

DATE 10/15/56
SH. 1 OF 2

TMC SPECIFICATION NO. S-310

COMPILED BY
R. W. B.

TITLE: ASSEMBLY PROCEDURE, MAIN GEAR PLATE-PMO-1, PMO-2 | JOB

APPROVED *[Signature]*

RTF

Ref. A-855 Main Gear Plate Assembly

1. Mount PM-413 (2 ea) on MGP. Square off with bottom of MGP.
2. Slide PM-317 on index screw and fasten screw to MGP.
3. Mount A-829 on MGP. Do not tighten securely.
4. Mount four PM-299's on MGP.
5. Insert A-830 through A-829 making sure PM-317 is properly threaded on shaft.
6. Mount A-829 on A-828. Do not tighten securely.
7. Insert PM-314 through GR-127. Leave $3/4$ " of shaft protruding from gear (Side Opp. Bushing) Tighten set screws.
8. Insert PM-314/GR-127 Assembly through bearing in MGP. Be sure to rotate free gear 1 to $1\frac{1}{2}$ teeth while assembling.
9. Place A-828 over the two shafts and fasten to PM-299.
10. Fasten PM-316 on non-threaded end of A-830.
11. Insert PN-109-5 through holes in threaded end of A-830. Be sure that PM-317 is between the holes.
12. Insert PM-323 in PM-207 and tighten set screws.
13. Insert four screws (SCBS0632BC12) through holes in PM-207 and secure screws to four TE-135-2 spacers.
14. Fasten this Assembly to MGP. using # 6 solder lug in place of lockwasher in top right hand corner.
15. Fasten A-827 to MGP. and square off with bottom edge of MGP.
16. Fasten three PM-298's to A-826.
17. Mount A-826 Assembly on MGP.
18. Insert $\frac{1}{4}$ " D. Steel shaft through A-826 bearings and adjust A-826 until shaft turns freely. DO NOT TOUCH THESE ASSEMBLIES AGAIN.
19. Slide PM-316 over CY-104 shaft and insert shaft in bearing on A-827.
20. Slide A-939 on end of shaft showing through bearing in A-827 before fastening CY-104 to MGP.

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- # 21. Mount CY-104 on MGP. using WA-108's as needed. Check to see that CY-104 shaft moves freely in A-827 bearing.
22. Tighten PM-316 on CY-104 shaft against bushing allowing sufficient clearance. (.003)
23. Insert PM-307 in bearing A-826 and place A-939 in position on PM-307. Allow 7/16" of PM-307 to protrude from rear of MGP. Tighten A-939 set screws.
24. Assemble PM-305, LD-193 and PM-308. Place this assembly on $\frac{1}{4}$ " shaft and check for distortion or "wobble."
25. Mount PM-305/LD-193/PM-308 assembly on PM-307. Tighten only one set screw.
26. Adjust A-939's as necessary to minimize noise.
27. Mount four PM-300's on MGP. Hand tighten only.