

TABLE 1

**ALUMINUM
RANGE**

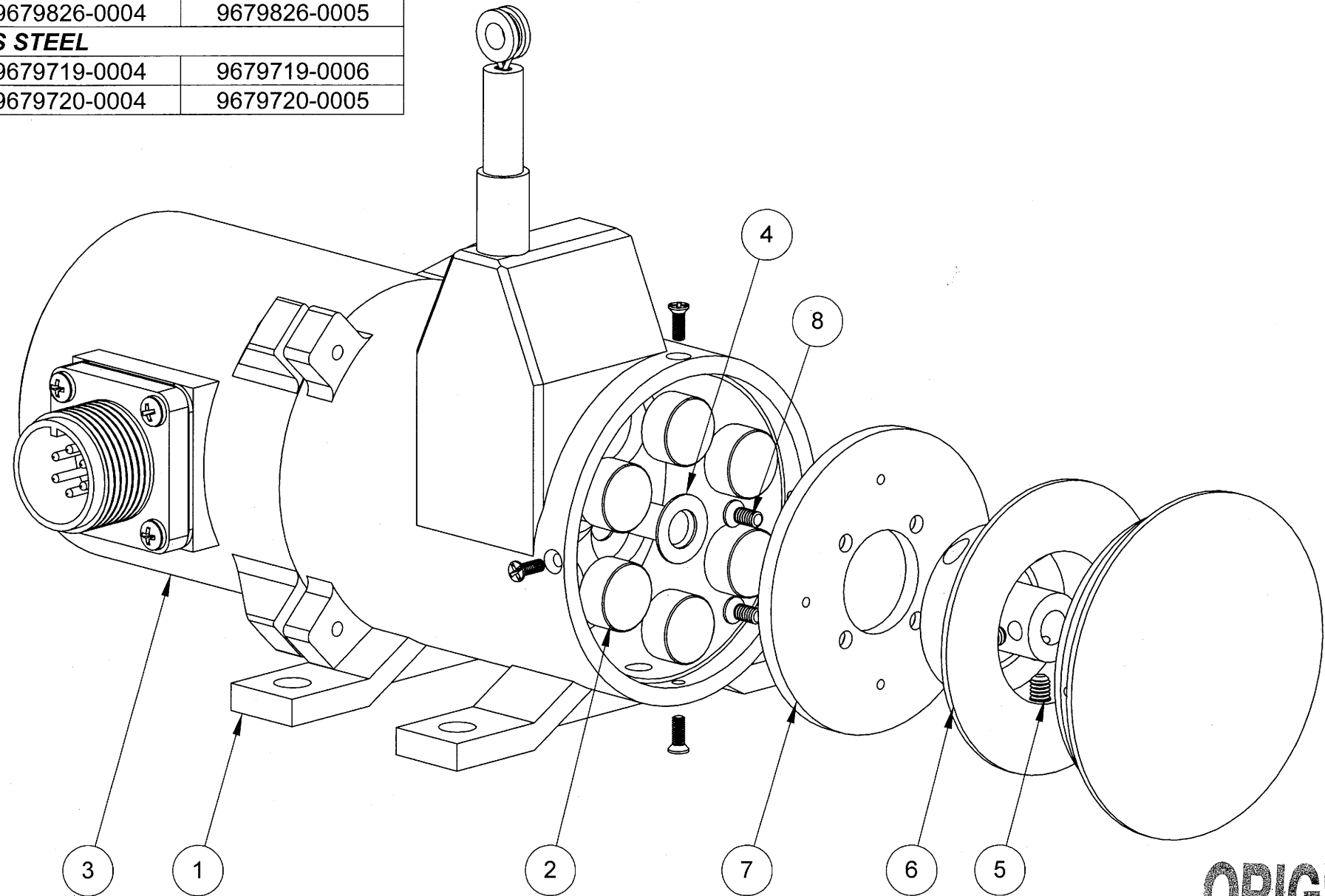
	10"	25", 50"	20", 40"	30", 60"
HOUSING	9678397-0002	9678397-0005	9678397-0004	9678397-0006
SPOOL	9679826-0010	9679826-0006	9679826-0004	9679826-0005

316 STAINLESS STEEL

HOUSING	9679719-0002	9679719-0005	9679719-0004	9679719-0006
SPOOL	9679720-0002	9679720-0006	9679720-0004	9679720-0005

REVISIONS

REV.	DESCRIPTION	DATE	APPROVED
A	SEE DCN: 6381	6.27.2008	W/SK

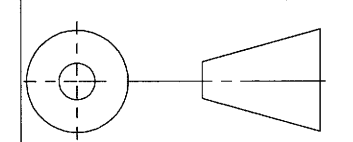


ORIGINAL

8	9006221-4405	MSCR CRES 0.112-40X0.25 XRSFLH	4
7	9678399-0000	DISK,COPPER,VLS8000	1
6	SEE TABLE 1	SPOOL,VLS8000	1
5	9011261-6305	SSCR,CRES,0.138-32 X .25 LONG,SKT	2
4	900330A-6005	WASHER,NYLON,1/4IDX1/2ODX0.02TK	1
3	9677276-0000	COVER,ALUM,MOD,PT8420/8510	1
2	9000130-0003	MAGNET, ROUND, INCLINOMETER	6
1	SEE TABLE 1	HOUSING,VLS8000	1
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.

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THIRD ANGLE PROJECTION



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Transducer Products Inc.

TITLE
**ASSEMBLY DRAWING
VLS8000 SERIES**

APPROVALS DATE

DRAWN E.GARCIA 6.27.2008

CHKD [Signature]

DO NOT SCALE DRAWING

SIZE CODE IDENT. NO DWG. NO REV

B 52158 PS-140 A

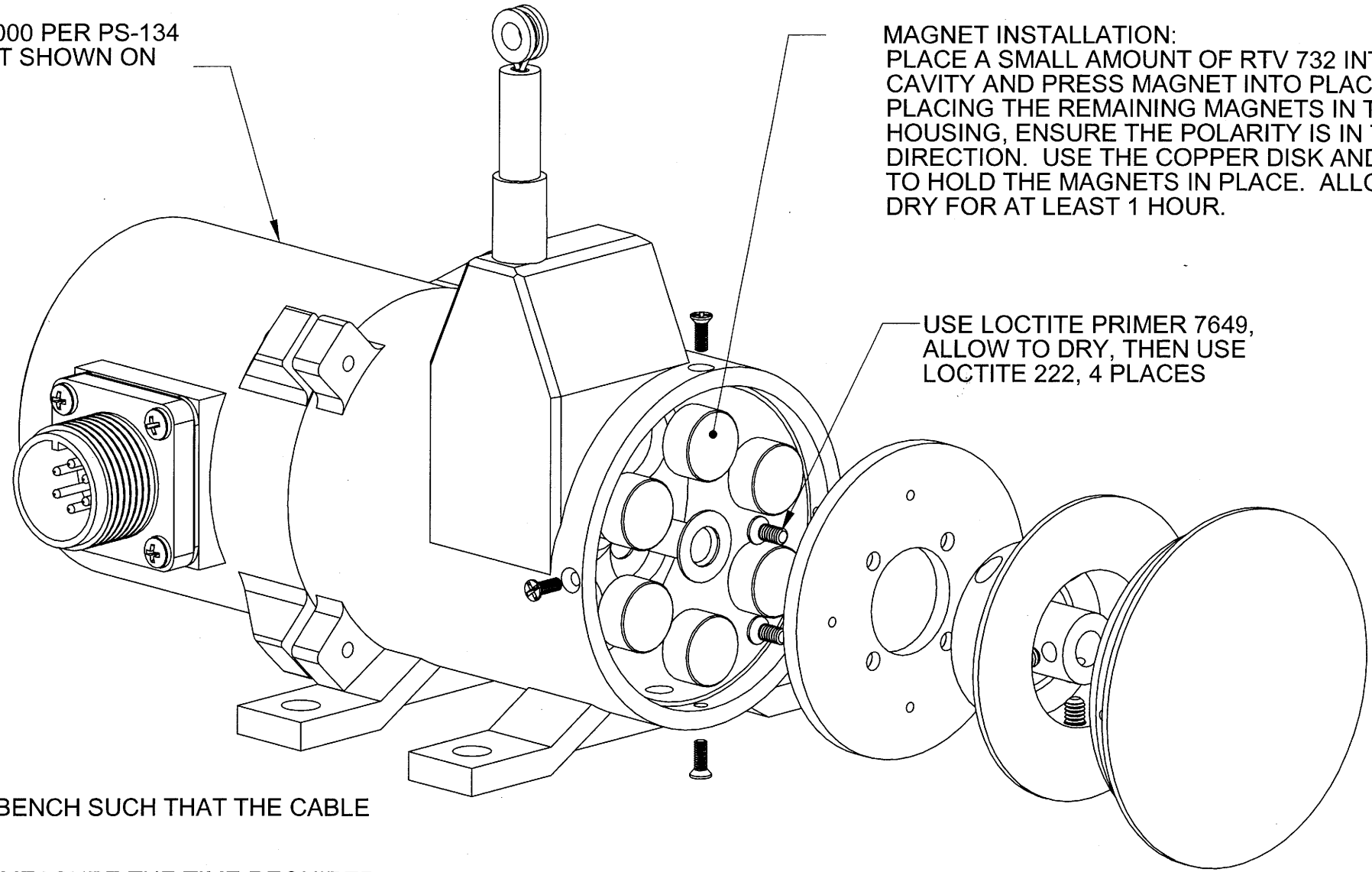
SCALE: 1:1 SHEET 1 OF 3

A
B
C
D
E
F
G

ASSEMBLE VLS8000 PER PS-134 FOR DETAILS NOT SHOWN ON THIS DRAWING

MAGNET INSTALLATION:
PLACE A SMALL AMOUNT OF RTV 732 INTO THE CAVITY AND PRESS MAGNET INTO PLACE. WHEN PLACING THE REMAINING MAGNETS IN THE HOUSING, ENSURE THE POLARITY IS IN THE SAME DIRECTION. USE THE COPPER DISK AND A CLAMP TO HOLD THE MAGNETS IN PLACE. ALLOW TO DRY FOR AT LEAST 1 HOUR.

USE LOCTITE PRIMER 7649, ALLOW TO DRY, THEN USE LOCTITE 222, 4 PLACES



ACCEPTANCE TEST PROCEDURE:

1. SECURE THE ASSEMBLED UNIT ONTO THE WORK BENCH SUCH THAT THE CABLE WILL EXIT PARALLEL TO WORKING SURFACE.
2. EXTEND THE CABLE TO ITS FULL RANGE.
3. USING A STOP WATCH, RELEASE THE CABLE AND MEASURE THE TIME REQUIRED FOR THE CABLE TO FULLY RETRACT. THE CABLE RETRACTION SPEED (C.R.S.) IS CALCULATED USING THE FOLLOWING EQUATION:

$$C.R.S. = \text{RANGE (in)} / \text{TIME (s)}$$

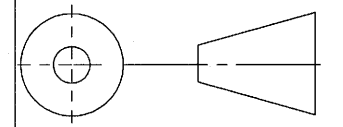
4. REFER TO THE ACCEPTANCE TEST CRITERIA, TABLE 3, FOR C.R.S LIMITS.
5. IF THE CABLE RETRACTION SPEED IS TOO GREAT, (OVER 55 INCHES/SECOND), REMOVE THE .020 THICK WASHER AND REPLACE IT WITH A .010 THICK WASHER, PART NUMBER 9000400-0171.
6. IF THE CABLE RETRACTION SPEED IS TOO SLOW, (UNDER 40 INCHES/SECOND), ADD A .005 THICK WASHER, PART NUMBER 9000400-0185, BETWEEN THE SPOOL AND THE HOUSING

ORIGINAL

TABLE 3	
ACCEPTANCE TEST CRITERIA	
C.R.S. (in / s)	40 - 55

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APPROVALS		DATE	SIZE	CODE IDENT. NO	DWG. NO.	REV
DRAWN	E.GARCIA	6.27.2008	B	52158	PS-140	A
CHKD	<i>[Signature]</i>	<i>[Signature]</i>				
DO NOT SCALE DRAWING			SCALE: 1:1		SHEET 2 OF 3	

