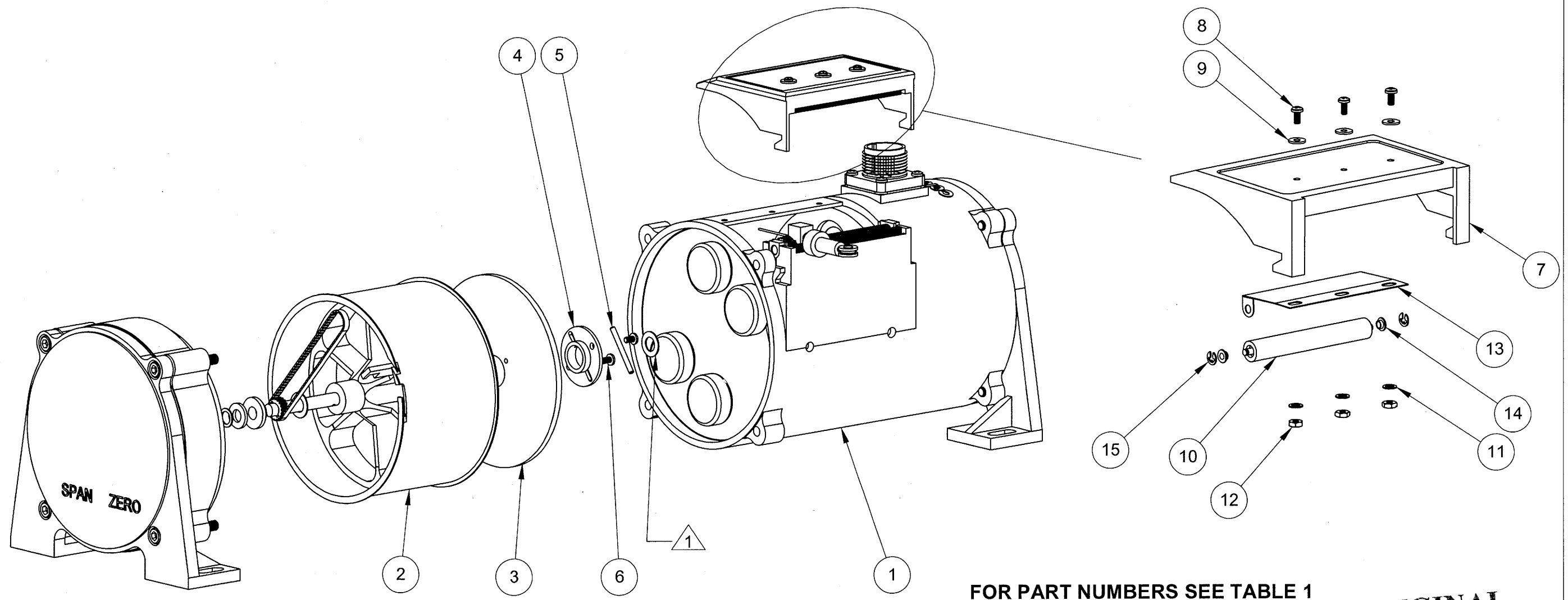


REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
E	SEE DCN: 7336	1/25/2010	

A  
B  
C  
D  
E



FOR PART NUMBERS SEE TABLE 1

**ORIGINAL**

- F 2. ASSEMBLE USING PS-119 FOR DETAILS NOT SHOWN ON THIS DRAWING.
- G 1. INSTALL ONE WASHER P/N 900330A-6005 BETWEEN SPOOL AND HOUSING. AFTER FINAL ASSEMBLY, TEST VELOCITY BY EXTENDING THE CABLE AND RELEASING IT. USE A STOP WATCH TO RECORD THE TIME IT TOOK TO FULLY RETRACT. TO CALCULATE VELOCITY, TAKE THE RANGE OF THE TRANSDUCER AND DIVIDE IT BY THE TIME IT TOOK FOR THE CABLE TO RETRACT.
- a. IF CABLE RETRACTION IS TOO FAST (OVER 55 INCHES PER SECOND), REPLACE .020 THICK WASHER WITH P/N 9000400-0171 (.010 THICK) AND RETRY.
  - b. IF CABLE RETRACTION IS TOO SLOW (UNDER 40 INCHES PER SECOND), ADD WASHER P/N 9000400-0185 (.005 THICK) AND RETRY.

NOTES: UNLESS OTHERWISE SPECIFIED

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**celesco**  
Transducer Products Inc.

THIRD ANGLE PROJECTION

TITLE  
**VLS9000 ASSEMBLY DRAWING  
RANGES 75 TO 550 INCHES**

APPROVALS		DATE	SIZE	CODE IDENT. NO	DWG. NO.	REV
DRAWN	M.KRATOFIL	12/12/2006	B	52158	PS-120	E
CHKD		1/25/10	SCALE: 1:2		SHEET 1 OF 4	

DO NOT SCALE DRAWING

1 2 3 4 5 6 7

A

B

C

D

E

F

G

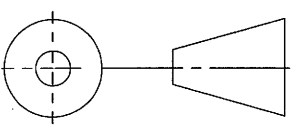
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
-	See Sheet1	-	-

TABLE 1				
ITEM NO.	DESCRIPTION	ALUMINUM	STAINLESS STEEL	QTY
1	SUBASSY,4 MAGNET,VLS9000	9604215-0000	9604215-0001	1
2	SPOOL,MODIFIED,VLS9000	9679581-0000	9678742-0000	1
3	DISK, COPPER, VLS9000	9679495-0000		1
4	PLATE, DISK MOUNTING,VLS9000	9679486-0000		1
5	PIN, DOWEL, $\phi$ 0.093 X 1.00 LONG	9015030-0002		1
6	SCREW,PAN HEAD MACHINE, 4-40 X 0.19 LONG	9650444-0125		2
7	COVER,CABLE,MODIFIED,VLS9000	9679715-0000	9678741-0000	1
8	SCREW,PAN HEAD MACHINE,2-56 X 0.19 LONG	9650444-0070		3
9	WASHER, PLAIN, CRES, $\phi$ 0.086	9650444-0071		3
10	CABLE TENSION ROLLER,CRES	9679713-0000		1
11	WASHER,LOCK,CRES,0.086 INTERNAL STAR	9650444-0222		3
12	NUT,CRES,0.086-56 HEX	9650444-0073		3
13	SPRING,FLAT,CABLE,VLS9000	9679716-0000		1
14	BUSHING,FLANGED,SHAFT,BRONZE	9679714-0000		2
15	RETAINING RING,EXT,0.094 DIA	9000460-0013		2

**ORIGINAL**

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TITLE  
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RANGES 75 TO 550 INCHES**

APPROVALS	DATE	SIZE	CODE IDENT. NO	DWG. NO.	REV
DRAWN M.KRATOFIL	12/12/2006	B	52158	PS-120	E
CHKD <i>MSL</i>	<i>1/24/07</i>	DO NOT SCALE DRAWING		SCALE: 1:2	SHEET 2 OF 4

1

2

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REVISIONS

REV.	DESCRIPTION	DATE	APPROVED
-	See Sheet1	-	-

A

B

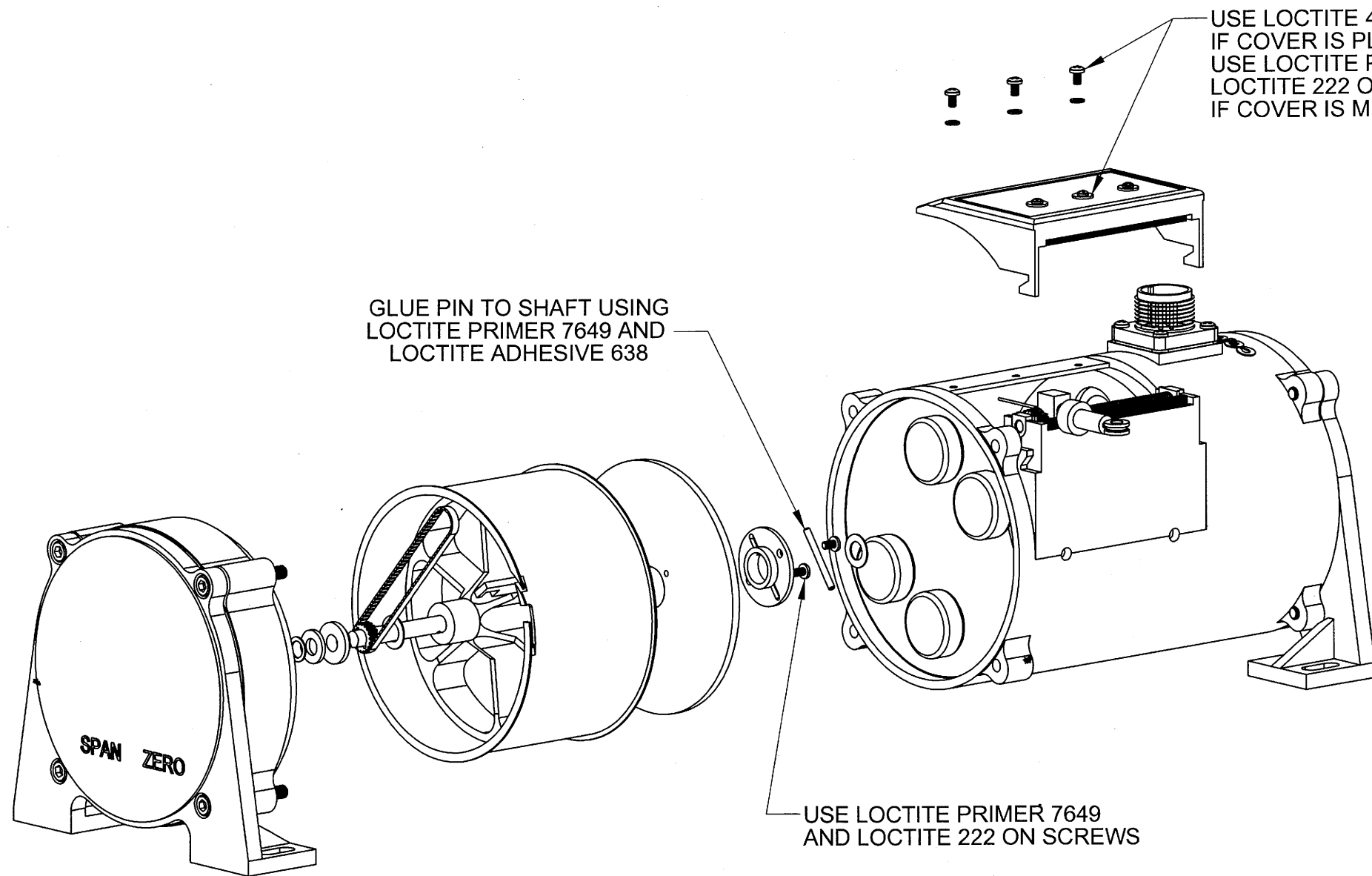
C

D

E

F

G



USE LOCTITE 425 ON SCREWS  
IF COVER IS PLASTIC.  
USE LOCTITE PRIMER 7649 AND  
LOCTITE 222 ON SCREWS  
IF COVER IS METAL.

GLUE PIN TO SHAFT USING  
LOCTITE PRIMER 7649 AND  
LOCTITE ADHESIVE 638

USE LOCTITE PRIMER 7649  
AND LOCTITE 222 ON SCREWS

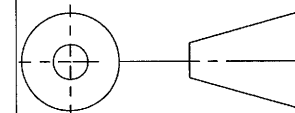
ORIGINAL

1.REFER TO PS-119 FOR LOCTITE USAGE  
NOT SHOWN ON THIS DRAWING

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DRAWN	M.KRATOFIL	12/12/2006	B	52158	PS-120	E
CHKD	MSK	12/10				
DO NOT SCALE DRAWING			SCALE: 1:2		SHEET 3 OF 4	

