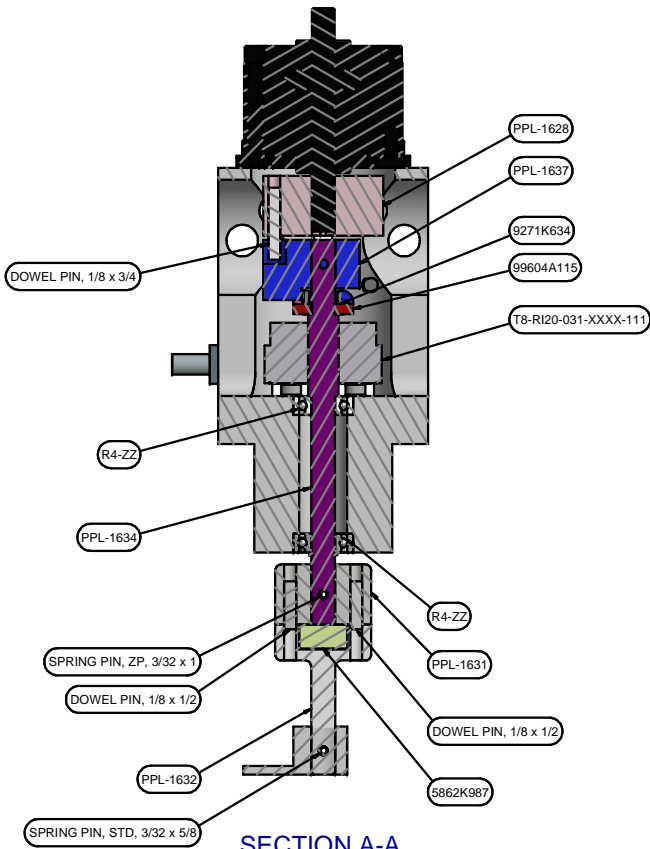
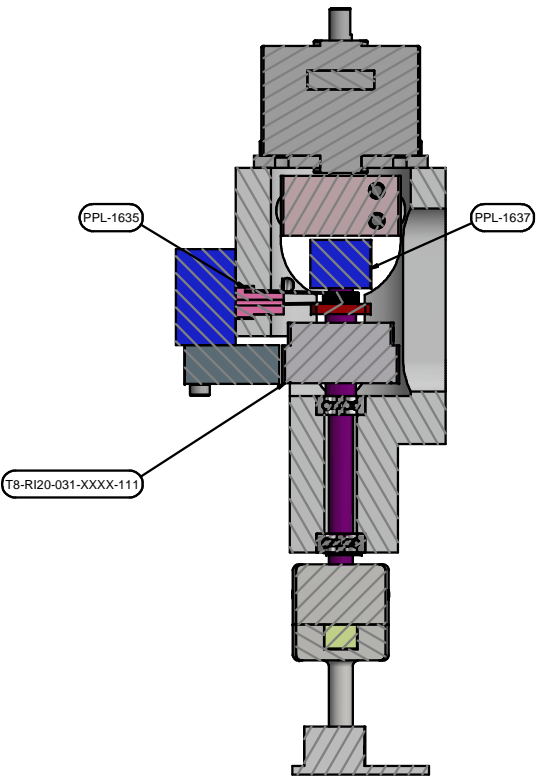
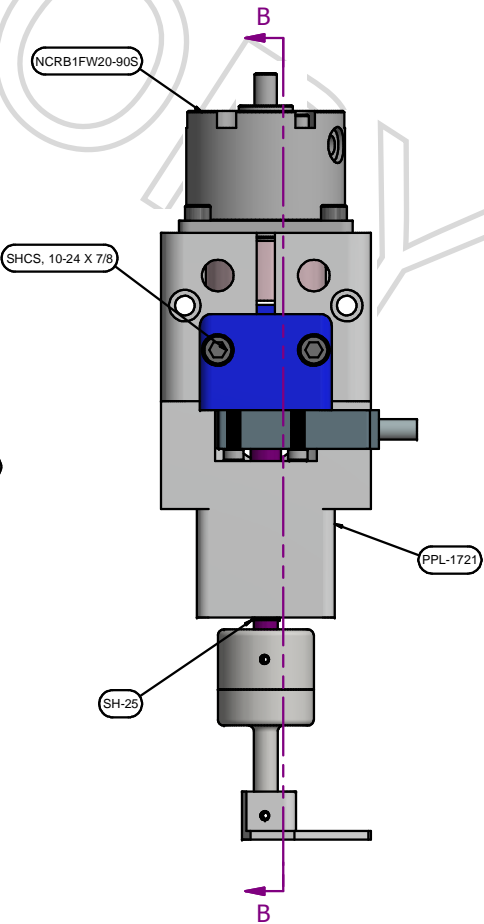
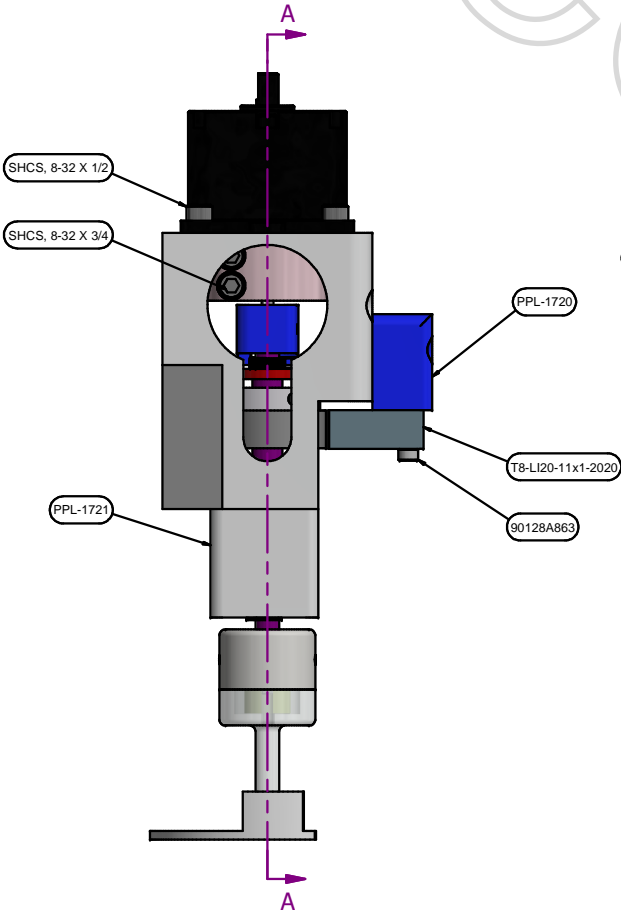


PARTS LIST			
QTY	PART NUMBER	DESCRIPTION	VENDOR
1	PPL-1628	ACTUATOR COUPLER	
1	PPL-1631	DEPTH SENSOR SHAFT HUB	
1	PPL-1632	DEPTH SENSOR SHOE MOUNT	
1	PPL-1634	ENCODER SHAFT	
1	PPL-1635	TORSION SPRING ANCHOR	
1	PPL-1636	DEPTH SENSOR SHOE, OPPOSITE HAND	
1	PPL-1637	TORSION SPRING CATCH, OPPOSITE HAND	
1	PPL-1720	DEPTH PROBE ENCODER MOUNT PLATE	
1	PPL-1721	DEPTH SENSOR HOUSING	
1	5862K987	NICKEL-PLATED ULTRA-HIGH-PULL NEODYMIUM MAGNET, .5" DIA., .25" THICK, 12 LB PULL	MCMaster-CARR
2	90128A863	ZINC-PLATED STEEL SHCS, 5-40 THREAD, 3/4" LONG, PACK OF 10	MCMaster-CARR
1	9271K634	LEFT-HAND TORSION SPRING, 360 DEG. ROTATION, .15 IN/LBS	MCMaster-CARR
1	99604A115	SILICONE SEALING WASHER, 1/4 SCREW SIZE, .23 ID, .625 OD, 55A DURO., 50 PER PACK	MCMaster-CARR
2	R4-ZZ	CONSOLIDATED BEARINGS, BALL BEARING 1/4" ID, 5/8" OD, .196 WIDE, TWO SEALS,	MOTION INDUSTRIES
1	SH-25	ROTORCLIP, 1/4" EXTERNAL SNAP RING, OR EQUAL	MOTION INDUSTRIES
1	NCRB1FW20-90S	180 DEGREE ROTATION ROTARY ACTUATOR	SMC
2	SHCS, 10-24 X 7/8	SOCKET HEAD CAP SCREW, BLACK OXIDE ALLOY STEEL, 10-24 X 7/8	STOCK



SECTION A-A



SECTION B-B

TOLERANCES: UNLESS OTHERWISE SPECIFIED

X = ± 0.1
XX = ± 0.05
XXX = ± 0.005
ANGULAR ± 1°

DO NOT SCALE THIS DRAWING

DESIGNED BY: BLH
DRAWN BY: BLH
DRAWN DATE: 11/2/2017

ERDMAN
Automation Corp.
1603 So. 14th Street, Plymouth, MN 55371

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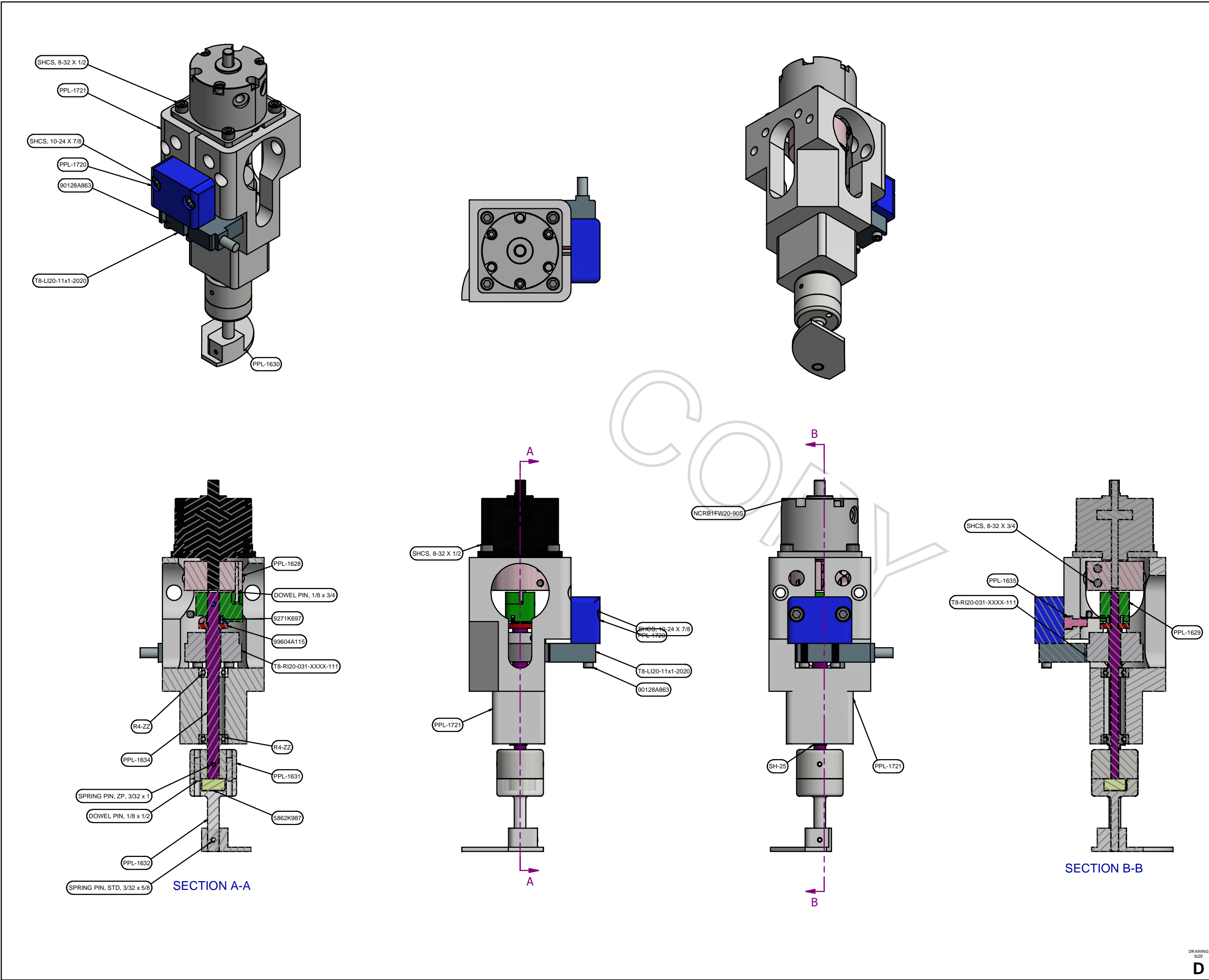
PART NAME: IG DEPTH PROBE ASSEMBLY (UPPER HEAD)

FINISH: AS SPECIFIED
MATERIAL: AS SPECIFIED

RETO # 1 OF 1
USED IN: A29

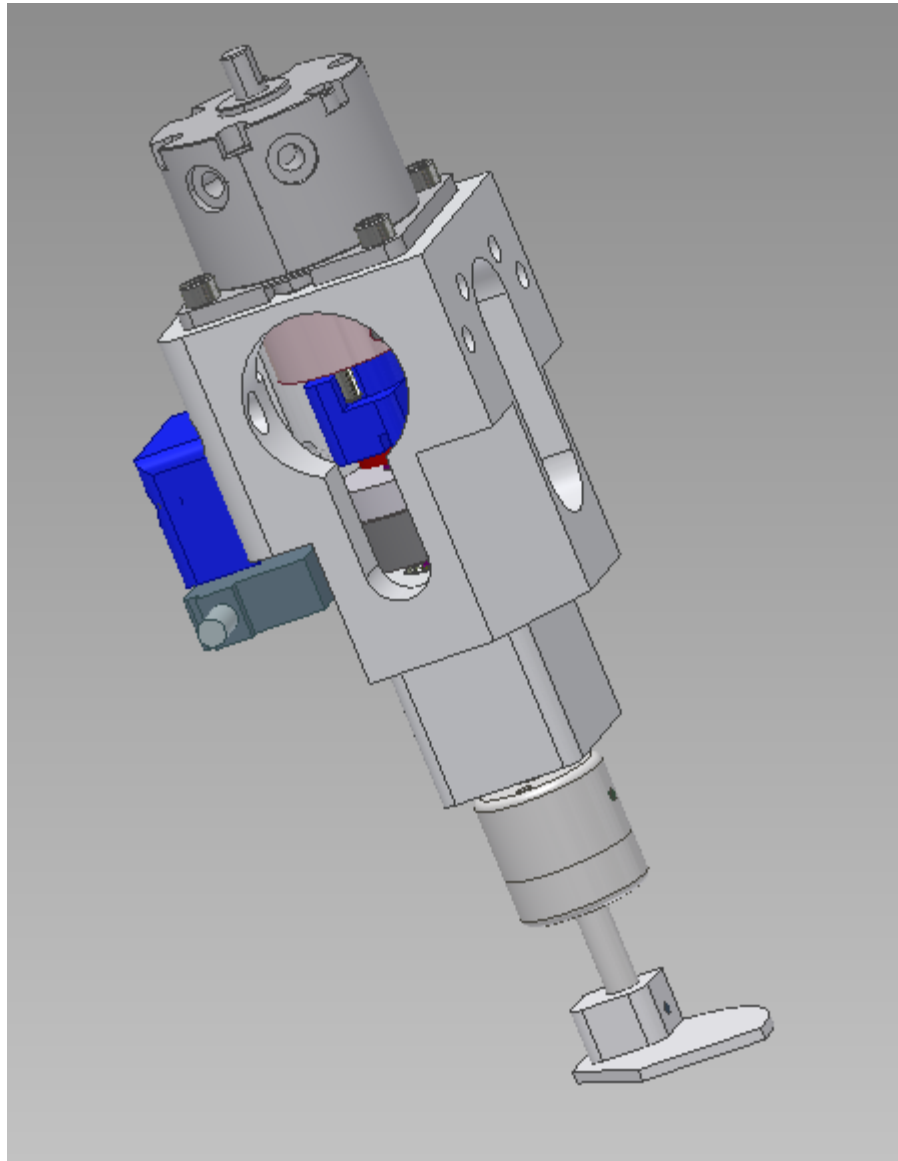
FAB Qty: 1
Erdman Job #: 171986

REV:
PART #: 171986-A16

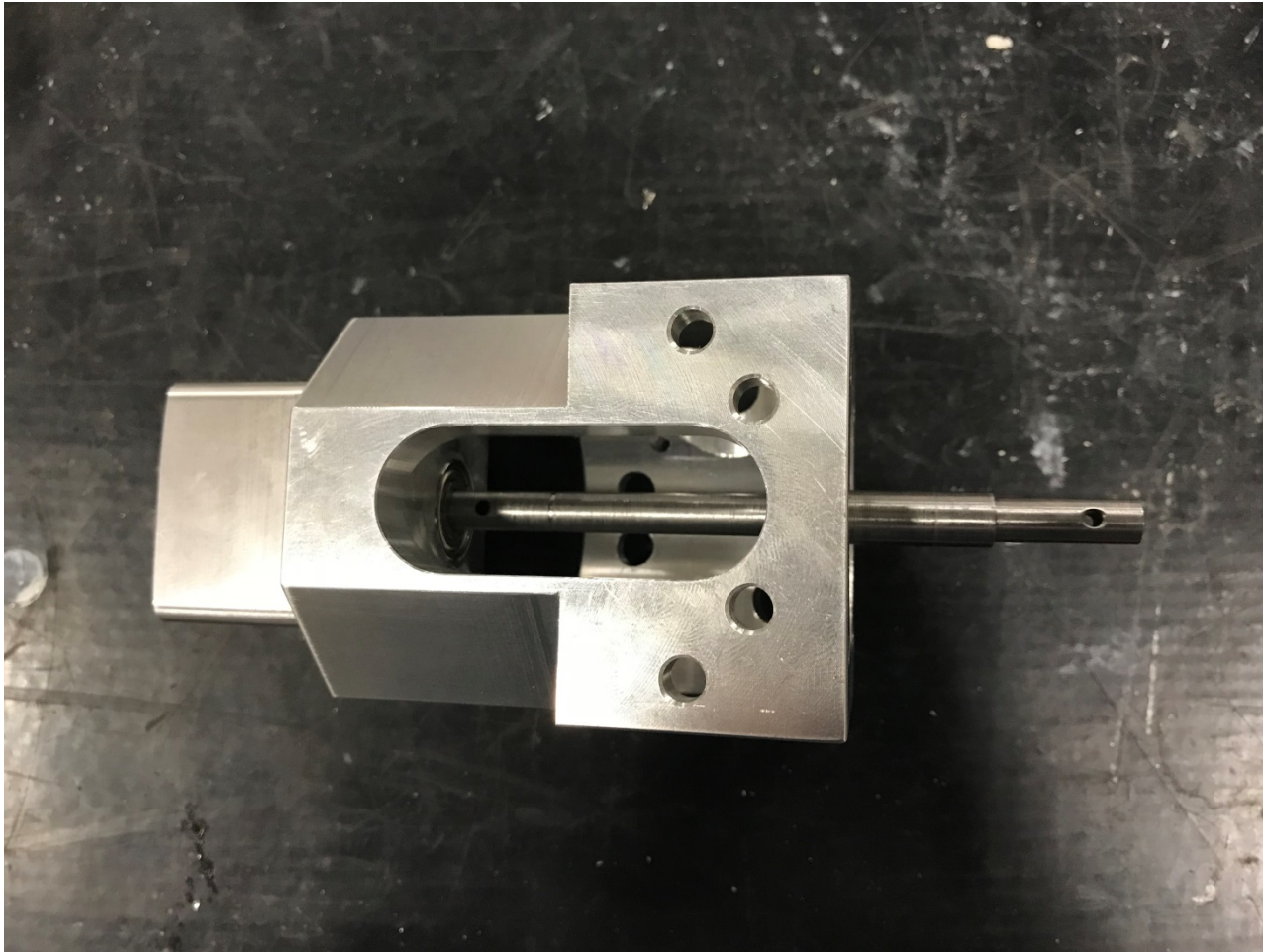


PARTS LIST			
QTY	PART NUMBER	DESCRIPTION	VENDOR
1	PPL-1628	ACTUATOR COUPLER	
1	PPL-1629	TORSION SPRING CATCH	
1	PPL-1630	DEPTH SENSOR SHOE	
1	PPL-1631	DEPTH SENSOR SHAFT HUB	
1	PPL-1632	DEPTH SENSOR SHOE MOUNT	
1	PPL-1634	ENCODER SHAFT	
1	PPL-1635	TORSION SPRING ANCHOR	
1	PPL-1720	DEPTH PROBE ENCODER MOUNT PLATE	
1	PPL-1721	DEPTH SENSOR HOUSING	
1	5862K987	NICKEL-PLATED ULTRA-HIGH-PULL NEODYMIUM MAGNET, .5" DIA., .25" THICK, 12 LB PULL	MCMaster-CARR
2	90128A863	ZINC-PLATED STEEL SHCS, 5-40 THREAD, 3/4" LONG, PACK OF 10	MCMaster-CARR
1	9271K697	RIGHT-HAND TORSION SPRING, 360 DEGREE ROTATE, .15 IN/LBS, QTY 6 PER PACK	MCMaster-CARR
1	99604A115	SILICONE SEALING WASHER, 1/4 SCREW SIZE, .23 ID, .625 OD, 55A DURO., 50 PER PACK	MCMaster-CARR
2	R4-ZZ	CONSOLIDATED BEARINGS, BALL BEARING 1/4" ID, 5/8" OD, .196 WIDE, TWO SEALS,	MOTION INDUSTRIES
1	SH-25	ROTORCLIP, 1/4" EXTERNAL SNAP RING, OR EQUAL	MOTION INDUSTRIES
1	NCRB1FW20-90S	180 DEGREE ROTATION ROTARY ACTUATOR	SMC

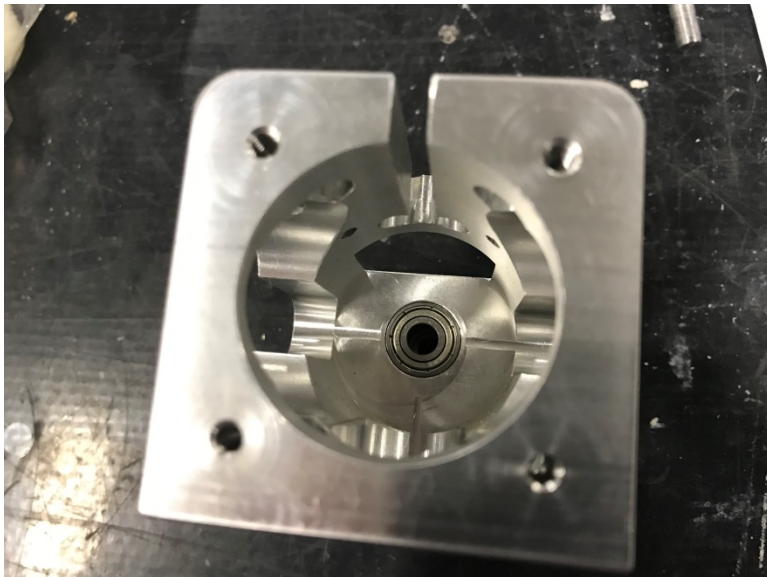
Depth probe assembly



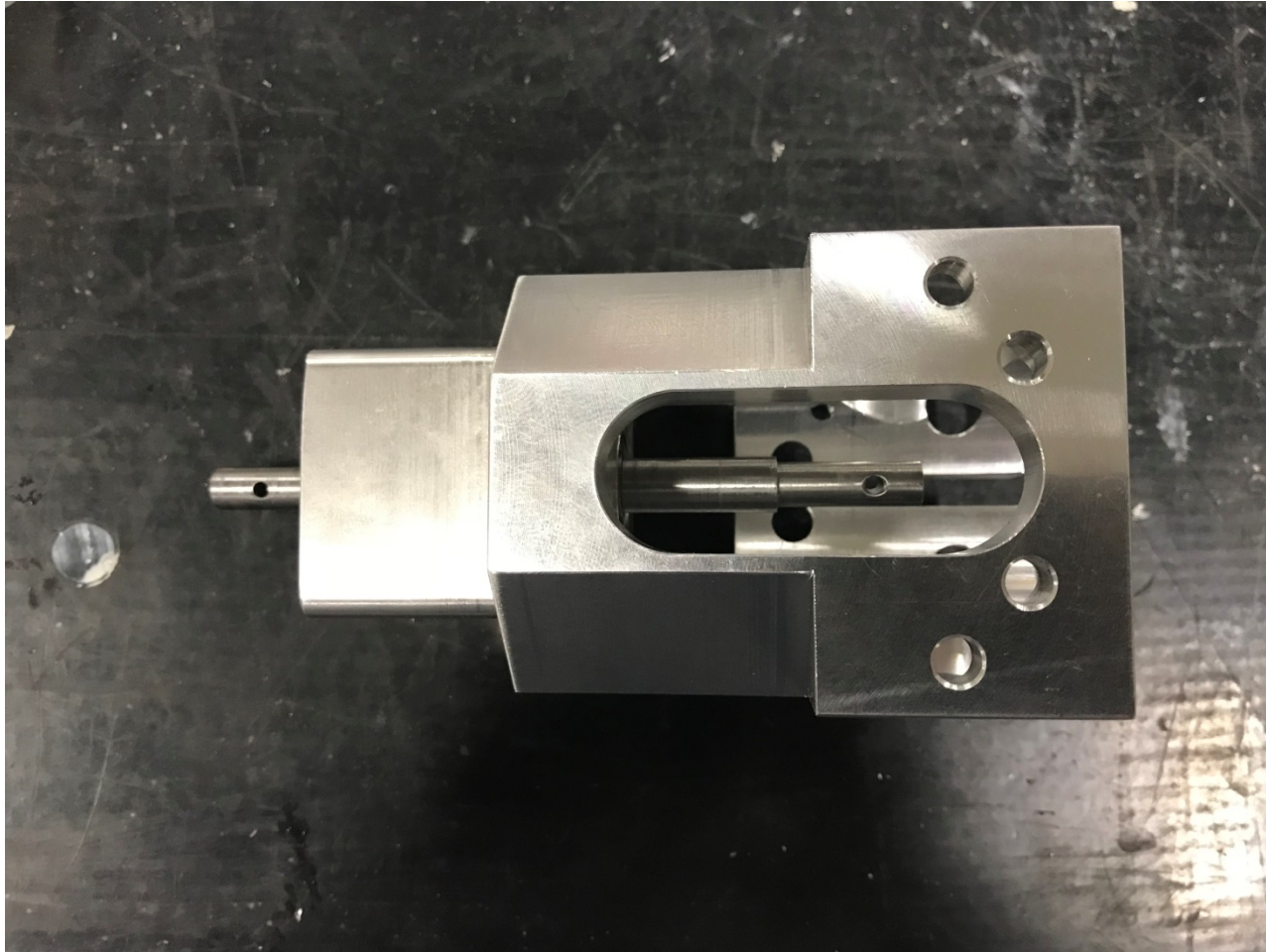
Install bearings using index shaft to align



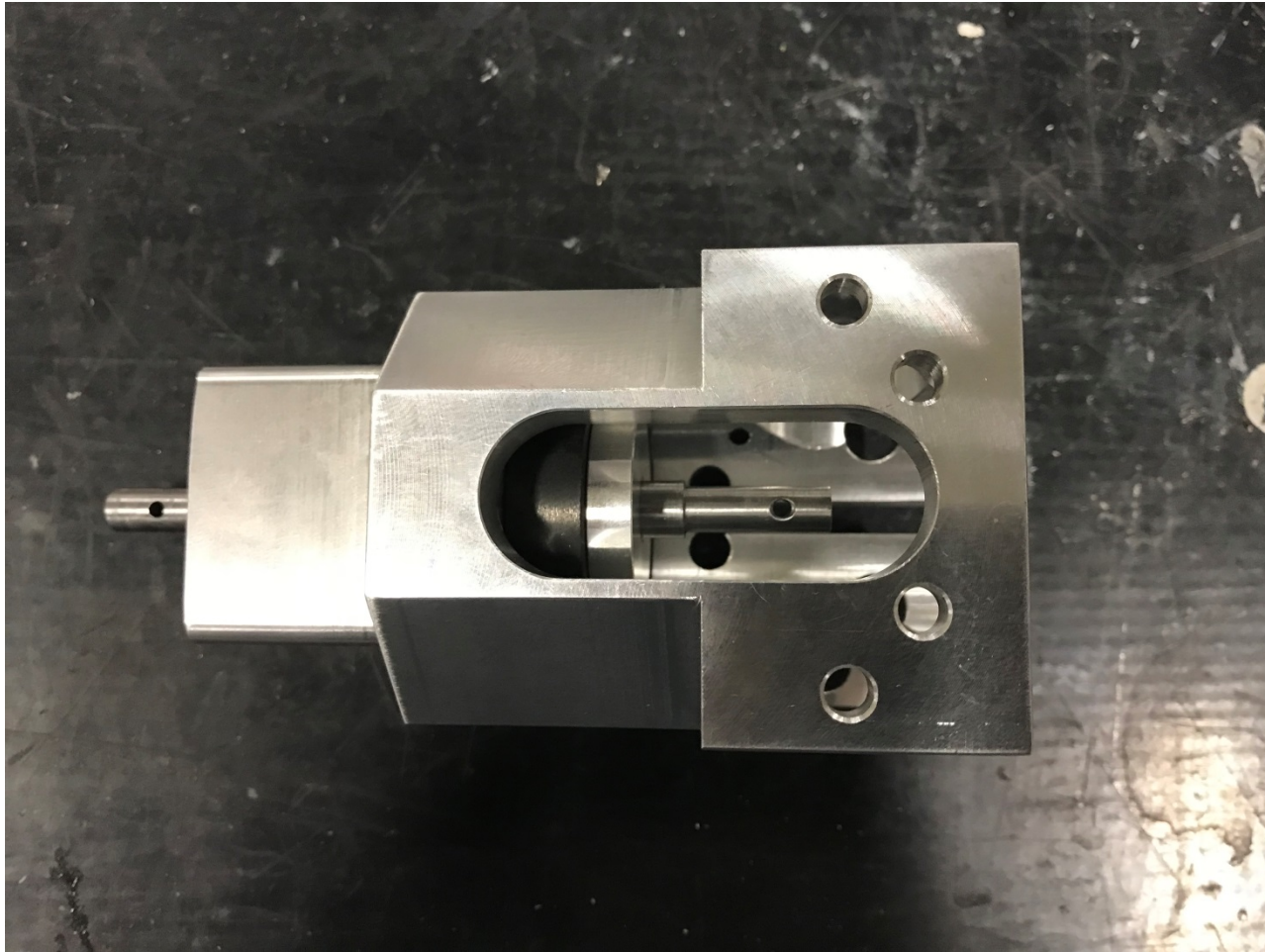
Bearings should be fully seated



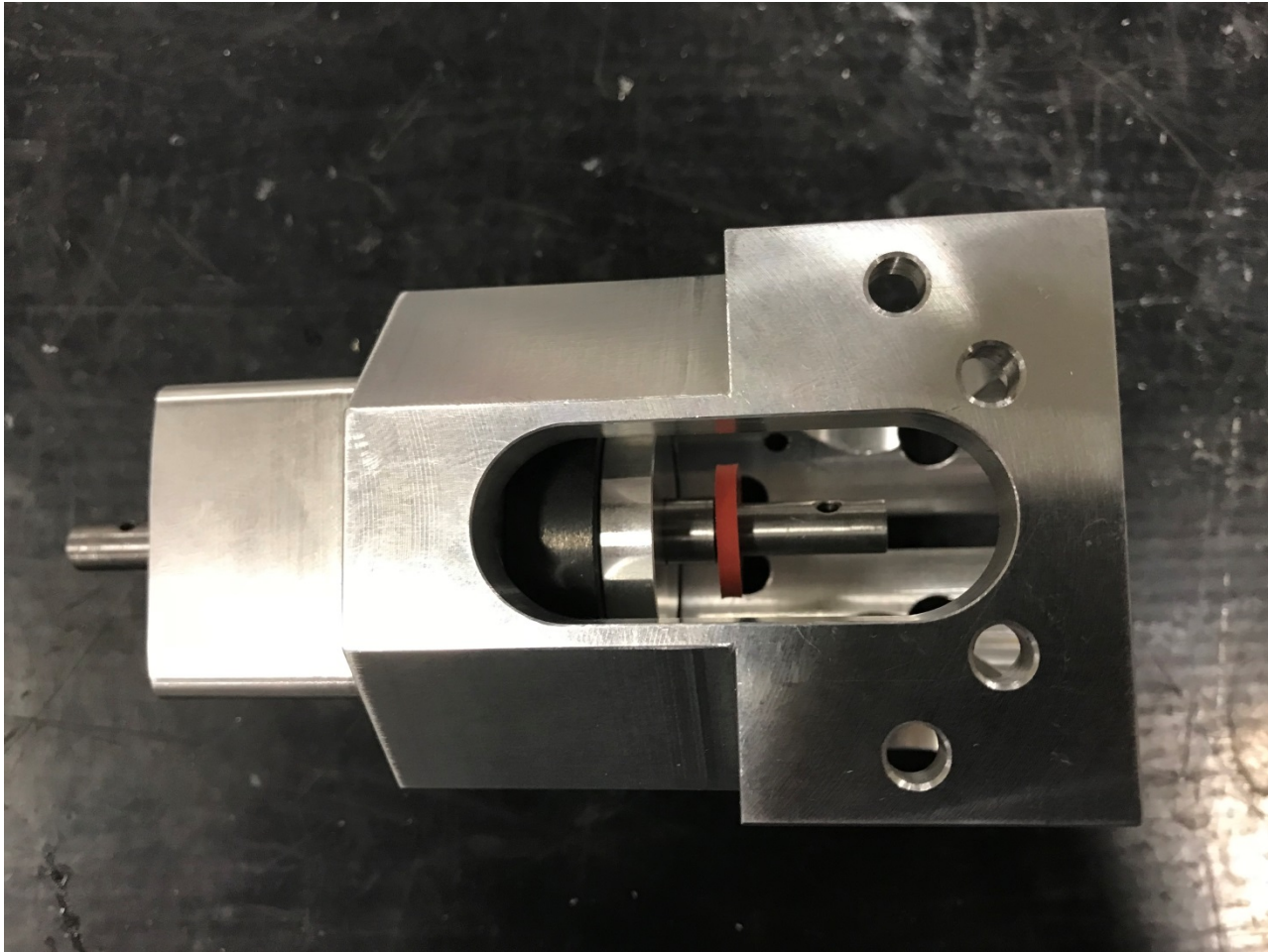
Install index shaft



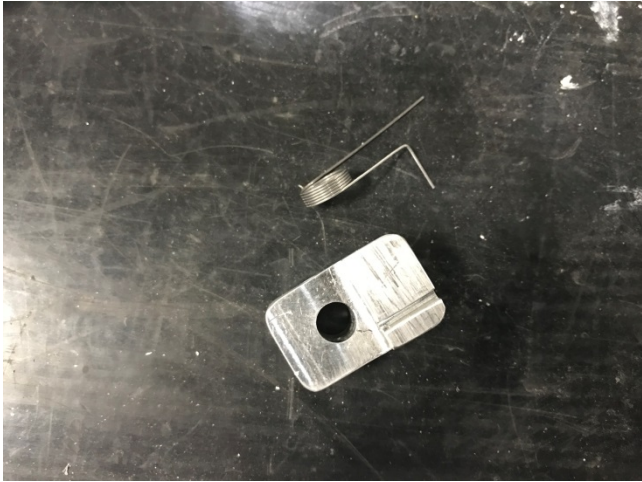
Slide encoder wheel in place, install snap ring to secure index shaft in place



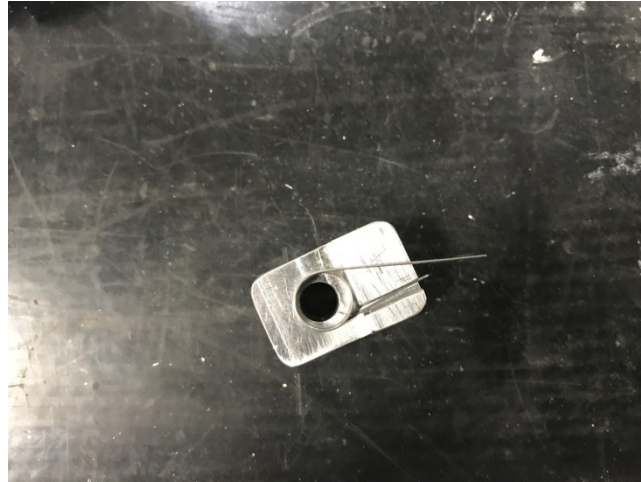
Slide silicone washer in place



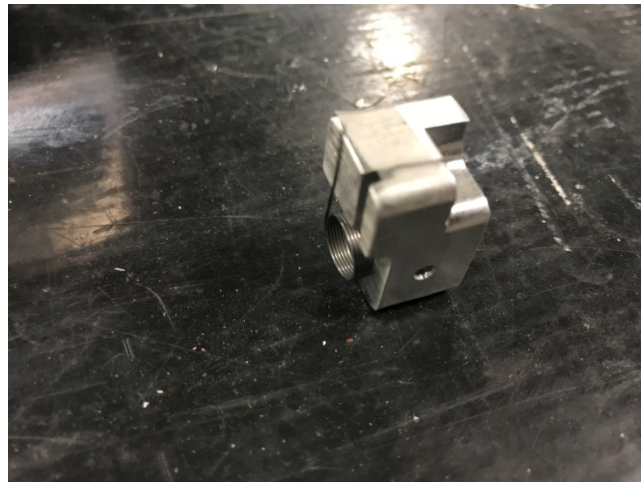
Left hand assembly shown (upper sealer head)



Bend bottom of spring leg to fit index block

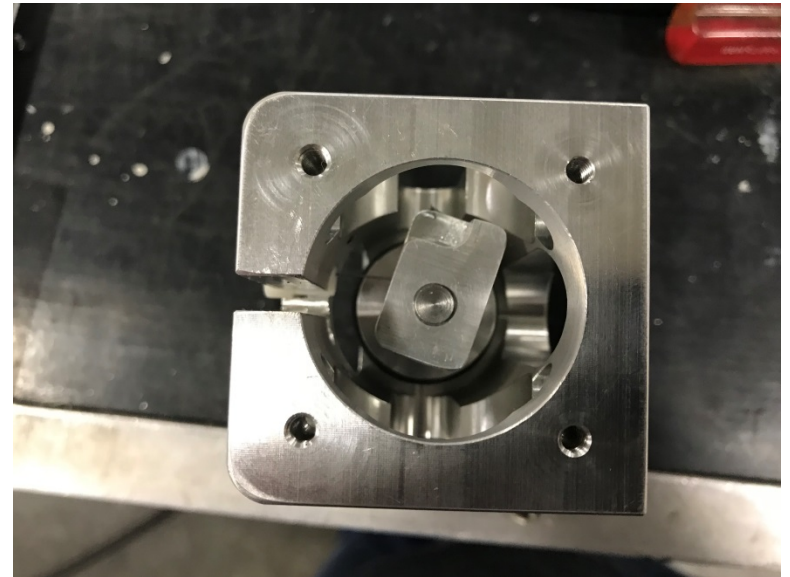
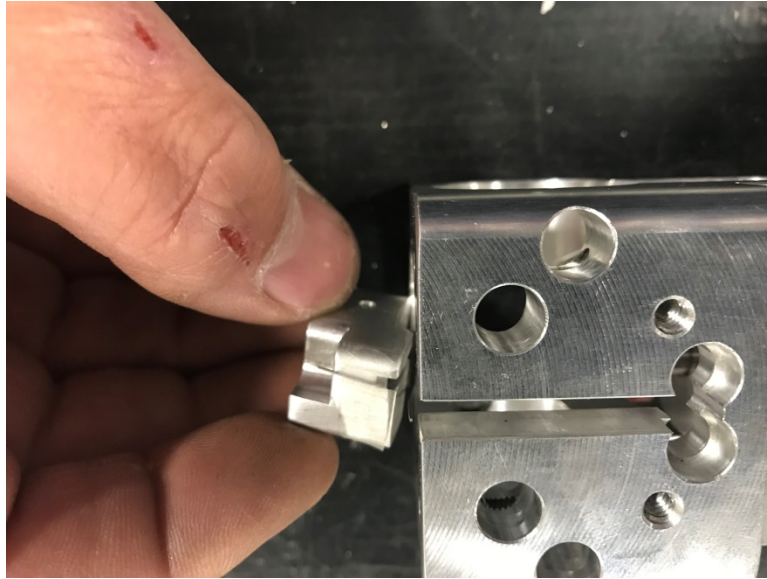


Set spring into index block



A small piece of tape will assist in installation

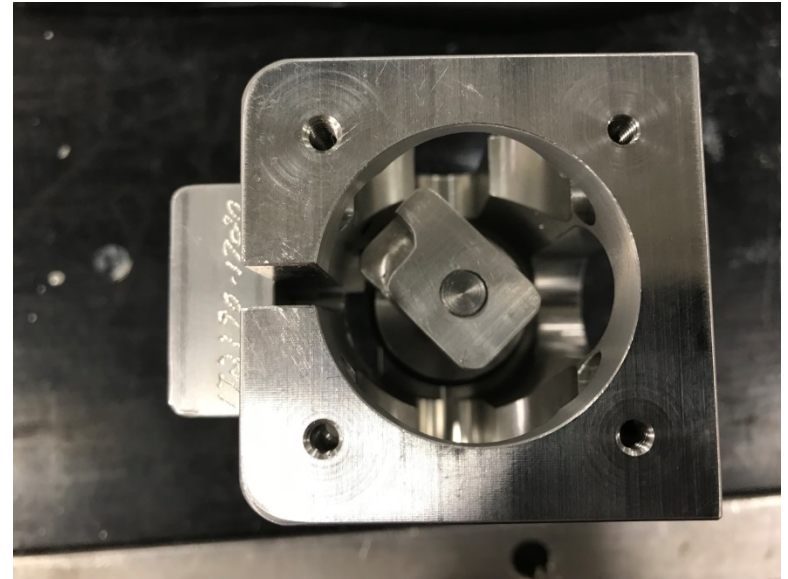
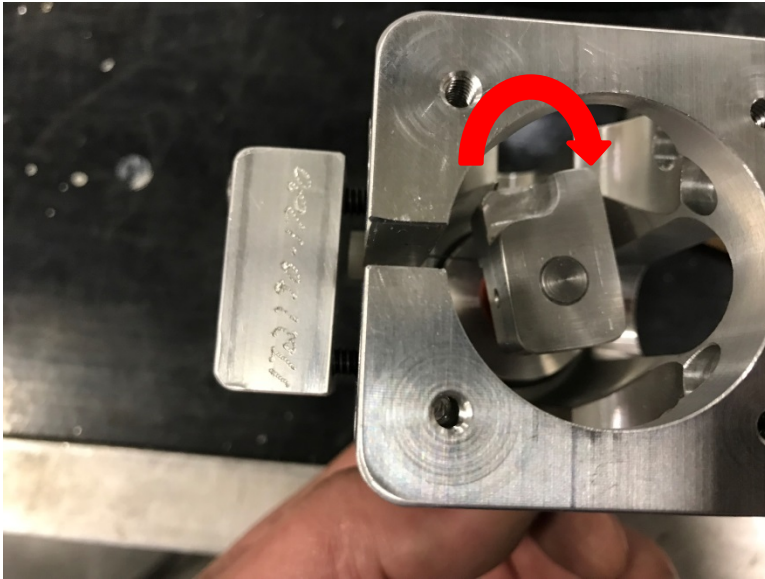
Align spring with slot and slide on to index shaft



Insert spring plug and start bolts for encoder block



Wind index block one revolution and slide spring plug into place and tighten encoder mount. This will keep spring tension.



With cylinder fully rotated 90 deg. Tighten drive wheel to shaft with drive pin at either 9:00 or 3:00 (depending on LH or RH)



Align and install pin or cotter key to secure index block, then install rotary actuator so that the drive pin aligns with index block

