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<p><b>1</b></p> <p>Beim Befestigen der Isolatoren (Item 2), verwende das Pole Plate (Item 3) zum Ausrichten.                  WHEN INSTALLING INSULATOR (ITEM 2) IN PLACE USE POLE PLATE (ITEM 3) FOR ALIGNMENT.</p> <p>A. Entferne die Bonderschicht.                  REMOVE THE PHOSPHATED SURFACE.                  Reinige Kontaktflächen mit Aceton.                  CLEAN CONTACT SURFACES WITH ACETON.</p> <p>B. Zum Kleben klemme Item 1 und Item 3 zusammen.                  TO KEEP ASSEMBLY FROM SEPERATING WHILE CURING ITEM 1 AND ITEM 3.</p> <p><b>2</b></p> <p>Verbinde Pole Plate (Item 3) mit Coil Assy (Item 1) unter Verwendung von Epoxy (Item 4).                  BOND POLE PLATE (ITEM 3) TO COIL ASSY (ITEM 1) WITH EPOXY (ITEM 4).</p> <p><b>3</b></p> <p>Epoxy (Item 4) darf nicht über den OD oder in den ID der Pole Plate (Item 3) bzw. in dem ID der Coil Assy (Item 1) überstehen.                  Das Epoxy muss vollständig im Magnetic Wire Insulator (Item 2) verfüllt sein.                  Blasenbildung im Epoxy ist nicht zulässig.                  ENSURE EPOXY (ITEM 4) DOES NOT PROUDE ABOVE THE OD OR INTO THE ID OF THE POLE PLATE (ITEM 3) RESP. INTO THE ID OF THE COIL ASSY (ITEM 1).                  IT MUST BE FULLY FILLED IN THE MAGNETIC WIRE INSULATOR (ITEM 2).                  ENSURE NO CAVITY INSIDE THE EPOXY.</p> <p><b>4</b></p> <p>Löten oder Widerstandsschweißen:                  Kabel (Item 6 bzw. 7) und Spulendraht (beim Löten nutze SN96) und Schumpfschlauch (Item 5) installieren.                  SOLDERING OR RESISTANCE WELDING:                  CABLE (ITEM 6 RESP. 7) TO MAGNET WIRE (FOR SOLDERING USE SN96) AND INSTALL HEAT SHRINK (ITEM 5)</p> <p><b>5</b></p> <p>Isolationstest mit Widerstandsmessgerät bei 500V (R&gt;500M Ohm)                  INSULATION TEST WITH MEGOHMMETER AT 500V (R&gt;500M OHMS)</p> <p><b>6</b></p> <p>Markieren nach MOP162 Methode C, mit Teilenummer und aktueller Revision.                  MARK ACC. TO MOP162 METHOD C, WITH PART NUMBER ACTUAL REVISION.</p> <p><b>7</b></p> <p>Prüfe die Funktionalität mit Kaliber P/N 10372282                  CHECK FUNCTIONALITY WITH GAGE P/N 10372282</p> <p><b>8</b></p> <p>Kleine Stelle der Eloxalschicht nur für Messung entfernen                  SMALL PORTION OF THE ELOXAL REMOVED ONLY FOR MEASUREMENT</p>	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="3">CONSUMABLE MATERIAL</th> </tr> <tr> <td>7</td> <td>102mm</td> <td>VENDOR SUPPLIED WIRE, 24AWG PTFE INSULATED 200°C (WHITE - FINISH LEAD)</td> </tr> <tr> <td>6</td> <td>102mm</td> <td>VENDOR SUPPLIED WIRE, 24AWG PTFE INSULATED 200°C (BLACK-START LEAD)</td> </tr> <tr> <td>5</td> <td>A/R</td> <td>VENDOR SUPPLIED HEATSHRINK, 1/16" FEB TFL CLR</td> </tr> <tr> <td>4</td> <td>A/R</td> <td>N67592 EPOXY, 1-PART PERMABOND ESP110/ESP310 (ES 550)</td> </tr> <tr> <th>ITEM NO.</th> <th>QTY.</th> <th>PART NO.</th> <th>DESCRIPTION</th> </tr> </table>						CONSUMABLE MATERIAL			7	102mm	VENDOR SUPPLIED WIRE, 24AWG PTFE INSULATED 200°C (WHITE - FINISH LEAD)	6	102mm	VENDOR SUPPLIED WIRE, 24AWG PTFE INSULATED 200°C (BLACK-START LEAD)	5	A/R	VENDOR SUPPLIED HEATSHRINK, 1/16" FEB TFL CLR	4	A/R	N67592 EPOXY, 1-PART PERMABOND ESP110/ESP310 (ES 550)	ITEM NO.	QTY.	PART NO.	DESCRIPTION																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
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      Tolerierung / TOLERANCES ISO 8015                  Allgemeine geometrische Toleranz / GENERAL GEOMETRICAL TOLERANCES ISO 2768-K                  Winkelabweichung / ANGLE TOLERANCE = ±0,50°                  Kanten gebrochen / REMOVE ALL SHARP EDGES = 0,130,50                  Ubergangsradien / FILLET RADIIUS = 1,20 MAX                  Feine Maße ohne Toleranzangabe / STANDARD TOLERANCES</p> <table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td>h6 / JS</td> <td>h7 / JS</td> <td>h8 / JS</td> <td>h9 / JS</td> <td>h10 / JS</td> <td>h11 / JS</td> <td>h12 / JS</td> <td>h13 / JS</td> <td>h14 / JS</td> <td>h15 / JS</td> <td>h16 / JS</td> <td>h17 / JS</td> <td>h18 / JS</td> <td>h19 / JS</td> <td>h20 / JS</td> <td>h21 / JS</td> <td>h22 / JS</td> <td>h23 / JS</td> <td>h24 / JS</td> <td>h25 / JS</td> <td>h26 / JS</td> <td>h27 / JS</td> <td>h28 / JS</td> <td>h29 / JS</td> <td>h30 / JS</td> <td>h31 / JS</td> <td>h32 / JS</td> <td>h33 / JS</td> <td>h34 / JS</td> <td>h35 / 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