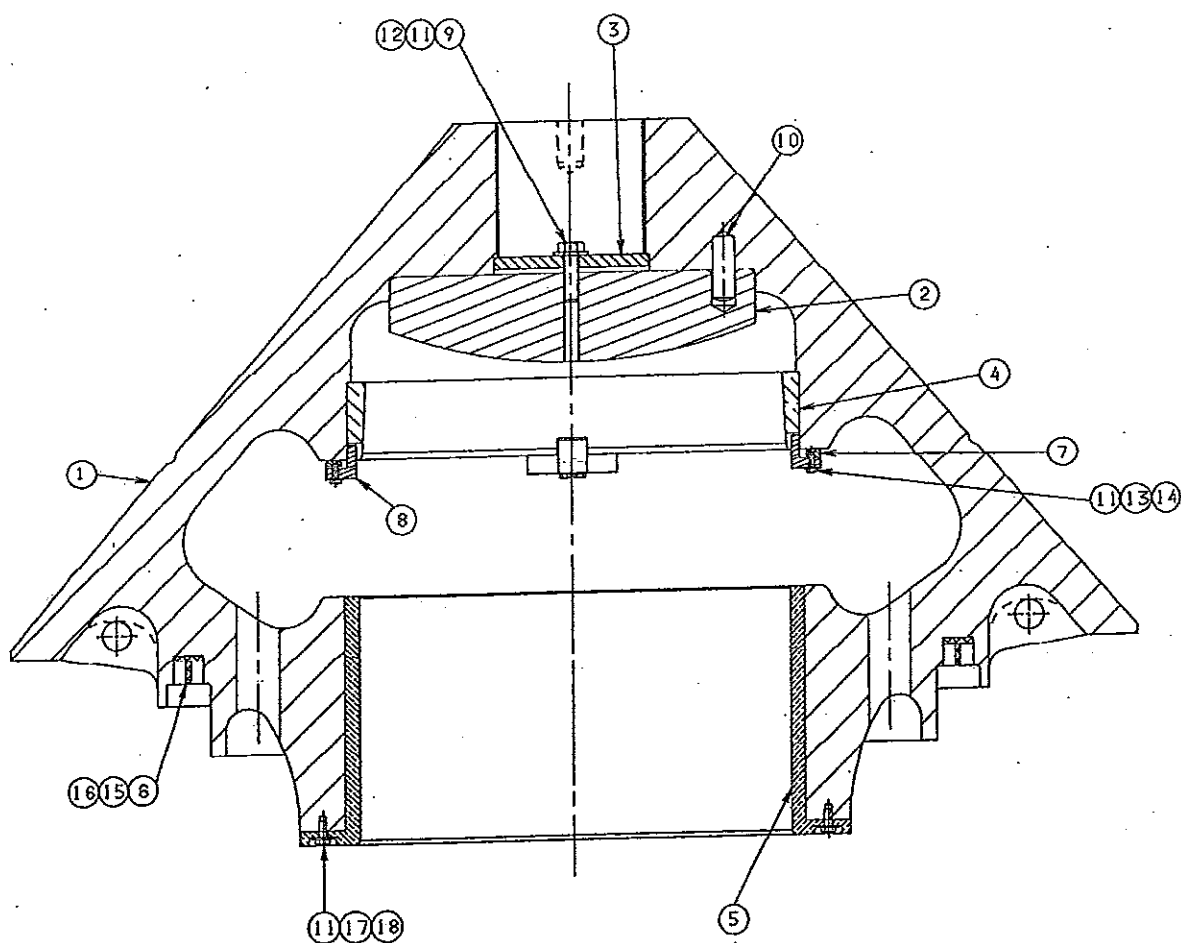


7090058016

HEAD ASSEMBLY
HAUPTWELLE+TRAGKEGEL
TUKIKARTIO, KOKOONPANO

ENSEMBLE TETE
CONJUNTO CABEZA
CONJUNTO DA CABEÇA



770 9005 8016 DWG 00

110-93050027

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NOTES CONT. :

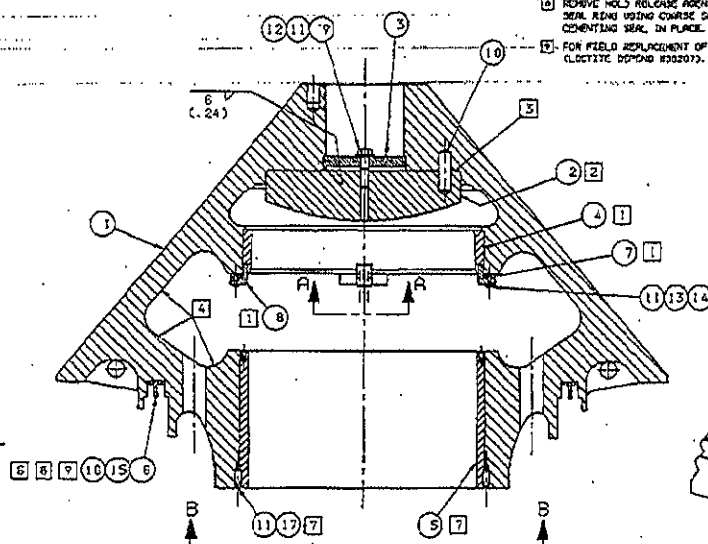
7 LOWER HEAD PUSHING ASSY. INSTRUCTIONS:

1) COOL THE BURNING IN DRY ICE FOR A MINIMUM OF 2 HOURS TO GIVE AT LEAST 40°C (72°F) TEMPERATURE DIFFERENCE BETWEEN THE HEAD AND THE BURNING.

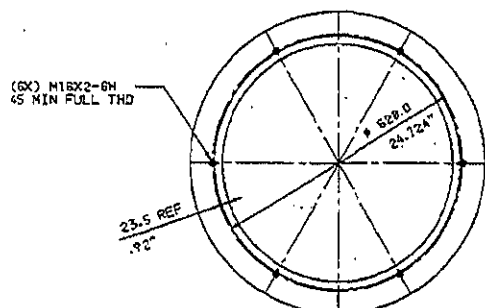
2) AFTER BURNING IS IN STALLED FLUSH WITH BOTTOM OF HEAD, DRILL AND TAP HEAD AND BURNING AS SHOWN IN VIEW D-B. INSTALL SET SCREWS, ITEM 17, WITH LOCTITE, ITEM 11, AND PUNCH PRICK.

② REMOVE HOLD RELEASE AGENT, OIL, GREASE, DIRT, ECT. FROM FLAT SURFACE OF SEAL RING USING COARSE SANDPAPER TO REMOVE SURFACE "SHINE" BEFORE REINSTALLING SEAL IN PLACE.

7. FOR FIELD REPLACEMENT OF A SEAL, ORDER ADHESIVE KIT, 10-04590340. (CLOTYPE DEPEND H30207). ONE KIT IS SUFFICIENT.



VIEW A-A
SCALE 1:2



VIEW B-B

(6X) M16X2-6H
45 MIN FULL THD

23.5 RE
82"

SURFACE PREPARATION, CLEANING
AND PAINTING SYMBOLS ACCORDING
TO COMPANY STANDARD 03-01-01.

BILL OF MATERIAL					
ITEM NO.	PART NUMBER	QTY REQD	PART NAME	UNIT REQD	W/CHRG NO.
	10 93050027		1 HEAD ASSEMBLY		2980
(1)	10 42464013	✓ 1	1 HEAD		A02676
(2)	10 57605124	1	1 HEAD BALL		A2 146
(3)	10 13340752	1	1 STRAP		A3 2 3
(4)	10 22147321	1	1 HEAD BUSHING-UPPER		A1 36 5
(5)	10 22147348	✓ 1	1 HEAD BUSHING-LOWER		A1 110
(6)	10 63518950	1	1 SEAL RING		A3
(7)	10 61340013	4	4 KEY RETAINER		A4 0.5
(8)	10 47098035	4	4 KEY		A3 1
(9)	10 03086086	1	1 SPRING WASHER		
(10)	10 03344787	3	3 STR PIN Ø 30 X 90		-
(11)	10 04826353	A/R	LOCTITE 277		-
(12)	10 03724606	1	1 HHCS M20 X 70		-
(13)	10 03722043	8	8 HHCS M8 X 25		-
(14)	10 03063291	8	8 LOCKPLATE M8		-
(15)	10 04590350	A/R	ADHESIVE		-
(16)	10 04590351	A/R	ACTIVATOR		-
(17)	10 02992689	6	6 SOC SET SCR M16X40		-

ABOUT THE AUTHOR

5. UPPER HEAD BUSHING & KEY ASSY INSTRUCTIONS:

B) LOCATE KEY, ITEM 8, IN KEY RETAINER, ITEM 7, AND TIGHTEN CAPSCREW WITHOUT USING ANY LOCKING.

c) POSITION KEY IN SLOTS OF MOUNTING WITH APPROX. 1mm (.04") CLEARANCE BETWEEN INNER SURFACE OF KEY AND HEAD BOX. THEN TACK WELD KEY RETAINER TO HEAD.

D) REMOVE KEY AND VELD KEY RETAINER, IN PLACE AS SHOWN.

E) APPLY LOCKTITE, ITEM 11, ON CAPSCREWS, ITEM 13, AND INSTALL KEY, ITEM 8, USING LOCKPLATE, ITEM 14.

② WHEN ASSEMBLING HEAD BALL TO HEAD, COOL THE HEAD BALL TO GIVE AT LEAST 50°C (119°F) TEMPERATURE DIFFERENCE.

HEAD BALL, 24734 S CONTACT HEAD BALL S

☐ ROAD BALL SHOULD CONTACT ROAD BALL RISING ON SURFACE INDICATED.

Ⓜ THOROUGHLY CLEAN CONED HEAD CAVITY.

2. EXERCISE CAUTION WHEN LOWERING THE HEAD ASSEMBLY INTO POSITION DUE TO THE SMALL CLEARANCE BETWEEN HEAD BUSHINGS AND SOCKET. USE SPECIAL LIFTING PLATE TO HOLD HEAD AT THE PROPER ANGLE DURING ASSEMBLY.

5 SEAL CEMENTING INSTRUCTIONS:
A) CLEAN GROOVES WITH OIL FREE SOLVENT AND DRY.

b) APPLY ACTIVATOR IN VERY THIN FILM TO BOTTOM OF SEAL RING. IF EXCESS ACTIVATOR IS APPLIED, A PARTIALLY CURED BOND MAY RESULT.

C) APPLY ADHESIVE TO BOTTOM OF GROOVE. APPLY ENOUGH ADHESIVE TO ENSURE MINIMAL SQUEEZES OUT.

D) POSITION SEAL RING INTO GROOVE AS SOON AS POSSIBLE AFTER ADHESIVE APPLICATION. SUFFICIENT PRESSURE TO KEEP THE TWO SURFACES IN CONTACT WITH EACH OTHER SHOULD BE MAINTAINED UNTIL A HANDLING BOND IS ATTAINED. A HANDLING BOND IS ATTAINED IN APPROX. THREE MINUTES.

CR2 STORED, DO NOT CHANGE MANUALLY

[illegible]

1	1	UPDATED TO ISO1000 ST
2	1	ITEM 7 10-01000000
3	1	WHD 10-74001015
4	1	ISSUED
5	REV.	DECRYPTION OF CHANGE

7090058016

**HEAD ASSEMBLY
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CONJUNTO DA CABAÇA**

ITEM REF. VIITE	PCS NBRE KPL	PART NO/NO ART. TEIL/PARTE N° OSA/CÓDIGO DA PEÇA	DESCRIPTION BENENNUNG NIMITYS	DESIGNATION DESCRIPCION DESCRICO	NOTES BEMERK/NOTA HUOM.
1	1	7082404310	HEAD KOPF TUKIKARTIO	CONE SUPPORT CABEZA CABEA	
2	1	1057605124	HEAD BALL LAGERSCHALE TUKIKARTION PALLO	BUTEE SPHERIQUE TOPE ESFRICO ESFRICO DACABEA	
3	1	1013340732	STRAP FLANSCH VANNE	BRIDE BRIDA CORREIA	
4	1	1022147321	UPPER HEAD BUSHING TRAGKEGELBUCHSE KARTION LAAKBRI, YLEMPI	BAGUE SUPERIEUR. DE TETE CASQUILLO SUP. DE CABEZA BUCHA SUPERIOR DA CABEA	1war
5	1	N15655252	LOWER HEAD BUSHING TRAGKEGELBUCHSE KARTION LAAKERI, ALEMPI	BAGUE INFERIEURE DE TETE CASQUILLO INFER. DE CABEZA BUCHA INFERIOR DA CABEA	1war
6	1	1063518930	GLAND RING WELLENDICHTRING TIIVISTYSRENGAS, PEHMEÄ	JOINT ETANCHEITE JUNTA DE ESTANQUEIDAD ANEL PARA CILINDRO	
7	4	N80500504	SUPPORT TRÄGER TUKI	SUPPORT SOPORTE SUPORTE	
8	4	1047098035	KEY BAR STANGE KIILATANKO	BARRE A CLAVETTE BARRA BARRA DA CHAVETA	
9	1	7001634020 TREF D20	ELASTIC WASHER SPRENGRING JOUSTAVA ALUSLEVY	RONDELLE RESSORT ARANDELA MUELLE ARRUELA ELSTICA	
10	3	7001619361	PIN NADEL TAPPI	GOUPILLE CLAVIA PINO	
11	1	7008010002 2875 / 7275	HARD THREAD LOCKER GEWINDEKLEBSTOFF KARKAISTU TERÄS	RESINE FREIN RESINA FRENO RESINA DE FREIO	
12	1	7001530421 ISO4017-M10X25-8.8-A3A	HEXAGONAL SCREW SCHRAUBE KUUSIORUUVI	VIS HEXAGONALE TORNIL. PARAFUSO SEXTAVADO	
13	8	7001530104 ISO4017-M8X25-8.8-A3A	HEXAGONAL SCREW SCHRAUBE KUUSIORUUVI	VIS HEXAGONALE TORNIL. PARAFUSO SEXTAVADO	
14	8	1003063291	NUT-LOCK MUTTER BREMS MUTTERI-LUKKO	FREIN D'ECROU FRENO DE TUERCA TRAVA DA PORCA	
15	1	7008010102 3830 / 7330	GLUE KLEBSTOFF LIIMA	COLLE PEGANTE COLA	
16	1	7008010103 7831 / 7371	ACTIVATOR KLEBSTOFFHAERTER KATALYYTTI	ACTIVATEUR ACTIVADOR ATIVADOR	
17	8	7001532140 ISO4017-M10X25-10.9	HEXAGONAL SCREW SCHRAUBE KUUSIORUUVI	VIS HEXAGONALE TORNIL. PARAFUSO SEXTAVADO	
18	8	7001631110 M10-NFE25511	WASHER UNTERLEGSCHIEBE ALUSLAATTA	RONDELLE ARANDELA ARRUELA	