


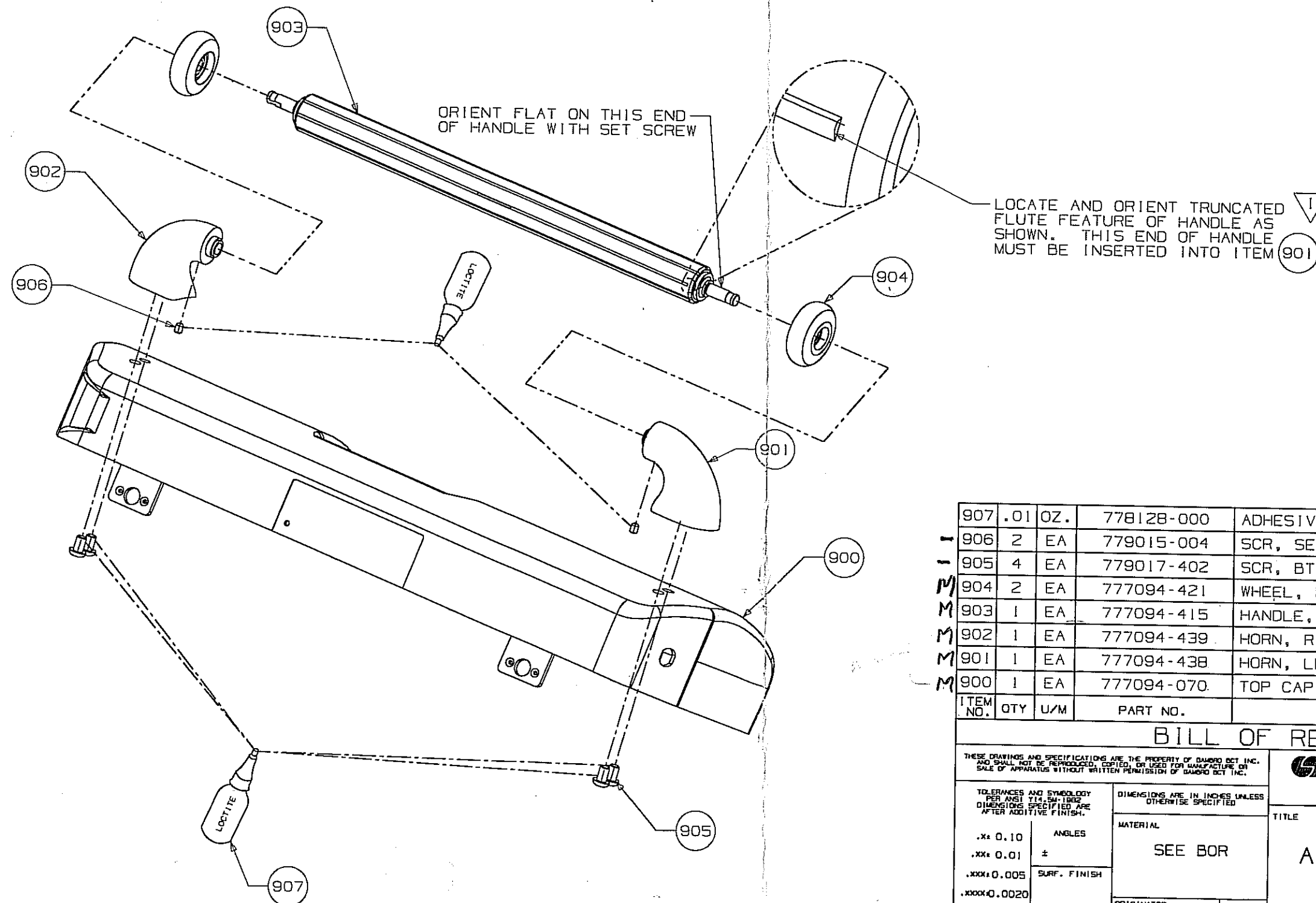


NOTES

1.  INDICATES FEATURE/DIMENSION TO BE CHECKED AT INCOMING INSPECTION.
2.  INSPECT PAINT FOR COSMETIC DEFECTS.
3.  "TESTED" STICKER IS ATTACHED TO CABLE.



REV	REVISION DESCRIPTION	BY	DATE	ECO #
A	ORIGINAL RELEASE, SIMILAR TO 777098-218.	DG	5/12/08	BCT016925
B	UPDATE TO OPTIA COLORS, ITEM 904 WAS 777096-466, ITEM 903 WAS 777098-036, ITEM 902 WAS 777096-065, ITEM 901 WAS 777096-064, ITEM 910 WAS 777098-194.	DG	09/25/08	BCT017808

907	.01	OZ.	778128-000	ADHESIVE, LOCTITE 242, BLUE
906	2	EA	779015-004	SCR, SET, HEX, CONE, SST, 10-32
905	4	EA	779017-402	SCR, BTN, HEX, SST 1/4-20 x 3/8
904	2	EA	777094-421	WHEEL, HANDLE
903	1	EA	777094-415	HANDLE, CUSHIONED
902	1	EA	777094-439	HORN, RIGHT
901	1	EA	777094-438	HORN, LEFT
900	1	EA	777094-070	TOP CAP, MACHINED, OPTIA
ITEM NO.	QTY	U/M	PART NO.	DESCRIPTION

BILL OF REFERENCE

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GAMBRO BCT

TOLERANCES AND SYMBOLS PER ANSI Y14.5M-1992 DIMENSIONS SPECIFIED ARE AFTER ADDITIVE FINISH.

DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED

.X± 0.10
.XX± 0.01
.XXX± 0.005
.XXXX± 0.0020

ANGLES
±
SURF. FINISH

ORIGINATOR

TITLE

ASSY., TOP CAP, OPTIA

SIZE SCALE DO NOT SCALE DIMS

DATE 05/11/08

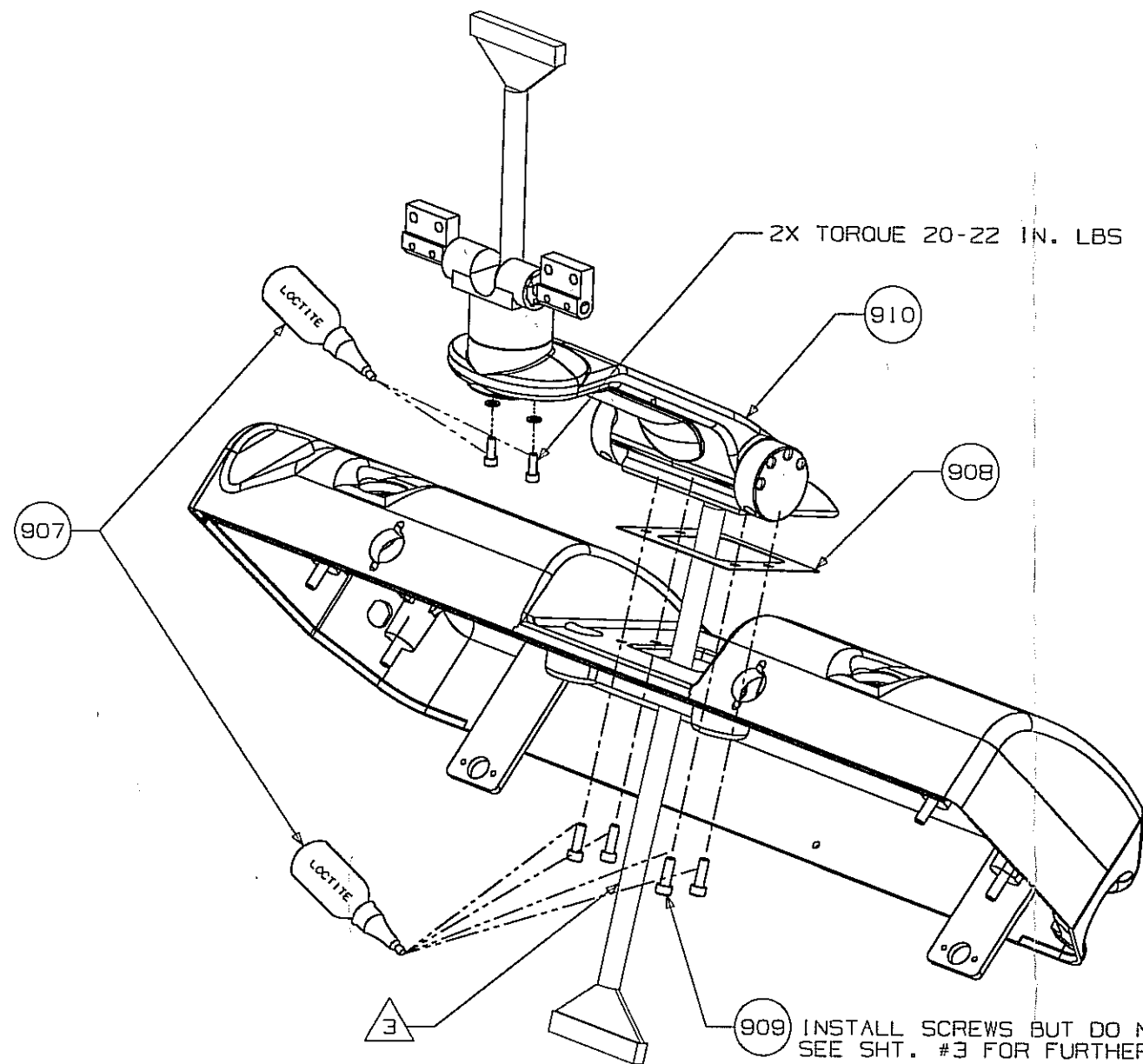
PART NO. 777094-290

REV B SHIT 1/3

UG DWG.

7-17-09 408

REV	REVISION DESCRIPTION	BY	DATE	ECO #
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IMPORTANT!
SCREWS MAY HAVE BEEN TEMPORARILY REMOVED WHILE
INSTALLING CABLE ASSEMBLY. APPLICATION OF
LOCTITE FOLLOWED BY PROPER SCREW TORQUING MUST
BE PERFORMED AT THIS ASSEMBLY LEVEL.

77094-290
cable

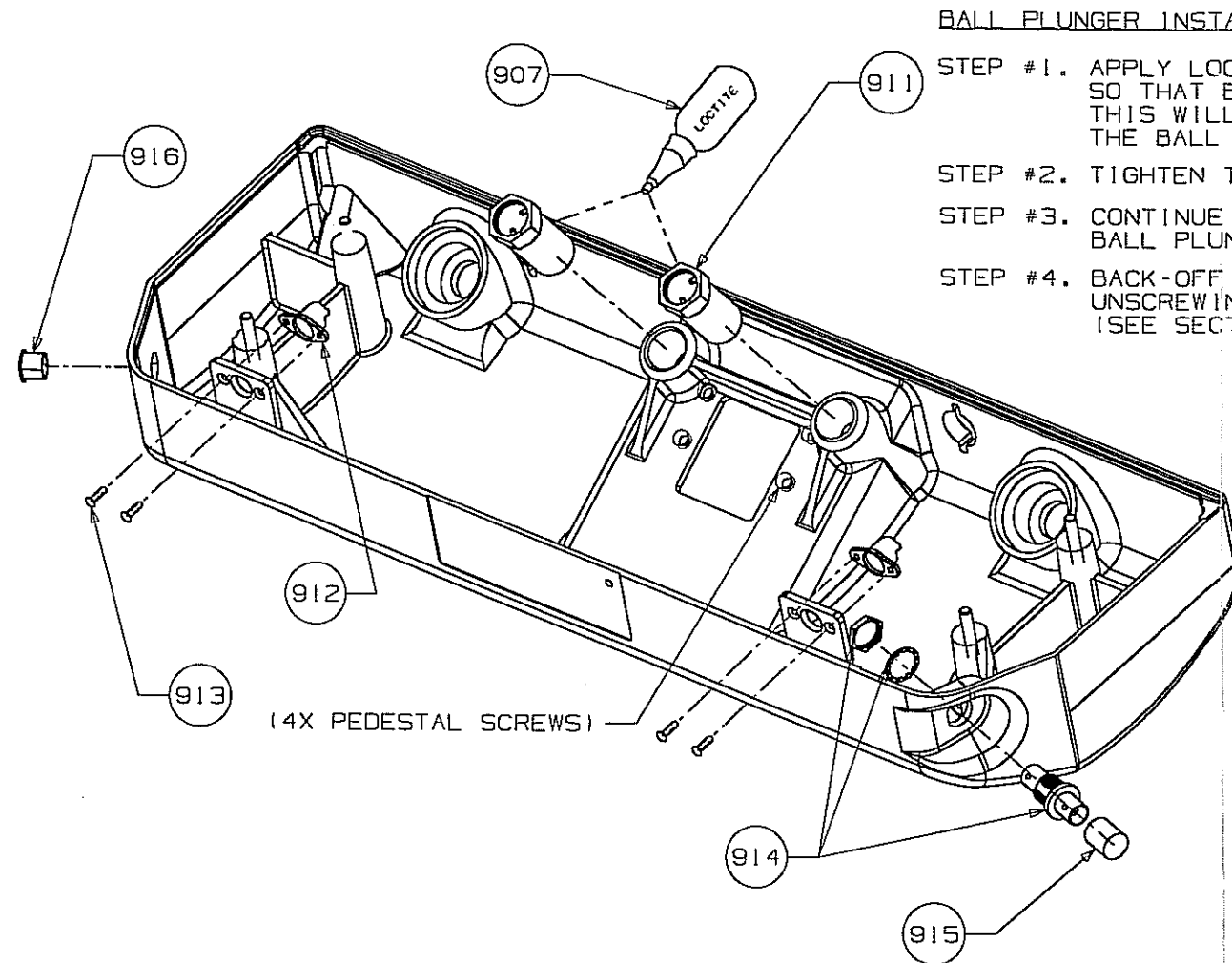
7-17-09 408

910	1	EA	777094-412	ASSY., DISPLAY ARM AND CABLE
909	4	EA	779019-303	SCR, SCH, SST, 8-32, 1/2
908	1	EA	777098-020	GASKET, PEDESTAL
ITEM NO.	QTY	U/M	PART NO.	DESCRIPTION

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<small>TOLERANCES AND SYMBOLS PER ANSI Y14.5M-1982 DIMENSIONS SPECIFIED ARE AFTER ADDITIVE FINISH.</small> .X± 0.10 .XX± 0.01 .XXX± 0.005 .XXXX± 0.0020		<small>ANGLES ± 2°</small> <small>SURF. FINISH N/A</small>		<small>DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED</small> MATERIAL ORIGINATOR DATE	
TITLE ASSY., TOP CAP, OPTIA				PART NO. 777094-290	
SIZE C	SCALE 1/2	DO NOT SCALE DWG	THIRD ANGLE PROJECTION Ⓢ	DRAWN D. GIBBONS	DATE 5/11/08
REV B				SHT OF 2/3	

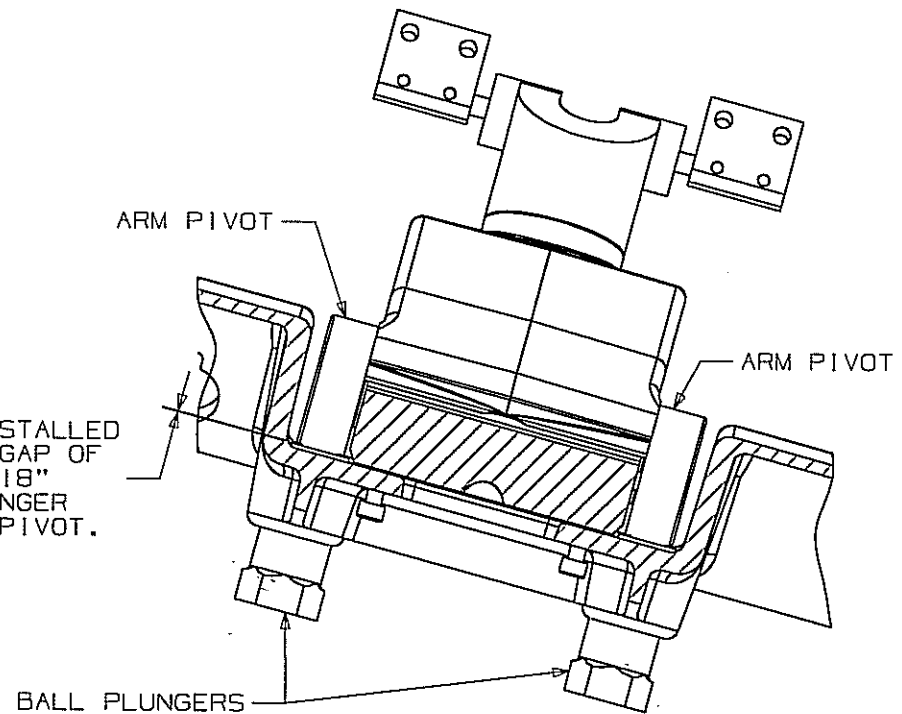
UG DWG.



BALL PLUNGER INSTALLATION

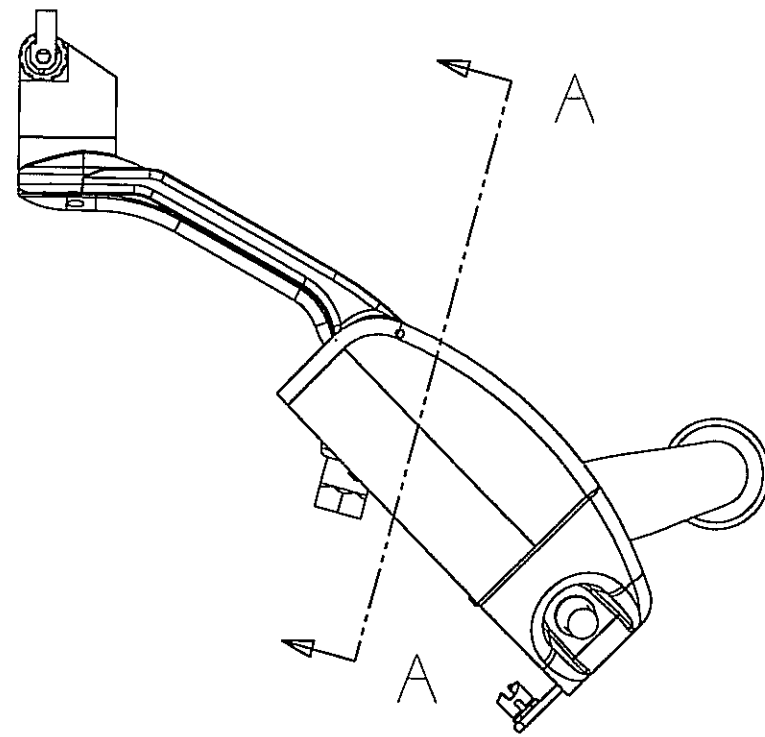
- STEP #1. APPLY LOCTITE AND INSTALL (2) BALL PLUNGERS SO THAT BALLS ENGAGE DETENTS IN ARM PIVOTS. THIS WILL PROPERLY ALIGN THE ARM PIVOTS TO THE BALL PLUNGERS.
- STEP #2. TIGHTEN THE (4) PEDESTAL SCREWS (30-32 IN. LBS. TORQUE).
- STEP #3. CONTINUE INSTALL OF (2) BALL PLUNGERS UNTIL BALL PLUNGER HOUSING CONTACTS ARM PIVOTS.
- STEP #4. BACK-OFF (2) BALL PLUNGERS FROM ARM PIVOTS BY UNSCREWING BALL PLUNGERS 1/2 TURN EACH. (SEE SECTION A-A)

WHEN PROPERLY INSTALLED THERE WILL BE A GAP OF APPROXIMATELY .018" BETWEEN BALL PLUNGER HOUSING AND ARM PIVOT.



SECTION A - A
SCALE 3:4

7-17-09 408



SIDE VIEW

916	1	EA	777098-174	HOLE PLUG, DOUBLE D		
915	1	EA	777096-869	CAP		
914	1	EA	773501-358	CONNECTOR, BNC		
913	4	EA	779306-102	POP RIVET, SST, 3/32, CSK HEAD		
912	2	EA	777096-471	1/4 TURN RECEPTACLE (DEEP)		
911	2	EA	777098-016	ASSEMBLY, BALL PLUNGER		
ITEM NO.	QTY	U/M	PART NO.	DESCRIPTION		
BILL OF REFERENCE						
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TOLERANCES AND SYMBOLS PER ANSI Y14.5M-1982 DIMENSIONS SPECIFIED ARE AFTER ADDITIVE FINISH.			DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED			
.X± 0.10			ANGLES			
.XX± 0.01			±			
.XXX± 0.005			SURF. FINISH			
.XXXX± 0.0020						
ORIGINATOR		DATE				
DRAWN		DATE				
SIZE	SCALE	DO NOT SCALE DRG	THIS HOLE PROJECTION			
C	1:2					
D. GIBBONS				DATE 5/11/08		
PART NO. 777094-290				REV B		
				SHT 3/3		

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GAMBRO BCT

TITLE

ASSY., TOP CAP, OPTIA