

A62022-31

NOTES:

1. APPLY A THIN, UNIFORM COATING, OF P/N 9575 TO THE FOLLOWING:
ALL O-RING SURFACES

FIND NO. 002 - THREADED PORTIONS & BORE
FIND NO. 003 - THREADED PORTIONS
FIND NO. 052 - THREADED PORTIONS
FIND NO. 056 - THREADED PORTIONS
FIND NO. 102 - THREADED PORTIONS
FIND NO. 103 - THREADED PORTIONS
FIND NO. 108 - THREADED PORTIONS
FIND NO. 201 - THREADED PORTIONS
FIND NO. 203 - THREADED PORTION & POINT

2. TORQUE REQUIREMENTS:

FIND NO. 002 - - - 40-50 FT-LBS.
FIND NO. 003 - - - 100-110 IN-LBS.
(GYLON DIAPH. 150 IN-LBS.)
FIND NO. 103 - - - 25-30 FT-LBS.
FIND NO. 050 - - - 70-75 IN-LBS. $\triangle 8$
FIND NO. 108 - - - 10-15 IN-LBS. $\triangle 5$ $\triangle 6$
FIND NO. 109 - - - 20-25 IN-LBS. $\triangle 5$ $\triangle 6$
FIND NO. 201 - - - 30-40 FT-LBS.

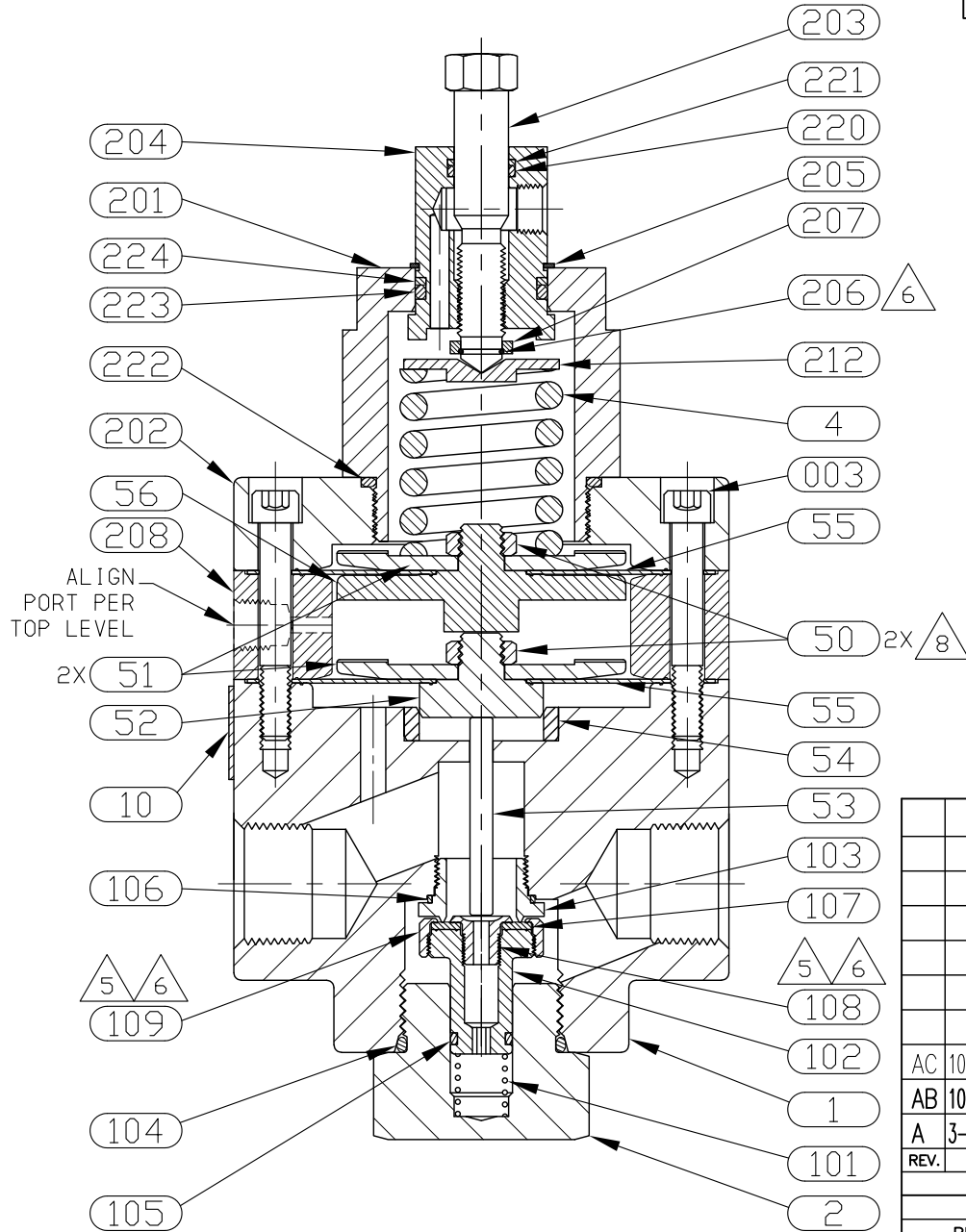
3. PRESS FIT INSERT (FIND NO. 054) INTO BODY (FIND NO. 001)
4. FOR PANEL MOUNT, ALIGN NOTCHES WITH IN AND OUT PORTS.

- $\triangle 5$ RETORQUE AFTER 1 HOUR.

- $\triangle 6$ FIND NO. 109 MUST BE TORQUED BEFORE FIND NO. 108.

- $\triangle 7$ CONFIRM THAT EXTERNAL RING (FIND NO. 206) IS POSITIONED
CORRECTLY INTO WASHER RING (FIND NO. 207).

- $\triangle 8$ APPLY 1 DROP OF LOCTITE 271 TO THREADS OF NUT (F/N 50).



AC	10-28-20	50840-20	EWN	MJW
AB	10-19-18	51051-18	ZXC	WRB
A	3-21-13	11096-13	DRM	TWL
REV.	DATE	ECO NO.	BY:	APPR

REVISIONS

REFERENCE DRAWING(S)

TESCOM
CORPORATION
INDUSTRIAL CONTROLS DIVISION
ELK RIVER, MN USA

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UNLESS OTHERWISE SPECIFIED:

.0 ± .020 ANGLES: ±1°
.00 ± .010
.000 ± .005

SURFACE ROUGHNESS: 100√

CORNER & FILLET RADII: .005-.020

THREADS: CLASS 2

REMOVE ALL BURRS

MFG. SPEC 60301

DRAWING MADE IN THIRD
ANGLE PROJECTION

(DO NOT SCALE DRAWING)

MATERIAL:

FINISH:

DRAWN BY:

DRM | 3-21-13

CHECKED BY:

TWL | 6-27-13

APPROVED BY:

TWL | 6-27-13

NAME

ASSEMBLY INFO. DH

SCALE: 1:1

CODE NO. 13669

SIZE

B

NUMBER

A62022-31

SHT. 1

OF 1