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REVISIONS

REV.	DESCRIPTION	DATE	APPROVED
B	SEE DCN: 7746	10/29/2010	<i>N.P.</i>

A

B

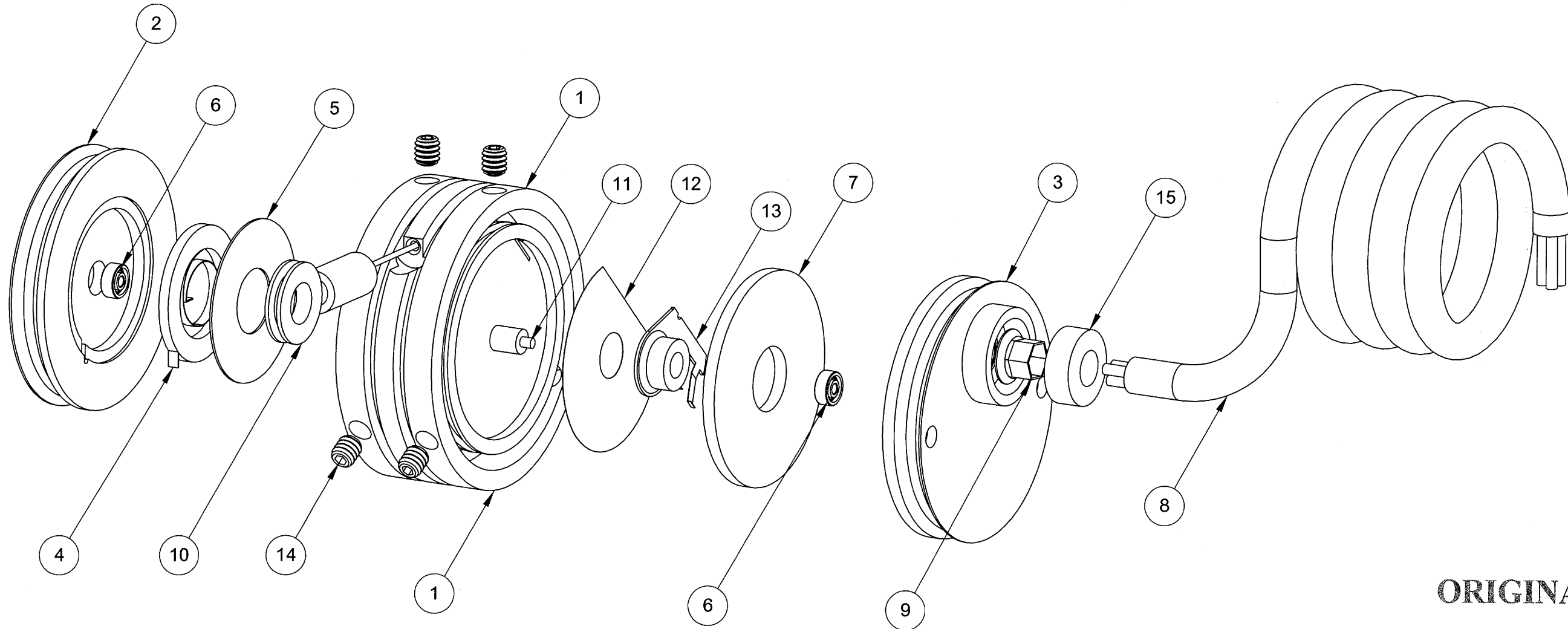
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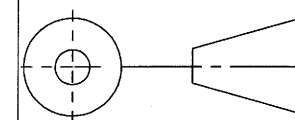
G



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THIRD ANGLE PROJECTION



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Transducer Products Inc.
20630 Plummer St
Chatsworth, CA, 91311
Tel: (818) 701-2750 Fax: (818) 701-2799
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TITLE
**ASSEMBLY DRAWING
MTA - 3"**

APPROVALS		DATE	SIZE	CODE IDENT. NO	DWG. NO.	REV
DRAWN	E.GARCIA	1/30/2009	B	52158	PS-152	B
CHKD	<i>MSK</i>	2/31/11				
DO NOT SCALE DRAWING			SCALE: 2:1		SHEET 1 OF 10	

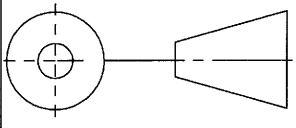
		1	2	3	4	5	6	7	8	9	10			
A	TABLE 1													
	ITEM NO	OPTIONS									QTY			
		3	3A	E	L	W	C							
	②	9678120-0000	9679037-0000	-	-	-	-				1			
	④	9678125-0000	9679036-0000	-	-	-	-				1			
	⑪	9678121-0000	9679038-0000	-	-	-	-				1			
	③	-	-	-	-	9678778-0000	9670114-0000				1			
	⑨	-	-	-	-	-	9000400-0170				1			
⑧	-	-	-	-	-	9000141-0030				3.5 FT				
B	⑩	-	-	CK603874-0003	CK603935-0003	-	-				1			
	C													
		D												
			E											

F	15	9000010-0052	ADHESIVE,EPOXY, ECCOBOND 286	1
	14	9650444-0038	SSCR,CRES,0.112-40 X .12 SKT HD	6
	13	9085000-0020	WIPER,1 TURN,5K OHM,MTA	1
	12	9678122-0000	DISK,INSULATING,TAPE,MTA	1
	11	SEE TABLE 1	SPOOL,ALUM,3 INCH,MTA	1
	10	SEE TABLE 1	KIT,CABLE,Ø0.024	1
	9	SEE TABLE 1	EYELET FOR "C" OPTION ONLY	1
	8	SEE TABLE 1	ELECTRICAL CONNECTION	1
	7	9085000-0027	ELEMENT,1 TURN,5K OHM,MTA	1
	6	9000410-0020	BEARING,BALL,.047 X .156	2
	5	9678127-0001	DISK,SPRING,.01THK,MTA	1
	4	SEE TABLE 1	POWER SPRING, MTA	1
	3	SEE TABLE 1	PLATE,POT SIDE,MTA-3	1
	2	SEE TABLE 1	PLATE,SPRING SIDE	1
	1	9678124-0000	HOUSING,SPOOL,ALUM,MTA-3	1
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	

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Transducer Products Inc.

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MTA - 3"

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DRAWN	E.GARCIA	1/30/2009	B	52158	PS-152	B
CHKD	WSK	3/31/11	SCALE: 3:2		SHEET 2 OF 10	

DO NOT SCALE DRAWING

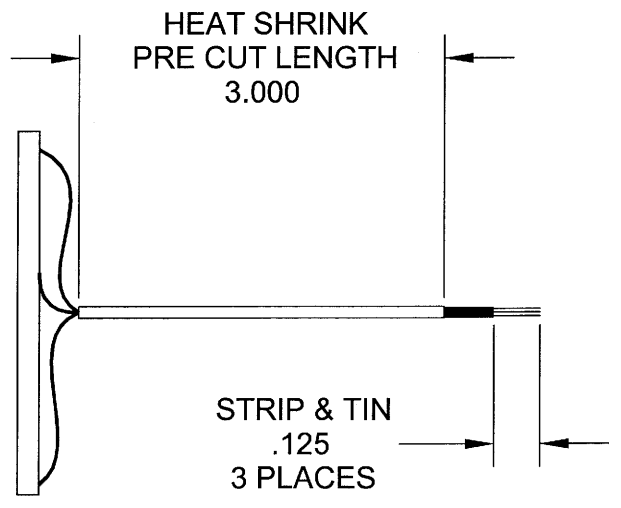
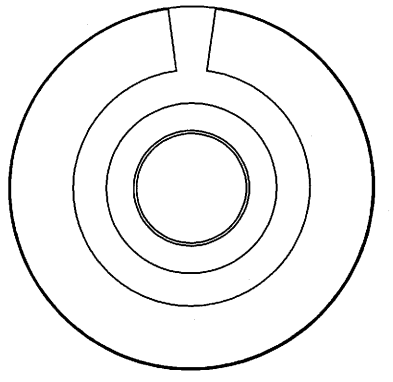
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STEP 1: RESISTIVE ELEMENT PREPARATION

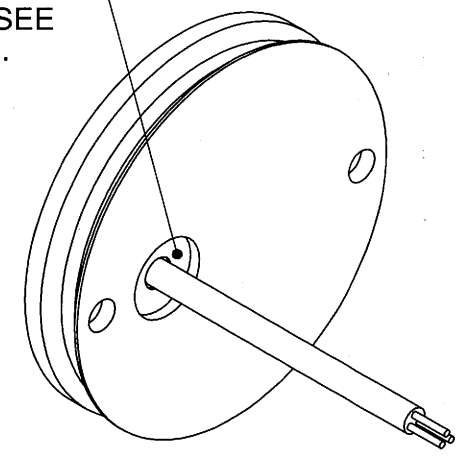
OPTION W:

- SLIDE SHRINK TUBING, P/N 9000320-0012, OVER ELEMENT WIRES. PLACE TUBING AS CLOSE TO THE ELEMENT AS POSSIBLE.
- SHRINK TUBING WITH HEAT GUN.
- STRIP CONDUCTORS TO THE DIMENSION SHOWN.

RESISTIVE ELEMENT



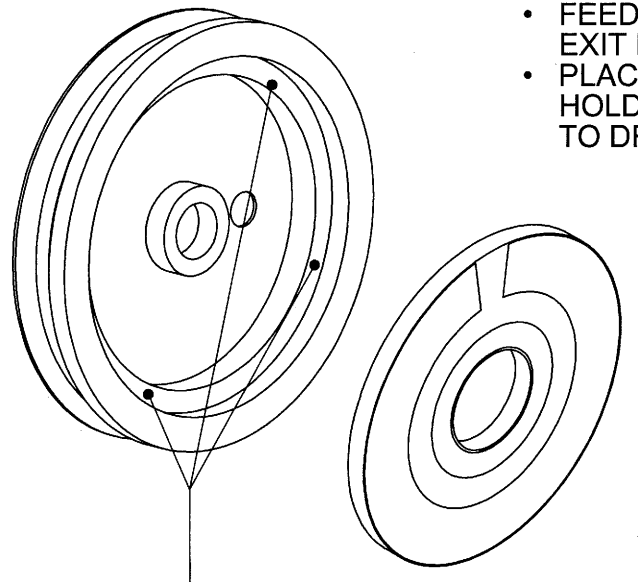
STEP 3: STRAIN RELIEF APPLICATION
FILL CAVITY WITH ECCOBOND 286, SEE MIXING INSTRUCTIONS ON SHEET 5.



STEP 2: ELECTRICAL CONNECTION

OPTION W:

- APPLY DOW CORNING RTV 732 TO THE INSIDE OF THE ELEMENT HOUSING AS NOTED.
- FEED RESISTIVE ELEMENT WIRES THRU THE EXIT HOLE.
- PLACE RESISTIVE ELEMENT ON THE RTV AND HOLD IN PLACE WITH A CLAMP AND ALLOW TO DRY FOR 1 HOUR MINIMUM.



PLACE RTV ON THIS SURFACE

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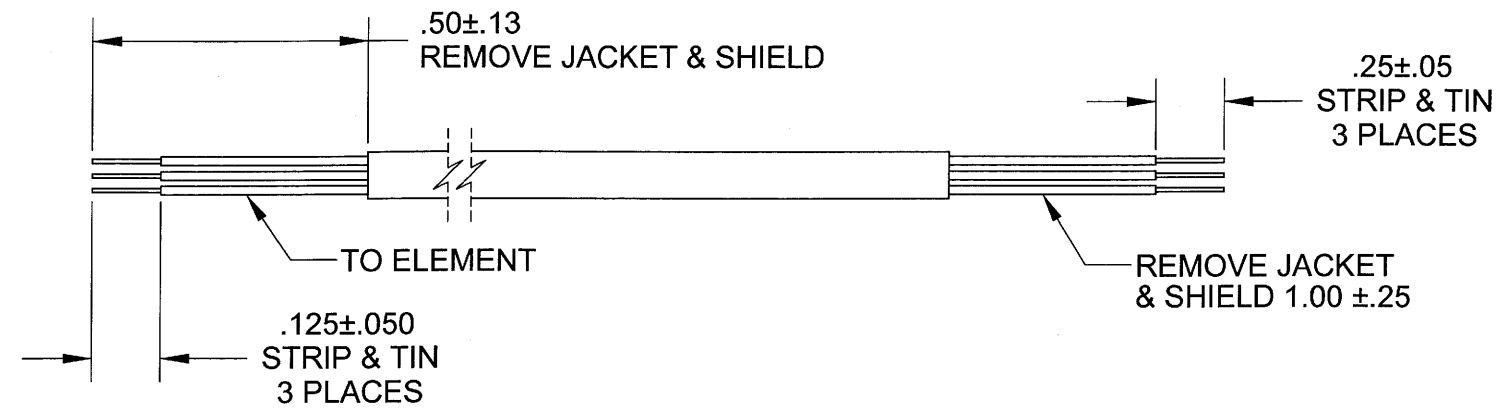
TITLE
**ASSEMBLY DRAWING
MTA - 3"**

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DRAWN E.GARCIA		1/30/2009	B	52158	PS-152	B
CHKD WSR		3/31/11	DO NOT SCALE DRAWING		SCALE: 3:2	SHEET 3 OF 10

ELECTRICAL CONNECTION

OPTION C - STEP 1:

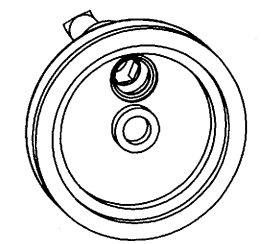
- TRIM ELECTRICAL CABLE & ELEMENT LEADS AS SHOWN.



ELECTRICAL CONNECTION

OPTION C: - STEP 3

- SECURE THE EYELET TO THE HOUSING USING LOCTITE 401.



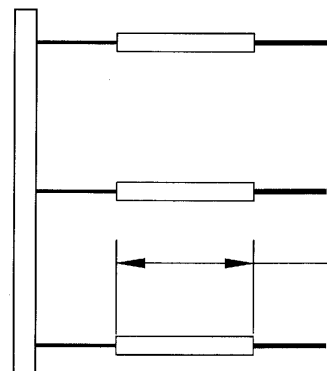
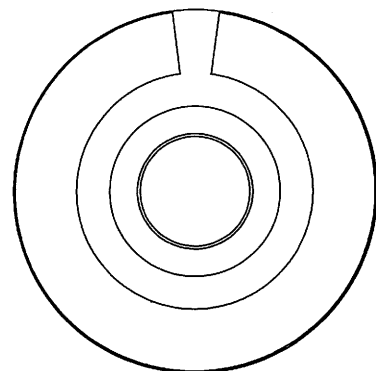
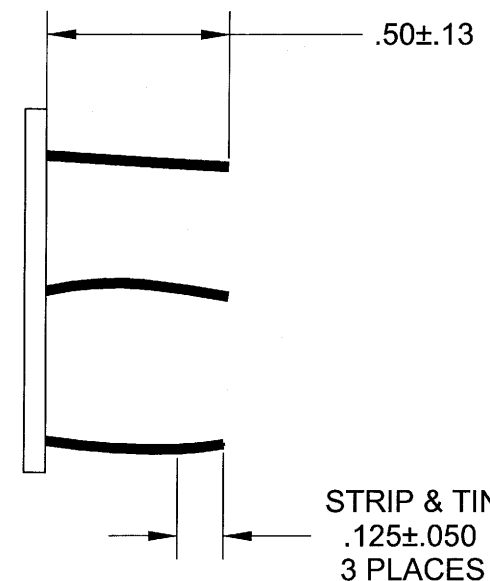
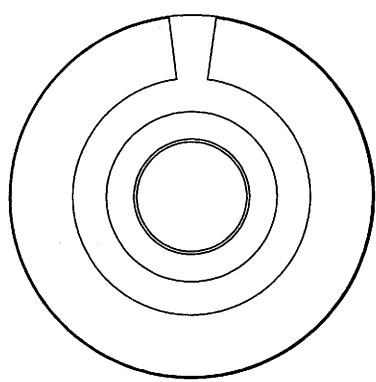
ELECTRICAL CONNECTION

OPTION C - STEP 4:

- SOLDER ELECTRICAL CABLE TO THE ELEMENT LEADS PER TABLE 2.
- USE .375 LONG PIECE OF HEAT SHRINK, 9000200-0023 TO SEAL CONNECTION.

RESISTIVE ELEMENT

RESISTIVE ELEMENT



PRE-SHRINK CUT LENGTH
.375±.125

ELECTRICAL CONNECTION

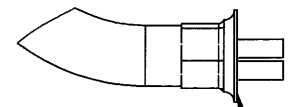
OPTION C: - STEP 5

- APPLY DOW CORNING RTV TO THE INSIDE OF THE ELEMENT HOUSING AS NOTED.
- PLACE RESISTIVE ELEMENT ON THE RTV (ENSURE THE HEAT SHRINK PORTION REMAINS IN THE HOUSING)
- HOLD ELEMENT IN PLACE WITH A CLAMP AND ALLOW TO DRY FOR 1 HOUR MINIMUM.
- FILL CAVITY WITH ECCOBOND 286, SEE MIXING INSTRUCTIONS ON SHEET 5.

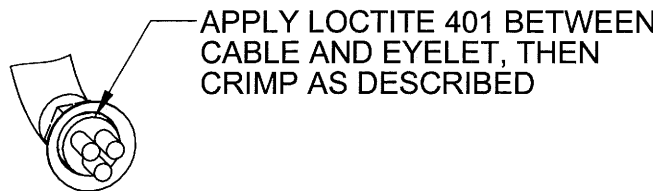
ELECTRICAL CONNECTION

OPTION C - STEP 2:

- SLIDE THE ELEMENT HOUSING OVER THE CABLE BEFORE THE EYELET AND ALIGN JACKET WITH FLANGE, SEE VIEW BELOW.
- SECURE THE CABLE TO THE EYELET USING LOCTITE 401, ALLOW TO DRY.
- USING SAVA CRIMPING PLIERS, T-185 POSITION "C", SECURE THE EYELET TO THE ELECTRICAL CABLE.

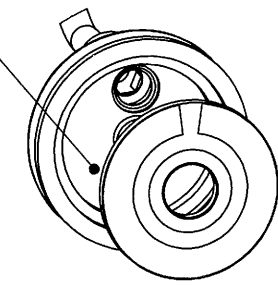


ALIGN JACKET TO
EDGE OF FLANGE



APPLY LOCTITE 401 BETWEEN
CABLE AND EYELET, THEN
CRIMP AS DESCRIBED

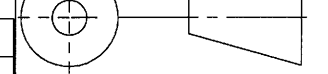
APPLY RTV ON
THIS SURFACE



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APPROVALS		DATE
DRAWN	E.GARCIA	1/30/2009
CHKD	MSL	3/31/11



Transducer Products Inc.

ELEMENT WIRE COLOR	ELECTRICAL CABLE COLOR
ORANGE	BLACK
BROWN	RED
RED	GREEN

TITLE			
ASSEMBLY DRAWING			
MTA - 3"			
SIZE	CODE IDENT. NO	DWG. NO.	REV
B	52158	PS-152	B
SCALE: 3:2		SHEET 4 OF 10	

A

MIXING INSTRUCTIONS:

- USE CONNECTOR COVER 9640087-0004 AS A MIXING BOWL, OR EQUIVALENT.
- MIX INTO THE CONNECTOR COVER, EQUAL PARTS OF ECCOBOND 286, CELESCO P/N: 9000010-0052.
- USE A TAPERED SYRINGE, CELESCO P/N: 9650732-0000, TO DISPENSE INTO THE CAVITY AS SHOWN.
- KEEP LEVEL AT LEAST FOR THE FIRST 30 MIN TO KEEP EPOXY FROM RUNNING OUT.
- ALLOW TO CURE AT LEAST 24 HOURS BEFORE HANDLING.

B

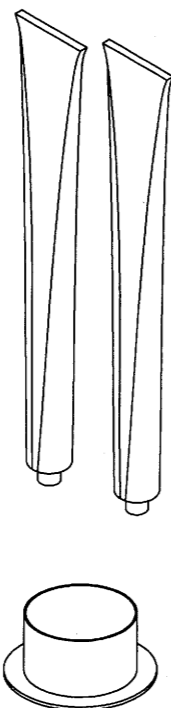
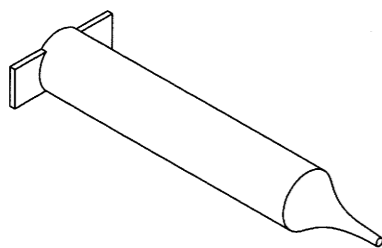
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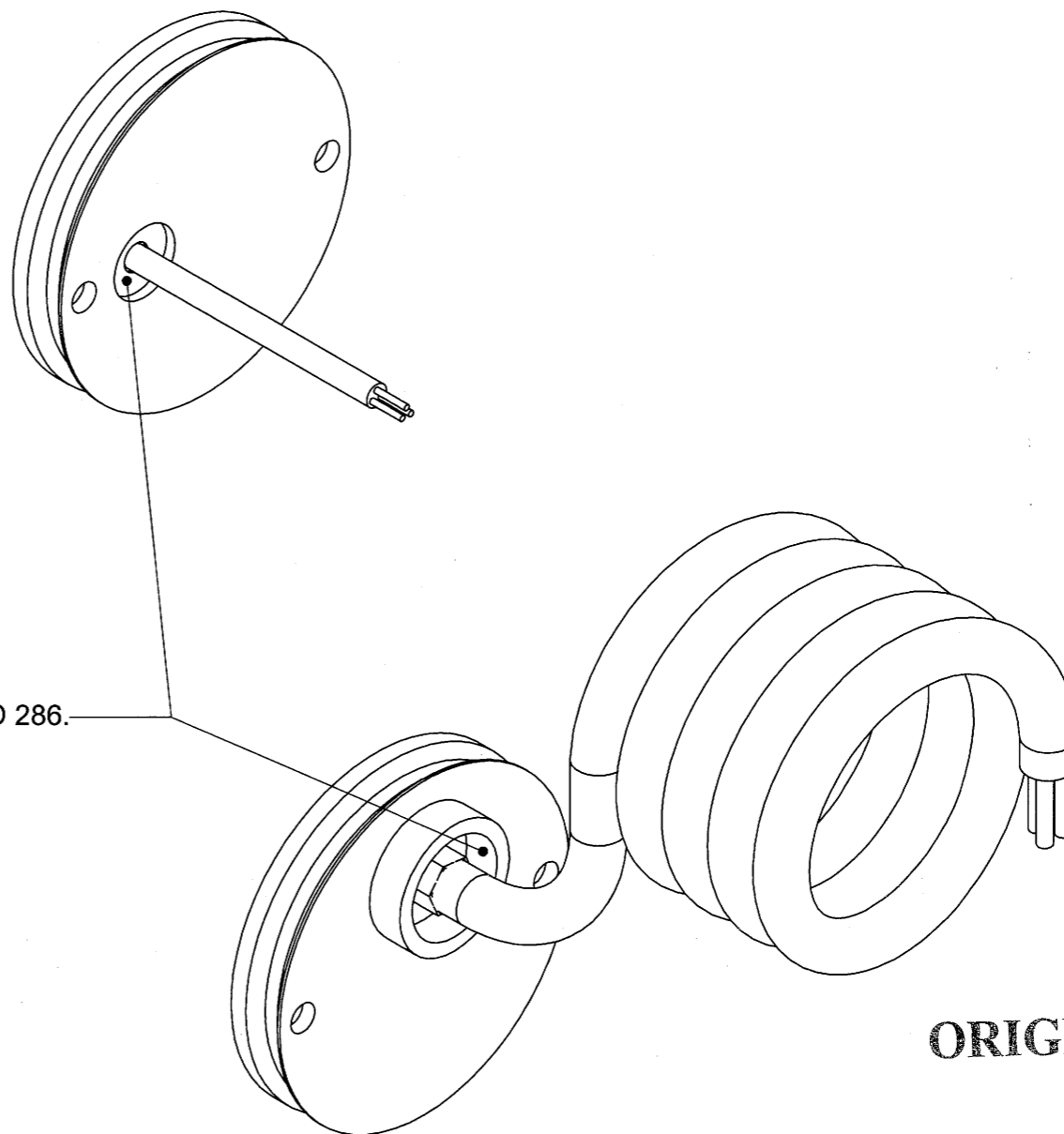
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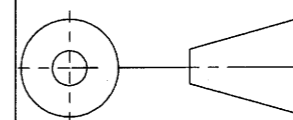
FILL CAVITY WITH ECCOBOND 286.



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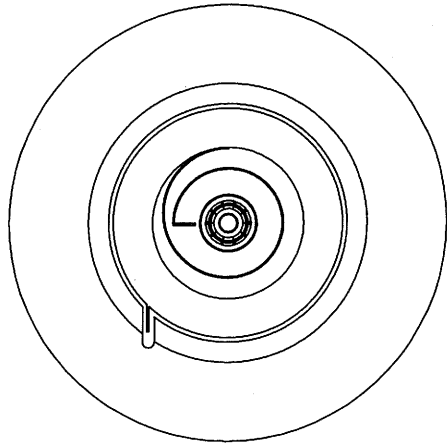
TITLE
**ASSEMBLY DRAWING
 MTA - 3"**

APPROVALS		DATE	SIZE	CODE IDENT. NO	DWG. NO.	REV
DRAWN E.GARCIA		1/30/2009	B	52158	PS-152	B
CHKD <i>MSK</i>		3/31/11	DO NOT SCALE DRAWING		SCALE: 2:1	SHEET 5 OF 10

ASSEMBLY

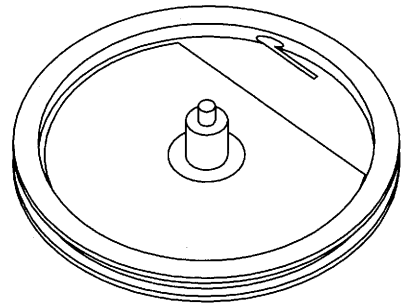
STEP 1 SPRING INSTALLATION

- INSERT BEARING INTO SPRING HOUSING.
- INSERT SPRING INTO HOUSING AS SHOWN.
- APPLY 2 DROPS OF SILICONE OIL, 9000000-00001, USING DISPENSER 9650601-0000.



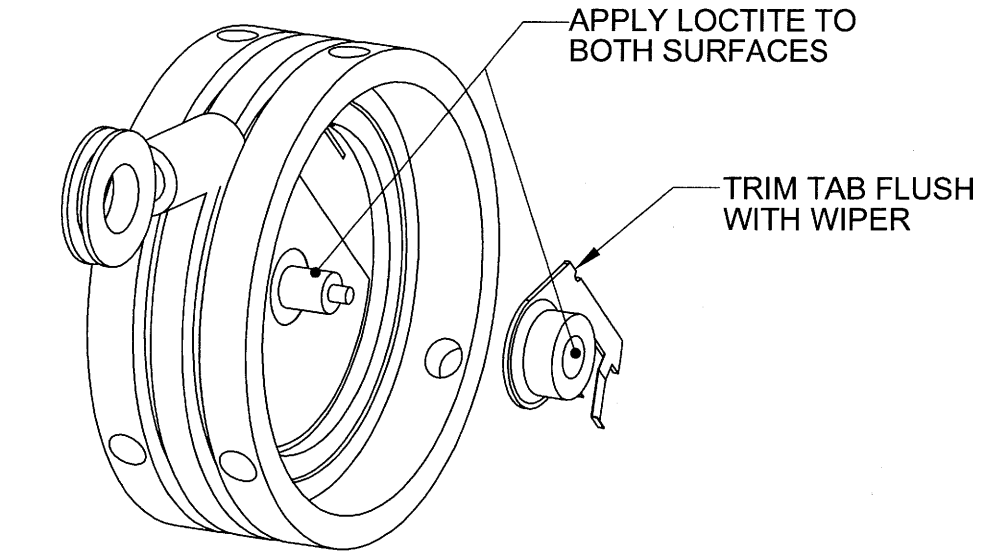
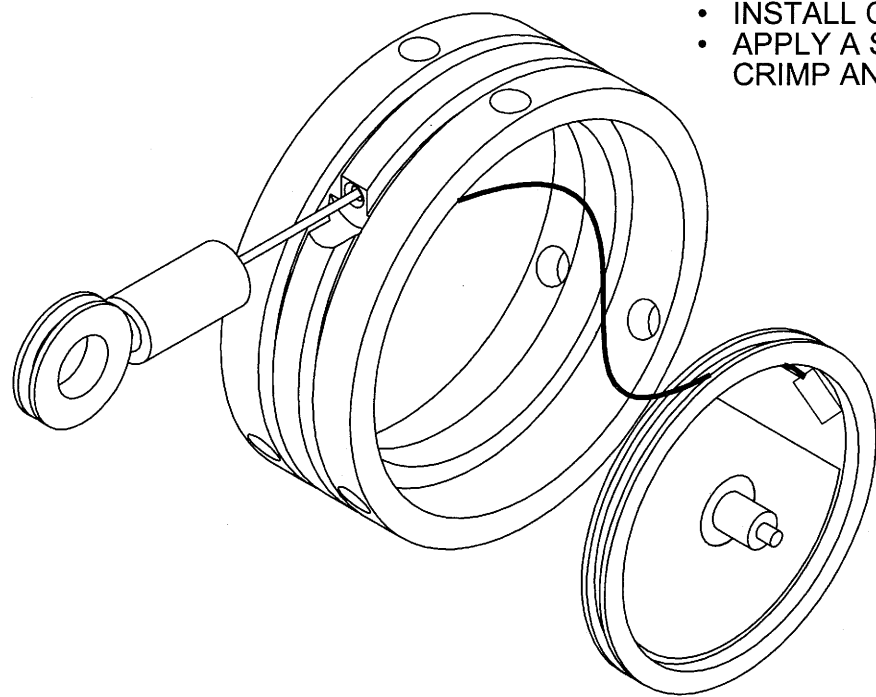
STEP 2 INSULATING DISK INSTALLATION

- INSTALL INSULATING DISK TAPE ON SPOOL AS SHOWN.
- ALIGN FLAT OF DISK, PARALLEL, WITH CABLE EXIT HOLE.



STEP 3 CABLE SUB ASSEMBLY INSTALLATION

- INSTALL CRIMP PER CABLE ASSEMBLY DRAWING.
- APPLY A SMALL DROP OF LOCTITE 401 BETWEEN THE CRIMP AND THE SPOOL, ENSURING IT LAYS FLAT.

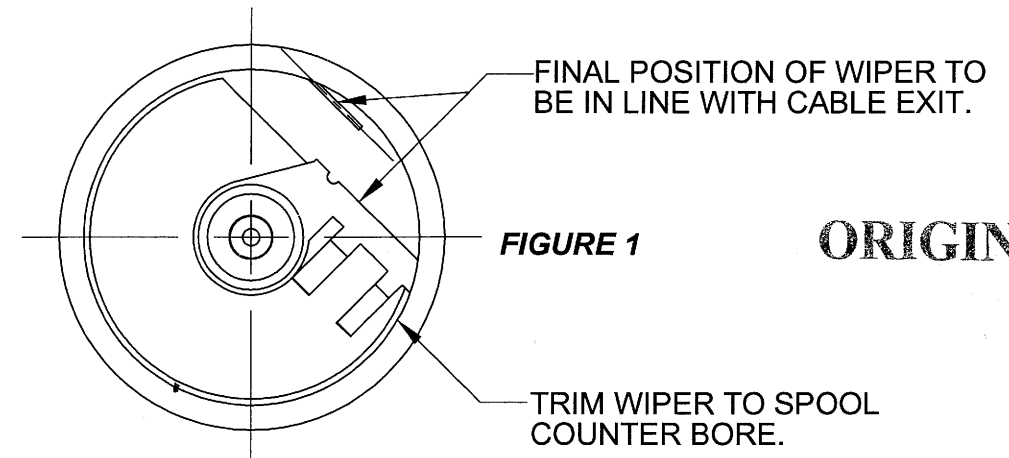


APPLY LOCTITE TO BOTH SURFACES

TRIM TAB FLUSH WITH WIPER

STEP 4 WIPER INSTALLATION

- PLACE WIPER ON SPOOL HUB AND TRIM WIPER TO INSIDE OF SPOOL COUNTER BORE, SEE FIGURE 1.
- AFTER TRIMMING, CLEAN SPOOL HUB AND WIPER BORE WITH ISOPROPYL ALCOHOL, ALLOW TO DRY.
- USING A PINK LOCTITE DISPENSER, P/N: 9650602-0001, APPLY 2 DROPS OF LOCTITE AROUND THE SPOOL HUB AND INSIDE THE ELEMENT BORE.
- ****FINAL POSITION OF WIPER TO BE IN LINE WITH CABLE EXIT HOLE, SEE FIGURE 1**.**



FINAL POSITION OF WIPER TO BE IN LINE WITH CABLE EXIT.

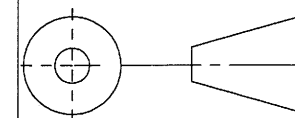
FIGURE 1

ORIGINAL

TRIM WIPER TO SPOOL COUNTER BORE.

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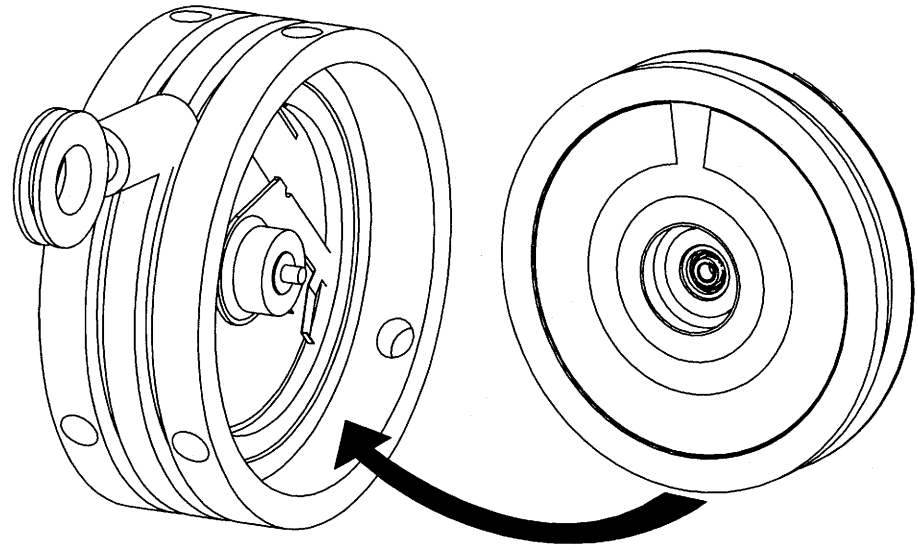


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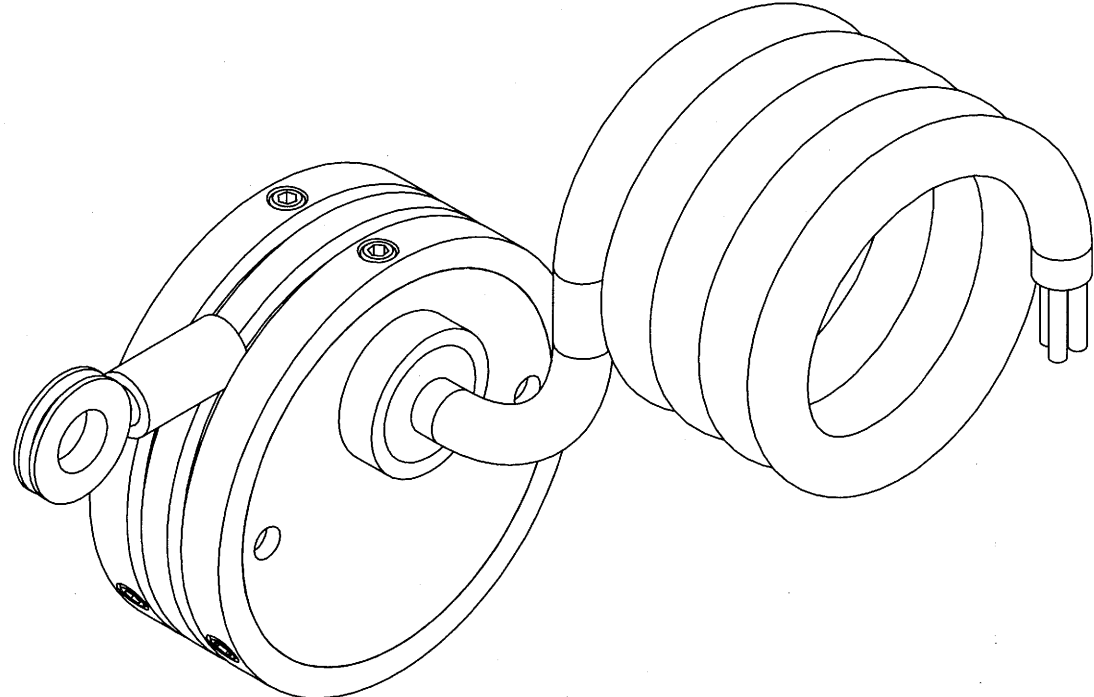
APPROVALS		DATE	SIZE	CODE IDENT. NO	DWG. NO.	REV
DRAWN	E.GARCIA	1/30/2009	B	52158	PS-152	B
CHKD	<i>MSK</i>	<i>3/31/11</i>				
DO NOT SCALE DRAWING			SCALE: 2:1		SHEET 6 OF 10	

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B
C
D
E
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STEP 5 ELEMENT ASSEMBLY INSTALLATION

- PREPARE 3 SET SCREWS FOR INSTALLATION USING LOCTITE PRIMER 7649, ALLOW TO DRY.
- INSERT THE BEARING INTO THE ELEMENT HOUSING, CHECK THAT THE BEARING ROTATES FREELY.
- SLIGHTLY SECURE THE ELEMENT TO THE SPOOL HOUSING WITH THE SET SCREWS.

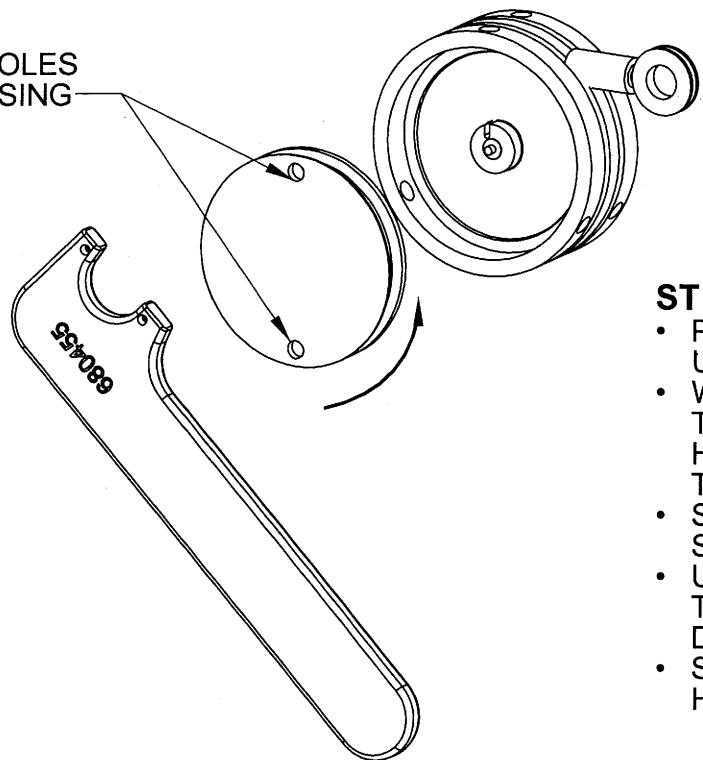


STEP 7 OUTPUT ADJUSTMENT

- USING A DVM, POWER SUPPLY SET TO 10.000 ±.001 VDC AND WIRED PER TABLE 3, ROTATE THE ELEMENT HOUSING TO ACHIEVE AN OUTPUT OF .04 - .06 VDC.
- SECURE ELEMENT HOUSING TO THE SPRING HOUSING, USE LOCTITE 222 ON THE THREE SCREWS.

ORIGINAL

USE SPANNER HOLES TO ROTATE HOUSING



STEP 6 SPRING ASSEMBLY INSTALLATION

- PREPARE 3 SET SCREWS FOR INSTALLATION USING LOCTITE PRIMER 7649, ALLOW TO DRY.
- WITH THE CABLE FULLY RETRACTED, INSERT THE SPRING ASSEMBLY INTO THE SPOOL HOUSING AND ENGAGE THE SPOOL ARBOR WITH THE SPRING HOOK.
- SLIGHTLY TIGHTEN THE SCREWS TO HOLD THE SPRING HOUSING IN PLACE.
- USING SPANNER WRENCH PN: 680455 ROTATE THE SPRING HOUSING 2.5 ± .5 TURNS IN THE DIRECTION INDICATED.
- SECURE THE SPRING HOUSING TO THE SPOOL HOUSING USING LOCTITE 222 ON ALL 3 SCREWS.

TABLE 3		
FUNCTION	ELEMENT WIRE OPTION	ELECTRICAL CABLE OPTION
+ INPUT	BROWN	RED
COMMON	ORANGE	BLACK
+ SIGNAL	RED	GREEN

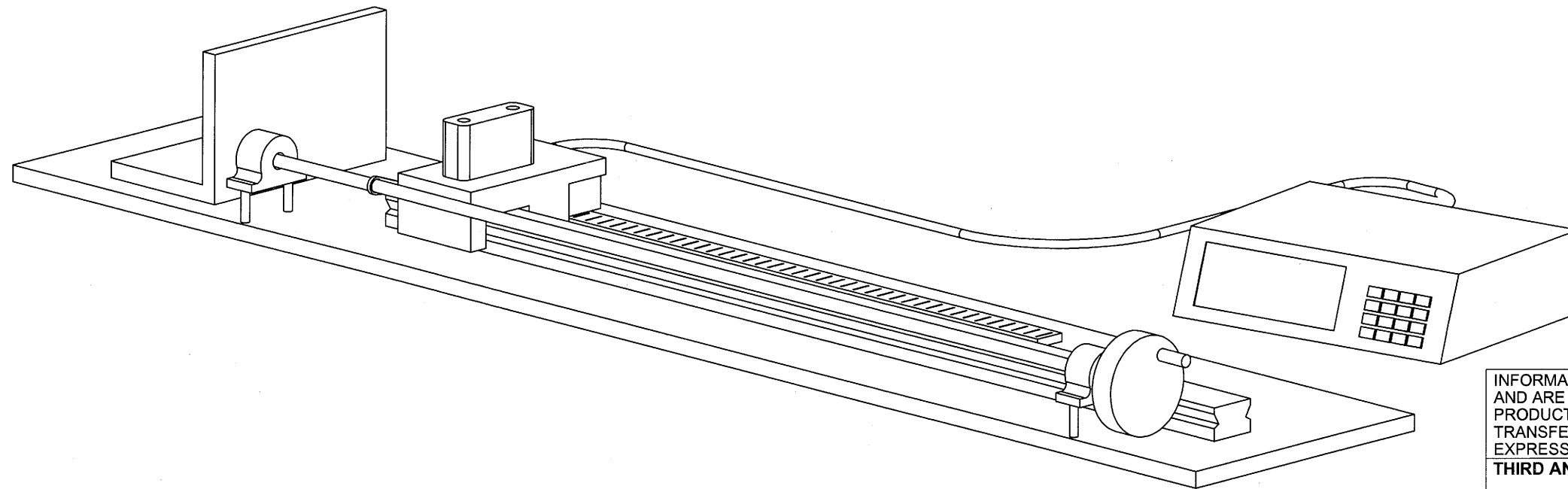
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TITLE ASSEMBLY DRAWING MTA - 3"					
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CHKD MSK	3/31/11	DO NOT SCALE DRAWING		SCALE: 2:1	SHEET 7 OF 10

ACCEPTANCE TEST PROCEDURE

- USING THE TEST FIXTURE CI3034 AND THE HARNESS LABELED "PT101", ENTER THE DATA PER THE SEQUENCE NUMBER IN TABLE 4 INTO THE TEST DATA COMPUTER. REFER TO TABLE 5 FOR LIMITS.

TABLE 4		
CABLE POSITION % F.S.	OUTPUT DURING EXTENSION	OUTPUT DURING RETRACTION
0%	#1	#22
10%	#2	#21
20%	#3	#20
30%	#4	#19
40%	#5	#18
50%	#6	#17
60%	#7	#16
70%	#8	#15
80%	#9	#14
90%	#10	#13
100%	#11	#12

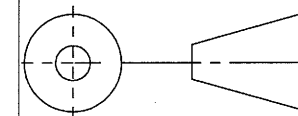


ORIGINAL

TABLE 5	
ACCEPTANCE TEST LIMITS	
0% F.S.	0.03-0.08 VDC
100% F.S.	9.30-10.00 VDC
%F.S. ACCURACY	±.4%

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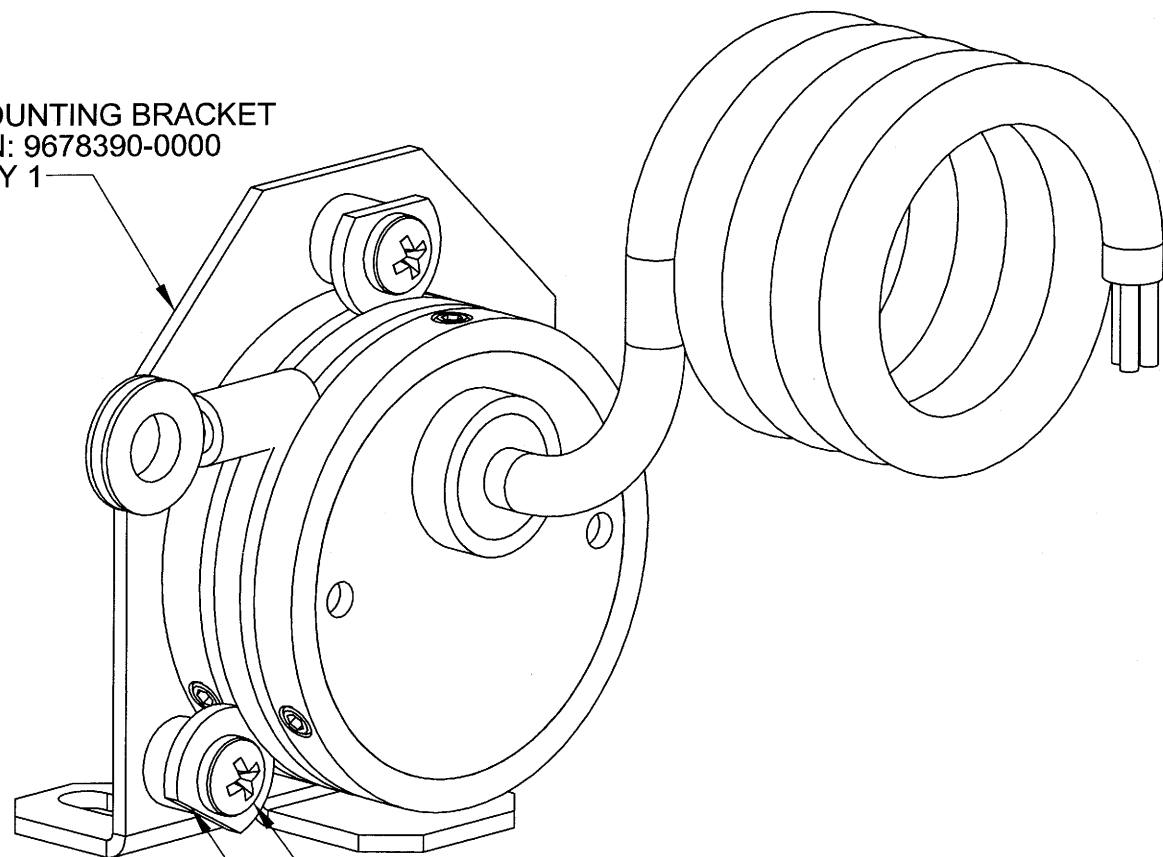
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CHKD <i>MSK</i>	3/31/11				
DO NOT SCALE DRAWING		SCALE: 1:4		SHEET 8 OF 10	

A

MOUNTING BRACKET OPTION

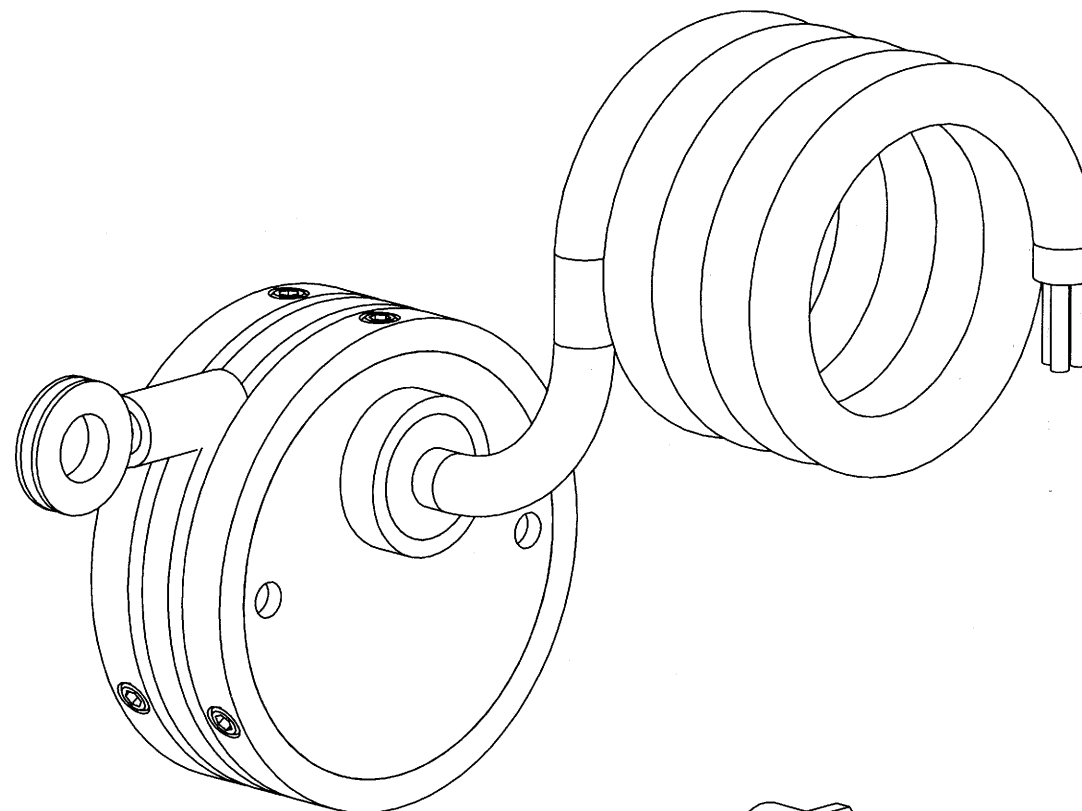
MOUNTING BRACKET
P/N: 9678390-0000
QTY 1



SERVO CLAMP
P/N: 9000400-0133
QTY 3

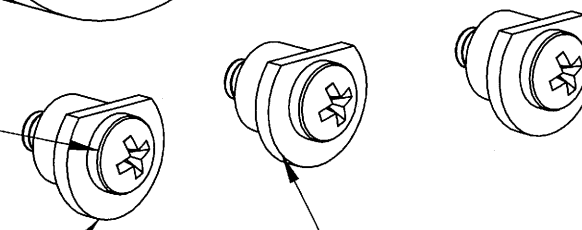
PAN HEAD SCREW
P/N: 9650444-0092
QTY 3

SERVO CLAMP OPTION



PAN HEAD SCREWS
P/N: 9650444-0092
QTY 3

SERVO CLAMP
P/N: 9000400-0133
QTY 3



ORIGINAL

PLACE CLAMPS AND SCREWS IN A PLASTIC BAG PRIOR TO SHIPPING; ATTACH TO UNIT.

B

C

D

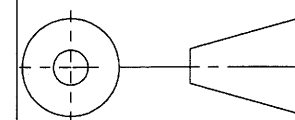
E

F

G

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THIRD ANGLE PROJECTION



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TITLE
**ASSEMBLY DRAWING
MTA - 3"**

APPROVALS		DATE	SIZE	CODE IDENT. NO	DWG. NO.	REV
DRAWN	E.GARCIA	1/30/2009	B	52158	PS-152	B
CHKD	<i>MSK</i>	3/31/11				
DO NOT SCALE DRAWING			SCALE: 2:1		SHEET 9 OF 10	



DRAWING CHANGE NOTICE

DRAWING NO. **PS-152** REV. **B**

SHEET 10 OF 10

DISPOSITION OF PARTS	USE AS IS	MUST CONFORM	PART NAME ASSEMBLY DRAWING			DCN NO. 7746		
IN FABRICATION		X	ENGINEERING APPROVAL			COPIES TO	YES	NO
IN STOCK		X		SIGNATURE	DATE	ENGINEERING	X	
BOXED PARTS	X		PREPARED BY	E.GARCIA	10/29/2010	INSPECTION	X	
IN ASSEMBLIES	X		CHECKED BY	<i>MSK</i>	3/31/11	PLANNING	X	
IN BOND	X		APPROVED	<i>N.O.</i>	3/31/11	PRODUCTION	X	
CUSTOMER REWORK		X	GEN MGR	X	X	PURCHASING	X	
			DCR NO. (IF APPLICABLE)	0000		QMR	X	
						SALES	X	

CHANGE NO	REVISED OR CHANGED FROM	SHEET / ZONE	ADDED OR CHANGED TO
1	REVISED STRAIN RELIEF INSTRUCTIONS.	5	CHANGED HOUSING FOR "C" OPTION
2	ADD ACCEPTANCE TEST SHEET	8	ADDED FOR COMPLETENESS
3	REVISED ORDER OF OPERATION	4	
4	"ROTATE SPRING HOUSING THREE FULL TURNS"	5/G5	"ROTATE THE SPRING HOUSING 2.5 ± .5 TURNS"
5	.75 ± .25	SH4/ A4	REMOVED DUAL DIMENSION
6	SHIM: P/N: 9678296-0000	SH3/ F2	REMOVED SHIM FROM DRAWING. SHIM IS NO LONGER USED.
7	ADHESIV,EPOXY	SH2/ E3/	ADHESIVE,EPOXY
8	DISK, INSULATING,MTA	SH2/ F3	DISK,INSULATING,TAPE,MTA
9	CHANGED VIEW OF SPRING ASSEMBLY	SH6/ B2	TO SHOW DIRECTION OF SPRING INSTALLATION
10	TO BE 180° FROM CABLE	SH6/ D9	TO IN LINE WITH CABLE

NOTES: OPTION "C" ELEMENT HOUSING DESIGN CHANGE REQUIRES ADDITIONAL STRAIN RELIEF

REMARKS: REVISED ORDER OF OPERATION TO ALLOW FOR EASE OF ASSEMBLY. CHANGED SPRING TURNS TO ALLOW FOR A TOLERANCE BETWEEN 2-3 TURNS. CABLE EXTENSION IS SMOOTHER WITH 2 TURNS. CHANGED DESCRIPTION ON TWO ITEMS IN BOM. CHANGED LANGUAGE OF WIPER INSTALLATION FOR CLARITY.

ORIGINAL