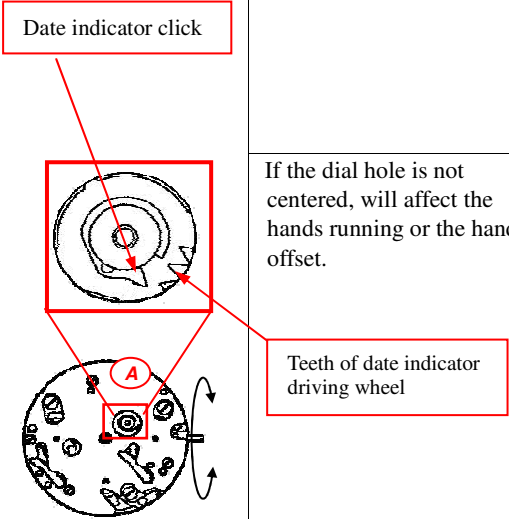





Caliber : 9238 / 1970

Function : Date · Day · Second Time Zone / 24-hour

Items	Operations	Tools	Remarks
1. Component's Visual checking	<ol style="list-style-type: none"> 1) Check the dial: need to flat, no scratches, no dust, no finger spots, no discoloration. 2) Check the hands: flat, no scratches, no dust, no finger spots. 3) Check the Case, case back and glass: no scratches, no dust, no finger spots, no discoloration. 4) Check the hand setting stem: not bent; the crown has to turn round. 		On the casing line, each component has to be checked visually by the collaborator just before assembly.
2. Dial fitting	<ol style="list-style-type: none"> 1) Pull the crown to position 2. Same as time-setting, turn the crown to position the date indicator click close to the teeth of the date indicator driving wheel, but leaving sufficient space between the two (as shown in the diagram). * The above step is to ensure that the movement is in a state that neither the date nor the day disc is going to jump-turn. This facilitates an easier observation when setting other hands. 2) Fit the dial. 3) Check the centered of the dial. 	 <p>Date indicator click</p> <p>Teeth of date indicator driving wheel</p>	If the dial hole is not centered, will affect the hands running or the hands offset.
3. Date & Day hands Fitting	<p>Place the movement into the movement holder TRT01-32B of the handfitting tool TRM03-01. The crown remains in position 2, and the movement is still in the state that neither the date nor the day is to of jump. Otherwise, the hands set later will be unable to point to the correct positions.</p> <ol style="list-style-type: none"> 1) Set the date hand onto the date counter pivot at 3 o'clock, align it to point the centre of any date as printed on the date sub-dial.. 2) Set the day hand onto the day counter pivot at 9 o'clock, align it to point to the centre of any day as printed on the day sub-dial. For example: "MON", the day hand should point to the centre of the "O". 		<ol style="list-style-type: none"> 1) Incorrect positioning or excessive strength may result in breakage or bend of the small hand. 2) Do not set the date hand or day hand if the date or day counter is in the state to jump-turn, otherwise the hands may risk to be misplaced and point to wrong positions.
4. Second Time Zone / 24 hour · Hour · Minute & · Second hands Fitting	<ol style="list-style-type: none"> 1) The crown remains at position 2. Same as time-setting, turn the crown clockwise to change the date. As soon the date jumps, stop immediately. Then, put the movement into the movement holder TRT01-32 of the handfitting tool TRM03-01. 2) Press B once, set the second time zone / 24 hour small hand onto the counter pivot at 6 o'clock and point to the centre of any hour of the 24 hour sub-dial at 6 o'clock. 3) Set the hour hand, minute hand and second hand one after one. Point them all to 12 o'clock. 4) Check the flatness and the height of all hands. 	<p>TRM03-01 3-head Handfitting tool with movement holder TRT01-32B (for fitting small hands)</p>	This step must be followed accordingly when setting the hands, otherwise, the Second Time zone / 24 hour hand will not synchronize with the central hour hand. Meanwhile, the date cannot be changed at 00:00 midnight.

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Function : Date · Day · Second Time Zone / 24-hour

Items	Operations	Tools	Remarks
5. Test the normal adjusting of date, day, and running of Second Time Zone / 24 hour small hand	<ol style="list-style-type: none"> 1) The crown remains at position 2. Turn it clockwise until the hour hand passes 00:00 midnight. The date hand will change for one day. 2) Continue to turn the crown clockwise, until the hour hand points to anywhere between 00:00 midnight and 04:30 in the morning, the day hand will change for one day. (Note: the day hand will jump two steps in order to complete the change for one day). 3) When testing the correction of date and day, inspect also the running of the second time zone / 24 hour small hand. See if it turns in the same pace as the central hour hand. 		Date advances one step (change for one day) when the hour hand passes 00:00. If not, you have to reassemble the hour hand and minute hand.
6. Test quick adjusting functions	<p>The crown remains at position 2. Turn it clockwise to set the time, until the hour hand has passed 06:00 in the morning. Then test the functions of each of the push-buttons :</p> <ol style="list-style-type: none"> 1) Quick correction of date : Press A step-by-step to test and observe if the push button functions correctly. 2) Quick correction of second time zone / 24 hour hour : Position the minute hand to point to anywhere between 55th minute and 5th minute of any hour. Press B step-by-step to test and observe if the second time zone / 24 hour hand function correctly. 3) Quick correction of day : Position the hour hand to point to anywhere between 22:00 and 06:00. Press C step-by-step to test and observe if the day hand functions correctly. 	<p>TRM03-01 3-head Handfitting tool with movement holder TRT01-32B (for fitting hour, minute & second hands)</p> 	Do not do quick day correction between 22:00 and 06:00.
7. Stem Removing	<ol style="list-style-type: none"> 1) Use the tweezers tip or other suitable tooling to press down the setting lever slightly then take out the stem. 	<p>TRT01-32B Movement holder</p>	
8. Casing	<ol style="list-style-type: none"> 1) Put the movement into the case and remove dust and particles. 2) Fit the handsetting. 3) Put and close the case back. 		

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Function : Date · Day · Second Time Zone / 24-hour

Items	Operations	Tools	Remarks
9. Watch head Initialization	1. Press the push buttons one by one to test and observe if they function correctly.		

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