

Assembly Front Page


Shop Order

☐ In Progress

☒ New

XXXXXX

Assembly Selection

 Shop Order

Calibrated Tools

Upper Piston
Assembly

Lower Piston
Assembly

Unit Assembly

Data Capture

<

Piston Assembly - Pocket 1.1

☰

1. Record all component serial numbers

Piston Assy SN (80038929)

Shaft SN (80038961)

Housing SN (80038960)

Flange SN (80038959)

Secondary Piston SNs (80051192)

O-Ring Information

<u>O-Ring.(PN)</u>	<u>Batch Number</u>	<u>Expiration Date</u>	Check if used for all assemblies
2-016 (80051284)	<input type="text"/>	<input type="text"/>	<input type="checkbox"/>
2-107 (80047173)	<input type="text"/>	<input type="text"/>	<input type="checkbox"/>
2-219 (90001617)	<input type="text"/>	<input type="text"/>	<input type="checkbox"/>
2-229 (90001524)	<input type="text"/>	<input type="text"/>	<input type="checkbox"/>
2-236 (90002644)	<input type="text"/>	<input type="text"/>	<input type="checkbox"/>

Written Procedure

<

Piston Assembly - Pocket 3.1

☰

9. Install wear bands (PN 80034033, QTY 2) into the two wider OD grooves of the piston shaft.



10. Install one (1) O-ring 2-223 (PN 90002751) each into the two narrower OD grooves on the piston shaft.



Unit Assembly Dashboard

Unit Assembly Dashboard		
● 6.1 Install BTR Housing to Base	● 6.11 SEC Circuit WP Test	● 6.21 Housing Pressure Test
● 6.2 Body Drift Test	● 6.12 RET Circuit Fill & Purge	● 6.22 Harnesses & Boards
● 6.3 Cleaning & Flushing of Body	● 6.13 Install Position Sensors	● 6.23 Hi-Pot Test
● 6.4 Lower Piston Installation	● 6.14 EXT Circuit Fill & Purge	● 6.24 Install Electronic Boards
● 6.5 Upper Piston Installation	● 6.15 RET Circuit Test	● 6.25 Sensor Calibration
● 6.6 Piston Piping	● 6.16 EXT Circuit Test	● 6.26 Electronics Test
● 6.7 Main Pocket Power Harness	● 6.17 Install Equalization Valve	● 6.27 Bearing Sealing Test
● 6.8 Check Valve Installation	● 6.18 Install RPM Sensors	● 6.28 Final Drift Test
● 6.9 SEC Circuit 1.5 x WP Test	● 6.19 Install Proximity Sensors	● 6.29 Function Test
● 6.10 Umbilical Plate Installation	● 6.20 Install P/T Sensors	● 6.30 Prepare for Shipment