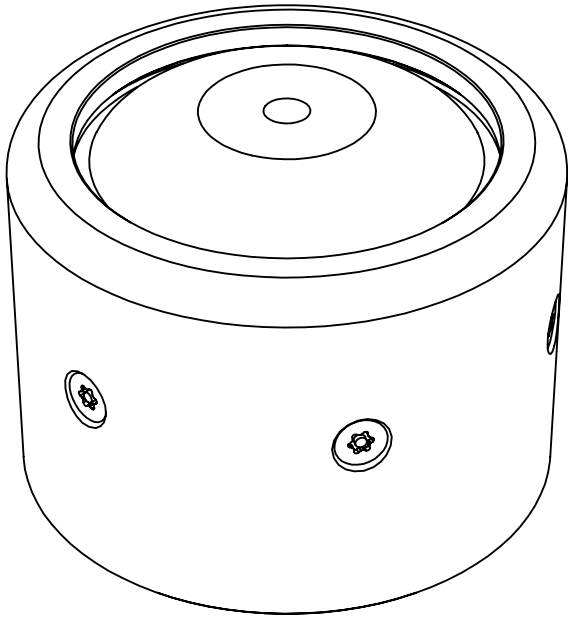
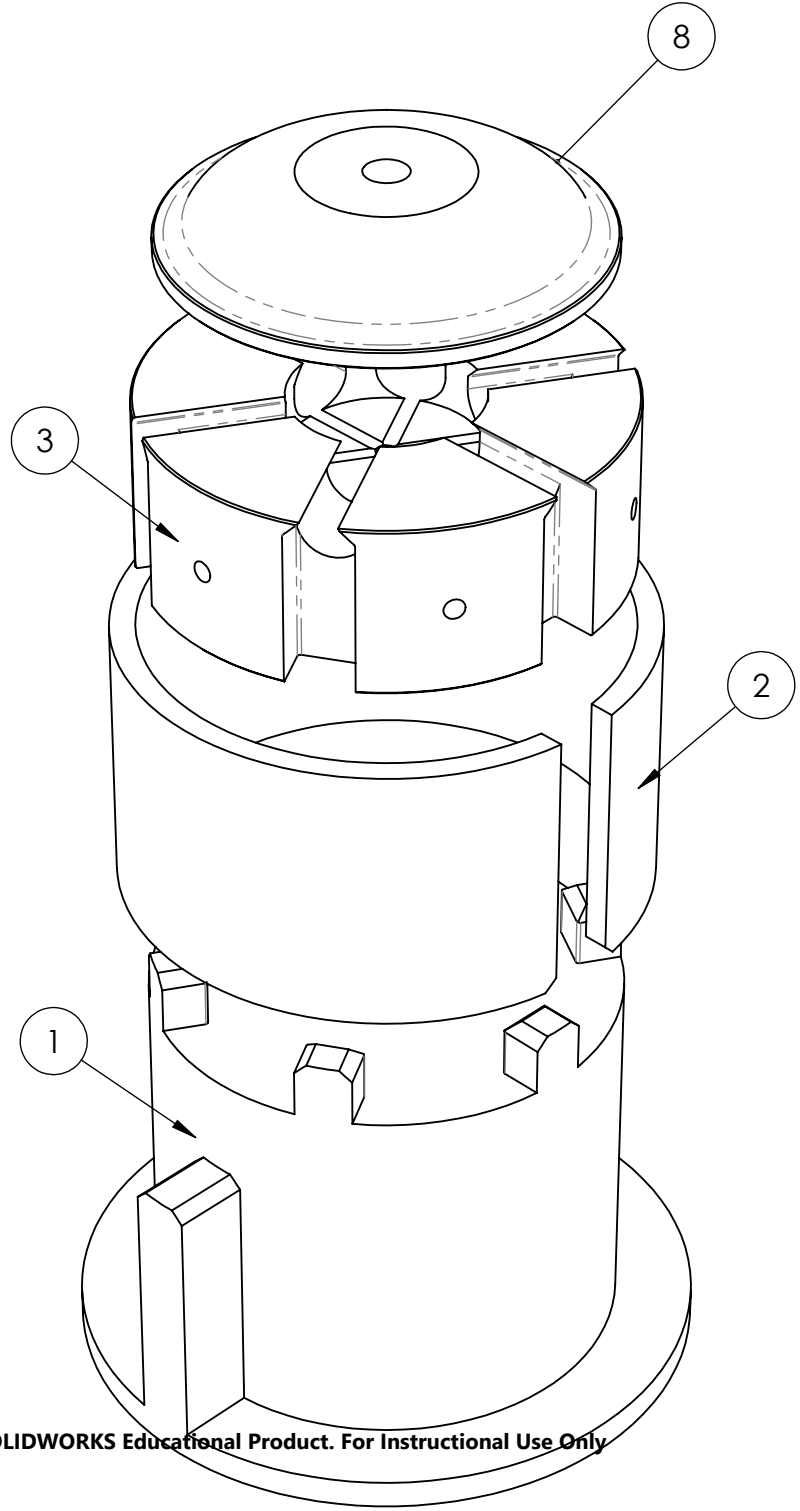
ISOFONICS
Assembly Instructions
ISO080-INS

R. S. Maguire

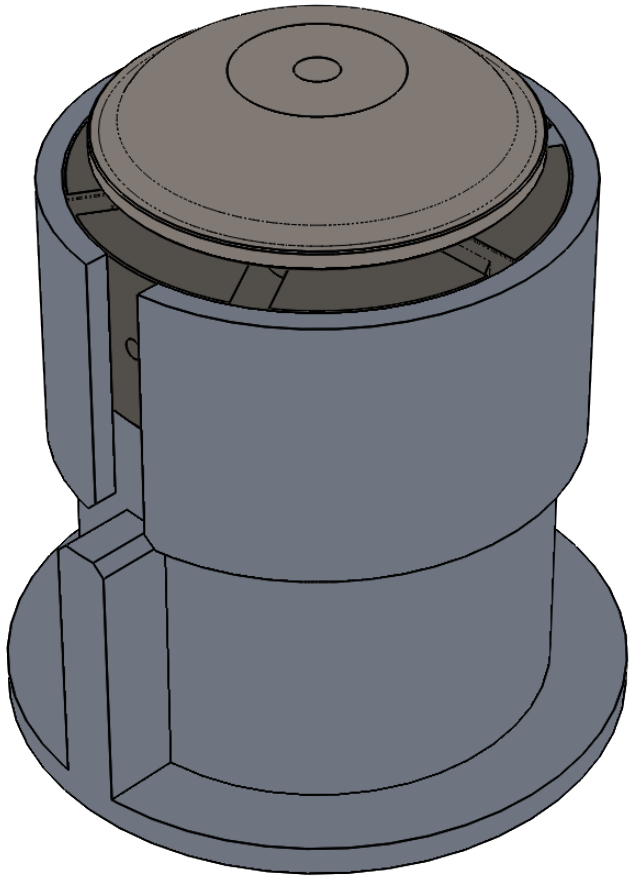


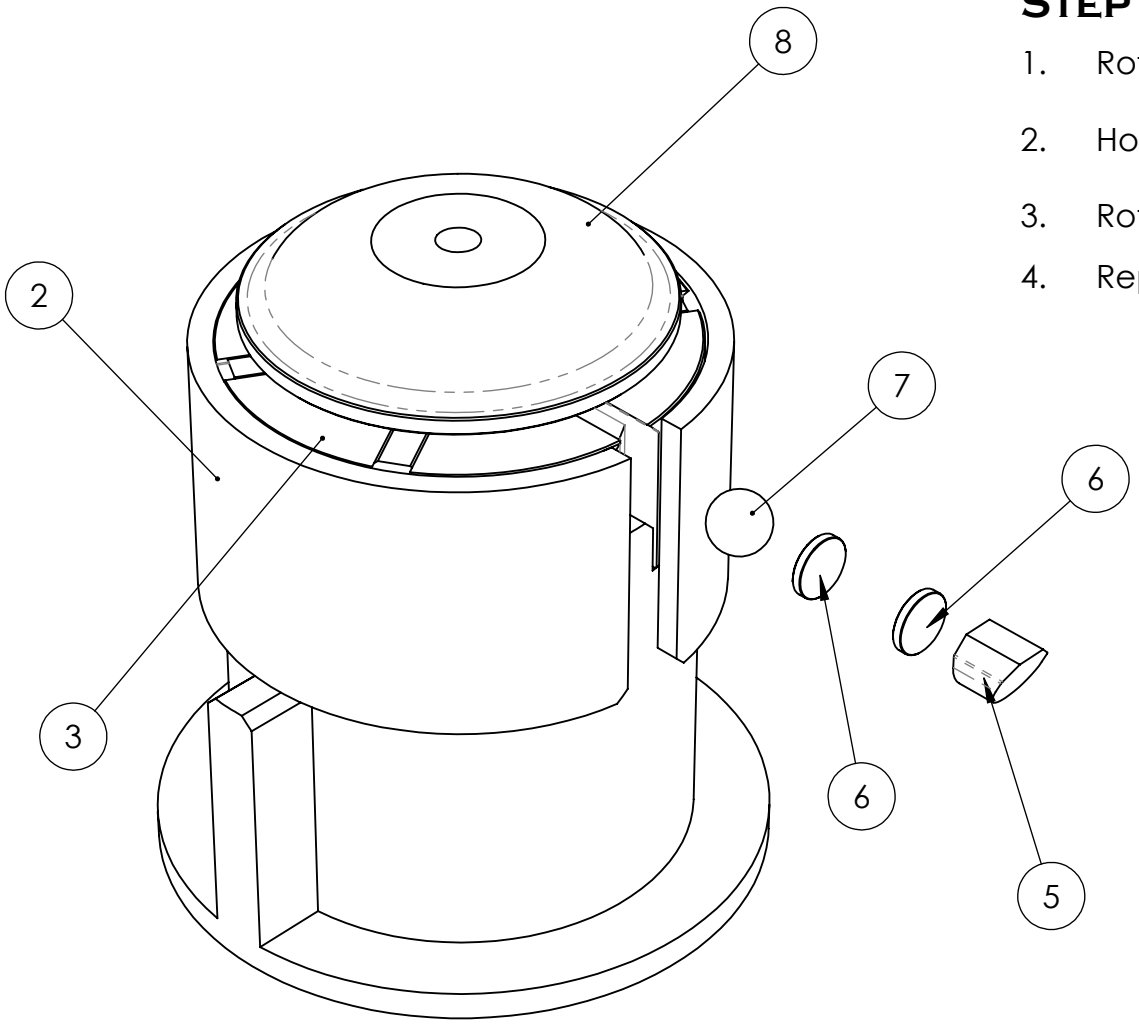
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	JIG080-0001	Assembly jig base	1
2	JIG080-1001	Assembly jig sleeve	1
3	COR080-0003	Isofonics core	1
4	PLD080-0003	Isofonics preloading crown	1
5	PLD010-1004	Isofonics preloading backstop	6
6	F669-N45SH-10 (first4magnets)	10 x 1.5mm neodymium magnet	12
7	10MMTUNGSTENBALLS (VXB Bearings)	10mm tungsten carbide ball	6
8	TOP080-0004A	Isofonics top piece	1
9	RET080-0003	Isofonics retainer	1
10	M4X20-CSK-ST (westfieldfasteners)	Partially threaded M4 x 20mm c'sunk security screw	6
11	M4X20-CSK-H (westfieldfasteners)	Partially threaded M4 x 20mm c'sunk hex socket screw	1
12	RET080-1002	Isofonics retainer bottom	1



Step 1

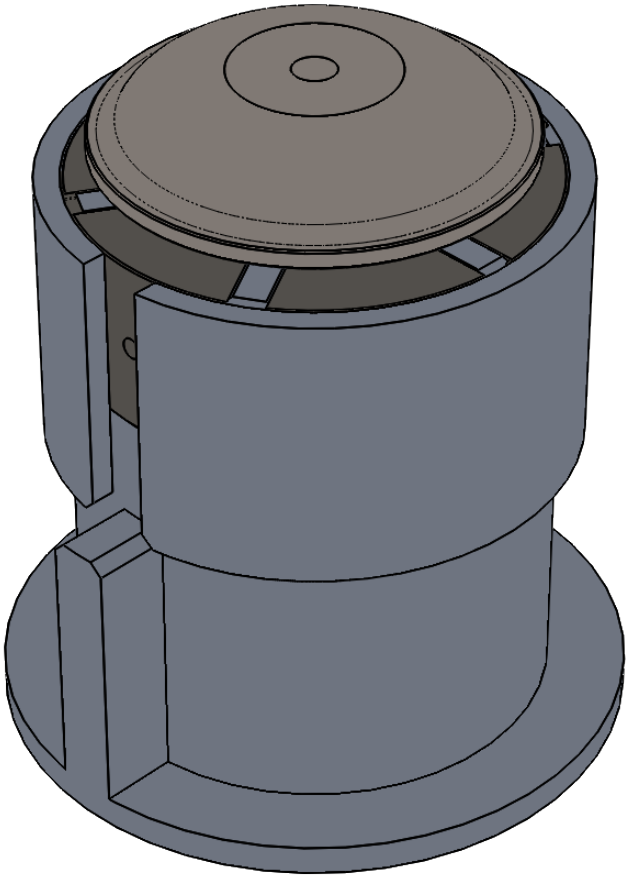
1. Slot (3) into (1)
2. Slide (2) over (1)
3. Place (8) ontop of (3)





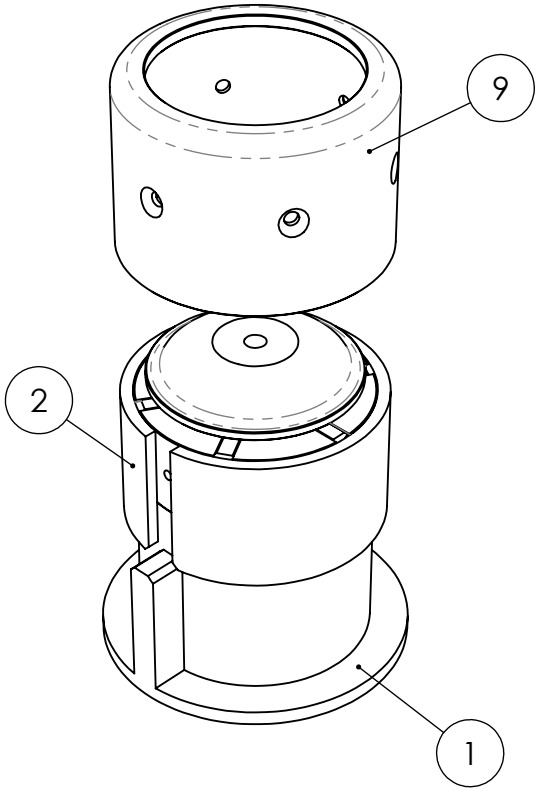
Step 2

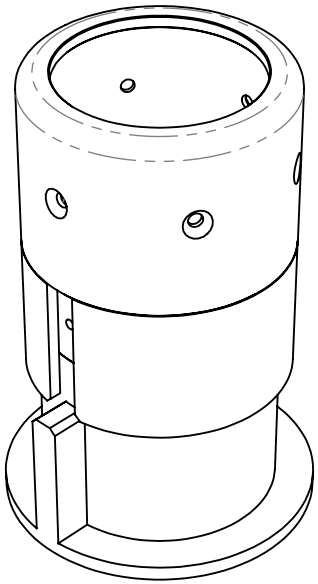
1. Rotate (2) until parallel with track in (3)
2. Holding firmly onto (8), slide parts onto track
3. Rotate (2) so parts are contained
4. Repeat for all six tracks

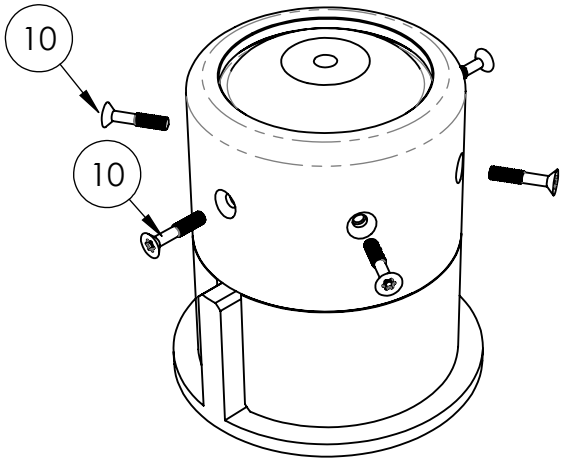


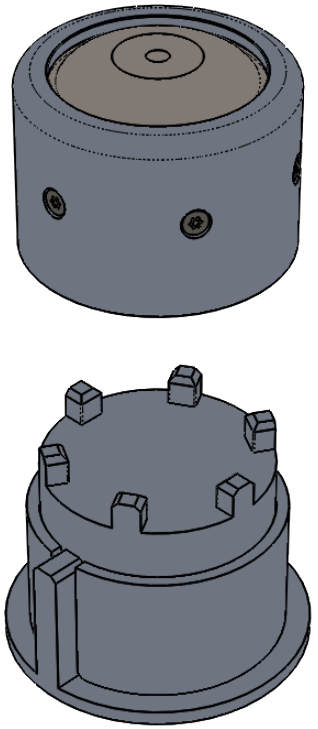
Step 3

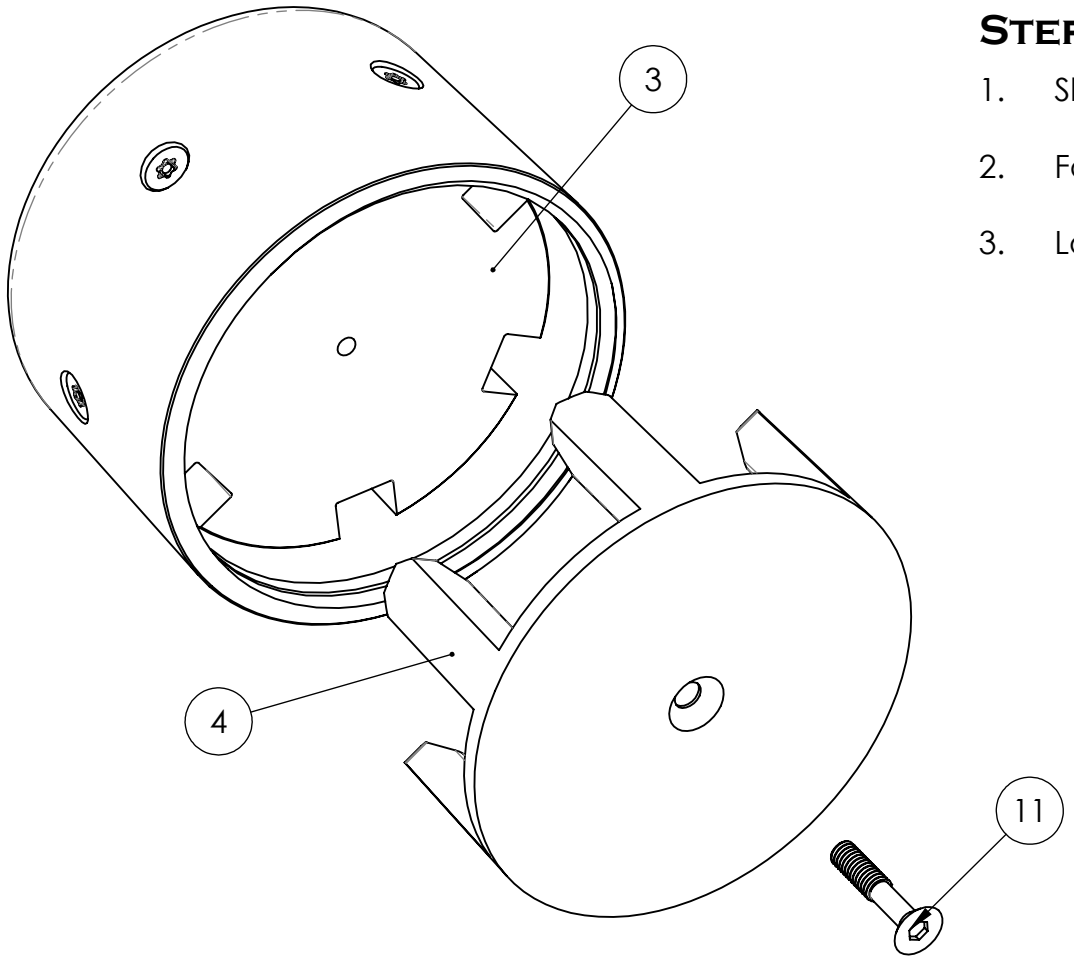
1. Rotate (2) until parallel with notch in (1)
2. Slide (9) over assembly, pushing down (2)
3. Fasten (9) with 6x (10)
4. Remove (1) and (2)





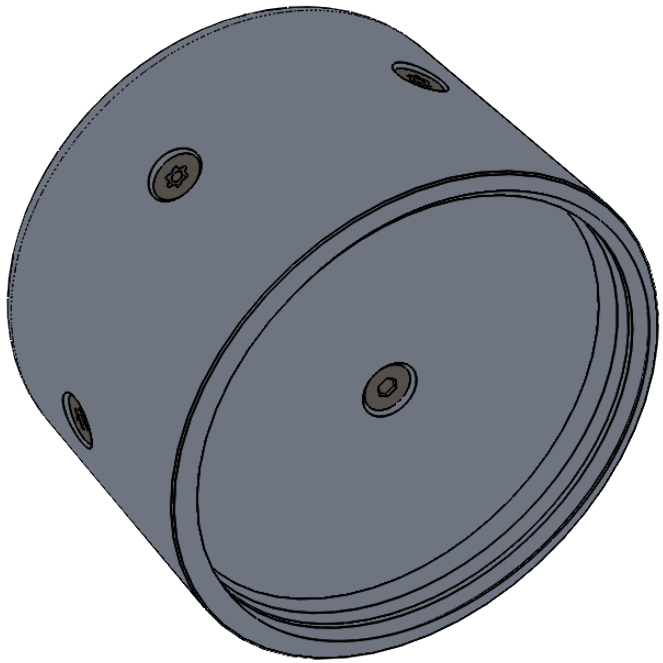






Step 4

1. Slot (4) into (3)
2. Fasten with (11)
3. Load (11) to 0.0250 Nm



Step 5

1. Screw (12) into (9)