

November 26, 2002
PS-90, Revision: A

Production Procedures

Mechanical Assembly MT2A Series

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- 1st Spray 4-40 screws and spool set screws with Loctite Primer "N" 7649 and allows it to dry completely, approximately 5 minutes.
- 2nd Create cable assembly per drawing 603933 Rev. latest.
- 3rd Using Loctite 401 to glue the cable guide into the housing and allow it to dry, approximately 5 minutes.
- 4th Install bearing in to spring housing.
(THIS MUST BE DONE BEFORE INSTALLING THE FR-4 DISK)
- 5th Insert phenolic-disk (**with the smaller center hole**) into the spool spring cavity.
- 6th Wipe the disk with a thin coat of heavy-duty lithium complex grease, moly fortified (reddish black in color).
- 7th Assemble the power-spring into the spring housing insuring the outside eye is inserted into the c-bore.
- 8th Insert the spring pin into the outer eye detail on the spring permanently fastening the spring to the housing.
- 9th Wipe the inner coils of the spring with a small amount of heavy-duty lithium complex grease, moly fortified, (reddish black in color).
- 10th Assemble the second phenolic-disk (**with the larger center hole**) above the power spring.
- 11th Assemble set screws into spool applying a small amount of Loctite 222 to the set-screws.
- 12th Install the cable assembly through the cable guide and fasten the cable to the spool using crimp 900400-0070
- 13th Place the spool and cable assemble into the completed spring housing and then assemble spool housing.
- 14th Rotate the housing feeding the cable into the transducer maintaining tension on the cable as it wraps around the spool.

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- 15th Once the cable is full retracted continuing rotating the spring housing placing 5 per turns on the spring.
- 16th Assemble the three 4-40 screws securing the two housing together use Loctite 222 on threads.
- 17th Rotate the potentiometer shaft by hand CCW until the potentiometer stops on the internal stop then fully extend the transducer and fasten the potentiometer to the spool with the 2 set screws. Insure that pressure is maintained on the back of the potentiometer while tightening the set-screws. This insures the potentiometer will not bind when the servo clips are tightened.
- 18th Install the potentiometer into the spool using Loctite 222 on the screws, which hold the servo-clips, do not tighten until potentiometer is adjusted.
- 19th Adjust the potentiometer to read between 0.050-0.1500 volts.
- 20th Tighten the screws fastening the servo clips to the housing securing the potentiometer.

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