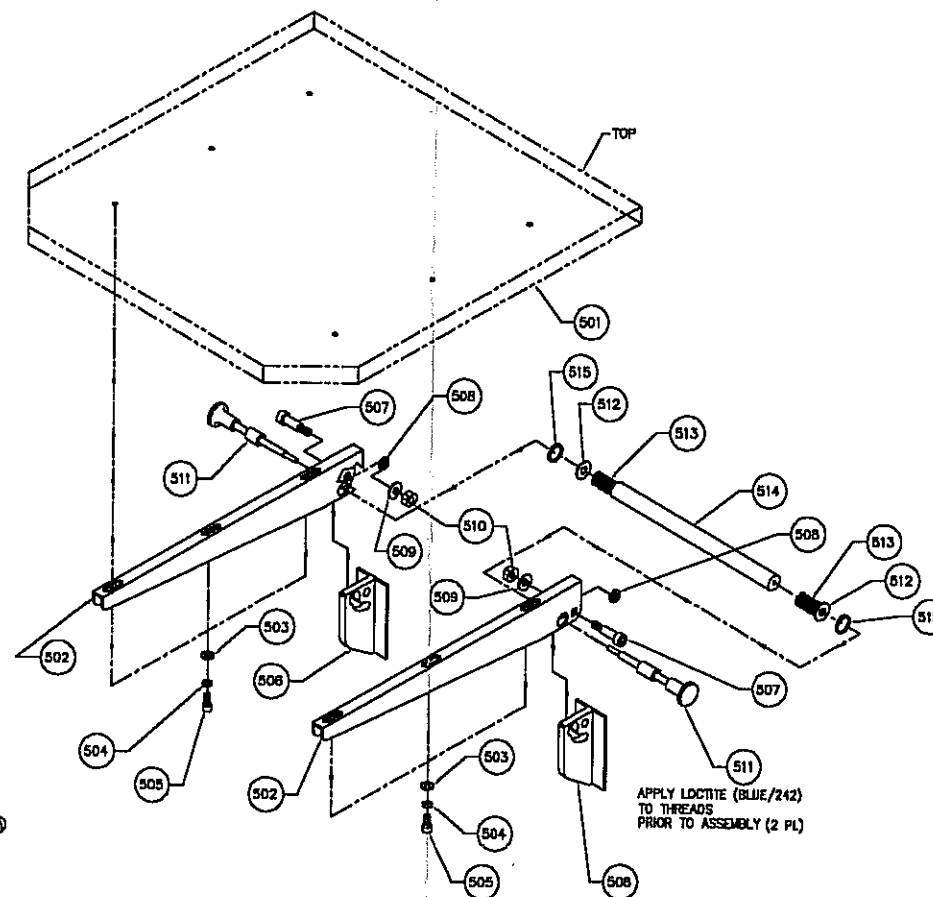
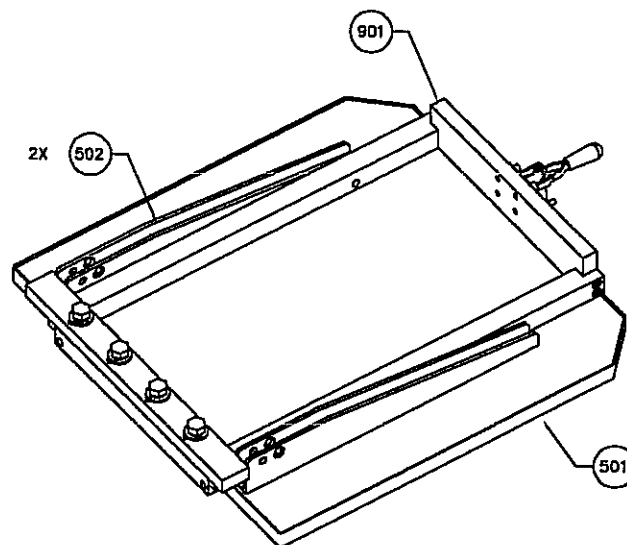


# NOTES:

PARTS ARE SHOWN AND LISTED IN  
BILL OF MATERIAL IN ORDER OF ASSEMBLY.

1. PLACE ITEM 1 ON FLAT WORK SURFACE  
UPSIDE DOWN (THREADED HOLES UP).  
ATTACH TO ITEM 2 USING ITEMS 3, 4 & 5 (6 PL).  
NOTE: DO NOT TIGHTEN SECURELY (SEE NOTE 2).
2. ALIGN ASSEMBLED PARTS HORIZONTALLY AND  
VERTICALLY TO ITEM 1, USING ITEM 801, THEN  
SECURELY TIGHTEN ITEMS 3, 4 & 5 (6 PL).
3. ATTACH ITEM 6 (2 PL) TO ITEM 2 BY INSERTING  
IT BETWEEN CHANNEL OF ITEM 2 AND PASSING  
ITEM 7 THRU OUTSIDE THEN THRU ITEM 8  
TOWARDS CENTER. SECURE USING ITEMS 9 & 10.  
NOTE: TIGHTEN ITEM 10 ONLY TO SEAT ITEM 9  
AGAINST ITEM 7.
4. INSERT ITEM 11 THRU BOTH ITEMS 2 & 6,  
THRU ITEMS 12, 13 & 15. APPLY GREASE  
(ITEM 16) TO MIDDLE SHOULDER (ALL OVER)  
OF ITEM 11. THREAD ITEM 11 INTO ITEM 14,  
USING LOCTITE 242. WIPE OFF EXCESS LOCTITE.
5. REPEAT FOR OPPOSITE SIDE BY PULLING  
PREVIOUSLY THREADED ITEM 11, COMPRESSING  
ITEM 13 TO ALLOW SUFFICIENT CLEARANCE  
FOR ASSEMBLY. WIPE OFF EXCESS LOCTITE.
6. CORRECT OPERATION OF ASSEMBLY CAN BE  
VERIFIED BY PUSHING/PULLING EITHER SIDE ITEM 11  
WHICH WILL RELEASE BOTH SIDES FROM ITEM 2  
ALLOWING THEM TO HINGE AWAY FROM ITEM 6  
IN 90° OF TRAVEL.
7. PACKAGE USING ITEMS 517 & 518.
8. ♦ INDICATES INSPECTION CRITERIA.
9. ♦ VERIFY THAT SHELF ASSEMBLY PART NUMBER IS ON  
SHIPPING CARTON.



REV	REVISION DESCRIPTION	BY	DATE	ECO #
A	ORIGINAL RELEASE	VLF	7/21/84	56781
B	ADDED BOR ITEMS 517 & 518, NOTE 7	VLF	1/31/85	BCT 000023
C	ADDED NOTES 8 AND 9	VLF	4/13/85	BCT 000188
D	ITEM 517 WAS 777087-726. ITEM 518 WAS 777087-727.	LA	05/13/85	BCT 011557

ITEM	QTY	U/M	PART NUMBER	DESCRIPTION
901	AR	EA	973501-456	ASSEMBLY FIXTURE, COMPUTER SHELF

## BILL OF REFERENCE

ITEM	QTY	U/M	PART NUMBER	DESCRIPTION
518	1	EA	777087-730	BOX, SHIPPING
517	1	EA	777087-730	END CAPS, SPECTRA SHELF
518	.01	OZ	777070-500	GREASE, LITHIUM
515	2	EA	820001-302	O-RING (1/4" X 1/2" X 1/8")
514	1	EA	777087-828	TUBE, CONNECTING
513	2	EA	777087-829	SPRING, COMPRESSION
512	2	EA	900138-902	WASHER, FLAT, 1/4" ID, S.S.
511	2	EA	777087-830	ROD, LOCKING
510	2	EA	900138-500	NUT, LOCKING, #10-32, S.S.
509	2	EA	900138-502	WASHER, FLAT, #10, S.S.
508	2	EA	900140-901	WASHER, HYDRA, 1/4" ID X 1/2" OD
507	2	EA	820001-132	SCR., SHLDR., 1/4" X 5/8", S.S.
506	2	EA	777087-825	PLATE, MOUNTING
505	6	EA	900254-302	SCREW, SHC, #8-32 X 3/8", S.S.
504	6	EA	900143-400	WASHER, LOCK, #8, S.S.
503	6	EA	777087-851	FLAT WASHER, SPECIAL
502	2	EA	777087-827	BRACKET, SHELF
501	1	EA	777087-833	SHELF

## BILL OF REFERENCE

ITEM	QTY	U/M	PART NUMBER	DESCRIPTION
518	1	EA	777087-730	BOX, SHIPPING
517	1	EA	777087-730	END CAPS, SPECTRA SHELF
518	.01	OZ	777070-500	GREASE, LITHIUM
515	2	EA	820001-302	O-RING (1/4" X 1/2" X 1/8")
514	1	EA	777087-828	TUBE, CONNECTING
513	2	EA	777087-829	SPRING, COMPRESSION
512	2	EA	900138-902	WASHER, FLAT, 1/4" ID, S.S.
511	2	EA	777087-830	ROD, LOCKING
510	2	EA	900138-500	NUT, LOCKING, #10-32, S.S.
509	2	EA	900138-502	WASHER, FLAT, #10, S.S.
508	2	EA	900140-901	WASHER, HYDRA, 1/4" ID X 1/2" OD
507	2	EA	820001-132	SCR., SHLDR., 1/4" X 5/8", S.S.
506	2	EA	777087-825	PLATE, MOUNTING
505	6	EA	900254-302	SCREW, SHC, #8-32 X 3/8", S.S.
504	6	EA	900143-400	WASHER, LOCK, #8, S.S.
503	6	EA	777087-851	FLAT WASHER, SPECIAL
502	2	EA	777087-827	BRACKET, SHELF
501	1	EA	777087-833	SHELF

**COE BCT**  
SHELF ASSEMBLY,  
COMPUTER

777087-835

4-11-07

408