

12: SUMMARY OF ASSEMBLY OPERATIONS

The following notes provide an overview of assembly of a unit and may be used in conjunction with the previous chapters for specific cross reference where there is any elaboration required for a particular assembly operation.

FUNCTION OVERVIEW ...

- 1: Select a boss using the Boss Selection Chart to match the particular orders to be assembled – Remove 5200 from freezer**
- 2: Assemble the Boss with a Blade Carrier – Check for interference
Clean and de-burr Blade Carrier**
- 3: De-Burr Flats & Internal Tap burrs
Wash with soap and water with Teepol
Install the 2 x M8 locking screws
Install the 3 x Reversing Rollers with Loctite – Check free**
- 4: Fit the Tripod to the Blade Carrier**

CHECK CONTACT SURFACES FOR BURRS – HONE & FILE

- 5: Select the Nose Cone – Shaft or Saildrive (Lombardini option)
Split on cut-off saw Drill spring hole in jig
Remove internal corners on Nose Cone
Sand faces on Sanding Disc - De-burr all edges and clean internal spigot**
- 6: Machine the Tripod to tolerances for final assembly**

INSERT FEELER GAUGES UNDER TRIPOD FOR CLEARANCE TOLERANCES

- 7: Select the Spring – Chamfer ends and check depth**
- 8: Assemble the Boss with grease with 3M 5200 on the Locking Screws only

Preload the internal Torsion Spring

Seal the Nose Cone joins with 3M 5200 and exit holes of the screws

Torque Nose Cone screws down
Clean up unit with Mineral Turps – Leave to dry**