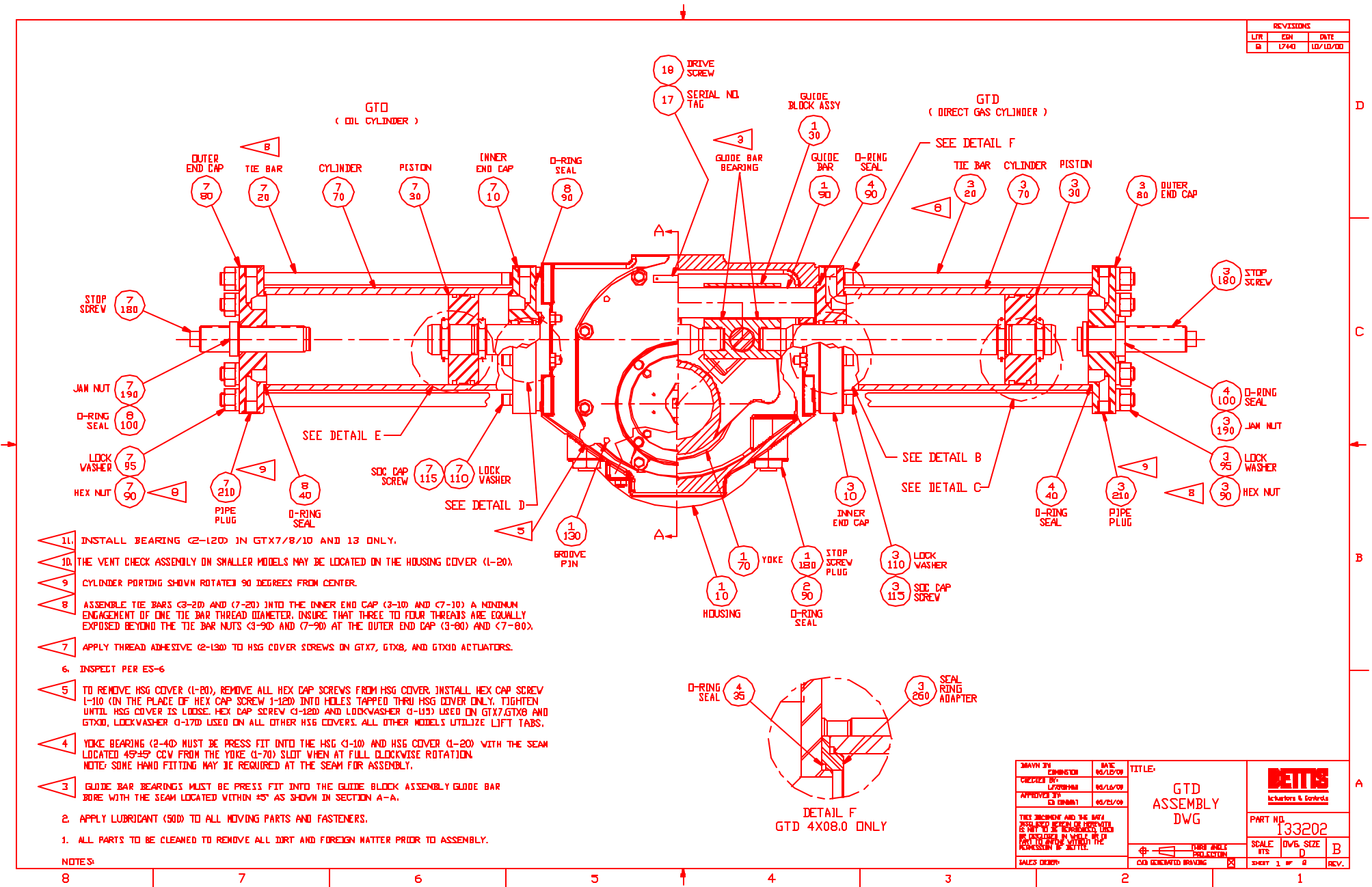


REVISIONS		
LTR	EDN	DATE
B	1744	10/10/00



- 11. INSTALL BEARING (2-120) IN GTX7/8/10 AND 13 ONLY.
- 10. THE VENT CHECK ASSEMBLY ON SMALLER MODELS MAY BE LOCATED ON THE HOUSING COVER (1-20).
- 9. CYLINDER PORTING SHOWN ROTATED 90 DEGREES FROM CENTER.
- 8. ASSEMBLE TIE BARS (3-20) AND (7-20) INTO THE INNER END CAP (3-10) AND (7-10) A MINIMUM ENGAGEMENT OF ONE TIE BAR THREAD DIAMETER. INSURE THAT THREE TO FOUR THREADS ARE EQUALLY EXPOSED BEYOND THE TIE BAR NUTS (3-90) AND (7-90) AT THE OUTER END CAP (3-80) AND (7-80).
- 7. APPLY THREAD ADHESIVE (2-180) TO HSG COVER SCREWS ON GTX7, GTX8, AND GTX10 ACTUATORS.
- 6. INSPECT PER ES-6
- 5. TO REMOVE HSG COVER (1-80), REMOVE ALL HEX CAP SCREWS FROM HSG COVER. INSTALL HEX CAP SCREW (1-110) (ON THE PLACE OF HEX CAP SCREW 1-120) INTO HOLES TAPPED THRU HSG COVER ONLY. TIGHTEN UNTIL HSG COVER IS LOOSE. HEX CAP SCREW (1-120) AND LOCKWASHER (1-115) USED ON GTX7, GTX8 AND GTX10. LOCKWASHER (1-170) USED ON ALL OTHER HSG COVERS. ALL OTHER MODELS UTILIZE LIFT TABS.
- 4. YOKE BEARING (2-40) MUST BE PRESS FIT INTO THE HSG (1-10) AND HSG COVER (1-20) WITH THE SEAM LOCATED 45°-45' CCW FROM THE YOKE (1-70) SLOT WHEN AT FULL CLOCKWISE ROTATION. NOTE: SOME HAND FITTING MAY BE REQUIRED AT THE SEAM FOR ASSEMBLY.
- 3. GUIDE BAR BEARINGS MUST BE PRESS FIT INTO THE GUIDE BLOCK ASSEMBLY GUIDE BAR BORE WITH THE SEAM LOCATED WITHIN ±5° AS SHOWN IN SECTION A-A.
- 2. APPLY LUBRICANT (500) TO ALL MOVING PARTS AND FASTENERS.
- 1. ALL PARTS TO BE CLEANED TO REMOVE ALL DIRT AND FOREIGN MATTER PRIOR TO ASSEMBLY.

NOTES:

DRAWN BY CHECKED BY APPROVED BY DATE 08/16/09 08/21/09	CONSTRUCTION DATE 08/16/09	TITLE: <b>GTD ASSEMBLY DWG</b>	
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SALES DEPT. <input checked="" type="checkbox"/> CAD GENERATED DRAWING	<input checked="" type="checkbox"/> THIRD ANGLE PROJECTION	SCALE NTS	DWG. SIZE D
SHEET 1 OF 8	REV.	B	B

