



ASSEMBLY PROCEDURE

1. MAKE UP RESTRICTOR BLOCK ASSEMBLY (AS DRG.200001 SHT.1 OF 2)
2. MAKE UP ARGON TUBE ASSEMBLY (AS DRG.200001 SHT.1 OF 2)
3. MAKE UP PUMP WIRING ASSEMBLY (AS PER DRG.200001 SHT.1 OF 2)
4. ASSEMBLE PUMP & TUBE(120159) AS DRG.200001 SHT.1 OF 2
5. CUT AWAY 15MM LENGTH OF FLANGE ON MOULDING 200011 AS SHOWN.
6. PCB & RUBBER BEZEL ASSEMBLY
 - a. ASSEMBLE SELF ADHESIVE LABEL(200019) TO LED MOUNTING PLATE (200032)
 - b. ASSEMBLE (200032 INTO RUBBER BEZEL 200029)
 - c. POSITION THIS ASSEMBLY OVER LEDS & DISPLAY ON PCB A/200101 SEE DRG.200001 SHT.1 OF 2
7. LOCATE THIS ASSEMBLY IN HAND UNIT MOULDING (DRG.200011) ENSURE EDGE OF PCB LOCATES IN GROOVE IN MOULDING SIDE
8. ASSEMBLE 'O' RINGS (7/1046) 2 OFF INTO GROOVES ON DETECTOR ASSEMBLY A/200003
9. LOCATE DETECTOR ASSEMBLY IN MOULDING (DRG.200011) SEE DRG.200001 SHT.2 OF 2
10. ASSEMBLE SECURING RING (200030) OVER UMBILICAL CABLE ASSEMBLY THEN ASSEMBLE UMBILICAL CABLE TO MOULDING (DRG.200011) USING CABLE CLAMP (DRG.200034) & SCREWS 4/139 & WASHER 4/008. ON RIGHT HAND SIDE OF CLAMP MOUNT RESTRICTOR BLOCK ASSY AND THEN TRAP RED RING TAG UNDER FIXING SCREW SEE 200001 SHT 2 OF 2
11. TEMPORARILY FOLD BACK WIRES ON UMBILICAL TO ALLOW FREE ACCESS TO PIPE UP DETECTOR.
12. CONNECT ARGON PIPING TO DETECTOR AS PER SCHEMATIC DIAGRAM SEE DRG.200001 SHT 1 OF 1. NOTE POSITIONING OF RESTRICTOR (120034) SEE 200001 SHT 2 OF 2. ENSURE THAT TUBING IS NOT KINKED WHEN ASSEMBLED
13. CONNECT TUBING TO DETECTOR, RESTRICTOR BLOCK & PUMP AS SHOWN IN SCHEMATIC DIAGRAM 200001 SHT 1 OF 2. ENSURE TUBING IS NOT KINKED WHEN ASSEMBLED.
14. ASSEMBLE MEMBRANE SWITCH PANEL ASSY (200016) INTO SLOT IN MOULDING & ROUTE FLEXIBLE TAIL IN POSITION SHOWN ON DRG.200001 SHT 2 OF 2. CONNECT TAIL TO PL4 ON PCB.
15. TERMINATE REMAINING CABLES AS PER SCHEMATIC OF ELECTRICAL CONNECTIONS.
16. ASSEMBLE LEFT HAND MOULDING (200010) TO RH MOULDING USING SCREWS (7/3452) & WASHERS 4/009
17. SLIDE HANDLE ALONG UMBILICAL CABLE AND SCREW INTO MOULDING ASSEMBLY
18. AFFIX ADHESIVE LABELS TO MOULDING ASSEMBLY AS SHOWN. (SEE 200001 SHT. 2 OF 2)
19. ASSEMBLE 'O' RING(2/708) TO NOZZLE(120039) SEE DRG.200001 SHT 2 OF 2
20. ASSEMBLE MEMBRANE(197038) TO DETECTOR SEE DRG.200001 SHT 2 OF 2
21. ASSEMBLE NOSE CONE(200033) & NOZZLE ASSY. TO DETECTOR BODY SEE 200001 SHT 2 OF 2

ISSUE	A	B	1	2					
CHG.	-	-	-	-					
DATE	28/9/94	8/4/94	12/7/94	8/9/94					
CONFORMS TO	BS308		DIMS. IN mm. DO NOT SCALE PRINT	REMOVE ALL BURRS & SHARP EDGES	TOLERANCES UNLESS OTHERWISE STATED	WHOLE NUMBERS ±0.4 1 DECIMAL PLACE ±0.2 2 DECIMAL PLACE ±0.1	SCREW THREADS, MET. FIT ANGLES ±30°		
CHG.	SCALE 1 : 1								
DRAWN	DATE	28/9/93	FINISH						
R.LAND					TITLE HAND UNIT ASSY (SHT.2 OF 2)	ORG. L/200001-2			
AlCambridge Ltd		LONDON ROAD, PAMPISFORD, CAMBRIDGE, CB8 4EP. FAX: (0223) 838260			THIS GEAR MUST NOT BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT PERMISSION OF AL				
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