

20.6.2 ASSEMBLY



Using a surface plate, insert a dial indicator "D4" and place it on the measurement ring T3 (See drawing T3) with a thickness ring of 20.2 mm.

Reset the depth-gauge to approximately 3 mm.



Bring the internal bearing (5), complete with its thrust block, under dial indicator.

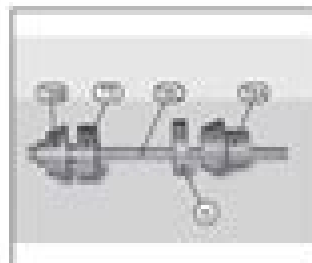
Determine overall thickness "D" of the bearing checking the discrepancy between this size and the size of the measurement ring.

CAUTION

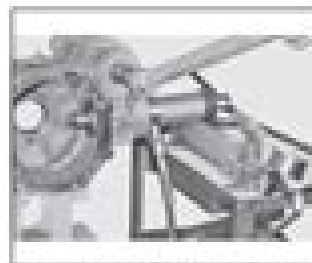
Press the thrust block to the center and take several more measurements while rotating the thrust block.



Manually insert the thrust block of the external bearing (15).



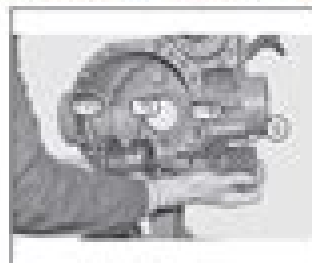
Install tension rod T6C (See drawing T6 p. 80), measurement ring T1 (See drawing T1) and thrust guide tool T6A (See drawing T6) on the thrust block of the external bearing (15).



Connect the tension rod to the joint and move the thrust block of the external bearing (15) into its seat. Disconnect the joint and release the tension rod.

NOTE

Before starting the next stage, make sure that the thrust block has been completely inserted into its seat.

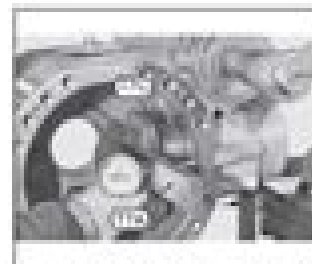


Insert tool T18 (See drawing T1 p. 81) complete with external bearing (15), measurement ring T1 (See drawing T1 p. 79) and gauged ring-rod T7C (See drawing T7 p. 81). Manually tighten.

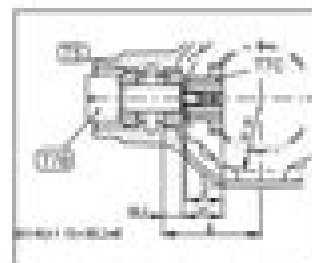


Fit a dial indicator "D4" with long stem into bar T19 (See drawing T7 p. 81), when the bar rests on two workblock "B2" of 37 mm, reset the gauge.

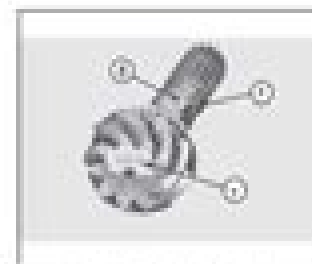
Reset the gauge to approximately 3 mm and read.



Use bar T19 (See drawing T7 p. 81) as gauged rod T7C (See drawing T7 p. 81) and take the measurement "W" at about 37 mm corresponding to the maximum diameter of joint center ring.

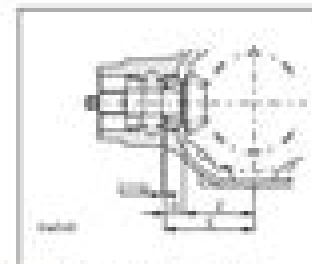


Calculate size "W" which will be the first useful value for calculating the size of the stems (16) that are to be inserted under the thrust block of the internal bearing (5).



Check the nominal size (2) marked on the piston and add or subtract the indicated variation (1) as in its data size "Z".
e.g. $26 \pm 0.1 \pm 0.1 \pm 0.1$

So $1.08 \pm 0.2 \pm 0.1 \pm 0.1$



Calculate size "C" which represents the second value for calculating the size of the stems (16) that are to be placed under the thrust block of the internal bearing (5).



Calculate the difference between sizes "W" and "C" as it to obtain the size "V" of the stem (16) that will go under the thrust block of the internal bearing (5).

Manitou 1740 Manual

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