

NOTES:

1. TILT AXIS TORQUE TO BE 37-49 IN LB TOTAL IN EACH DIRECTION. 118.5-24.5 IN-LB PER SIDE
2. SWIVEL AXIS TORQUE TO BE 20-27 IN LB IN EACH DIRECTION.
3. THE FOLLOWING IS THE PROCEDURE TO MEASURE THE HINGE TORQUE FOR THIS ASSEMBLY. TEST EQUIPMENT INCLUDES A SNAP-ON 1/4 IN. DRIVE TORQUEMETER M/N TO S4 FUA. THE TORQUE VALUE WILL BE READ FROM THE DIAL DURING STEADY, SLOW MOVEMENT. A COPY OF THE TEST RESULTS MUST BE PROVIDED BY THE VENDOR WITH EACH LOT.

PIVOT AXIS

- A. CYCLE THE JOINT SIX TIMES. (ONE CYCLE CONSISTS OF APPROXIMATELY 180° FORWARD ROTATION AND APPROXIMATELY 180° BACKWARD ROTATION. EACH MOVEMENT OF 180° SHOULD TAKE THREE SECONDS TO COMPLETE. THERE IS TO BE A SEVEN SECOND REST BETWEEN CYCLES.)
- B. ON THE SEVENTH CYCLE RECORD THE MEASUREMENT WHEN ROTATING FORWARD, ROTATING THE HINGE SMOOTHLY 180° IN THREE SECONDS.
- C. ON THE EIGHTH CYCLE RECORD THE MEASUREMENT WHEN ROTATING BACKWARD, ROTATING THE HINGE SMOOTHLY 180° IN THREE SECONDS.
- D. REPEAT STEPS "A" THROUGH "C" TWO MORE TIMES RECORDING THE RESULT EACH TIME.
- E. CALCULATE THE AVERAGE FOR THREE FORWARD MEASUREMENTS. DO THE SAME FOR THE BACKWARD MEASUREMENTS.
- F. COMPARE TOTAL CALCULATED TORQUE TO THE SPECIFICATION IN NOTE #1.

SWIVEL AXIS

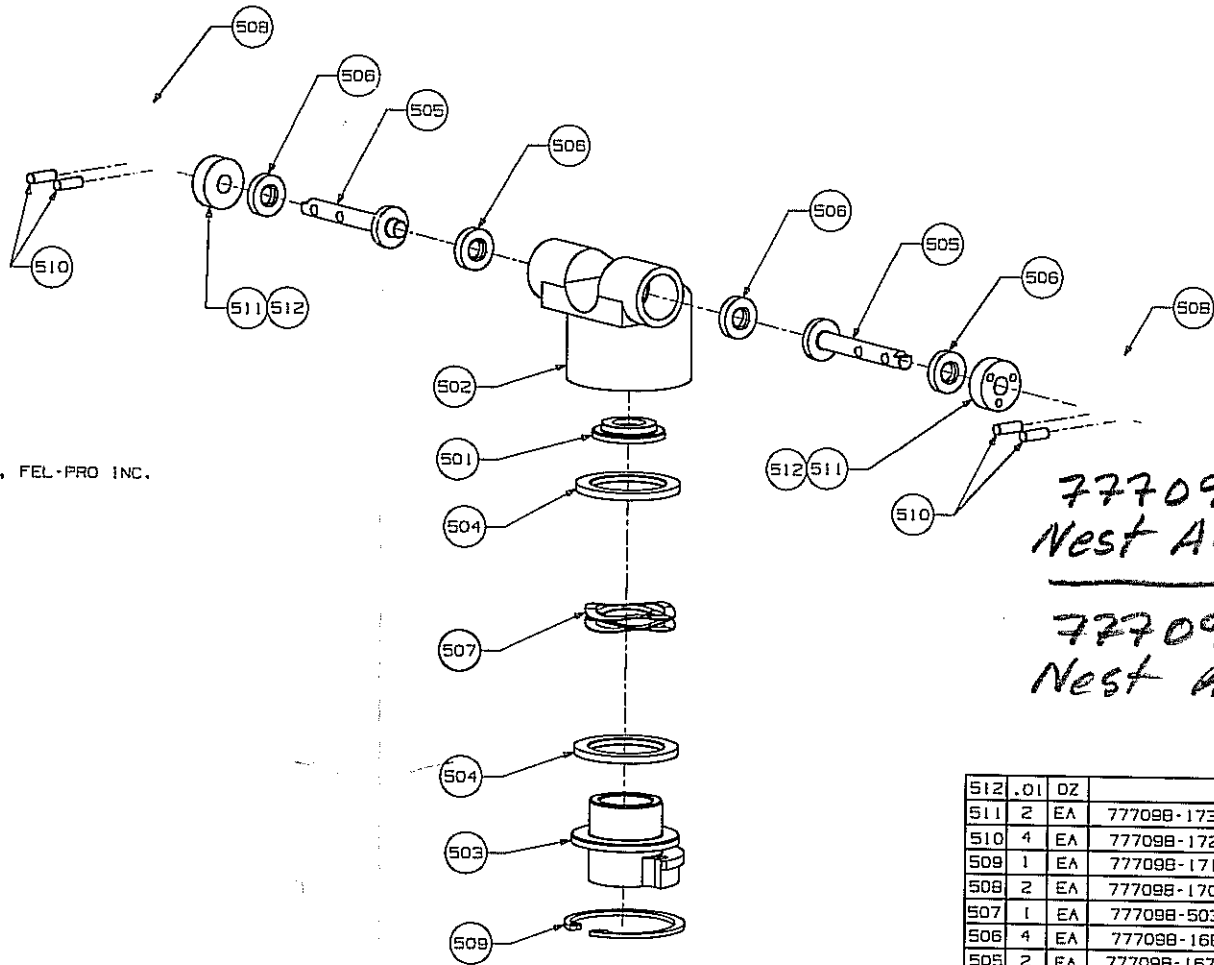
- A. CYCLE THE JOINT SIX TIMES. (ONE CYCLE CONSISTS OF A CLOCKWISE ROTATION OF APPROXIMATELY 180° AND A COUNTERCLOCKWISE ROTATION OF APPROXIMATELY 180°. DO NOT ALLOW NEST TO CONTACT SWIVEL STOPS. EACH 180° MOVEMENT SHOULD TAKE APPROXIMATELY THREE SECONDS TO COMPLETE AND THERE IS TO BE A SEVEN SECOND REST BETWEEN CYCLES.)
- B. ON THE SEVENTH CYCLE RECORD THE MEASUREMENT FOR THE CLOCKWISE ROTATION, ROTATING SMOOTHLY 180° IN THREE SECONDS.
- C. ON THE EIGHTH CYCLE RECORD THE MEASUREMENT FOR THE COUNTERCLOCKWISE ROTATION, ROTATING SMOOTHLY 180° IN THREE SECONDS.
- D. REPEAT STEPS "A" THROUGH "C" TWO MORE TIMES RECORDING THE RESULT EACH TIME.
- E. CALCULATE THE AVERAGE FOR THE THREE CLOCKWISE MEASUREMENTS. DO THE SAME FOR THE COUNTERCLOCKWISE MEASUREMENTS.
- F. COMPARE EACH DIRECTION TO THE SPECIFICATION IN NOTE #2.

4. AREA THRU HOLE TO BE FREE OF BURRS AND SHARP EDGES.

5. ▽ INDICATES DIMENSION TO BE INSPECTED BY INCOMING Q.C..

6. PAINT FOCUS LIGHT GRAY PER SPECIFICATION 777098-070 ON EXTERNAL SURFACES OF HOUSING AND END CAPS. ALL OTHER COMPONENTS OF ASSEMBLY TO BE FREE OF PAINT.

7. IN SWIVEL AXIS, LUBRICATE ALL CONTACT/FRICTION SURFACES OF SHAFT, WASHERS, RETAINING RING AND HOUSING WITH A LIGHT COATING OF HIGH PERFORMANCE GREASE P/N 51242, FEL-PRO INC.



777094-409-1
Nest Assy Basic (Unpainted)

777098-162
Nest Assy

Painted

B-24-09

408

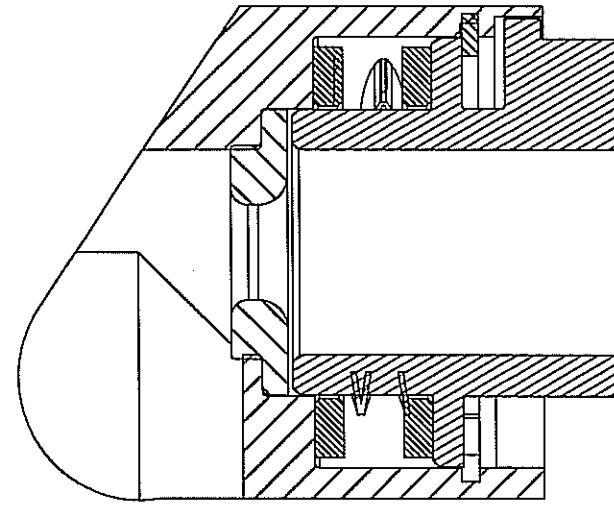
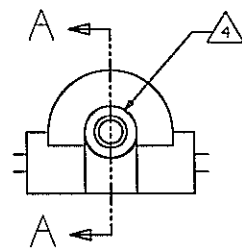
512	.01	OZ		ADHESIVE, LOCTITE 680, GREEN
511	2	EA	777098-173	END CAP, NEST
510	4	EA	777098-172	DOWEL PIN, NEST
509	1	EA	777098-171	RETAINER, NEST
508	2	EA	777098-170	PLATE, DISPLAY MOUNTING, NEST
507	1	EA	777098-503	SPIRALWAVE SPRING, NESTED
506	4	EA	777098-168	WASHER, TILT, NEST
505	2	EA	777098-167	SHAFT, TILT, NEST
504	2	EA	777098-504	WASHER, SWIVEL, NEST
503	1	EA	777098-165	SHAFT, SWIVEL, NEST
502	1	EA	777098-164	HOUSING, NEST
501	1	EA	777098-163	SEAL, CABLE, NEST
ITEM NO.	QTY	U/M	PART NO.	DESCRIPTION

BILL OF REFERENCE

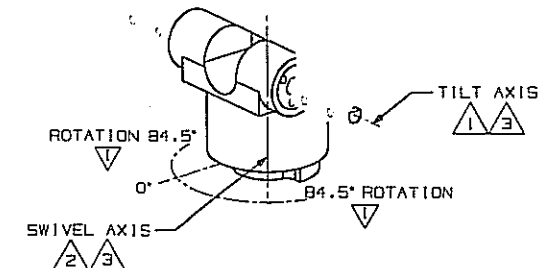
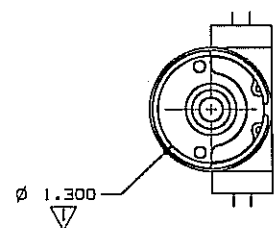
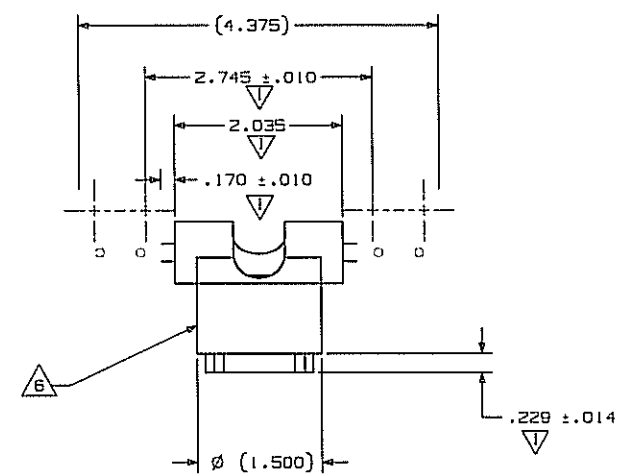
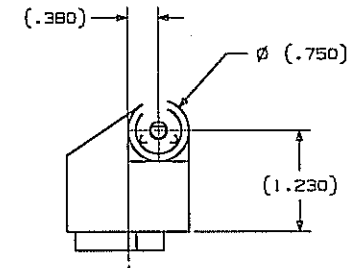
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UNIGRAPHICS

REV	REVISION DESCRIPTION	BY	DATE	ECO #
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SECTION A - A
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8-24-09 408

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DATE 01/11/09		DATE 08/24/09	
SCALE 1:1		PART NO. 777098-162	
DRAWN BILODEAU		REV 2/2	

UNIGRAPHICS