



ZONE	REV	REVISION DESCRIPTION	DATE	REVISED BY	APPROVED BY
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES GENERAL TOLERANCES		PROJECTION 	DO NOT SCALE THIS DRAWING BREAK ALL SHARP EDGES REMOVE BURRS & FLASH		AMERICAN MACHINING, INC. FENTON, MICHIGAN
FRACTIONS: $\pm 1/32$.XX DECIMALS: $\pm .010$.XXX DECIMALS: $\pm .005$.XXXX DECIMALS: $\pm .001$	ANGLES: $\pm 1^\circ$	FINISH: N/A ✓ SPECIAL FINISH: N/A
THIS DRAWING HAS BEEN FURNISHED BY AMERICAN MACHINING, INC. THE INFORMATION AND KNOW-HOW CONTAINED MAY NOT BE USED NOR MAY THE DRAWING BE REPRODUCED WITHOUT THE WRITTEN PERMISSION OF AMERICAN MACHINING, INC. ALL REPRODUCTIONS IN WHOLE OR IN PART, INCLUDING VENDOR SHOP DRAWINGS, SHALL BEAR OR REFER TO THIS NOTE.		DRAWN BY: M. SCHULTE CHECKED BY: REICH APPROVED BY: <i>G.P.S.</i>	05-21-03 06/04/03 DATE: 06/05/03	DESCRIPTION INSTRUCTIONS - ASSEMBLY CAM SEAL STYLE "B"	
SIZE A		PART NUMBER 114661		REV A	
SCALE: NONE			MAT'L: N/A		SHEET 1 OF 2

ASSEMBLY INSTRUCTIONS

1. Ensure that all components are clean, dry, and in good condition prior to assembly.
2. Place cover, detail #10, on workbench with flange up.
3. Install o-ring, detail #8, in groove on bearing, detail #5.
4. Place bearing, detail #5 on installation tool (AMI 114391).
5. Install bearing with o-ring into cover flange until bearing is flush with flange surface.
6. Apply two drops of Loctite™ #242 onto threads of retainer pins, detail #11.
7. Thread retainer pins into flange, torque to 18-22 foot/pounds (24.4-29.8 Nm).
8. Apply two drops of Loctite™ #242 onto threads of screws, detail #12.
9. Place screws, detail #12 into locking lug, detail #13, and thread into flange.
10. Torque screws and locking lugs to 25-30 foot/pounds (33.9-40.7 Nm).
11. Insert shaft, detail #9, through bottom of flange until paint sling contacts lower portion of flange.
12. Place o-ring, detail #6, on shaft, placed approximately 2" from end of shaft.
13. Place key, detail #7, into keyway on shaft. Key must fit snugly in keyway. Do not force fit key into keyway.
14. Slide coupling, detail #3, onto shaft, making sure that key way is aligned with slot in coupling.
15. Coupling must slide freely onto shaft/key.
16. Place thrust washer, detail #2 onto top of coupling, thread retaining screw, detail #1, into shaft.
17. Torque retaining screw, detail #1, to 15-20 foot/pounds (20.3-27.1 Nm).
18. Install set screw, detail #4, into coupling, torque set screw to 15-20 foot/pounds (20.3-27.1 Nm)

ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
001	110037	1	SCREW - HHCS 18-8 SS NYLOC
002	110036	1	WASHER - THRUST
003	110066	1	COUPLING - REMOVABLE W/DOGS AND CAM ASSY
004	110101	1	SCREW - SQ HD SET 18-8 SS
005	114439	1	BEARING - THERMOPLASTIC
006	110067	1	O-RING - BUNA
007	110102	1	KEY - 18-8 SS
008	114438	1	O-RING - EPDM
009	-----	1	SHAFT - DETERMINED BY SIZE OF TANK / COVER ASSEMBLY
010	-----	1	FLANGE - PART OF COVER ASSEMBLY
011	110049	2	PIN - RETAINER
012	110034	2	SCREW - SHCS 18-8 SS
013	110035	2	LUG - LOCKING

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