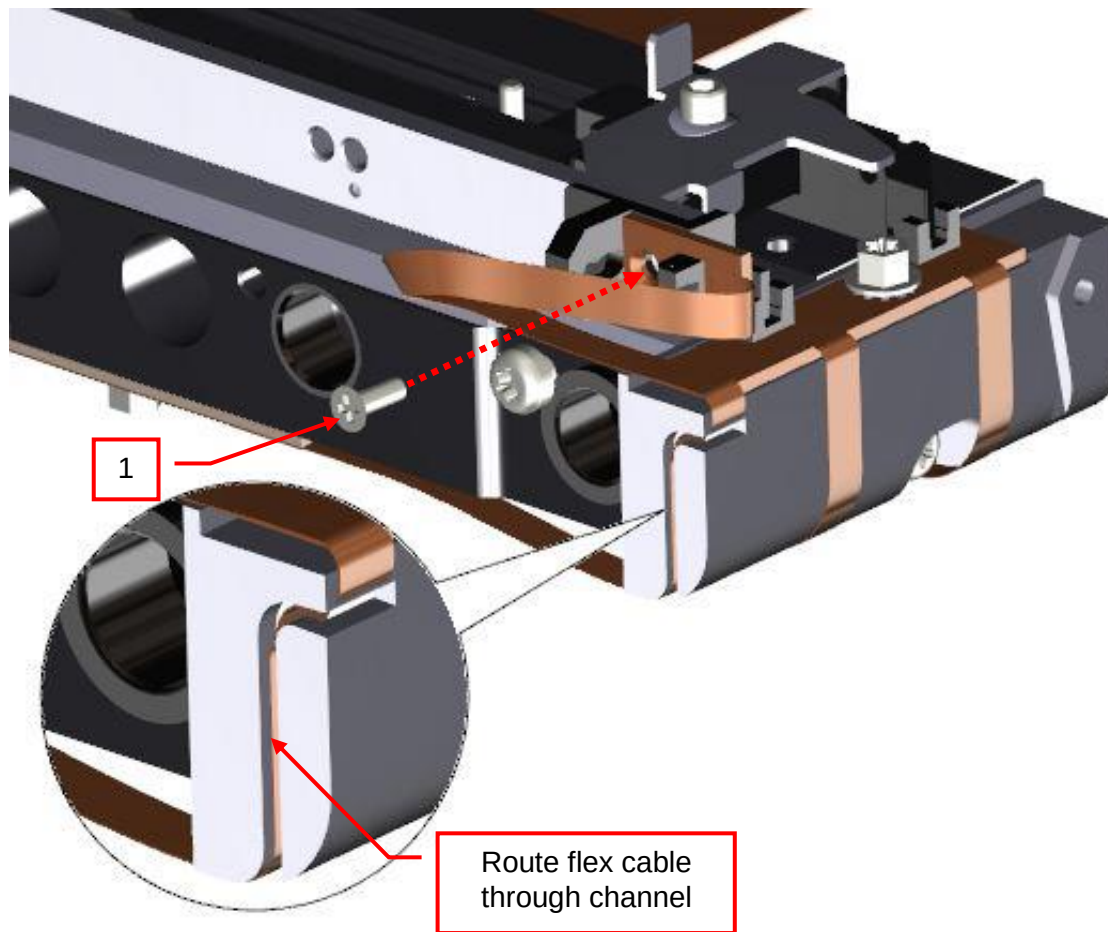
TOOL #	DESCRIPTION
N/A	Torque Driver (41 in-ozs) with Phillips Bit
999038335	Vertical Assembly Fixture (optional)

6.24 Route flex cable through channel in opto mounting plate, as shown.

6.25 Secure the flex cable with a screw.



6.26 Torque screw to 41 in-ozs.



Verify



Scan



Torque



Critical Clean



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OPER
7.0

OPERATION DESCRIPTION
STRIPPER FORK ASSEMBLY

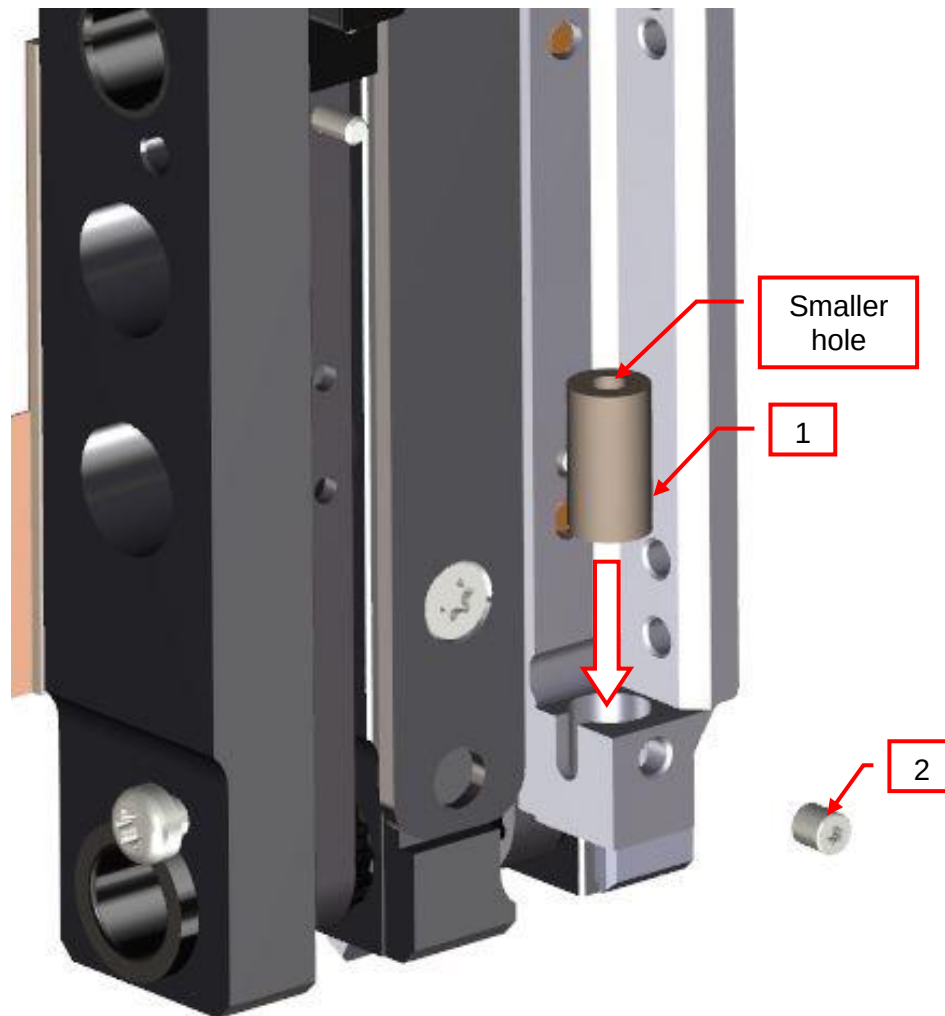
ITEM	QTY	PART #	DESCRIPTION
1	1	405008854	Sample Needle Guide
2	1	WAT417303	M3 Set Screw

TOOL #	DESCRIPTION
N/A	Torque Driver (30 in-ozs) with T6 Torx Bit
999038335	Vertical Assembly Fixture (optional)

- 7.1 Orient sample needle guide with smaller hole on top.
- 7.2 Insert sample needle guide into stripper guide block where shown.
- 7.3 Secure sample needle block with a screw.



- 7.4 Torque screws to 30 in-ozs.



Verify



Scan



Torque



Critical Clean



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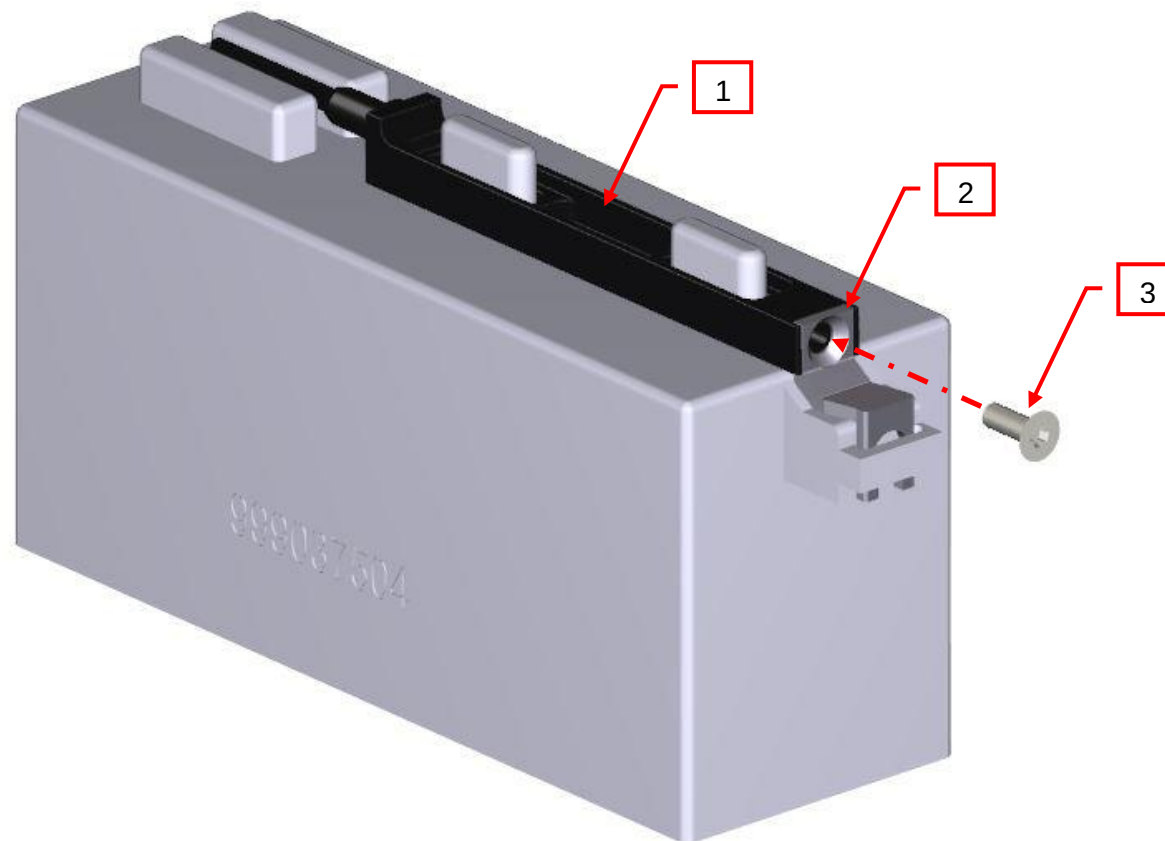
OPER
7.0

OPERATION DESCRIPTION
STRIPPER FORK ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	405015809	FTN Stripper Fork Base
2	1	405011116	Stripper Fork
3	1	WAT270394	M3 Screw

TOOL #	DESCRIPTION
N/A	Phillips Screwdriver
999037504	Stripper Fork Assembly Fixture

- 7.5 Load stripper fork and stripper fork base onto fixture, as shown.
- 7.6 Secure the stripper fork to stripper fork base with a screw.
- 7.7 Remove assembly from fixture.



Verify



Scan



Torque



Critical Clean



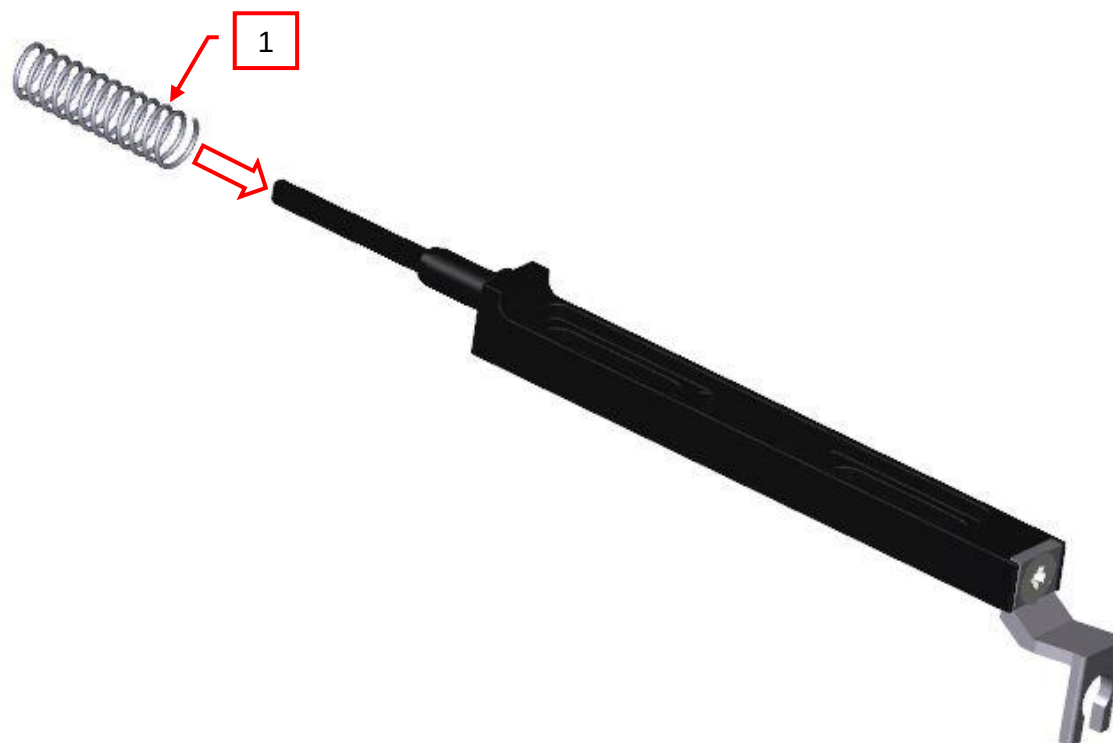
Electrostatic

OPER
7.0

OPERATION DESCRIPTION
STRIPPER FORK ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	410002171	Spring

7.8 Slide a spring onto stripper fork base assembly.



Verify



Scan



Torque



Critical Clean



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OPER
7.0

OPERATION DESCRIPTION
STRIPPER FORK ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	2	410001539	M3 Should Screw

TOOL #	DESCRIPTION
N/A	Torque Driver (10 in-lbs) with 2mm Hex Bit
999038335	Vertical Assembly Fixture (optional)

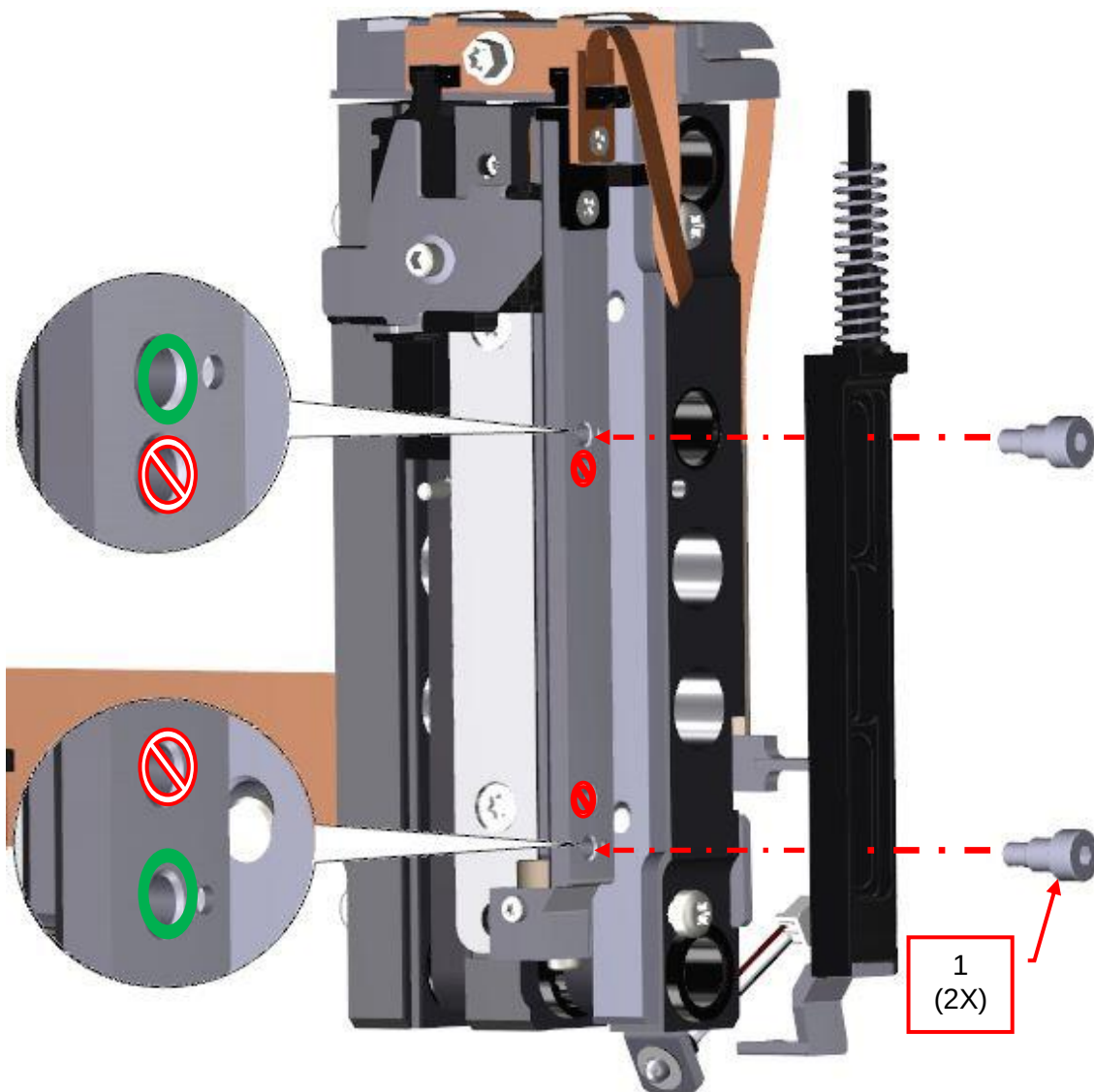
7.9 Attach stripper fork assembly to stripper guide block using two outer holes, where shown with two shoulder screws.



7.10 Torque screws to 10 in-lbs.



7.11 Verify shoulder screws are installed in outer two holes in stripper guide block.



Verify



Scan



Torque



Critical Clean



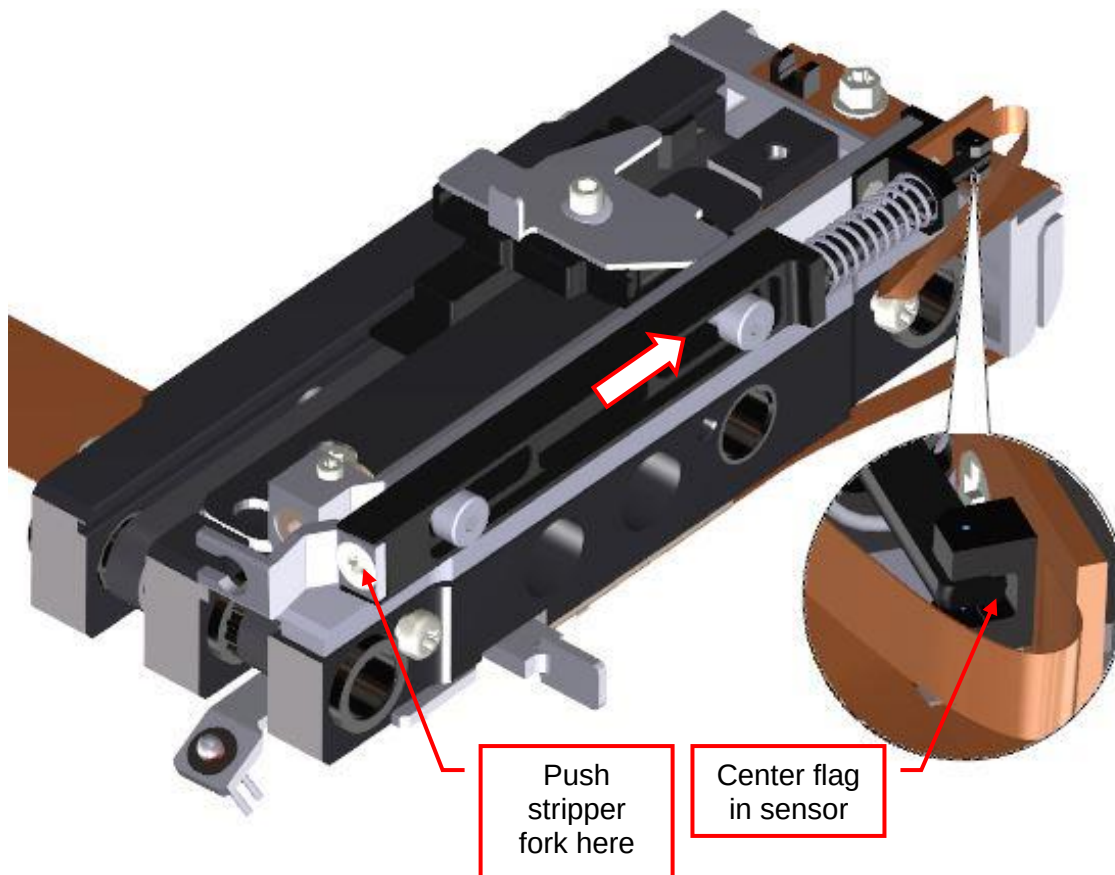
Electrostatic

OPER
7.0

OPERATION DESCRIPTION
STRIPPER FORK ASSEMBLY



7.12 Push stripper fork assembly towards sensor and verify flag on stripper fork is centered in sensor.



Verify



Scan



Torque



Critical Clean



Electrostatic

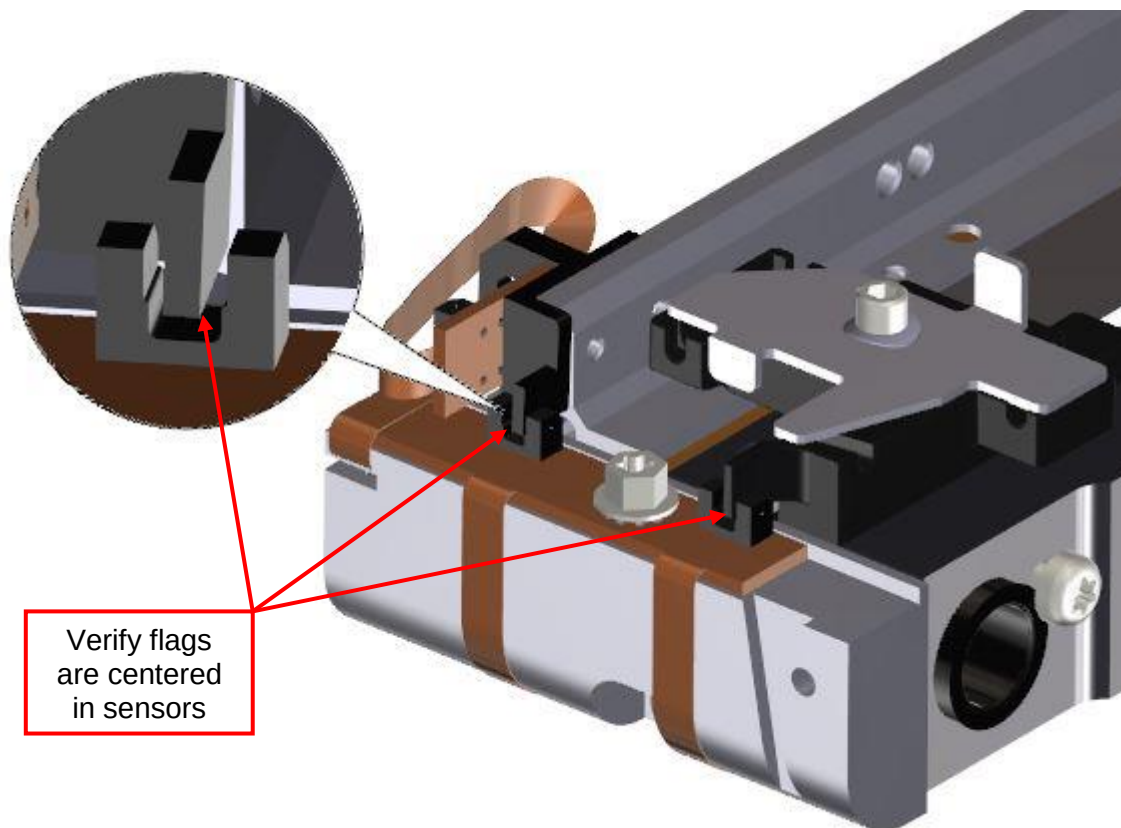
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OPER
7.0

OPERATION DESCRIPTION
STRIPPER FORK ASSEMBLY



7.13 Move both belt assemblies forward into sensors. Verify flags are centered in sensors. If necessary, adjust sensors.



Verify



Scan



Torque



Critical Clean



Electrostatic

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OPER
8.0

OPERATION DESCRIPTION
BEARING ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	405002227	Bearing
2	1	405014527	Bearing Clamp
3	1	WAT411306	M3 Screw

TOOL #	DESCRIPTION
N/A	Torque Driver (10 in-lbs) with T10 Torx Bit
999038335	Vertical Assembly Fixture (optional)

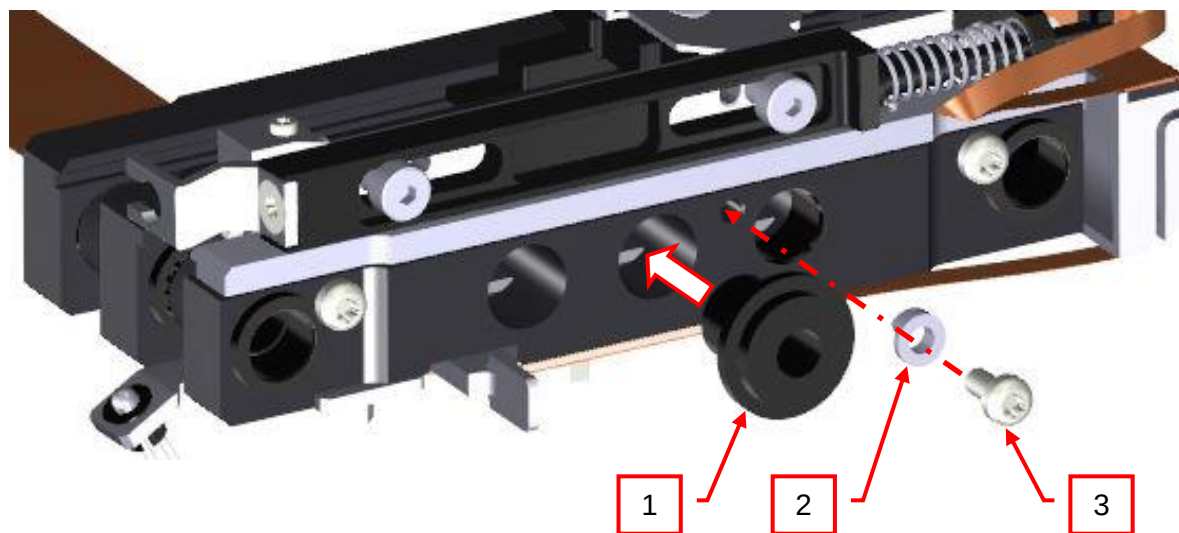
8.1 Insert a bearing into the **RIGHT SIDE** of needle carriage block assembly.

8.2 Secure bearing with a bearing clamp and screw.



8.3 Torque screw to 10 in-lbs.

Right Side
(Stripper Fork Side)



Verify



Scan



Torque



Critical Clean



Electrostatic

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OPER
8.0

OPERATION DESCRIPTION
BEARING ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	405002227	Bearing
2	1	405014527	Bearing Clamp
3	1	WAT411306	M3 Screw

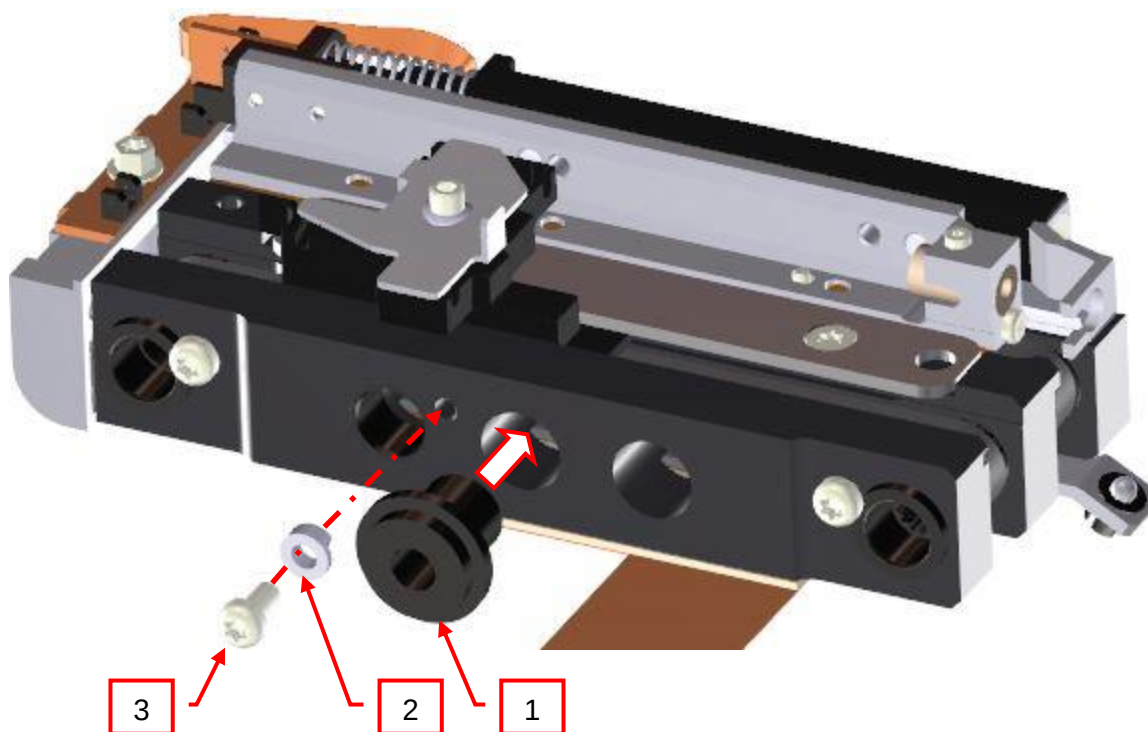
TOOL #	DESCRIPTION
N/A	T10 Torx Driver

8.4 Insert a bearing into the **LEFT SIDE** of needle carriage block assembly.

8.5 loosely install a bearing clamp and screw.

NOTE Do not tighten screw at this time.

Left Side
(Needle Retainer Side)



Verify



Scan



Torque



Critical Clean



Electrostatic

OPER
8.0

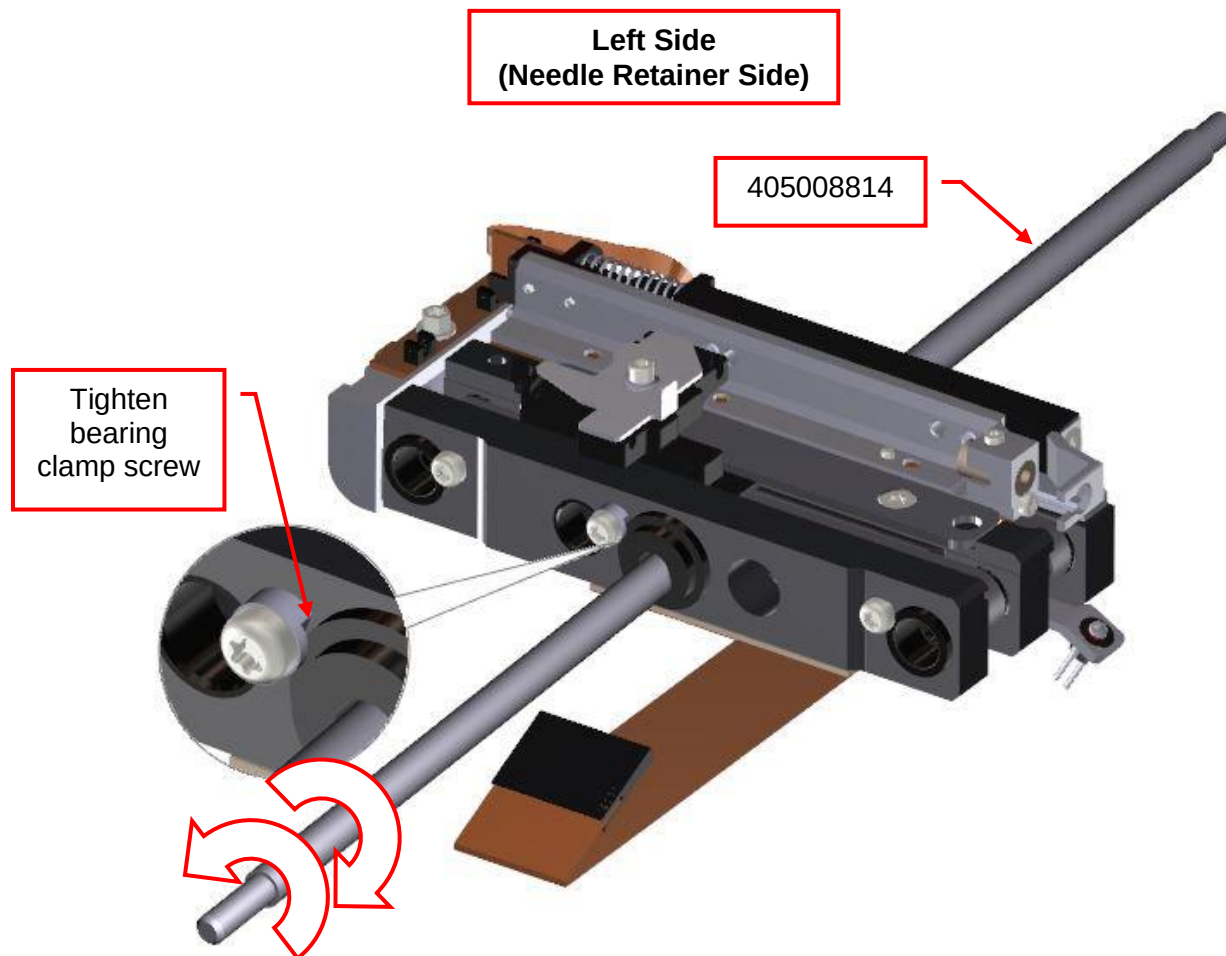
OPERATION DESCRIPTION
BEARING ASSEMBLY

TOOL #	DESCRIPTION
405008814	Lead Screw
N/A	Torque Driver (10 in-lbs) with T10 Torx Bit

- 8.6 Insert lead screw through both bearings.
- 8.7 Tighten left side bearing clamp screw until lead screw turns easily and does not fall out when assembly is held vertically.



- 8.8 If successful, torque screw to 10 in-lbs. If unsuccessful, remove lead screw, loosen screw, reposition bearing and repeat operations 8.6 through 8.8.



Verify



Scan



Torque



Critical Clean



Electrostatic