DS-1692 – Assembly Instructions with Customer Tooling

Model #9371-00000

Caution: Read all instructions before proceeding. Use safety equipment and follow instructions on all warning labels.

1.) Refer to "Cut Length" chart on DS-1684 for cut location and "Finished Length" chart on DS-1684 for bend location based on tank depth.
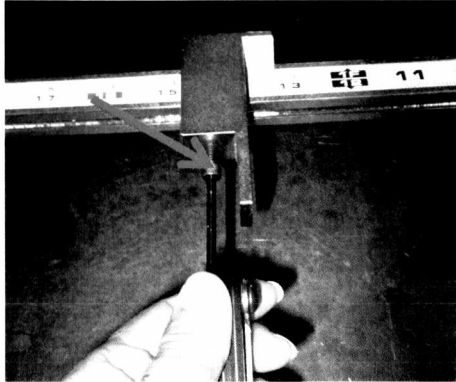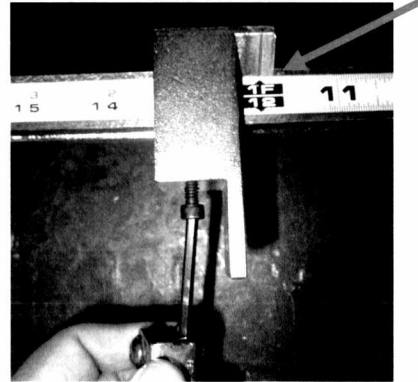2.) Using Allen wrench, loosen the set screw on the float stop (Figure 1).

Figure 1.

Figure 2.

3.) Slide the stop and align the red mark on the correct measurement, using the fixture- mounted scale. Tighten the set screw. (Figure 2).
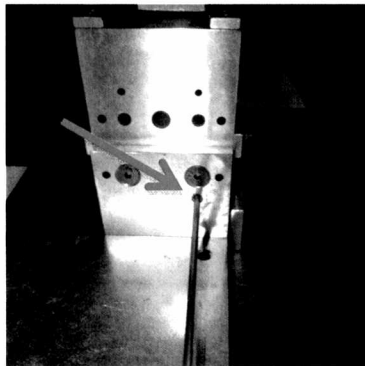4.) Insert the free end of the float s/a into the X-1759 "Float Rod Cutter" (Figure 3).
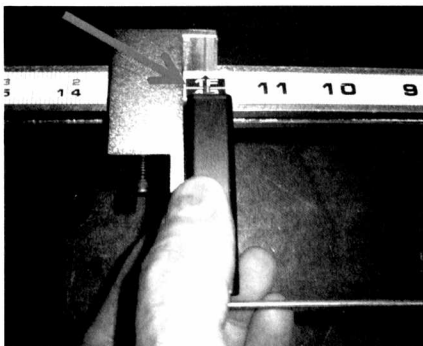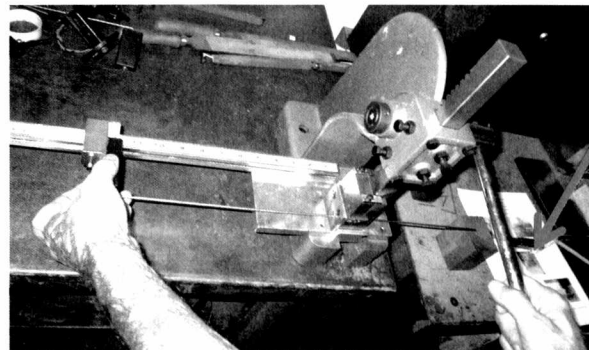

Figure 3.

Figure 4.

Figure 5.

5.) Place the float against the float stop (Figure 4). While holding the float against the float stop with one hand, use the other hand to pull the handle on the Float Rod Cutter all the way down (Figure 5). Verify that the part is cut to the correct length per the "Cut Length" chart.
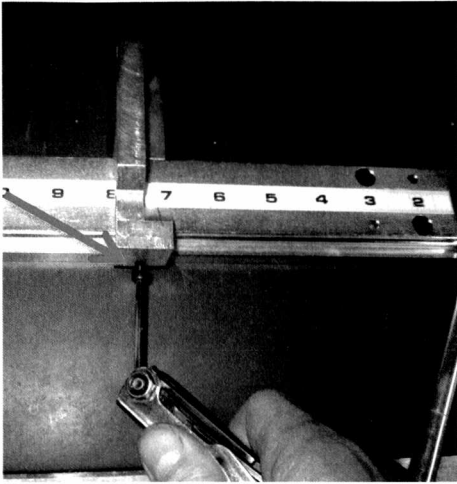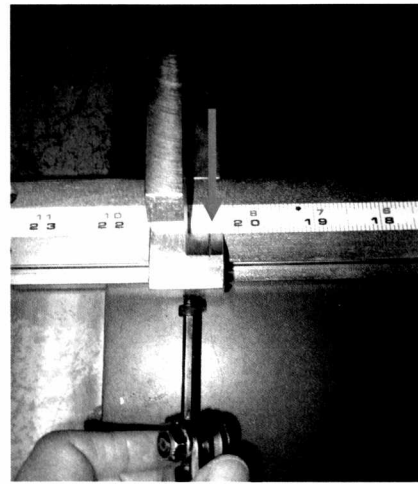
Figure 6.   Figure 7.

6.) Using the Allen wrench, loosen the set screw on the float stop on the X-1760 "Float Rod Bender" (Figure 6).

7.) Slide the float stop and align the red mark on the correct measurement, using the fixture-mounted scale. Tighten the set screw (Figure 7).
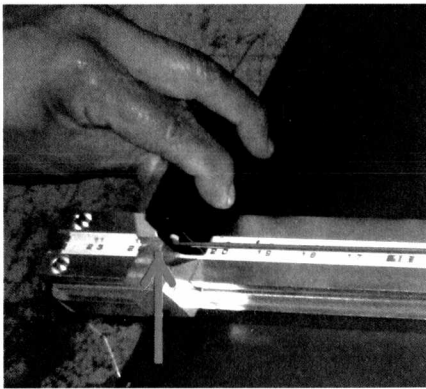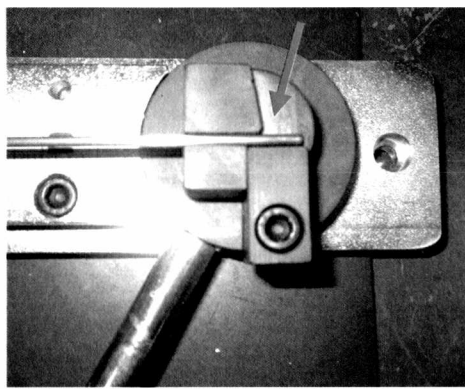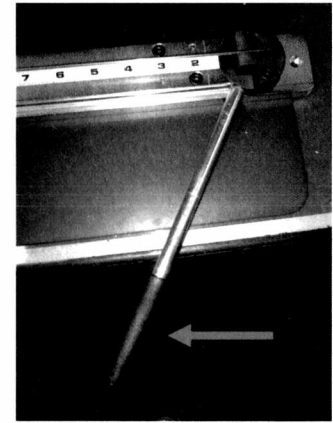

Figure 8.   Figure 9.   Figure 10.

8.) Place the float against the float stop on the X-1760 "Float Rod Bender" (Figure 8).

9.) While holding the float in place (Figure 8), insert the free end of the float s/a into the bending portion of the "Float Rod Bender" (Figure 9).

10.) Before bending the wire, MAKE SURE the handle is down or in a vertical position as shown (Figure 10). If the handle is in a horizontal position, the wire will be bent backwards.
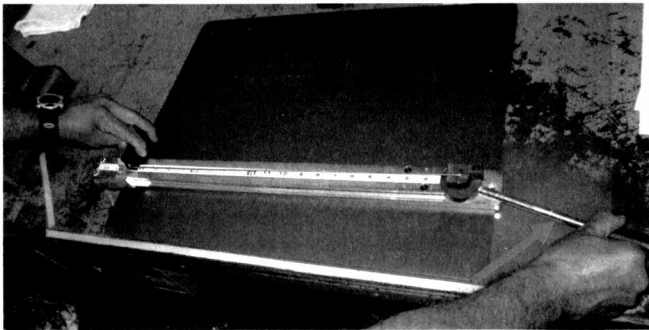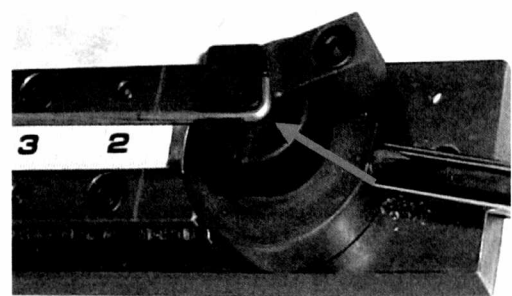

Figure 11.   Figure 12.

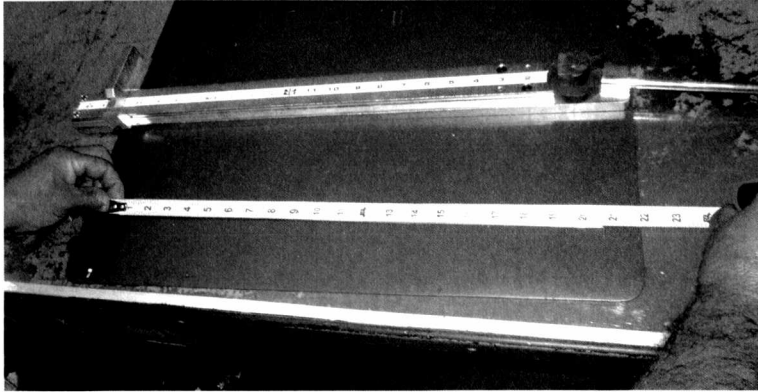11.) Holding the float against the float stop, push the handle all the up to bend the wire (Figure 11 & 12)

Figure 13

12.)Remove the s/a from the "Float Rod Bender". Using a tape measure, measure the length of the bent wire to verify the length is within specification (Figure 13).
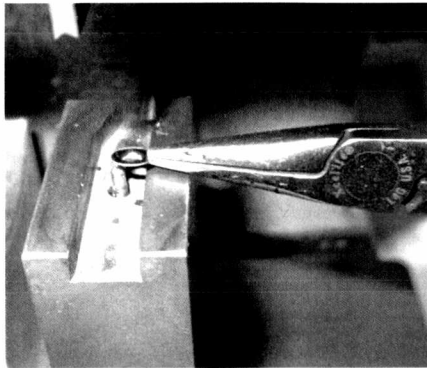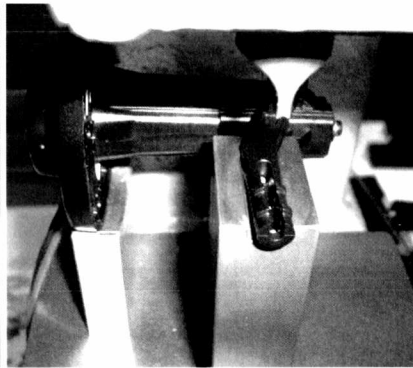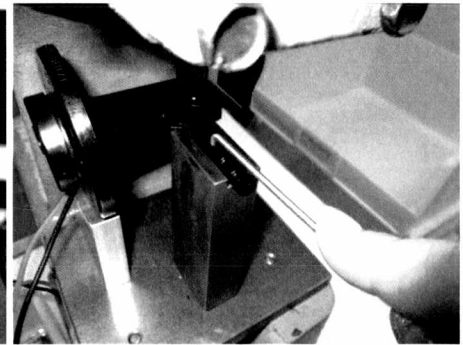

Figure 14.

Figure 15.

Figure 16.

13.)Using needle nose pliers, grab a push nut with the flat side up. Insert the push nut onto the guide post on the X-1761 "Float Rod Assembler" nest (Figure 14).
14.)Place the housing and pivot arm assembly onto the nest with the hole on the pivot arm over the guide post where the push nut is located (Figure 15).
15.)Take one float s/a. Insert the free end of the wire into the hole on the pivot arm, making sure the float s/a remains perpendicular to the work surface (Figure 16).
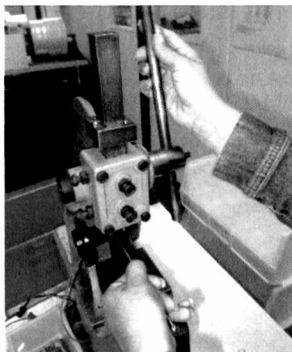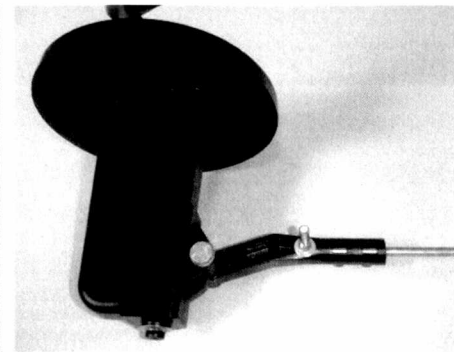

Figure 17.

Figure 18.

Figure 19.

16.)Pull the handle towards the operator all the way down (Figure 17).
17.)Remove the gauge form the press and verify the rod is properly installed in the pivot arm (Figure 18 & 19).