

- NOTES:
- 1 TILT AXIS TORQUE TO BE 37-49 IN LB TOTAL IN EACH DIRECTION. (18.5-24.5 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 54 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.

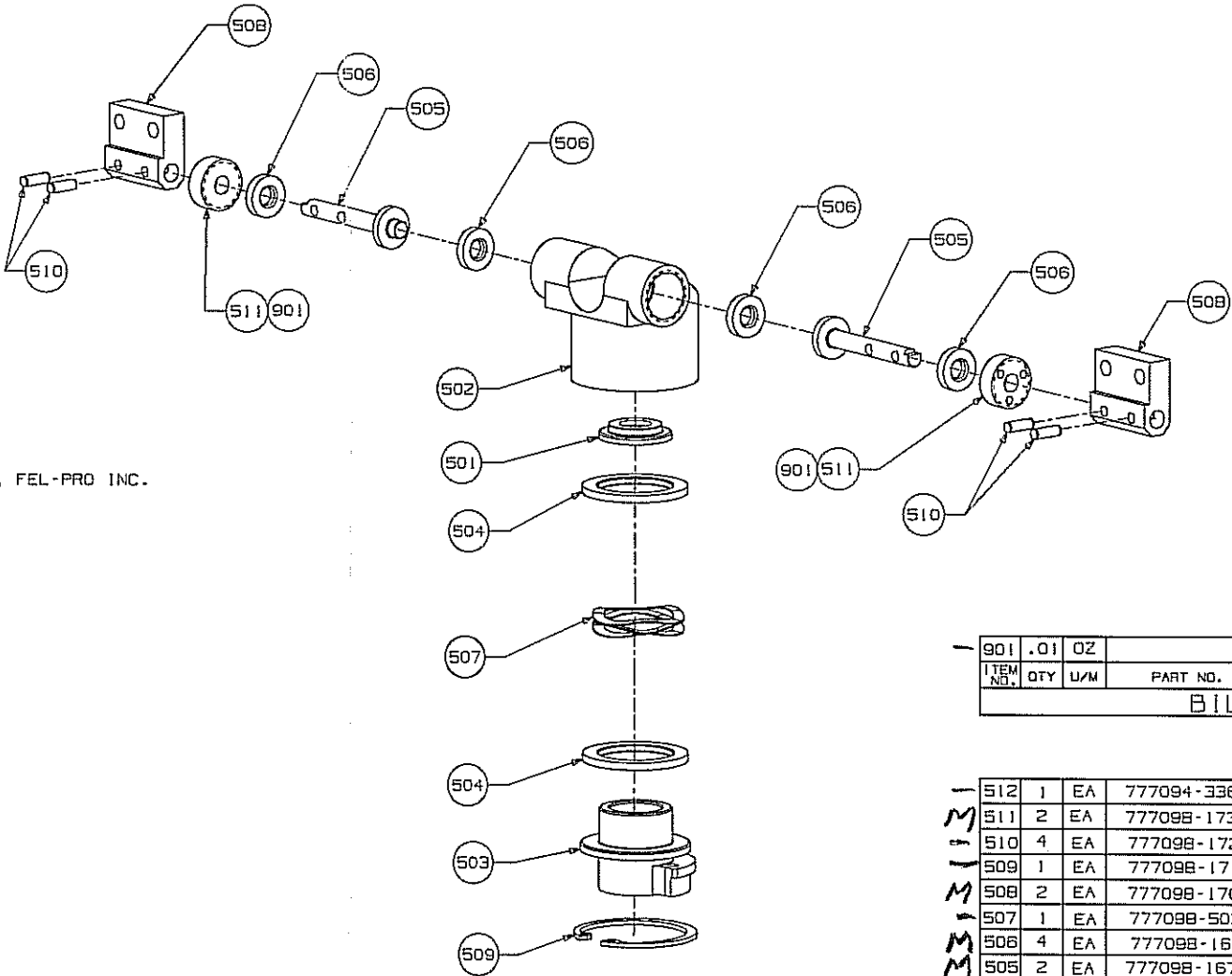
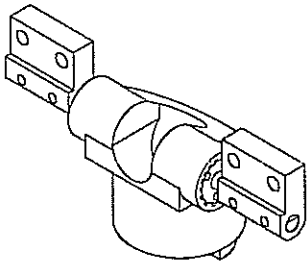
PIVOT AXIS

- 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 160° AND A COUNTERCLOCKWISE ROTATION OF APPROXIMATELY 160°. DO NOT ALLOW NEST TO CONTACT SWIVEL STOPS. EACH 160° 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 160° IN THREE SECONDS.
- C. ON THE EIGHTH CYCLE RECORD THE MEASUREMENT FOR THE COUNTERCLOCKWISE ROTATION, ROTATING SMOOTHLY 160° 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 OPT1A DARK GREY PER BOR 512 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.



7-20-09 408

ITEM NO.	QTY	U/M	PART NO.	DESCRIPTION
901	.01	OZ		ADHESIVE, LOCTITE 680, GREEN

BILL OF EQUIPMENT

ITEM NO.	QTY	U/M	PART NO.	DESCRIPTION
512	1	EA	777094-336	SPECIFICATION, PAINT, OPT1A
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	SPIRAWAVE 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

BILL OF REFERENCE

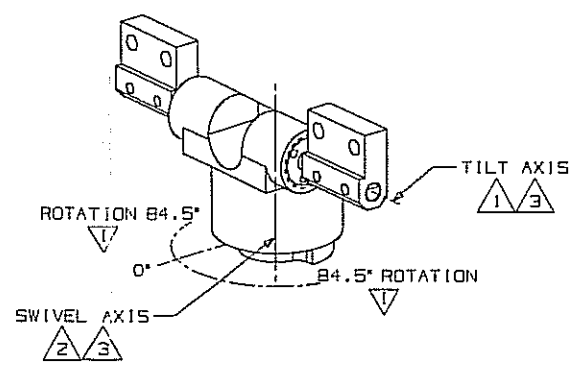
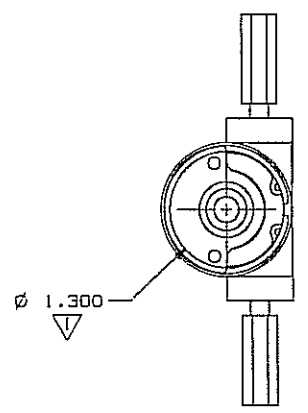
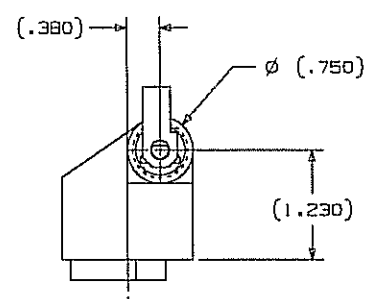
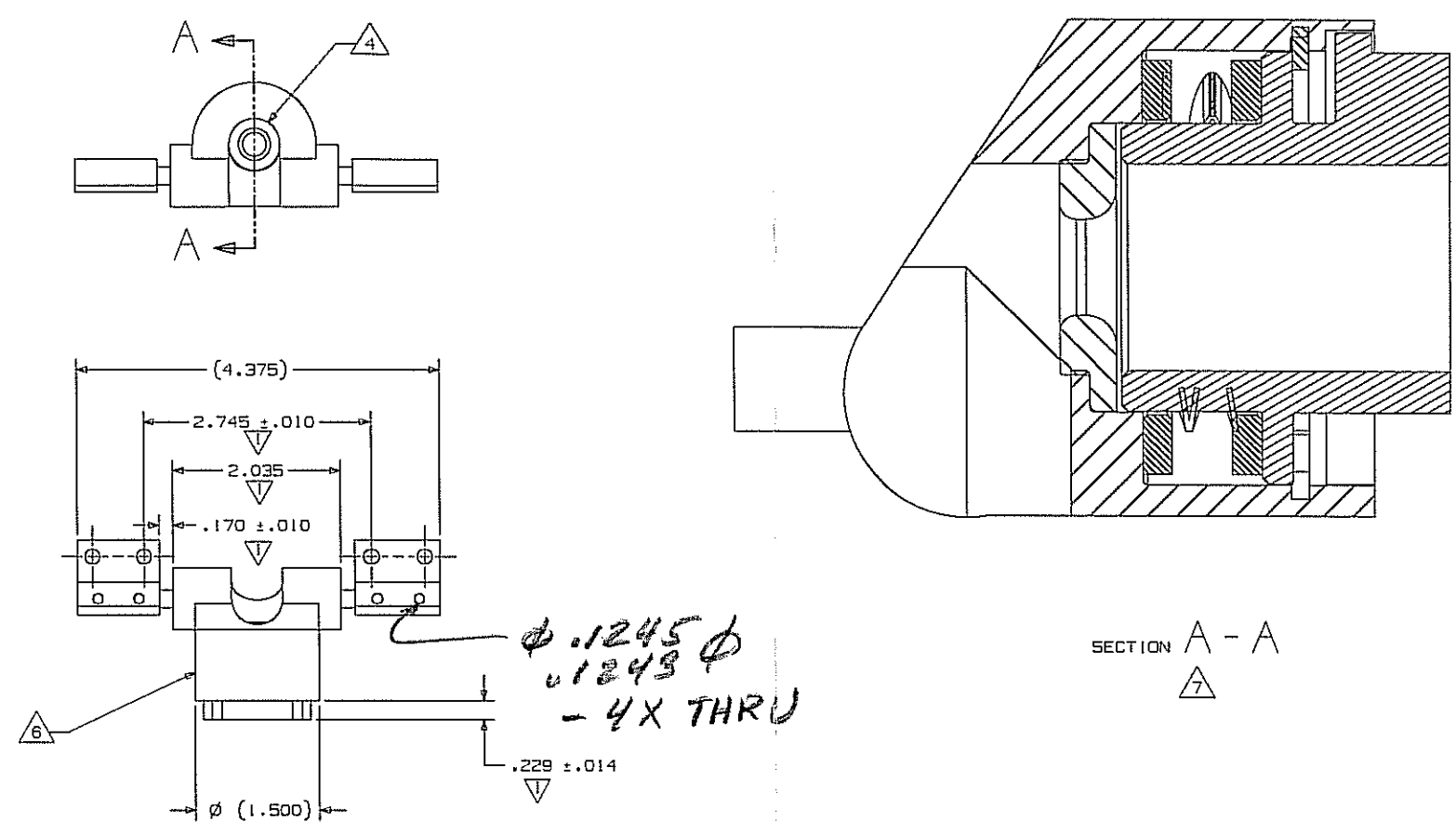
TOLERANCES AND DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.	
.XX .010		.XX .010	
.XX .005		.XX .005	
.XX .0020		.XX .0020	
ORIGINATOR		DATE	
NGUYEN		M. GLOVER	
DATE		DATE	
11/15/06		11/15/06	
SIZE		SCALE	
1:1		1:1	
REV		REV	
A		A	
PRT NO.		PRT NO.	
777094-409		777094-409	
REV		REV	
A		A	
DWT		DWT	
1/2		1/2	

GAMBRO. BCT

NEST ASSEMBLY OPT1A

UNIGRAPHICS

REV	REVISION DESCRIPTION	BY	DATE	ECO #
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720-09 408

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<small>TOLERANCES AND FINISHES PER ANSI Y14.5M-1992 UNLESS OTHERWISE SPECIFIED AND AFTER ADDITIVE FINISH.</small>		<small>DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED</small>		<small>TITLE</small> NEST ASSEMBLY			
<small>FINISH</small> .F+ 0.10 .XX+ 0.01 .XXX+ 0.005 .XXXX 0.0020	<small>ANGLES</small> ± 3°	<small>MATERIAL</small>		<small>DATE</small>			
<small>DESIGNER</small> NGUYEN		<small>DATE</small>		<small>PART NO.</small> 777094-409			
<small>SIZE</small> D1:1	<small>SCALE</small> 1:1	<small>REV</small> 1	<small>DATE</small> 01/15/08	<small>DRAWN</small> M. GLOVER	<small>REV</small> A	<small>SHEET</small> 2	<small>OF</small> 2

UNIGRAPHICS