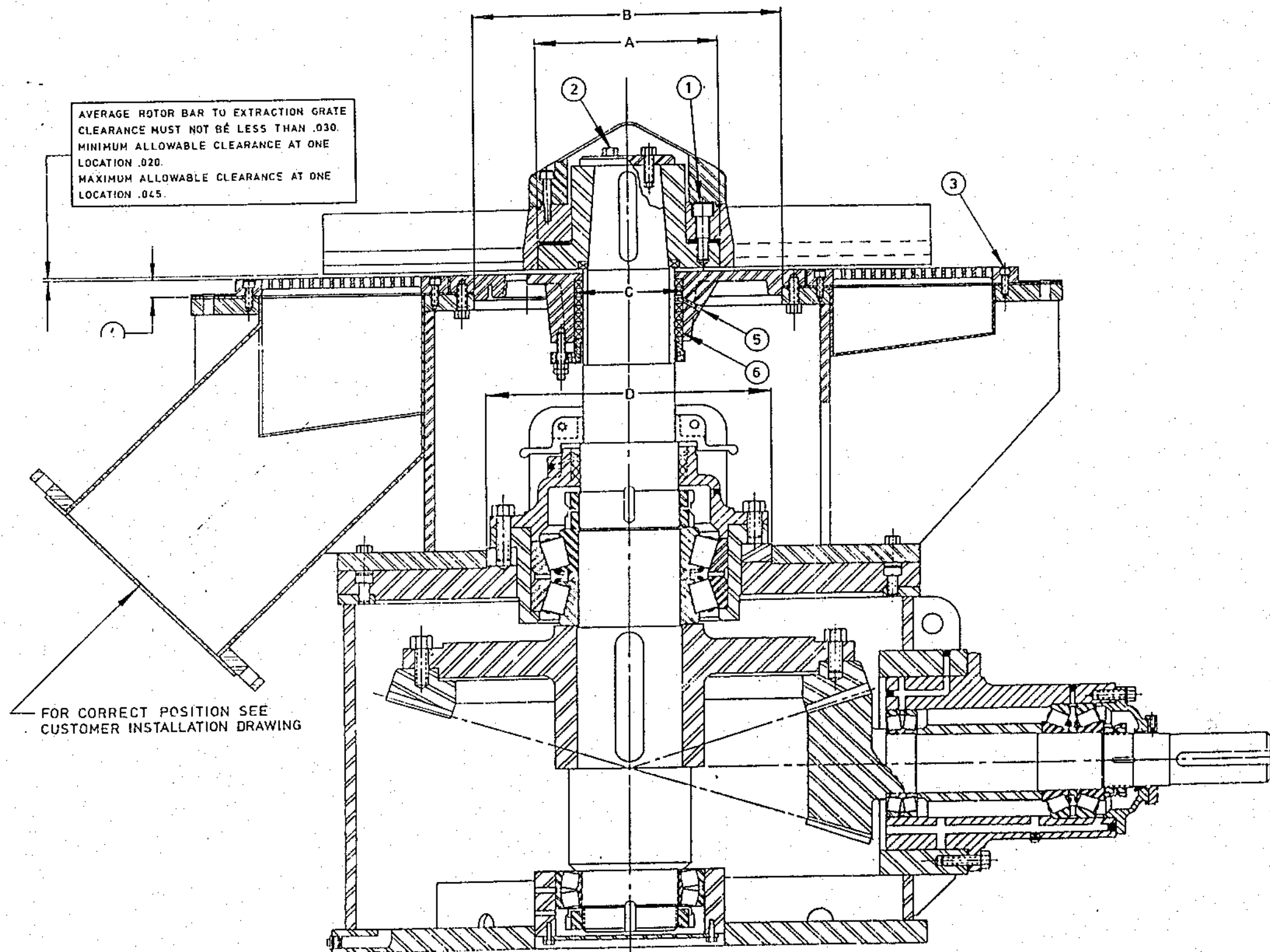


FIT	I.D.	O.D.	MEAN FIT	TEMP. OF I.D. PART
A	13.500/13.502	13.500/13.498	+.002	COLD
B	22.750/22.754	22.745/22.743	+.008	COLD
C	8.000/8.005	7.985/7.980	+.020	COLD
D	21.010/21.013	21.000/20.997	+.013	COLD



NOTES: UNLESS OTHERWISE SPECIFIED

- ① TORQUE TO 420-440 FT. LBS. (LUBRICATED*)
- ② TORQUE TO 240-260 FT. LBS. (DRY)
- ③ TORQUE TO 130-150 FT. LBS. (DRY)
- ④ EXTRACTION PLATE THICKNESS 1.250 ± .002
- ⑤ CHECK ALIGNMENT OF LANTERN RING WITH HOLES IN GLAND HOUSING, AFTER GLAND FOLLOWER NUTS ARE HAND TIGHT.
- ⑥ LUBRICATE PACKING FOR BREAK-IN.
- ⑦ ANTI-SEIZE COMPOUND TO BE USED ON ALL INTERFERENCE FITS.
- ⑧ ASSEMBLY OF PARTS CLASSIFIED AS COLD REPRESENTS 70°F.
- ⑨ SEE DRAWING NUMBER D76213 FOR MANUFACTURING ASSEMBLY OF THE GEARDRIVE.

* = USE ANTI SEIZE COMPOUND ON ALL S.S. CAPSCREWS WHICH THREAD INTO S.S. THREADS. HAND TIGHTEN CAPSCREWS & TORQUE BY HAND. DO NOT USE IMPACT WRENCH.

A		NOTE #1 LUBRICATED DRY 550-580 FT. LBS. (DRY)		REV
REV	DATE	BY	CHKD	DATE
1	5/28/86	AZ		
VOITH-MORDEN INC.		PORTLAND OREGON U.S.A.		
FIRST USED ON		MANUFACTURING ASSY.		
DATE		SCALE		
5/28/86		NONE		
OWN		BY		
AZ		A		
D21-190009		SHEET 1 OF 1		