

ASSEMBLY NOTES:

1. PRESS BEARING, #908, INTO SENSOR MTG. PLATE, #902, TO FLUSH OR BELOW SURFACE -A-.
2. ATTACH SENSOR MTG. PLATE, #902, TO DOOR LOCK SOLENOID HSG., #901, USING FLAT HEAD SCREW, #912 WITH LOCTITE, #913.
3. SLIP SPRING, #909, OVER STEM #906. SLIDE STEM, #906, THRU STEM BEARING, #908, AND ATTACH STEM HEX EXTENSION, #905, TO STEM, #906.
4. ATTACH ANTI ROTATION BLOCK, #904, TO SENSOR MTG. PLATE, #902, USING SOC. HEAD CAP SCR., #911 WITH LOCTITE, #913. PLACE 0.004" SHIM BETWEEN ANTI ROTATION BLOCK AND HEX EXTENSION PRIOR TO TIGHTENING SCREWS. REMOVE SHIM WHEN THIS STEP IS COMPLETED.
5. ATTACH SENSOR FLAG, #903, TO STEM HEX EXTENSION, #905, USING SOC. HEAD CAP SCR., #910 WITH LOCTITE, #913.
6. ATTACH LOCK HSG. HEX EXTENSION, #907 WITH LOCTITE ITEM #913, TO DOOR LOCK SOLENOID HSG., #901.

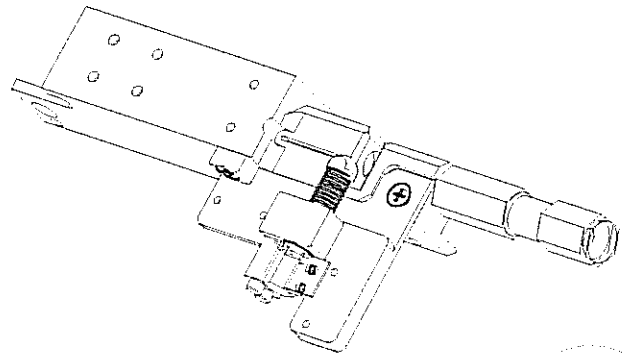
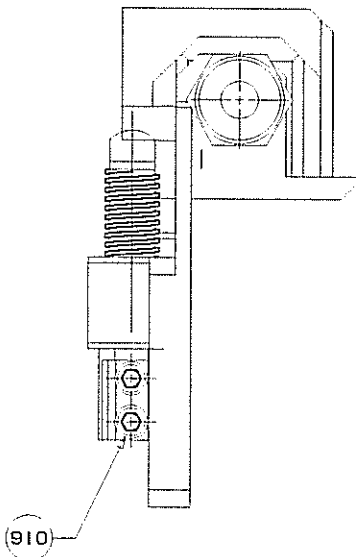
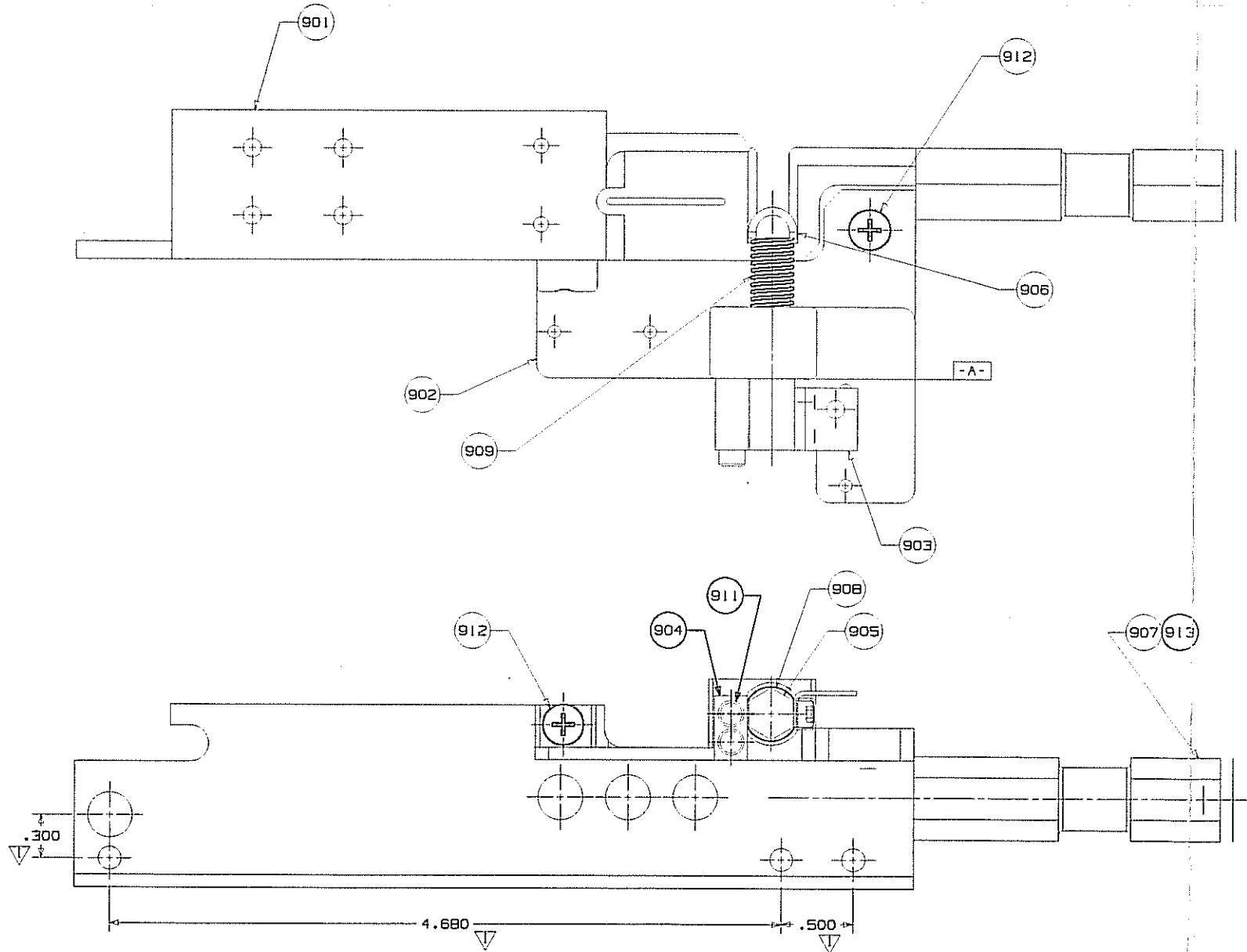
GENERAL NOTES:

1. ▽ INDICATES KEY DIMENSIONS TO BE CHECKED AT INCOMING D.C.

FLATS ON ITEM # 906 USED FOR ASSEMBLING  
ORIENTATION NOT CRITICAL.

REFERENCE EMAIL DATED  
11/24/09, MASTER FILE

HEX FOR ASSEMBLING. ORIENTATION NOT CRITICAL




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12/15/09

913	.001	oz.	778128-000	ADHESIVE, LOCTITE 242, BLUE
912	2	EA.	778208-305	SCR, FLH, PHH, SST, 6-32, 3/8
911	2	EA.	779019-105	SCR, SCH, SST, 4-40, 3/4
910	2	EA.	779019-101	SCR, SCH, SST, 4-40, 1/4
909	1	EA.	777096-088	SPRING, LOCK HOUSING SENSOR
908	1	EA.	777096-092	BEARING, STEM
907	1	EA.	777096-294	HEX EXTENSION, LOCK HOUSING
906	1	EA.	777096-293	STEM
905	1	EA.	777096-292	HEX EXTENSION, STEM
904	1	EA.	777096-B28	BLOCK, ANTI ROTATION
903	1	EA.	777096-280	FLAG, SENSOR
902	1	EA.	777096-289	MOUNTING PLATE, SENSOR
901	1	EA.	777098-071	SOLENOID HOUSING, DOOR LOCK
ITEM NO.	QTY	U/M	PART NO.	DESCRIPTION

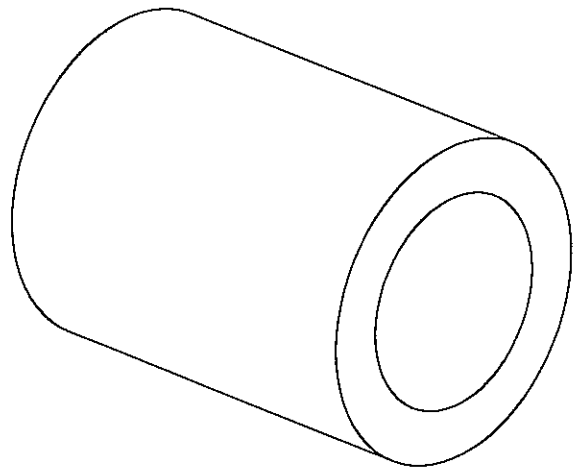
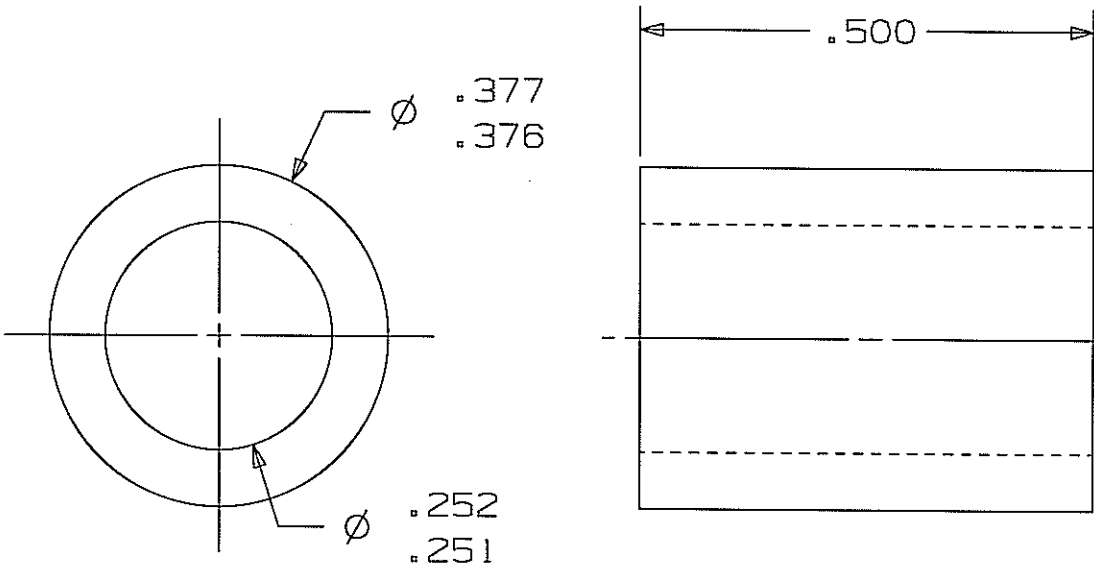
BILL OF REFERENCE

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TOLERANCES AND SPECIFICATIONS ARE THE PROPERTY OF CARIDIAN INC. AND SHALL NOT BE REPRODUCED, COPIED OR USED FOR MANUFACTURE OR SALE OF ANYTHING WITHOUT WRITTEN PERMISSION OF CARIDIAN INC.				MATERIAL		ASSEMBLY, DOOR LOCK HOUSING.	
.XX ± 0.1				ANGLES			
.XX ± 0.01				± 1°			
.XXX ± 0.005				SURF. FINISH			
.XXX ± 0.0020							
ORIGINATOR				DATE		PART NO.	
K. KLIMEK				25/97		777098-074	
DRAWN				DATE		REV	
K. KLIMEK				25/97		C 1/1	
DATE		SCALE		DO NOT SCALE		DATE	
D 2:1		2:1		DO NOT SCALE		DATE	

NOTES:

1. BREAK ALL EDGES AND CORNERS  
R.005-.020 OR 45°.
2. ▽ INDICATES KEY DIMENSION TO BE  
CHECKED AT INCOMING Q.C.

REV	REVISION DESCRIPTION	BY	DATE	ECO #
A	INITIAL RELEASE	ELH	5/13/97	BCT 002160
B	MATERIAL CALLOUT WAS BRONZE, MIL-B-5687a, TYPE 1, COMPOSITION A	JBB	06/22/04	BCT 013713



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9/24/09


SPECIFICATION CONTROL DRAWING

VENDOR PART NUMBERS ARE FOR REFERENCE ONLY.  
ANY MANUFACTURER WHOSE PRODUCT MEETS ALL PARAMETERS  
OF THIS SPECIFICATION IS CONSIDERED AN APPROVED SOURCE.

SUGGESTED SOURCE OF SUPPLY

1. ▽ EAGLE Picher #AA307-3
2. ▽ OILITE #AA307-3
3. ▽ BERG #B6-11

UG DWG

THESE DRAWINGS AND SPECIFICATIONS ARE THE PROPERTY OF GAMBRO BCT INC. AND SHALL NOT BE REPRODUCED, COPIED, OR USED FOR MANUFACTURE OR SALE OF APPARATUS WITHOUT WRITTEN PERMISSION OF GAMBRO BCT INC.				 10811 Collins Avenue, Lakewood, Colorado 80215-4440 USA	
TOLERANCES AND SYMBOLS PER ANSI Y14.5M-1982 DIMENSIONS SPECIFIED ARE AFTER ADDITIVE FINISH.		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		TITLE	
.X± 0.1 .XX± 0.01 .XXX± 0.005 .XXXX± 0.0020		MATERIAL BRONZE MIL-B-5687D TYPE 1 GRADE 1		BEARING, STEM DOOR LOCK SOLENOID	
ANGLES ± 2		ORIGINATOR K KLIMEK		DATE 4/1/97	
SURF. FINISH		DRAWN EL HORNAUER		DATE 4/1/97	
SIZE B	SCALE 5:1	DO NOT SCALE DWG	THIRD ANGLE PROJECTION	PART NO. 777096-092	REV B
				SHT 1	OF 1

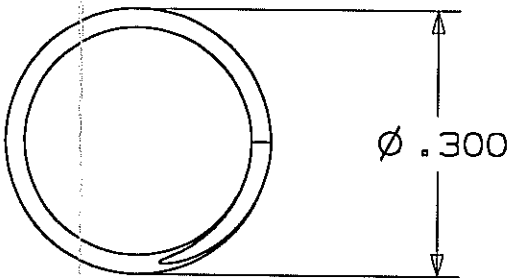
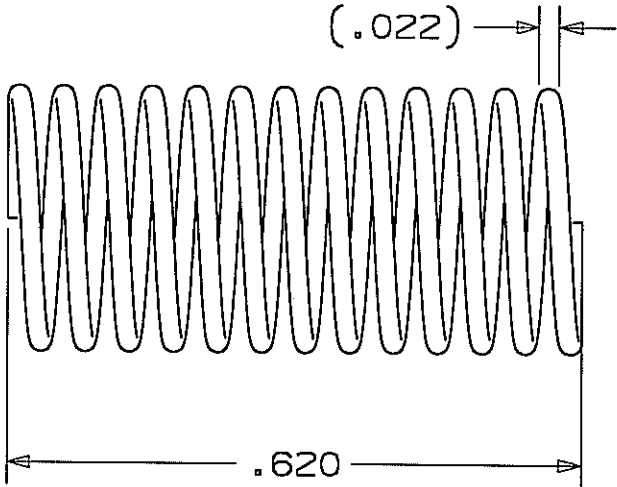
FOR ASSY # 777098-074

NOTES:

1. ▽ INDICATES KEY DIMENSION TO BE CHECKED AT INCOMING Q.C.

SPECIFICATIONS:

- ▽ 1. SPRING RATE: 4.17 LB/IN ± 10%
2. SOLID HEIGHT: .126
- ▽ 3. LOAD AT LENGTH .237 IS 1.62 LBS ± 10%
4. ENDS TO BE GROUND AND SQUARE.



SPECIFICATION CONTROL DRAWING

VENDOR PART NUMBERS ARE FOR REFERENCE ONLY.  
ANY MANUFACTURER WHOSE PRODUCT MEETS ALL PARAMETERS  
OF THIS SPECIFICATION IS CONSIDERED AN APPROVED SOURCE.


SUGGESTED SOURCE OF SUPPLY

1. COLORADO COILING
2. ASSOCIATED SPRINGS #C0300-022-0620-S

REV	REVISION DESCRIPTION	BY	DATE	ECO #
A	INITIAL RELEASE	ELH	5/12/97	BCT 002160

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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	
		MATERIAL STAINLESS STEEL SPRING TEMPER PASSIVATED Ø.022 WIRE	
.X± 0.1	ANGLES ± 2	ORIGINATOR K KLIMEK	DATE 4/4/97
.XX± 0.01	SURF. FINISH	DRAWN EL HORNAUER	DATE 4/4/97
.XXX± 0.005			
.XXXX± 0.0020			
SIZE B	SCALE 5:1	DO NOT SCALE DWG	THIRD ANGLE PROJECTION

	10811 Collins Avenue Lakewood, Colorado 80215-4440 USA	
TITLE		
SPRING, LOCK HSG SENSOR		
PART NO. 777096-088	REV A	SHT / OF 1 / 1

UG DWG

FOR ASSY # 777098-074