

REVISIONS				
REV	DESCRIPTION	BY	DATE	APP
A	ECO 97B46	DR	07 07 11	SS
B	ECO 97B90	DR	01 11 13	MY
C	ECO 108704	DR	09 02 14	MY

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

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

[2] ASSEMBLE RED AND CLEAR TUBES TO VALVE

1. VISUALLY INSPECT. HOLDER FOR DEFECTS SUCH AS DULL SURFACES, SCRATCHES, TOOL MARKS. REJECT PARTS THAT HAVE THESE AND OTHER DEFECTS  
ASSEMBLY PROCEDURE:

NOTES: UNLESS NOTED

ITEM	PART NO.	DESCRIPTION	QTY
18	933328	1/4" DIA BRASS BALL	1
17	922094-0806	6-32 X 1/2" LG BUTTON HEAD SOCKET SCREW	1
16	91074-0084	1/8" OD X 2 1/2" LG BLUE TUBE	1
15	500024212	KNDR. FINE WATER ADJUSTMENT	1
14	50002422	FINE WATER ADJUSTMENT BLOCK	1
13	91660	CLEAR ADHESIVE	A/R
12	92113-0806	6-32 X 3/8 LG FLAT HEAD SCREW	2
11	93183-08	3/32 X 1/2" LG DOWEL PIN	1
10	92941	VALVE ASSY, NORMALLY OPEN	1
9	92908-0805	6-32 X 5/16 LG BUTTON HEAD SOCKET SCREW	2
8	92129-1006	10-32 X 3/8 SET SOCKET SCREW	1
7	92129-0806	6-32 X 3/8 SET SOCKET SCREW	1
6	91076-0084	1/8" OD X 1 7/8 LG RED TUBE	1
5	91073-0086	1/8" OD X 1 7/8 LG CLEAR TUBE	1
4	5000111	LEVER	1
3	5000110	MAIN BLOCK	1
2	50001072	BOTTOM PLATE	1
1	50001062	20CAVITY UNI-HOLDER, LFT	1
ITEM	PART NO.	DESCRIPTION	QTY

LIST OF MATERIALS

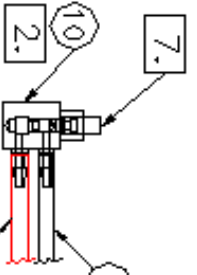
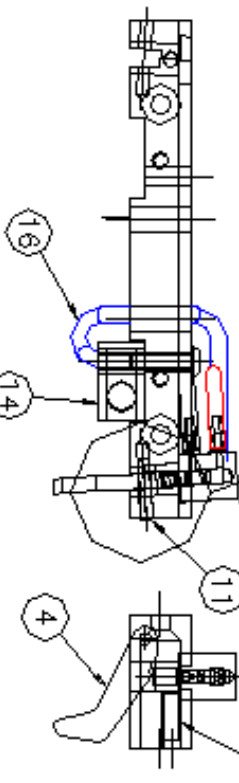
REVISED	DATE	WFL	SEE LIST OF MATERIALS	WFL P/N
APPROVED	DATE	DATE	DATE	DATE
UNLESS NOTED:	DATE	DATE	DATE	DATE
- BREAK SHARP EDGES .0005 - .010	DATE	DATE	DATE	DATE
- MACHINED SURFACES 125	DATE	DATE	DATE	DATE
- DIMENSIONS IN INCHES	DATE	DATE	DATE	DATE
- TOLERANCES	DATE	DATE	DATE	DATE
INFORMATION HEREON IS THE CONFIDENTIAL PROPERTY OF PRIMA. IT MAY NOT BE USED OR DISCLOSED WITHOUT PRIOR WRITTEN CONSENT.				
TEST ASSY	TEST ONE	TEST 1/1	TEST 1/1	TEST 1/1
500021301				
B 1 of 2				
C				

ACAD: 500021301A-REVC

3. 4. apply glue here then push pin both sides

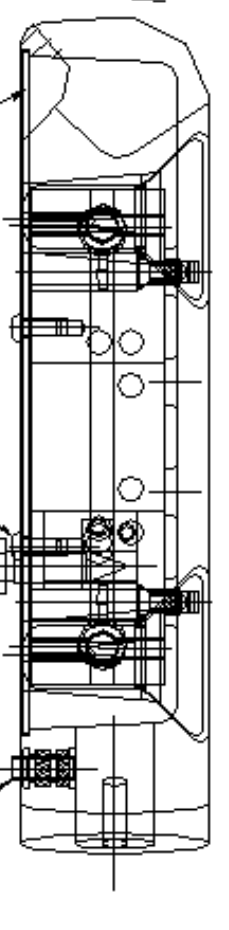
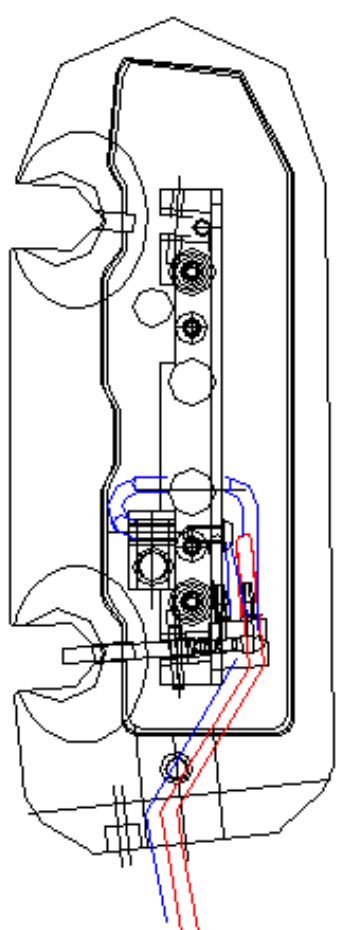


10 REF



5 CLEAR TUBE (AIR OUT)

6 RED TUBE (AIR IN)



BLOCK  
LEVER  
#6 SET  
SCREW  
VALVE

ACAD: 500021301A-REV C

REVISIONS				
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SEE PAGE 1 OF 2				

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REV	DESCRIPTION	BY	DATE	APP
1	UN-HOLDER ASSY, 1-VALVE WITH WATER CONTROLS, RIGHT MOUNT	XXX	1/1	
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