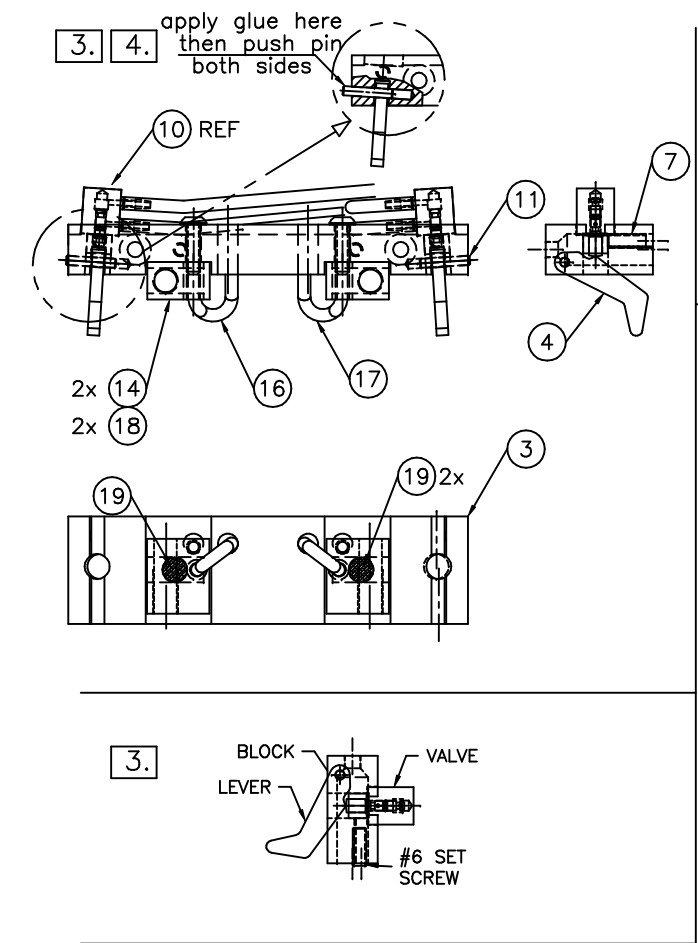


REVISIONS				
REV	DESCRIPTION	BY	DATE	APP
A	RELEASE TO PROD	DR	07 07 11	SS
B	ECO 97690	DR	01 11 13	MV
C	ECO 108704	DR	09 02 14	MV



2. INSERT A HANDPIECE NUT IN & OUT OF THE CAVITY. NUT SHALL GO IN & OUT OF THE CAVITY SMOOTHLY AND NO AIR LEAK SHALL BE HEARED WHEN NUT IS "IN" OR "OUT" OF CAVITY.

1. APPLY 80 PSI AIR PRESSURE TO RED TUBE WHILE CLEAR TUBE IS PLUGGED.

TEST PROCEDURE:

7. LUBRICATE O-RING ON PLUNGER USING CLEAR SILICONE LUBE

6. INSTALL 10-32 SET SCREW TO HOLDER USING BLUE LOCTITE ON THREADS

5. MOUNT BLOCK SUB-ASSEMBLY TO HOLDER USING TWO (2) 6-32 X 3/8 FLAT HEAD PHILLIPS SCREWS (ITEM 12) NOTE: PASS TUBES THRU SIDE HOLE FIRST.

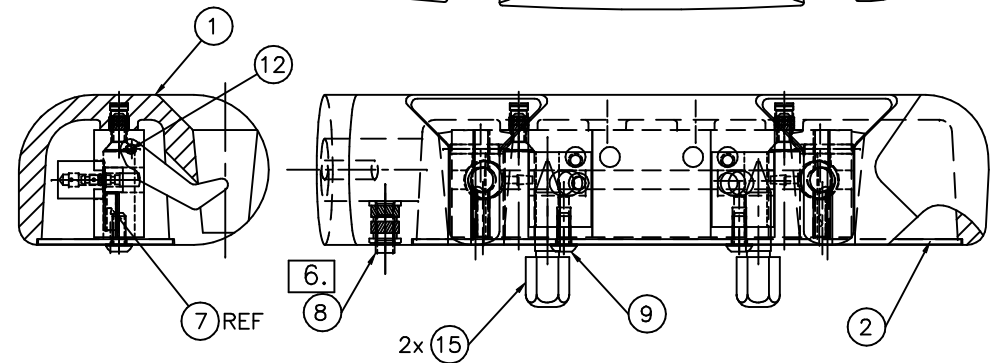
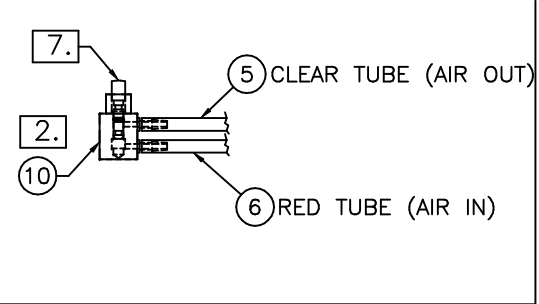
4. ASSEMBLE WATER BLOCKS WITH 1/4" BRASS BALL TO BLOCK.
 - PASS BLUE TUBES THROUGH WATER BLOCKS AND MAIN BLOCK AS SHOWN.
 - ASSEMBLE LEVERS TO BLOCK USING THE 3/32 DIA DOWEL PINS (ITEM 11) AND CLEAR GLUE (ITEM 13)
 - APPLY GLUE WHEN PIN IS IN POSITION SHOWN. WARNING! AVOID EXCESS GLUE ON PIN.

3. MOUNT VALVES TO BLOCK USING #6 SET SCREWS (ITEM 7) PUSH VALVE ALL THE WAY INTO THE BLOCK AND TIGHTEN #6 SET SCREW.

2. ASSEMBLE RED AND CLEAR TUBES TO VALVES

1. VISUALLY INSPECT HOLDER FOR DEFECTS SUCH AS DULL SURFACES, SCRATCHES, AND TOOL MARKS. REJECT PARTS WITH THESE AND OTHER DEFECTS.

ASSEMBLY PROCEDURE:



20	91624	CLEAR SILICONE LUBE	A/R
19	93328	1/4" DIA BRASS BALL	2
18	92206-0608	6-32 X 1/2" LG BUTTON HEAD SOCKET SCREW	2
17	91074-0100	1/8 OD X 25" LG BLUE TUBE	1
16	91074-0084	1/8 OD X 21" LG BLUE TUBE	1
15	500024212	KNOB, FINE WATER ADJUSTMENT	2
14	50002422	FINE WATER ADJUSTMENT BLOCK	2
13	91550	CLEAR ADHESIVE	A/R
12	92113-0606	6-32 X 3/8 LG FLAT HEAD SCREW	2
11	93163-08	3/32 X 1/2" LG DOWEL PIN	2
10	92941	VALVE ASSY, NORMALLY OPEN	2
9	92206-0605	6-32 X 5/16 LG BUTTON HEAD SOCKET SCREW	2
8	92139-1006	10-32 X 3/8 SET SOCKET SCREW	1
7	92129-0606	6-32 X 3/8 SET SOCKET SCREW	2
6	91076-0068	1/8 OD X 17" LG RED TUBE	2
5	91073-0068	1/8 OD X 17" LG CLEAR TUBE	2
4	5000111	LEVER	2
3	5000110	MAIN BLOCK	1
2	500024252	BOTTOM PLATE	1
1	50001052	2CAVITY UNI-HOLDER, RIGHT	1

ITEM		PART NO.	DESCRIPTION	QTY
LIST OF MATERIALS				
DRAWN:	DR	DATE:	02 01 11	MAT'L
CHECKED:		DATE:		SEE LIST OF MATERIALS
APPROVED:		DATE:		FINISH: NONE
UNLESS NOTED: - BREAK SHARP EDGES .005 - .010 - MACHINED SURFACES 125 - DIMENSIONS IN INCHES - TOLERANCES				HEAT TREAT: NONE
INFORMATION HEREON IS THE CONFIDENTIAL PROPERTY OF PROMA. IT MAY NOT BE USED OR DISCLOSED WITHOUT PRIOR WRITTEN CONSENT.				DECIMALS .X = ±.025 .XX = ±.015 .XXX = ±.008
NEXT ASSY: -				FRACTIONS ± 64
RECD: ONE				ANGLES ± 1°
SCALE: 1 / 1				TITLE: UNI-HOLDER ASSY, 2-VALVE WITH WATER CONTROLS, RIGHT MOUNT
DWG NO: 50002129A				SIZE: C
				PAGE: 1 OF 1
				REV: C