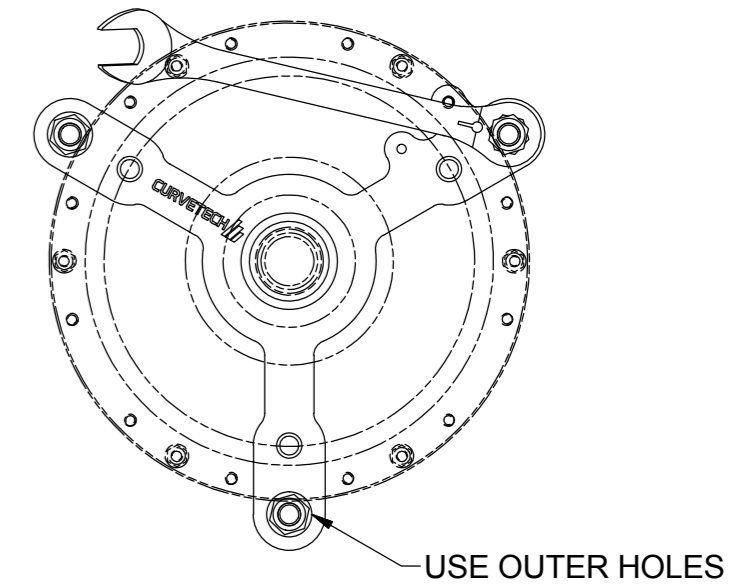


PROCEDURE FOR USE: DISASSEMBLY.

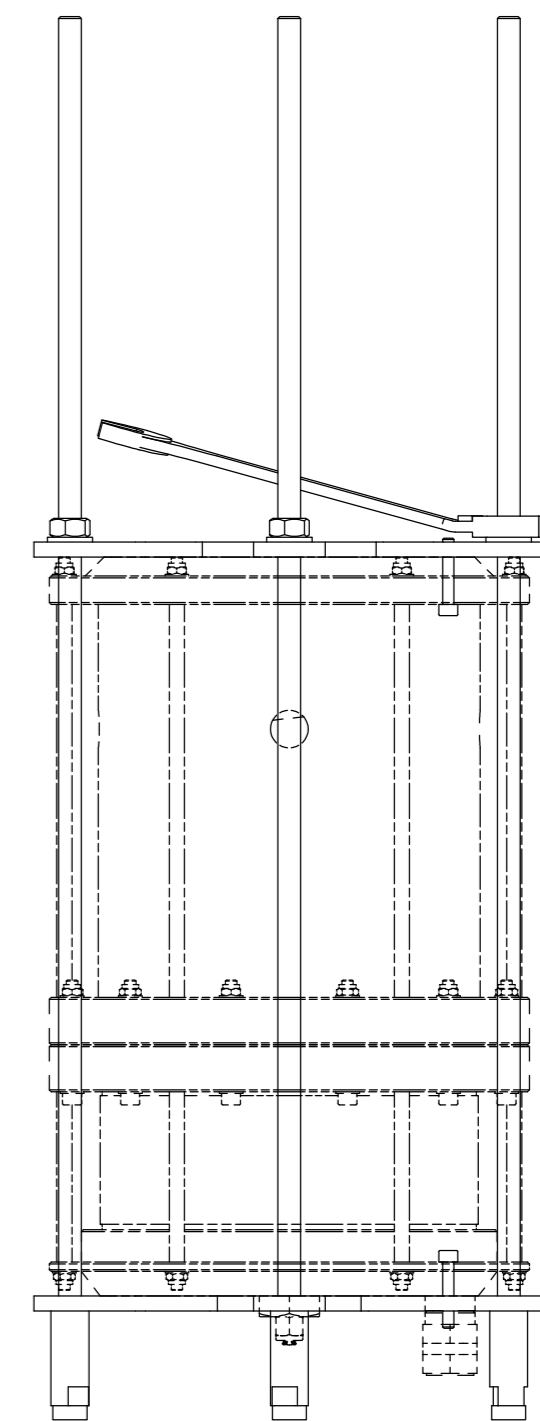
1. THREAD ITEM 3 THOUGH ITEM 5 BY APPROX. 20mm.
USE INNER HOLES FOR 2.75L AND OUTER HOLES FOR 3 / 6L COMPENSATOR.
2. LOCK IN PLACE USING ITEM 7 AND FIT ITEM 1.
3. PLACE VERTICAL AND INSERT COMPENSATOR INTO TOOLING.
4. FIT ITEM 6 AND RETAIN WITH ITEMS 8 AND 4 - FINGER TIGHTEN.
5. ORIENTATE COMPENSATOR AND FIT ITEM 9 TOP AND BOTTOM.
6. RELEASE COMPENSATOR NUTS - SPRING LOAD WILL BE TRANSFERED ONTO TOOLING.
7. USE ITEM 2 TO RELEASE SPRING LOAD EVENLY.
8. ONCE LOAD IS RELEASED, REMOVE NUTS BY HAND.

REVERSE PREOCEDURE FOR ASSEMBLY.

WARNING! COMPENSATORS CONTAIN COMPRESSED SPRINGS WITH STORED ENERGY. ALWAYS ENSURE THAT THIS ENERGY IS DISSIPATED IN A CONTROLLED MANNER (IE. USING THIS TOOL OR A PRESS) PRIOR TO DISASSEMBLY.

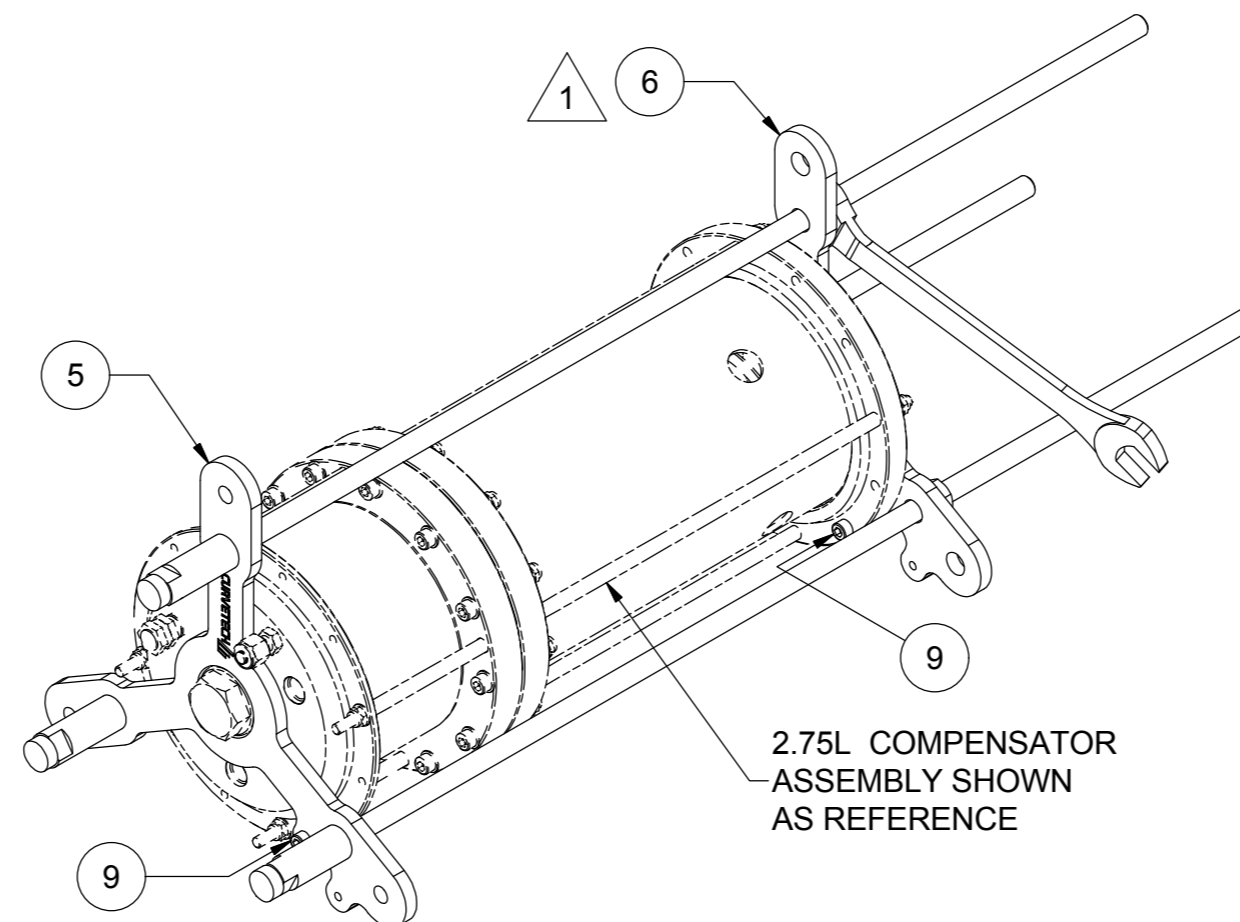
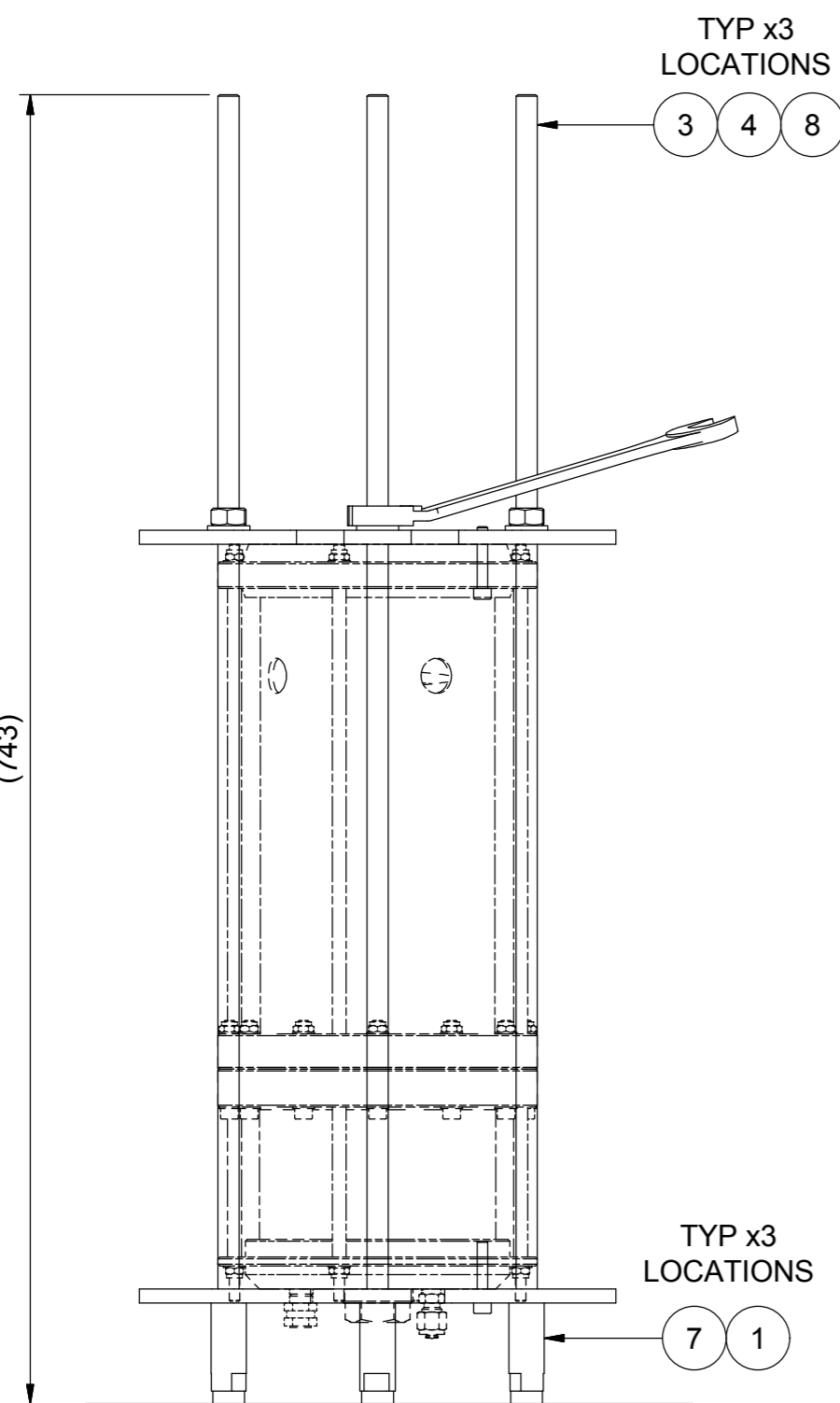


SET UP ARRANGEMENT FOR 3/6L COMPENSATOR



NOTES :-

1. ASSEMBLE IN ACCORDANCE WITH SMD SPECIFICATION SMDW100



PARTS LIST				
ITEM	PART No	DESCRIPTION	QTY	
1	AB1743	RUBBER BUFFER MALE M6	3	
2	AD7033	TOOL 19MM RATCHET COMBINATION SPANNER	1	
3	AD9792	STUDDING M12 X 700mm SS A4	3	
4	AE8020	WASHER M12 FLAT BS4320 FORM A SS A4	3	
5	AJ7389	PLATE COMPENSATOR SPRING COMPRESSOR TOOL	1	
6	AJ7393	PLATE COMPENSATOR SPRING COMPRESSOR TOOL	1	
7	AJ7398	BAR 20mm ROUND M6 / M12 TAP	3	
8	ON_1027	NUT M12 SS A4-80	3	
9	PB4770	BOLT M6 X 35 SHCS SS A2-70	2	

USE TOOL KIT ON FLAT WORK SURFACE. RUBBER FEET PROVIDE STABILITY AND ANTI-SLIP

REV	DATE	CHANGE COMMENT	ZONE	DRAWN	CHECKED	APPD	DATE	EST. MASS	DIMENSIONS	SCALE	PROJECTION 3RD	TITLE																									
1	03-JUN-16	ITEM AJ7393 REPLACES AJ7396	C3	LO	PM	MvZ	16 MAR 16	4.4 kg	mm	1:4		ASSEMBLY COMPENSATOR SPRING COMPRESSION TOOL KIT																									
<table border="1" style="width: 100%;"> <tr> <td>DESIGNED PM</td> <td>DRAWN LO</td> <td colspan="4">TOLERANCES UNLESS OTHERWISE STATED</td> <td colspan="2">MATERIAL:- N/A</td> </tr> <tr> <td>CHECKED DAL</td> <td>APPROVED DAL</td> <td>FABRICATION</td> <td>± 1.0</td> <td>± 1.5</td> <td>± 2.0</td> <td>± 3.0</td> <td>DO NOT SCALE IF IN DOUBT ASK</td> </tr> <tr> <td colspan="2"></td> <td>MACHINED PART</td> <td>± 0.15</td> <td>± 0.4</td> <td>± 0.8</td> <td>± 1.0</td> <td></td> </tr> </table>												DESIGNED PM	DRAWN LO	TOLERANCES UNLESS OTHERWISE STATED				MATERIAL:- N/A		CHECKED DAL	APPROVED DAL	FABRICATION	± 1.0	± 1.5	± 2.0	± 3.0	DO NOT SCALE IF IN DOUBT ASK			MACHINED PART	± 0.15	± 0.4	± 0.8	± 1.0			
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