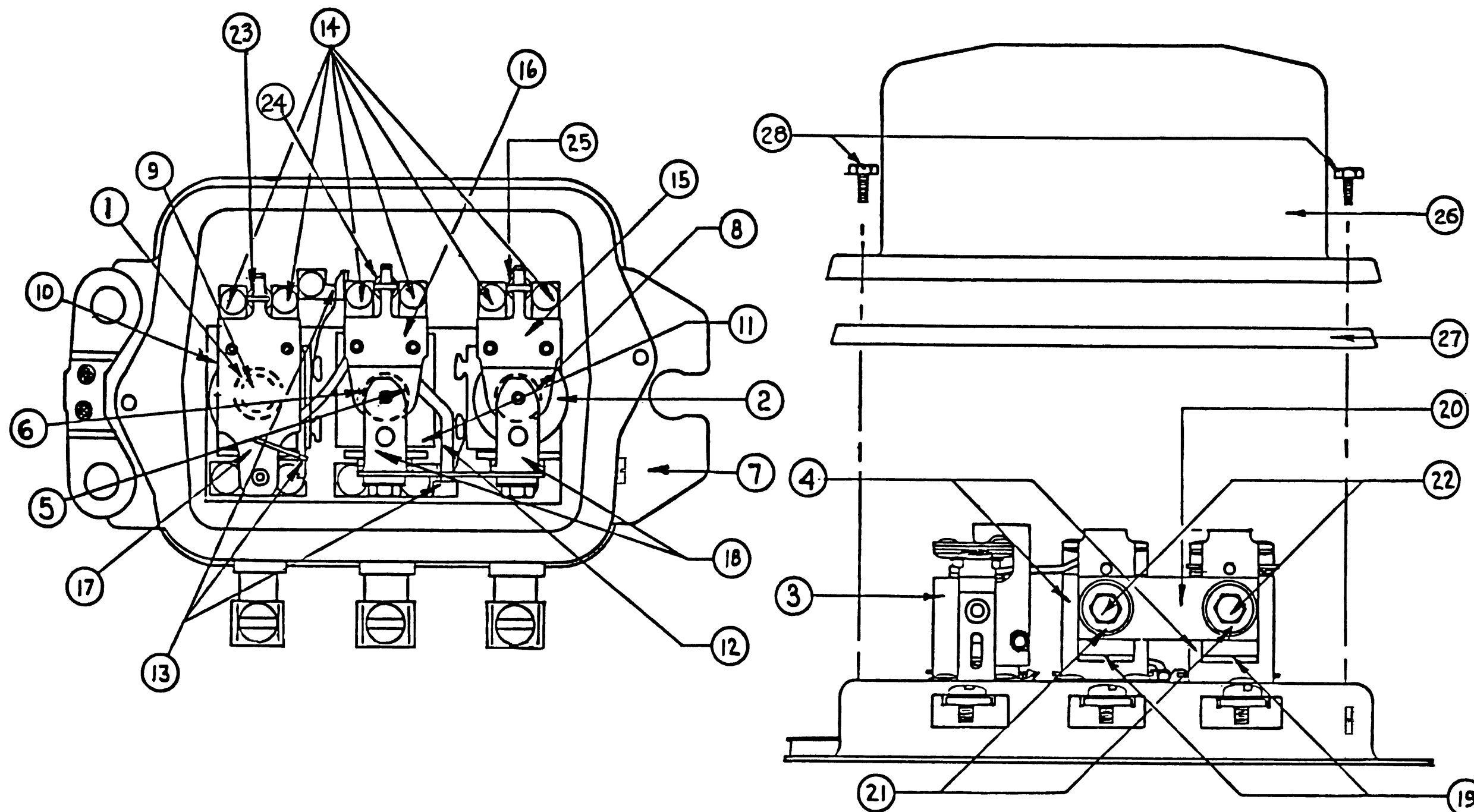


**NOTES:**

1. STAKE COIL & U-MAGNET ASSEMBLIES TO BASE ASSEMBLY. THE U-MAGNETS ARE TO BE CHECKED WITH A TORQUE DRIVER & SHALL WITHSTAND A MINIMUM TORQUE OF 18 IN. LBS. AND A MAXIMUM TORQUE OF 32 IN. LBS. BEFORE TURNING ON BASE. THE CORES SHALL NOT BE COLLAPSED MORE THAN .005 AS A RESULT OF STAKING OPERATION.
2. COIL LEADS, CR COIL & TUBING TO BE ASSEMBLED & TERMINATED PER PRINT NUMBER 400405.
3. CONNECTION TO BE SOLDERED WITH SUFFICIENT HEAT TO REMOVE INSULATION & PROVIDE A SOLDER CONNECTION THAT WILL MEET STANDARD QUALITY SOLDER SPECS.
4. RIVETS TO BE TIGHT SUCH THAT THE ARMATURE WILL NOT MOVE IN SIDE-TO-SIDE DIRECTION WITH A SEVEN POUND PULL APPLIED.
5. ALIGN CONTACTS, SET CORE & POINT GAP PER SPEC. #400116
6. ALIGN CONTACTS, SET CORE GAPS PER 400116 & TIGHTEN SCREWS TO 12 IN. LBS. MIN. TORQUE.
7. SEE SPECIFICATION #400116
8. INSTALL COVER & GASKET TO REGULATOR WITH SCREWS WITH A TORQUE OF 8-12 IN. LBS.
9. SEE SPECIFICATION #400517 FOR Q.C. TEST.

OUTLINE DRAWING: 400672

BASE STAMP * 521187

BILL OF MATERIAL & LABOR									
SEQ. NO	ITEM NO	PART NO.	QTY	DESCRIPTION	SPECIAL TOOLING	PROCESS SPECS. DWG NO	NOTE #	LABOR STD	
	1	914015	1	C.O. COIL ASSEMBLY					
	2	914016	1	V.R. COIL ASSEMBLY					
	3	910181	1	C.O. U-MAG ASSEMBLY					
	4	910178	2	V.R./C.R. U-MAGNET ASSEMBLY					
	5	710052	1	C.R. CORE					
	6	710053	1	C.R. PAPER TUBE					
	7	921024	1	BASE ASSEMBLY					
	8	100051-018	1	V.R. WASHER (.036)					
	9	100051-020	1	C.O. WASHER (.075)					
-	-	-	-	STAKE U-MAG ASSY'S TO BASE ASSY			1		
	10	822076	1	C.O. LOWER WASHER					
	11	811013	1	C.R. LOWER WASHER					
	12	814069	1	C.R. COIL ASSEMBLY					
-	-	-	-	ASSEMBLE WASHER & COIL, CRIMP			2		
-	-	-	-	AND HOOK-UP					
	13	510020	AR	SOLDER					
-	-	-	-	SOLDER BOBBIN & COIL LEADS			3		
	14	100001-047	6	RIVETS					
	15	910103	1	V.R. ARMATURE ASSEMBLY					
	16	921041	1	C.R. ARMATURE ASSEMBLY					
	17	910106	1	C.O. ARMATURE ASSEMBLY					
-	-	-	-	RIVET ARMATURE ASSY'S TO U-MAGS			4		
-	-	-	-	BASE STAMP					
	18	910136	2	V.R./C.R. POINT MOUNT ASSEMBLY					
	19	710063	2	INSULATORS					
	20	911006	1	CONNECTION BAR					
	21	710036	2	SHOULDER BUSHING					
	22	100109	2	SCREWS, #8-32 HEXHEAD					
-	-	-	-	ASSEMBLE & RIVET PT. MTS. TO					
-	-	-	-	U-MAGS					
	23	710006	1	C.O. SPRING					
-	-	-	-	POINT SET AND SPRING - C.O.			5		
	24	710005	1	C.R. SPRING					
	25	710006	1	V.R. SPRING					
-	-	-	-	POINT SET AND SPRING- C.R./V.R.			6		
-	-	-	-	POINT SET AND SPRING - C.R./V.R.			6		
-	-	-	-	ELEC. SET REG.			7		
	26	922201	1	COVER					
	27	724029	1	GASKET					
	28	100670-003	2	SCREWS					
-	-	-	-	ASSEMBLE COVER TO REGULATOR			8		
-	-	-	-						
-	-	-	-						
-	-	-	-						
-	-	-	-	DATE STAMP					
010	-	-	-	BELT LINE OPERATION - 11 OPERATORS					

9-1-16	H	34464	510020 WAS 500181, REMOVED 100923 & 100671-005	CS	MCB
9-15-10	G	29935	500181 WAS 510020	DM	ACD
12-13-04	F	27166	REVISED BOM PER P.E.	JP	MM
8-25-89	E	14730	REV. BILL OF MAT'L.	AM	B
5/12/87	D	13072	CHANGED P.N. 100109 TO 100105	CS	CS
8-1-86	C	12406	REV. NOTE #6	CJH	KE
7-24-86	B	12295	REV. B/M	CJH	KE
3-22-85	A	11224	GRD. SCREW LOCATION CHANGED	CJH	KE
DATE	SYM	P.E. NO.	REVISION	DR.	CR'D

USED ON: VR-152

TOLERANCES				Automotive Controls Corporation Independence, Kansas			
DECIMAL				SCALE	DRAWN BY	A.M.	
± N.A.				NONE	APPROVED BY	ES	
FRACTIONAL				REGULATOR ASSY. - 24 VOLT			
± N.A.				DATE	DRAWING NUMBER	2152	ISSUE
ANGULAR				3-8-85			H
± N.A.				P.E. NO: 11142			