

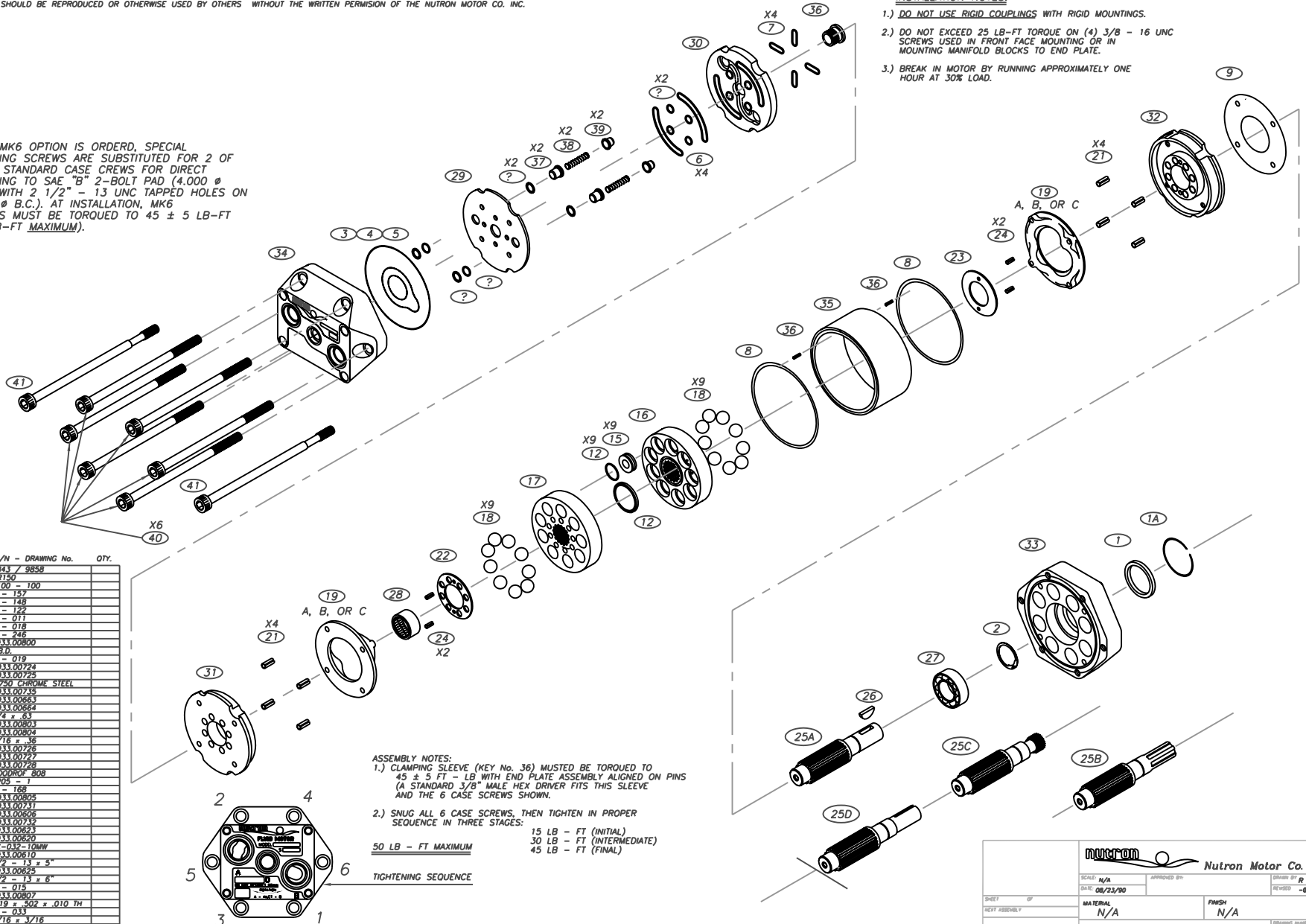
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**NOTE:**

WHEN MK6 OPTION IS ORDERED, SPECIAL MOUNTING SCREWS ARE SUBSTITUTED FOR 2 OF THE 6 STANDARD CASE CREWS FOR DIRECT MOUNTING TO SAE "B" 2-BOLT PAD (4.000 Ø PILOT WITH 2 1/2" - 13 UNC TAPPED HOLES ON 5.750 Ø B.C.). AT INSTALLATION, MK6 SCREWS MUST BE TORQUED TO 45 ± 5 LB-FT (50 LB-FT MAXIMUM).

**INSTALLATION NOTES:**

- 1.) DO NOT USE RIGID COUPLINGS WITH RIGID MOUNTINGS.
- 2.) DO NOT EXCEED 25 LB-FT TORQUE ON (4) 3/8 - 16 UNC SCREWS USED IN FRONT FACE MOUNTING OR IN MOUNTING MANIFOLD BLOCKS TO END PLATE.
- 3.) BREAK IN MOTOR BY RUNNING APPROXIMATELY ONE HOUR AT 30% LOAD.



KEY	DESCRIPTION	P/N - DRAWING No.	QTY.
1	SHAFT SEAL - Buna/Viton	8843 / 8858	
1A	RETAINING RING - OIL SEAL	UR150	
2	RETAINING RING - BALL BEARING	4100 - 100	
3	O - RING (END-CAP 1, DIST. PL. 2)	2 - 157	
4	O - RING (END CAP)	2 - 148	
5	O - RING (END CAP)	2 - 122	
6	O - RING (DST. PL.)	2 - 011	
7	O - RING (DST. PL.)	2 - 018	
8	O - RING (HOUSING)	2 - 245	
9	DELPHI ROTOR SEAL	4933.00800	
10	SPRING PIN (HOUSING)	T.B.D.	
14	CYLINDER SEAL (CURRENT)	2 - 019	
15	ROTOR HALF - COUNTERBORED	8933.00724	
16	ROTOR HALF - FLAT	8933.00725	
17	BALL PISTON	0.750 CHROME STEEL	
18	WAVECAM 10 cu. in./rev.	8933.00715	
19	WAVECAM 6 cu. in./rev.	8933.00663	
20	WAVECAM 3 cu. in./rev.	8933.00664	
21	ROLL PIN (2'S PLATES)	174 x .63	
22	PORT FACING	8933.00803	
24	SEAL FACING	8933.00804	
25	ROLL PIN (2'S FACING)	3716 x .36	
26	SHAFT, STD 1" Ø W/KEY	8933.00726	
27	SHAFT, SAE 6B SPLINE	8933.00727	
28	SHAFT, 1.30 SPLINE	8933.00728	
29	SHAFT KEY	W600009-808	
30	BALL BEARING	6205 - 1	
31	NEEDLE BEARING	8 - 166	
32	VALVE BAFFLE PLATE	8933.00805	
33	FRONT FLANGE (SMB)	C933.00731	
34	END PLATE	C933.00606	
35	HOUSING	8933.00712	
36	CLAMPING SLEEVE	4933.00623	
37	POPPERET	4933.00620	
38	VALVE SPRING	16-012-108W	
39	VALVE SEAT	4933.00610	
40	S.H.G.S. 3	1/2" - 13 x 5"	
41	MKS MOUNTING SCREW	4933.00625	
42	SMB MOUNTING SCREW	1/2" - 13 x 6"	
43	O - RING (BAFFLE PLATE)	2 - 015	
44	PLATE SEALS	4933.00807	
45	WASHER - SPACER (VALVE ASSY)	.619 x .402 x .010 TH	
46	O - RING (DST. PLATE)	2 - 033	
47	DOWEL PIN (HOUSING)	1/16 x 3/16	

**ASSEMBLY NOTES:**

- 1.) CLAMPING SLEEVE (KEY No. 36) MUST BE TORQUED TO 45 ± 5 FT - LB WITH END PLATE ASSEMBLY ALIGNED ON PINS (A STANDARD 3/8" MALE HEX DRIVER FITS THIS SLEEVE AND THE 6 CASE SCREWS SHOWN).
- 2.) SNUG ALL 6 CASE SCREWS, THEN TIGHTEN IN PROPER SEQUENCE IN THREE STAGES:
 

15 LB - FT (INITIAL)
30 LB - FT (INTERMEDIATE)
45 LB - FT (FINAL)

**50 LB - FT MAXIMUM**

**TIGHTENING SEQUENCE**

<b>NUTRON</b> <small>Nutron Motor Co. Inc.</small>	
SCALE: N/A	APPROVED BY: <small>DRIVER BY R PARKER</small>
DATE: 08/23/90	REVISED: -0-
MATERIAL: N/A	FINISH: N/A
ASSEMBLY DRAWING	
933.01001	