

- NOTES:
- DRAWING IS IN ACCORDANCE WITH MIL-STD-100.
 - ADJUST SHIMS SUCH THAT WORN GEAR WEAR PATTERN IS VERTICALLY SYMMETRICAL ABOUT WORN GEAR CENTERLINE. WORN GEAR END PLAY IS .002-.001. WORN GEAR TURNING TORQUE SHALL NOT EXCEED FINGER TORQUE FOR 50 TURNING MIN. IN BOTH DIRECTIONS.
 - ADJUST SHIMS SUCH THAT WORN GEAR WEAR PATTERN IS SYMMETRICAL ABOUT WORN GEAR TOOTH FLANK TO MIRROR MATE TOOTH FLANK. WORN END PLAY IS .003-.005.
 - WITH FINGER MOTOR SHAFT PULLED UP TO REMOVE END PLAY. ADJUST SHIMS TO ACHIEVE TOOTH TO TOOTH BACKLASH OF .002-.003 WITH HELLS OF METER GEARS ALIGNED.
 - WITH LEVER FINGER SET IN VERTICAL POSITION AND CLAMPED. ADJUST SHIMS TO ACHIEVE BACKLASH OF .002-.003 WITH HELLS OF BEVEL GEAR ALIGNED. UNCLAMP HANDLE AND REDHECK.
 - ADJUST DEC FINGER #48 UTILIZING SHIMS FINGER #50 AND FINGER #129 AS REQUIRED, SUCH THAT SQUEEZING OF LEVER FINGER #51 WILL OPERATE SWITCH WITHIN .003 VERTICAL TRAVEL OF BEVEL GEAR SHAFT. TORQUE CAN NOT EXCEED #48.
 - ADJUST SUCH THAT SQU TORQUE AT PINION SHALL BE 600-1200 IN LBS. AFTER BREAKING IN THE CLUTCH BY SLIPPING IT FIVE (5) TIMES FOR 300 IN BOTH DIRECTIONS. MAKE ADJUSTMENT AFTER A MINIMUM OF THIRTY (30) MINUTES ELAPSED TIME FOLLOWING BREAK IN.
 - FILL GEARBOX WITH LUBRICATING OIL. INTERNAL COMBUSTION ENGINE TACTICAL SERVICE PER MIL-L-2104 GRADE 15W-40 TO APPROXIMATE CENTER OF SHIM GEAR #44. APPROXIMATELY 850CC OF OIL (89 QT).
 - PACK MANUAL DRIVE CRANK AND HANDLE WITH GREASE PER MIL-C-1029A.
 - APPLY SEALANT PER MIL-S-46163 TYPE I GRADE N.
 - ADJUST SHIMS FOR .005-.010 VERTICAL PLAY.
 - ALL UNUSED CONTACTS SHALL BE INSTALLED INTO CONNECTOR WITH MCFIARF SEALING PLUGS (AS APPLICABLE) INSERTED IN UNUSED CROMMET HOLES OF CONNECTOR.
 - REBARR BEFORE USING.
 - TORQUE TO 75-77 IN. LBS.
 - TORQUE TO 11-13 FT. LBS.
 - TORQUE TO 20-25 IN. LBS.
 - TORQUE TO 30-32 IN. LBS.
 - TORQUE TO 10-12 FT. LBS.
 - TORQUE TO 25-27 IN. LBS.
 - TORQUE TO 20-22 IN. LBS.
 - TORQUE TO 8-10 IN. LBS.
 - TORQUE TO 2-3 IN. LBS.
 - TORQUE TO 7-8 IN. LBS.
 - INSTALL PIN PER MSC3540.
 - FOR SHIPPING ONLY.
 - INSTALL WITH MARKINGS ON SIDE INDICATED.
 - CUT WIRES TO 4.5 INCHES.
 - MOUNTING HARDWARE SUPPLIED WITH PART.
 - VENDOR ITEM. SEE SPECIFICATION CONTROL DRAWING.
 - VENDOR ITEM. SEE SOURCE CONTROL DRAWING.
 - DO NOT PAINT AREAS INDICATED.
 - FINISH CLASS F, TYPE 2, PER DRAWING 80064-2584542.
 - MUST MEET ALL REQUIREMENTS OF PRODUCT FABRICATION SPEC 6289045.
 - APPLY DECALS (FIND NO. 124 AND 125) AFTER PAINTING (FAR SIDE).
 - BACKSHELL PER MIL-C-30049/31.
 - DAMPED CONTACTS SHALL MEET THE PERFORMANCE REQUIREMENTS OF MIL-C-39029.
 - PLUG PER SPEC SEA-014.
 - REMOVE AND DISCARD SETSCREW.
 - QUALITY ASSURANCE REQUIREMENTS (QAR):
 - GENERAL QAR 2589142 APPLIES.
 - CLASSIFICATION OF CHARACTERISTICS: MAJOR AQL 2.5% M101 THRU M105
 - METAL STAMP TRAVERSE MECHANISM DATE OF MANUFACTURE, REVISION LEVEL OF DRAWING, SERIAL NO. AND NON WITH LETTERS .003 HIGH ON IMMEDIATE FIND NO. 126.

