

20.6.2 ASSEMBLY



Using a surface plate, insert a dial indicator "10" and place it on the measurement ring "11" (See drawing 10) with a thickness of 20.2 mm).

Insert the depth gauge to approximately 2 mm.



Bring the internal bearing (16), complete with its thrust block, under dial indicator.

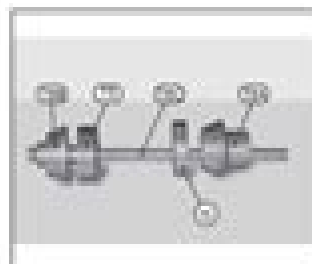
Determine actual thickness "12" of the bearing checking the discrepancy between this size and the size of the measurement ring.

CAUTION

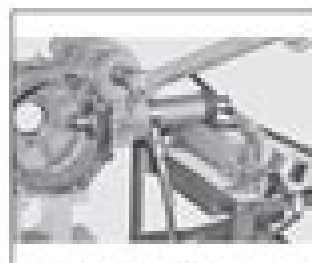
Press the thrust block to the center and take several more measurements while rotating the thrust block.



Manually insert the thrust block of the external bearing (13).



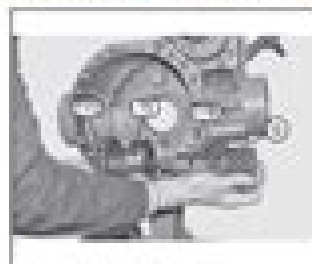
Install tension rod "14" (See drawing 14 p. 80), measurement ring "11" (See drawing 11) and front guide tool "15" (See drawing 15) on the thrust block of the external bearing (13).



Connect the tension rod to the jaws and move the thrust block of the external bearing (13) into its seat. Disconnect the jaws and release the tension rod.

NOTE

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

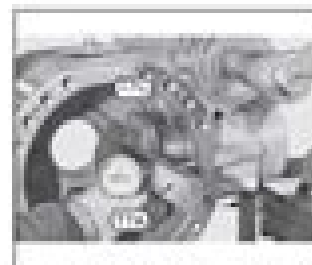


Insert tool "17" (See drawing 17 p. 81) complete with external bearing (13), measurement ring (11) and gauge ring "16" (See drawing 16 p. 81). Manually tighten.

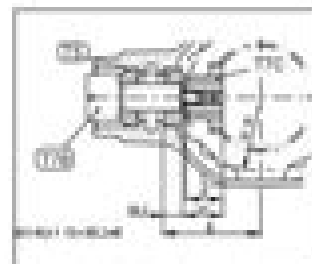


Fit a dial indicator "10" with long stem into bar "17" (See drawing 17 p. 81) when the bar rests on two workblock "18" of 17 mm, reset the gauge.

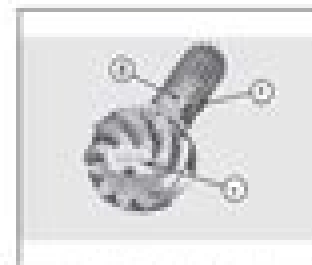
Reset the gauge to approximately 2 mm and read.



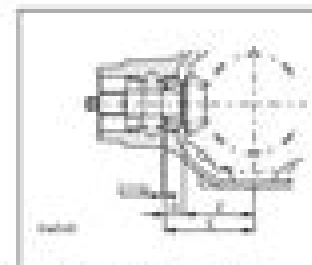
Use bar "17" (See drawing 17 p. 81) as gage rod "19" (See drawing 19 p. 81) and take the measurement "19" at about 17 mm corresponding to the maximum diameter of jaws center turning.



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



Check the nominal size (20) marked on the piston and add or subtract the indicated variation (1) as in the formula size "2".
e.g. $20 \pm 0.1 \pm 0.1 \pm 0.1$
So $19.9 \pm 0.2 \pm 0.1 \pm 0.1$



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 (16).



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

Manitou 1740 Manual

H Kauffman



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