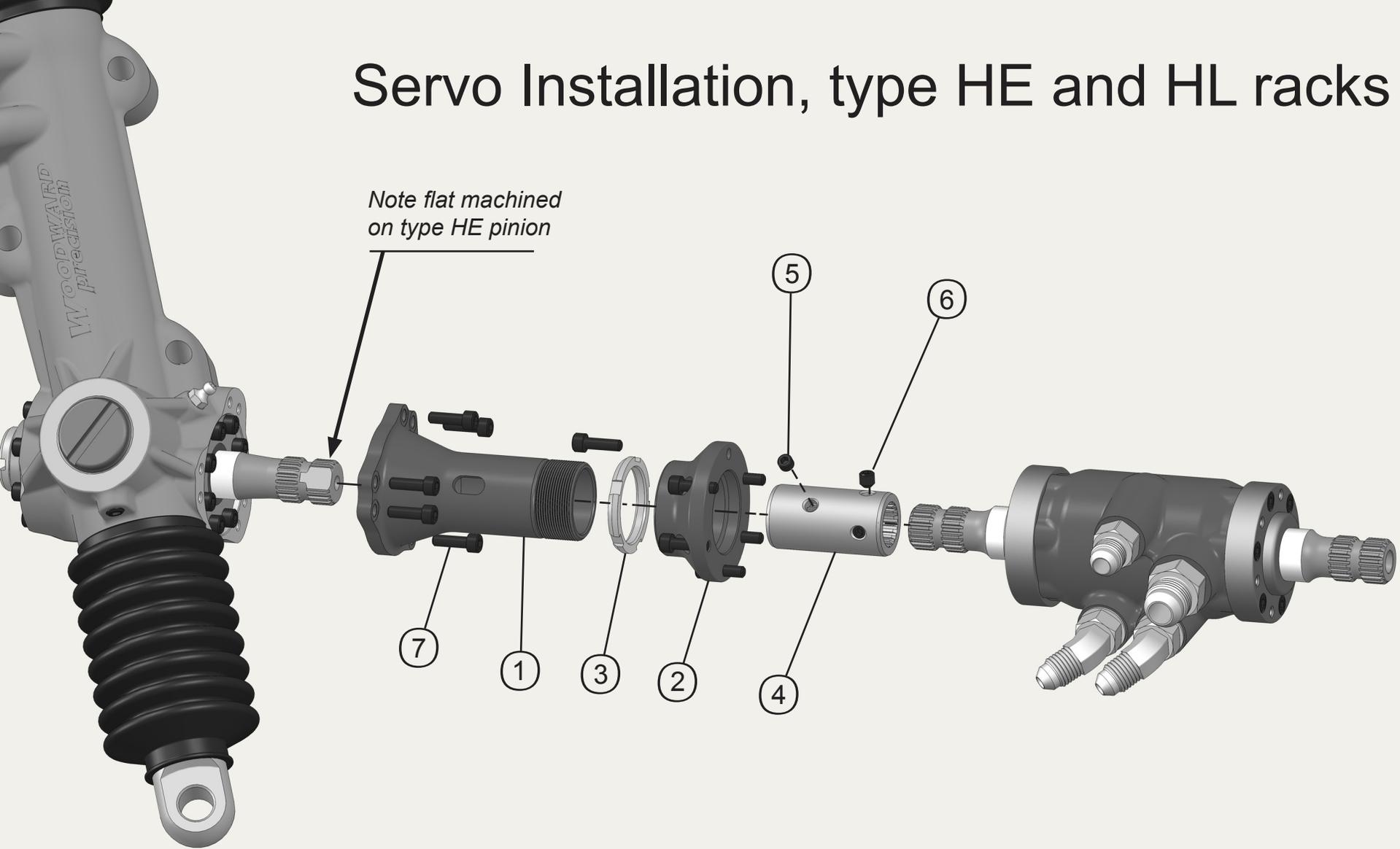


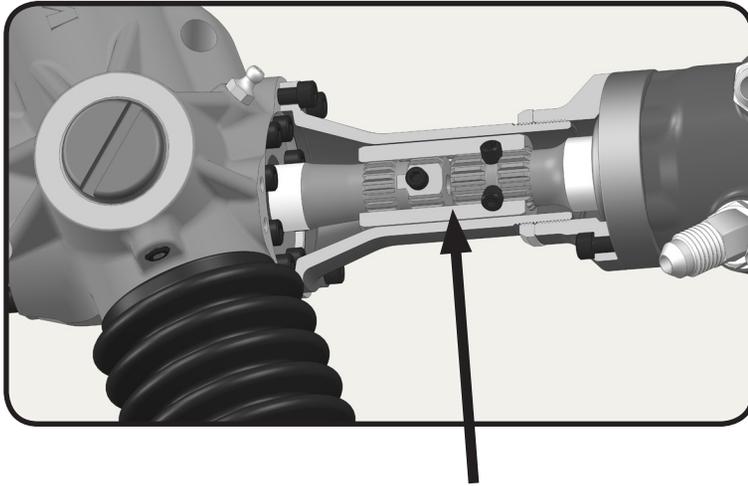
Servo Installation, type HE and HL racks



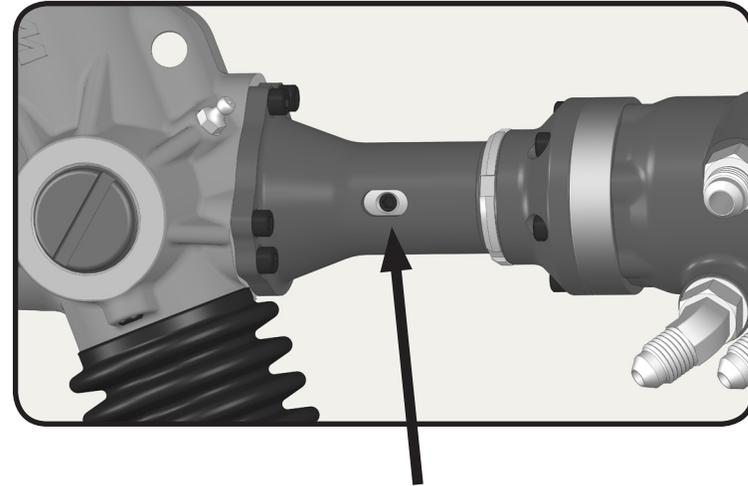
Parts List

Dwg no.	Part no.	Description	Dwg no.	Part no.	Description
1	GE584	Servo adapter flange	5	VHE201A	1/4-28 x 3/16 knurled cup point set screw
2	GE585	Servo adapter cap	6	VHE201B	1/4-28 x 1/4 knurled cup point set screw (2)
3	GE586	1-5/16-24 spanner type jam nut	7	GE351	#10-24 x 5/8 socket head cap screw (12)
4	VHE201	Splined coupler			

Assembly Sequence



Minimum .005 (0,13) gap



Set screw visible in slot

1. Assemble parts 1, 2, and 3 together using anti-seize compound on the threads. Temporarily bolt the flange to the rack housing and the cap to the servo. Screw the adapter together until the servo shaft touches the pinion, then adjust it out until the two parts are separated by .005 and the hose fittings on the servo are aimed approximately where you want them. Snug the jam nut to hold the parts in place.

2. Unbolt the adapter assembly from the rack and servo. Coat the splined shafts with anti-seize or grease. Secure the splined coupler onto the servo shaft with the two set screws VHE201B. Install the short set screw VHE201A so it is just flush with the surface of the coupler. Make sure it clears the inside of the adapter.

3. Bolt the assembly to the servo so that the short set screw is visible in the access slot. Align the set screw with the flat on the pinion.

4. Slide the servo and adapter onto the pinion and bolt the flange to the rack housing.

5. Rotate the servo to its final position (or connect its hoses and let them dictate the final position). Tighten the jam nut.

6. Carefully remove the short set screw and apply threadlocking adhesive (blue Loctite® #242 or #243, or equivalent). Reinstall the set screw, but not fully tight.

7. Loosen the 6 screws holding the assembly to the rack housing and retighten them.

8. Last, tighten the set screw. Wipe off any excess threadlocker and wrap electrical tape over the access slot to keep water out of the splined connection.