

WATERS MANUFACTURING ASSEMBLY PROCEDURE

PAGE 1 OF 7
289004794 REV J
DATE
11/14/2009

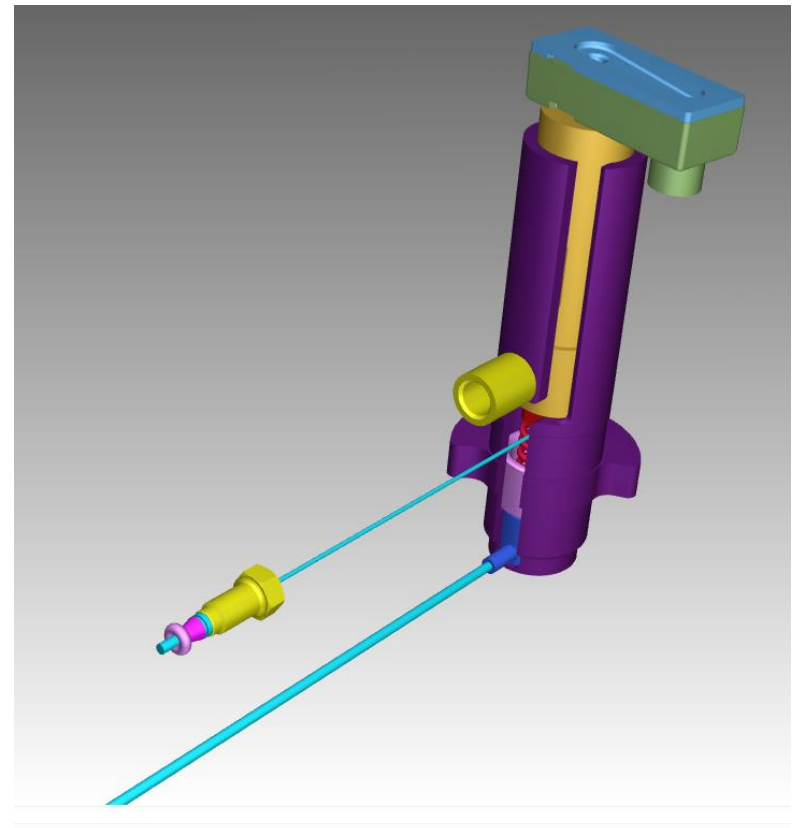
ITEM NUMBER
289004794

DESCRIPTION
ASSY, SEAL WASH HOUSING

WRITTEN BY
S. CASEY

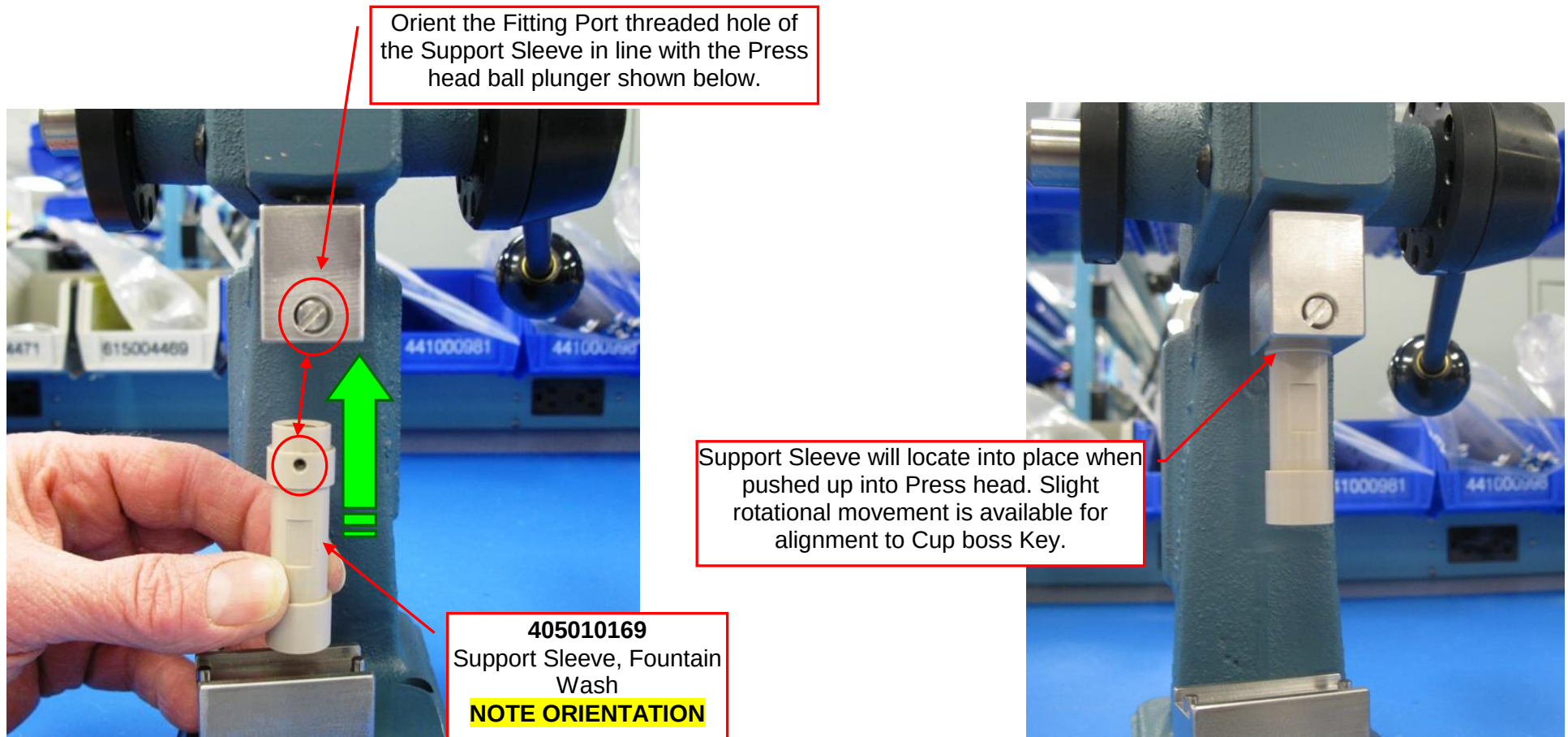
REVISION RECORD

<u>REV</u>	<u>AUTHORITY</u>	<u>NOTES</u>
A	S. CASEY	CM 9149183
B	C. CASEY	CM 9150967
C	H. Guilmain	CM 9154434
D	H. Guilmain	ECO 9155257
E	H. Guilmain	ECO 9158149
F	H. Guilmain	ECO 9159245
G	M. AUBIN	ECO 9178445
H	M. AUBIN	ECO 9189477
J	C. HUDSON	ECO 9190232



<u>OPER</u>	<u>OPERATION DESCRIPTION</u>	<u>TOOL NUMBER/DESCRIPTION</u>
	SUPPORT SLEEVE TO CUP ASSY	Press Fixture 999033553

- 1.0 Insert the Support Sleeve, (threaded Fitting hole at the top), into Press Fixture head. (Orient Sleeve with threaded hole facing the front of Press Fixture head as shown.)

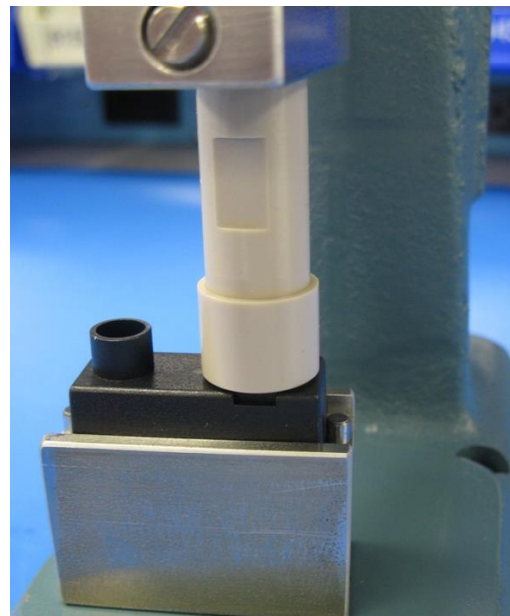
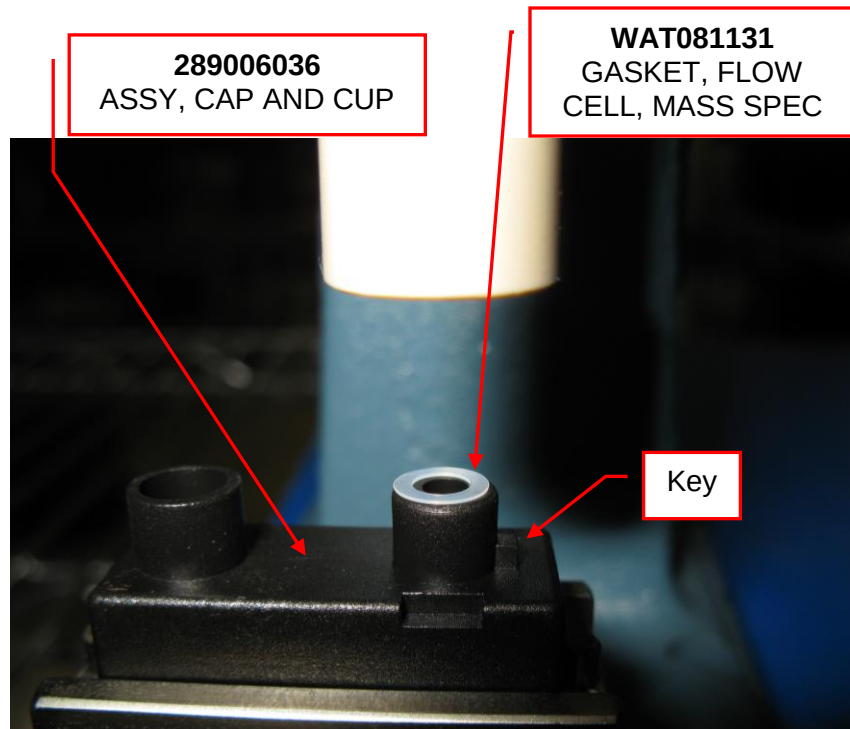
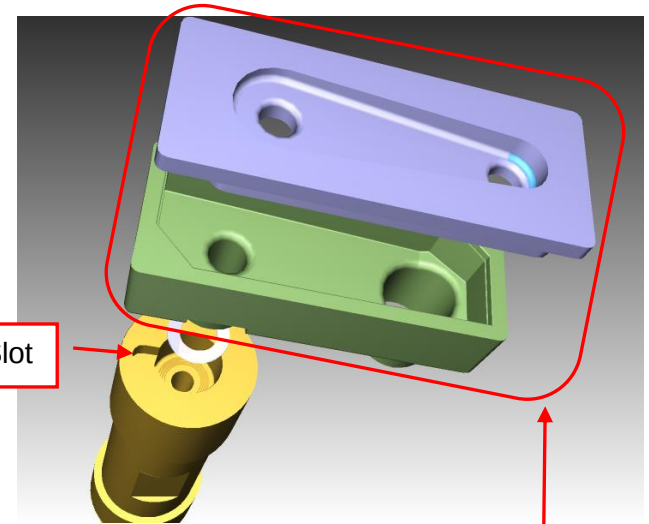


<u>OPER</u>	<u>OPERATION DESCRIPTION</u>	<u>TOOL NUMBER/DESCRIPTION</u>
	SUPPORT SLEEVE TO CUP ASSY, cont'd	Press Fixture #999033553

- 1.1 Place Cap and Cup Assy, into Press Fixture base. (Orient Assy. with the keyed boss being under the Support Sleeve.)

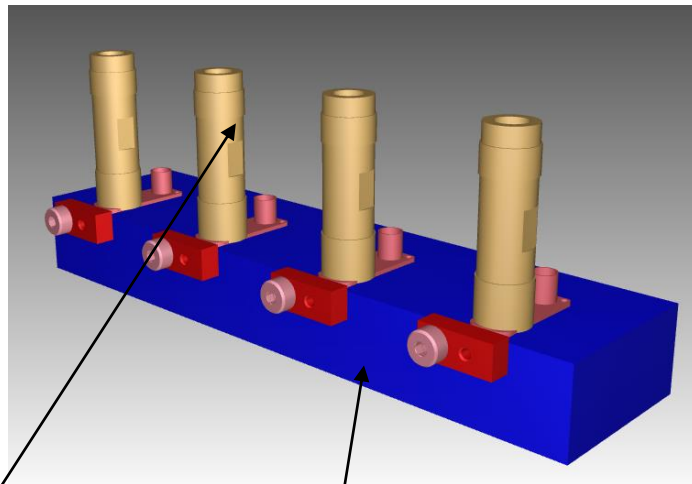
[NOTE: Cap orientation on Cup is important. If pressed on backwards, could cause damage to Needle of Injector. (Holes of Cap should line up with holes of Cup.)]

- 1.2 Place Gasket (WAT081131), (Qty 1) onto Cup Assy. boss as shown.
- 1.3 Press Support Sleeve onto Cup boss using Press Fixture #999033553.



Orientation of Cap to Cup should be as shown above. Trough of Cap leads down to large id boss of Cup.

<u>OPER</u>	<u>OPERATION DESCRIPTION</u>	<u>TOOL NUMBER/DESCRIPTION</u>
1.4	Use Fixture 999033450 for steps 1.3 to 1.5 to aid in assembly Load up to (4) assemblies in fixture as shown.	999033450
1.5	Blow off seat using ION gun. Insert Seat (405011492) into Support Sleeve (405010169)—note orientation into c-bore	ION GUN

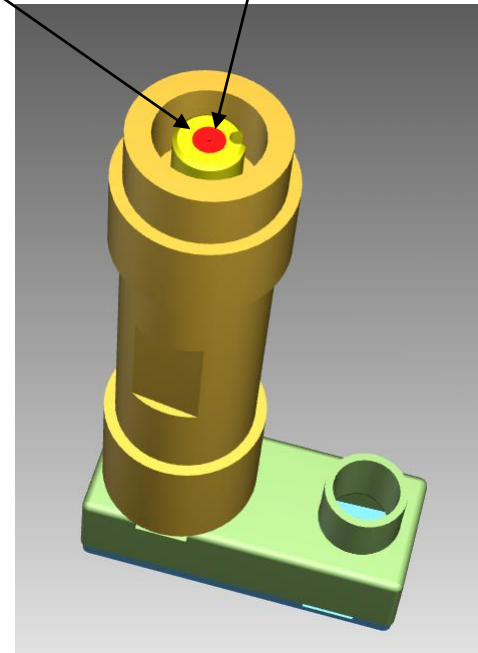


405010169
SUPPORT SLEEVE,
FOUNTAIN WASH

FIXTURE 999033450

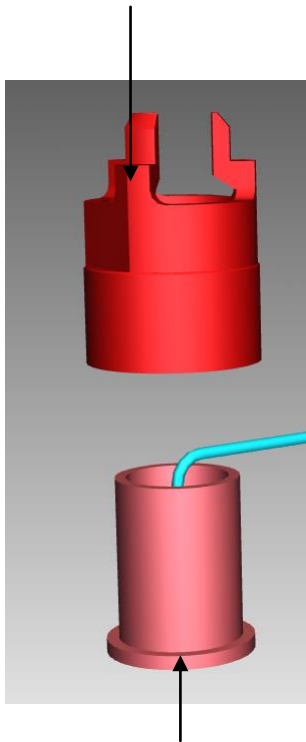
405011492
SEAT, VESPEL
W/ANTI-ROT
(CRITICAL
CLEAN PART)

SMALL HOLE THIS END



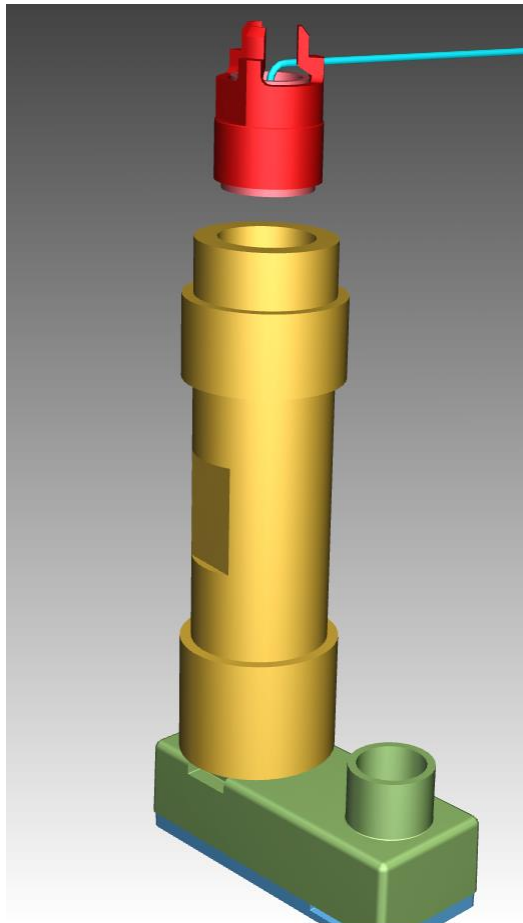
<u>OPER</u>	<u>OPERATION DESCRIPTION</u>	<u>TOOL NUMBER/DESCRIPTION</u>
1.6	Slide SEAT PORT W/ANTI-ROT onto NUT, PORT, LOCKING, EXT as shown NOTE: TUBE STILL IN UNBENT CONDITION!	7/16 IN. OPEN END WRENCH
1.7	Screw Nut with Tube Assy into Support Sleeve— first finger tight then ¼ turn.	5/16 IN.OPEN END WRENCH
1.8	Bend Tube 90 degrees in-line with Fitting Port as shown NOTE: Make sure bent tube is below surface for Spring.	

405008175
NUT, PORT, LOCKING, EXT

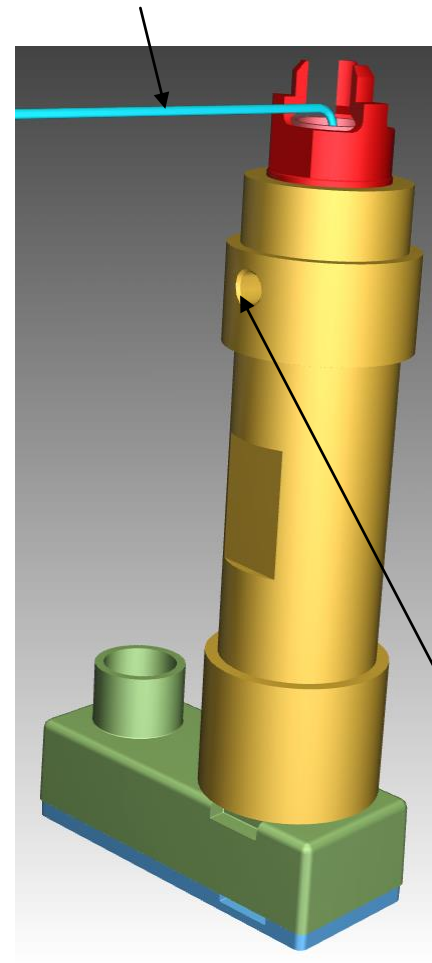


430002810
ASSY, SEAT PORT
Critical Clean part

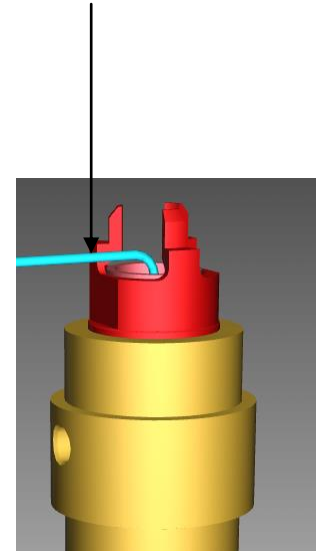
SCREW NUT/TUBE ASSY ¼ TURN
AFTER FINGER TIGHT



BEND TUBE 90 DEGREES
IN-LINE WITH FITTING PORT



MAKE SURE TUBE IS BENT
BELOW THIS SURFACE
AS SHOWN



FITTING PORT

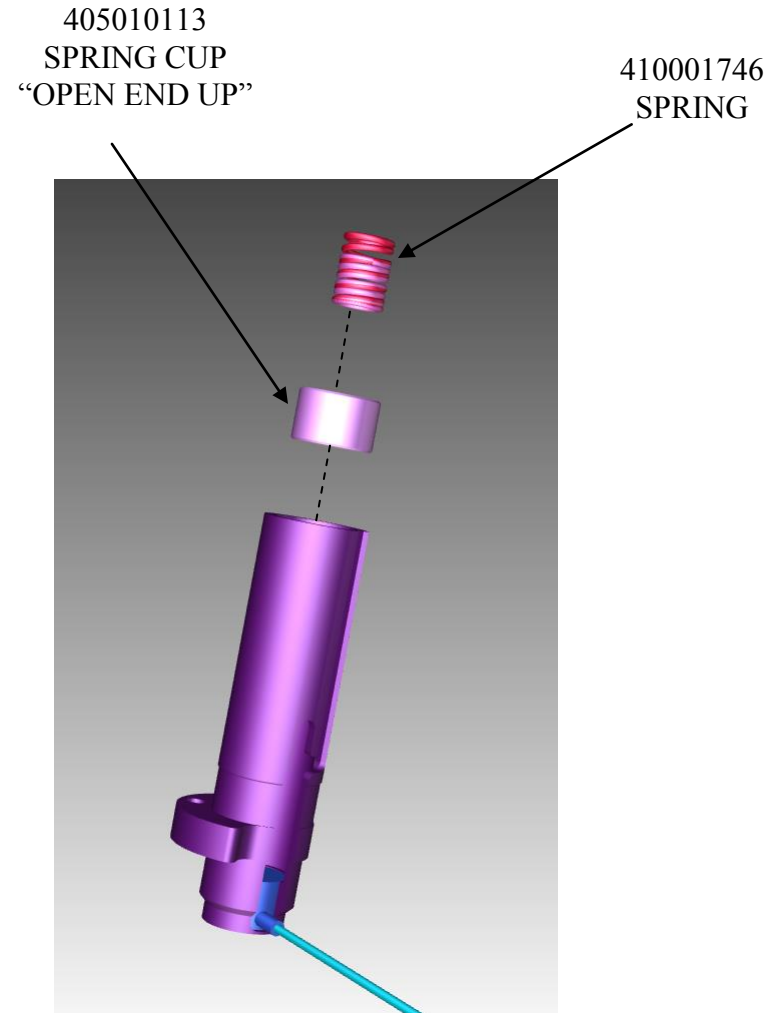
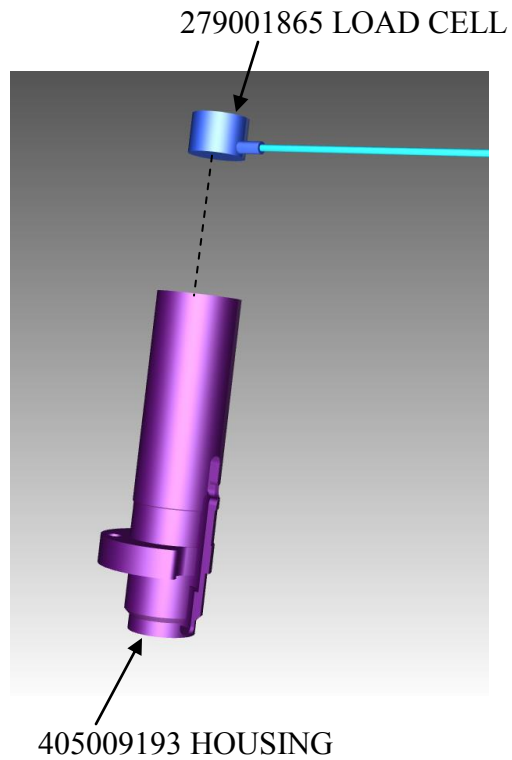
OPER **OPERATION DESCRIPTION**

TOOL NUMBER/DESCRIPTION

1.9 Slide Load Cell into Housing as shown

ION GUN TO BLOW OFF CELL

1.10 Drop in Spring Cup and Spring as shown



<u>OPER</u>	<u>OPERATION DESCRIPTION</u>	<u>TOOL NUMBER/DESCRIPTION</u>
2.0	Slide Support Sleeve with Tube Assy into Housing as shown NOTE: SUPPORT SLEEVE SHOULD SLIDE FREELY INSIDE HOUSING	
2.1	Screw Fitting into Support Sleeve NOTE: COMPRESS SUPPORT SLEEVE ASSY—MAKE SURE TUBE ASSY IS PROPERLY SEATED IN SPRING	
2.2	Assemble Compression Screw, Ferrule and O Ring to end of Tube as shown.	
2.3	Bag assembly into Critical Clean Bag (290000416) (9 X 12). Place paperwork in 6 X 9 plastic bag.	

