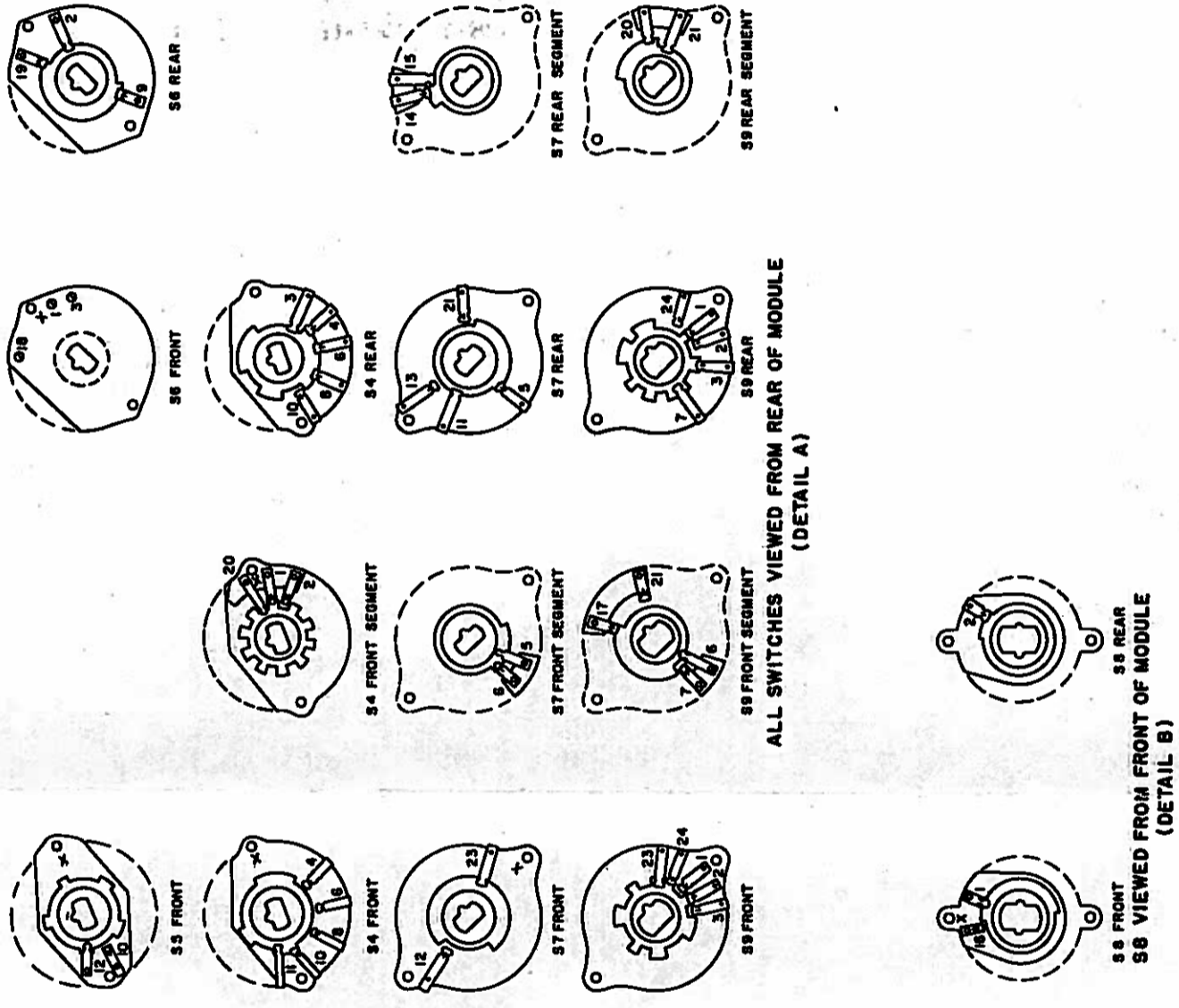


NOTE:

1. PRIOR TO STOWING WITH THE MODULE PER FOLLOWING NOTES TO THRU TO MAKE THE FOLLOWING:
 - (a) THAT BOTH AUTOPROTECTORS ARE FULLY ENGAGED IN RESPECTIVE STOP-HEEL NOTCHES.
 - (b) THAT THE 2 MC DRIVE SHAFT COLLAR IS FULLY ENGAGED IN DETAIL "A". THIS CORRESPONDS TO A SEAT AUTOPROTECTOR POSITION AS SHOWN IN DETAIL "A".
2. VISUALLY ALIGN ROTOR OF FRONT AND REAR SWITCH SETS AS SHOWN IN DETAIL "A". THIS CORRESPONDS TO A SEAT AUTOPROTECTOR POSITION AS SHOWN IN DETAIL "A".
3. DOES NOT LIMIT AUTOPROTECTORS END PLAY. TIGHTEN LEFT SET SCREW (VIEWED FROM FRONT OF MODULE) OF 2 MC DRIVE GEAR CLAMPING COLLAR. BE SURE THAT THE END PLAY OF THE 2 MC AUTOPROTECTORS THROUGH THE COLLAR. POSITION THE DRIVE GEAR IN THE CENTER OF ITS END PLAY BEFORE TIGHTENING THE COLLAR.
4. POSITION TABLE AND LOWER ON LOWEST "OPERATING" POINT ON CAM. POSITION GEAR ITEM (A) TO ALIGN THE 2 MC DRIVE SHAFT COLLAR AND FULLY TIGHTEN SET SCREWS IN POSITION SHOWN ON GEAR CLAMPING COLLAR (DETAIL A).
5. AS SHOWN IN DETAIL "A", POSITION 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
6. VISUALLY CENTER THE 2 MC DRIVE SHAFT COLLAR WITH THE BEARING PLATE APERTURE. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
7. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
8. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
9. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
10. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
11. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
12. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
13. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
14. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
15. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
16. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
17. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
18. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
19. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
20. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
21. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
22. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
23. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".
24. POSITION THE 2 MC DRIVE SHAFT COLLAR IN POSITION SHOWN IN DETAIL "A".



ALL SWITCHES VIEWED FROM REAR OF MODULE (DETAIL A)

S8 REAR VIEWED FROM FRONT OF MODULE (DETAIL B)

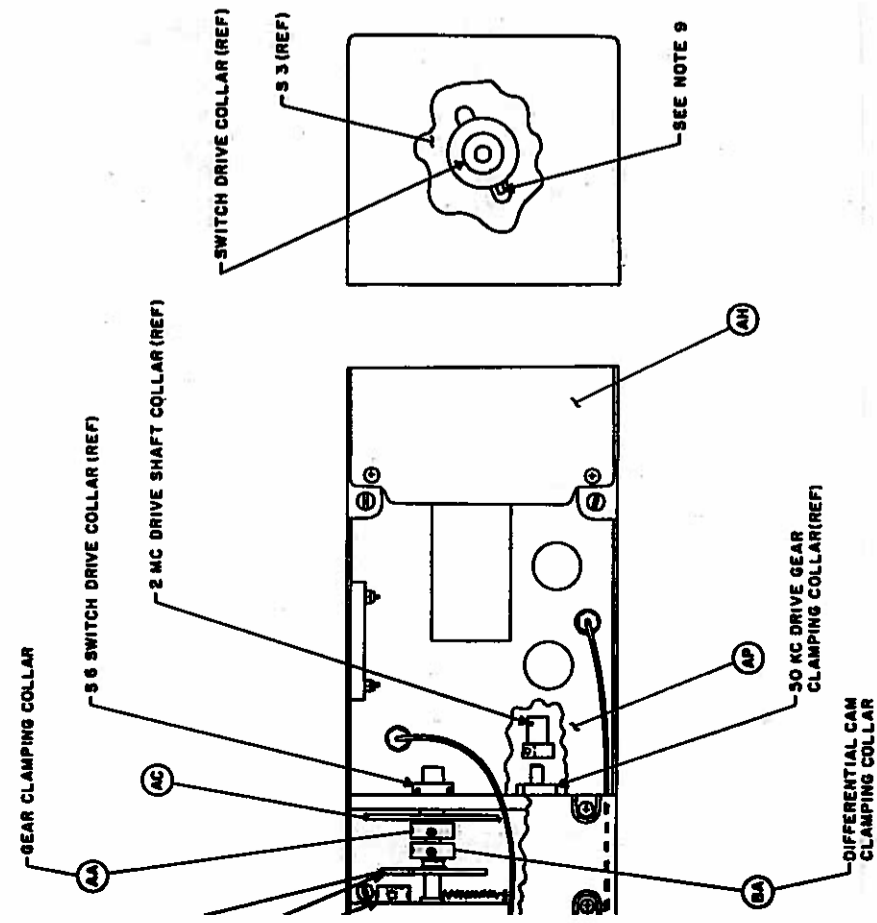


Figure 7-40. Mechanical Alignment Procedure for 51X-2B Units Through MCN 7867