Assembly Instructions

Step 1: Place detent retainer and yellow spring onto threaded end of drive pin with detent as shown above.

Step 2: Apply "Loctite" #242 in threaded pin holes of drive hub.

Step 3: Place drive pins into the drive hub holes and tighten to 45-50 lb.ft. torque. Be sure the yellow springs are not caught under the shoulders of the pins.

Step 4: Place armature over the pins so the pins protrude thru the bushings in the armature.

Step 5: Place spring retainers and blue springs on pins as shown and secure with retainer rings.

Step 6: Push the armature away from the hub toward the top of the pins as far as possible. All detent retainers must then be pushed against the armature bushing flanges.

⚠️ WARNING ⚠️ Failure to follow these instructions may result in product damage, equipment damage, and serious or fatal injury to personnel.
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