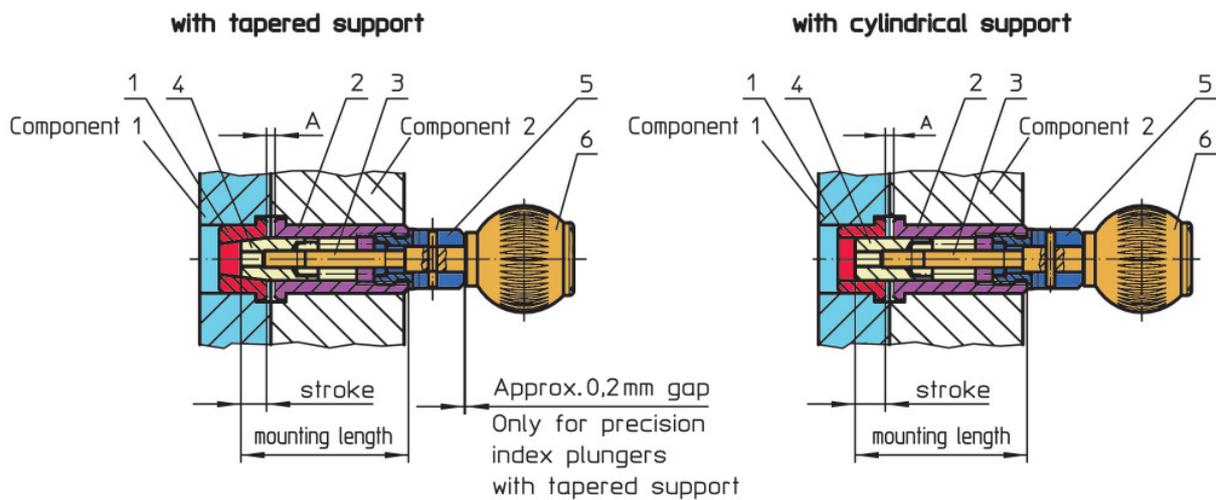


Precision Index Plunger EH 22130. Assembly and Mounting Instructions



Assembly:

1. Mount conical or cylindrical (pos. 1) bush into component 1.
2. Mount bush (pos. 2) into component 2.
3. Establish mounting length (nominal dimension).
Mounting length = $A + \text{stroke} + \text{length pos. 2}$.
Consider 0,2 mm gap for index precision bolts with conical support.
4. Glue threaded rod (pos. 3) and centering pin (pos. 4) by means of anaerobic glue but avoid any oil or grease. Recommended glue: Loctite 638.
5. Screw centering pin with nut (pos. 5) and grip ball (pos. 6) into the assembled bush (pos. 2). If necessary glue with anaerobic glue but avoid any oil or grease.
6. Check function. For precision index plungers with locking keep to the releasing stroke according to catalogue.

Note:

Precision index plungers are only operative after the hardening time indicated for the used glue.

When gluing the different components together glue must not reach the moveable parts.