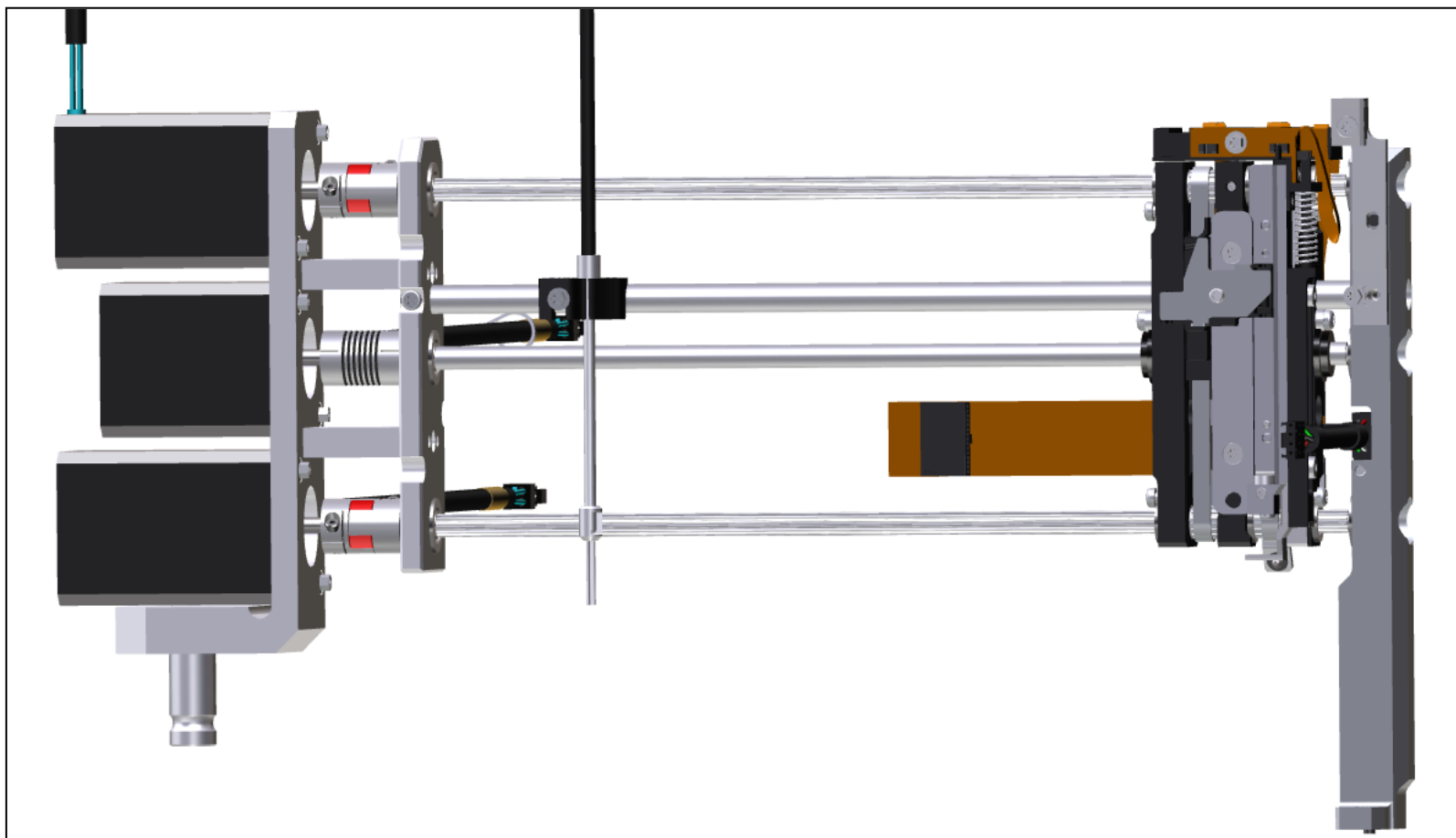


Author: D. Farley II
Revised By: M. Aubin



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REVISION "G" INCLUDED (ECR 9224335):

- Entire document - replace all RH images with new color specific views
- Oper 1.1 & 1.2 - split up instructions and RH specific images to two separate pages to de-clutter instructions and image clarity. Split up material table to identify the relative items of assembly for each operation.
- Oper 1.2 - Delete all non-relative part number callouts on image, edit instruction text to simplify run-on sentence and break-up paragraph format of instructions to make for easier reading.
- Oper 1.4 - Add "**Torque Screw at 60 in-oz.**" to instruction sentence. Add "60 IN-OZ TORQUE DRIVER w/ T10 Bit" to TOOL Table.
- Oper 1.6 - Edit instruction text to simplify run-on sentence and break-up paragraph format of instructions to make for easier reading.
- Create a new TEST step, Oper 2.0, adding photo to depict new "T" mark identifying test has PASSED.



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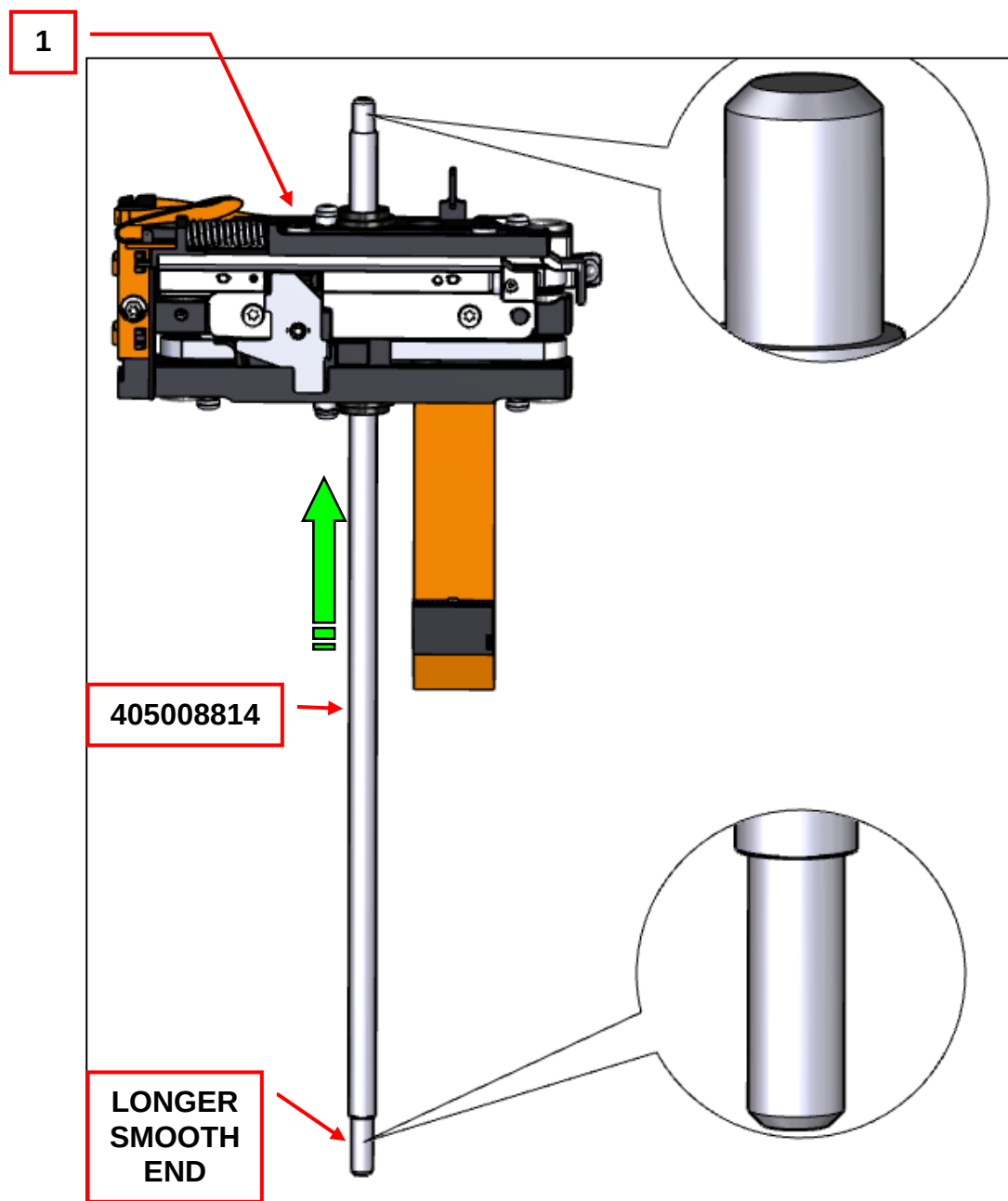
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OPER
1.0

OPERATION DESCRIPTION
MAIN ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	289004640	NEEDLE CARRIAGE

- 1.1 Screw the Lead Screw (405008814) from the Motor Stack through the Needle Carriage with the longer smooth end of the Lead Screw oriented as shown.



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OPER
1.0

OPERATION DESCRIPTION
MAIN ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	1	279001992	MOTOR STACK

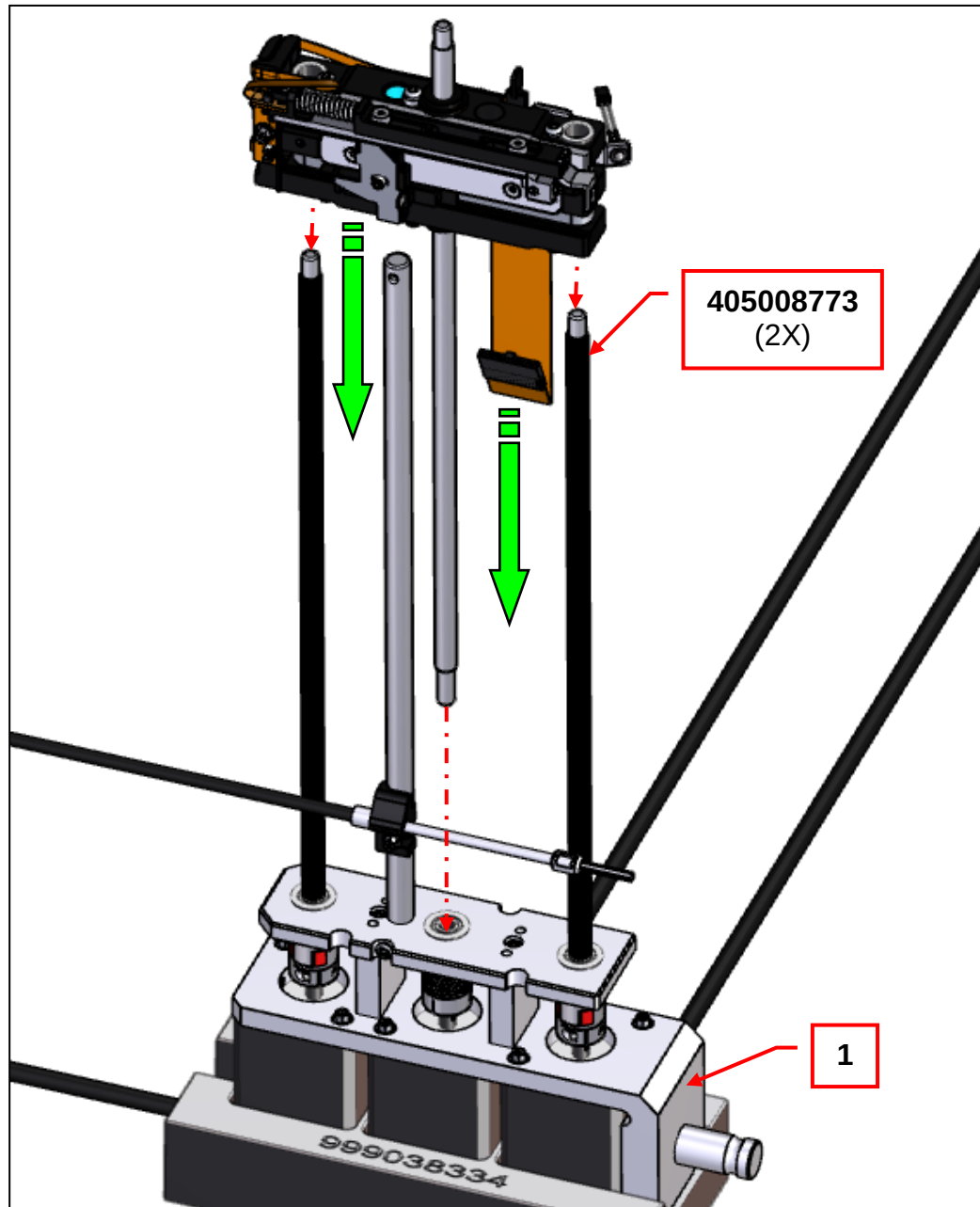
TOOL #	DESCRIPTION
999038334	FTN MOTOR MOUNT ASSEMBLY FIXTURE
N/A	70 IN-OZ TORQUE DRIVER W/ 1.5 mm ALLEN BIT

- 1.2 With the Motor Stack in the 999038334 fixture, slide the Needle Carriage down the Spline Shafts (405008773) and Shaft (405009346) with the longer smooth end of the Lead Screw towards the Flex Coupling (410003141) as shown.



Slide the longer, smooth end of the Lead Screw through the Bearing (410000824) and into the center Flex Coupling.

Torque the set-screw, farthest from the R Motor, in the Flex Coupling to **70 in-ozs**.



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OPER
1.0

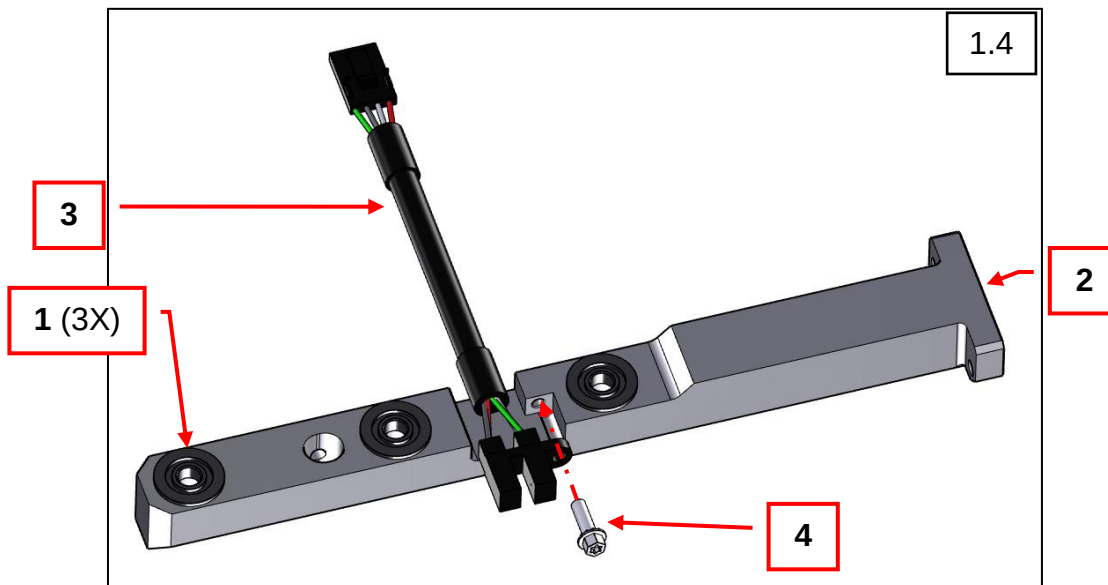
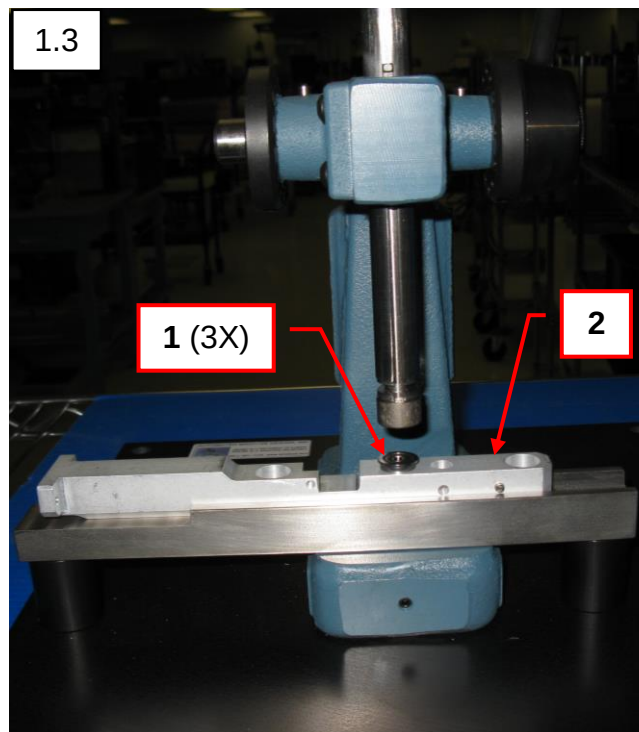
OPERATION DESCRIPTION
MAIN ASSEMBLY

ITEM	QTY	PART #	DESCRIPTION
1	3	410000824	BALL BEARING
2	1	405010269	END PLATE
3	1	441000936	NEEDLE HOME SENSOR CABLE
4	1	WAT081265	SCREW

TOOL #	DESCRIPTION
999034508	PRESS FIXTURE
N/A	60 IN-OZ TORQUE DRIVER w/ T10 Bit

1.3 Using the 999034508 press fixture, press the Ball Bearings into the End Plate.

1.4 Attach the Needle Home Sensor Cable to the End Plate with the Screw. **Torque Screw at 60 in-oz.**



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OPER
1.0

OPERATION DESCRIPTION
MAIN ASSEMBLY

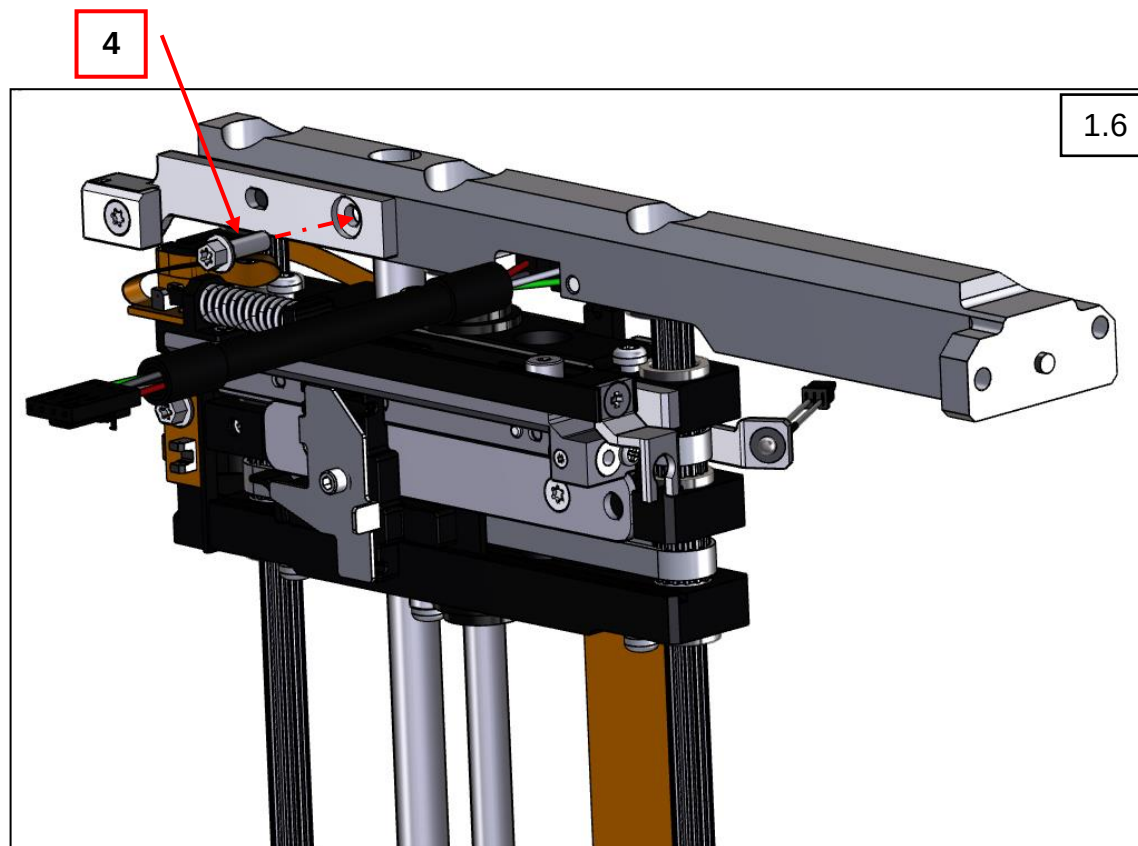
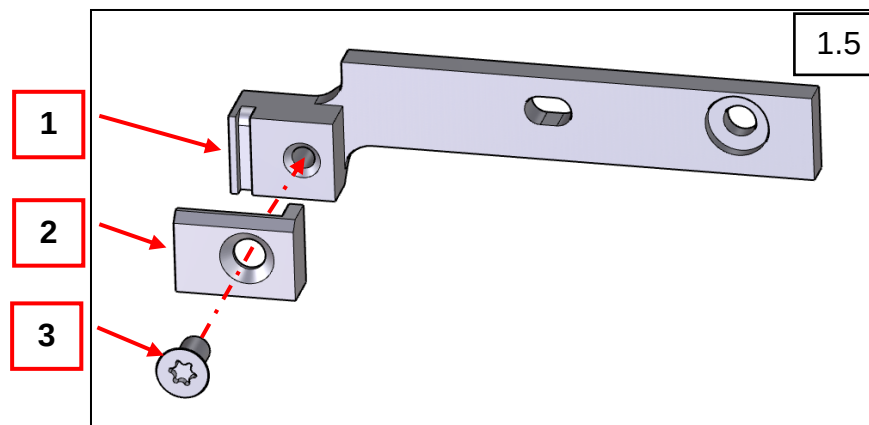
ITEM	QTY	PART #	DESCRIPTION
1	1	405011162	NEEDLE GUIDE
2	1	405011134	NEEDLE TUBE CLAMP
3	1	WAT414306	SCREW
4	1	WAT081265	SCREW

TOOL #	DESCRIPTION
999038334	FTN MOTOR MOUNT ASSEMBLY FIXTURE
N/A	TORX T10

- 1.5 Attach the Needle Tube Clamp to the Needle Guide with the Screw.
- 1.6 Slide the End Plate (405010269) assembly over the Spline Shafts (405008773), Lead Screw (405008814), and Shaft (405009346).

Loosely attach the Needle Guide and End Plate to the Shaft with the WAT081265 Screw.

Remove the assembly from the 999038334 fixture.



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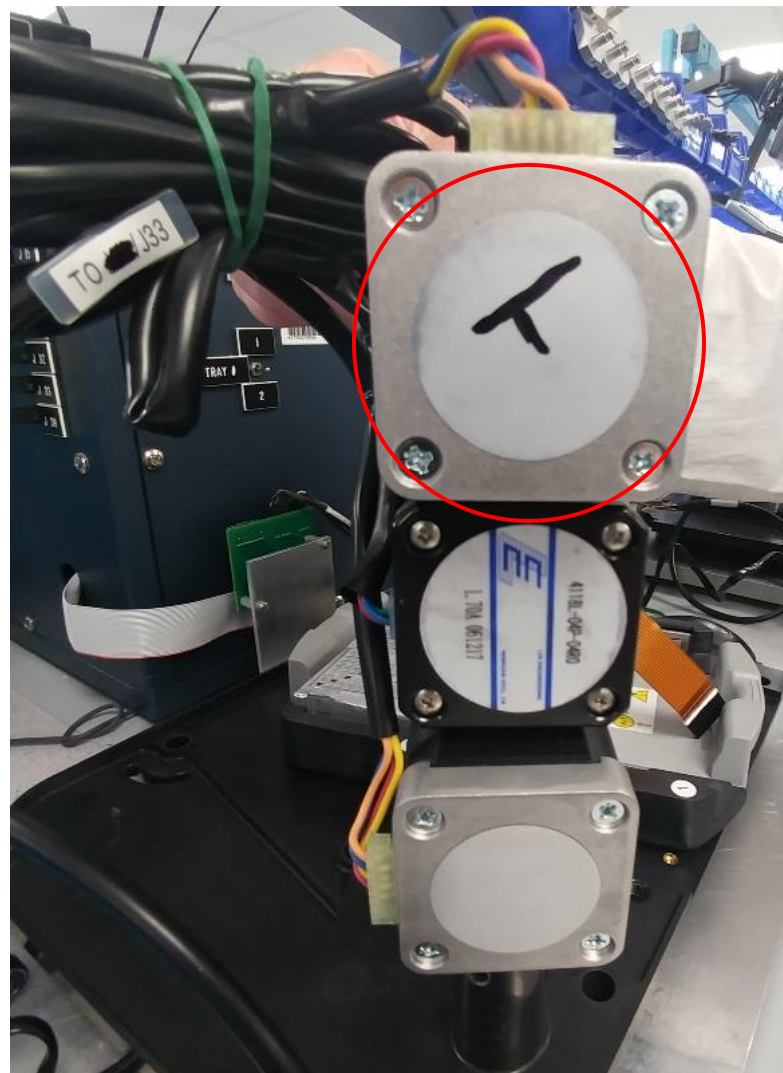
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<u>OPER</u>	<u>OPERATION DESCRIPTION</u>
2.0	TEST ASSEMBLY

2.1 Test assembly per TSP.

Using a Black indelible marker, mark the Upper Z-Zp motor label with a "T", confirming test has (PASSED). See photo.



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