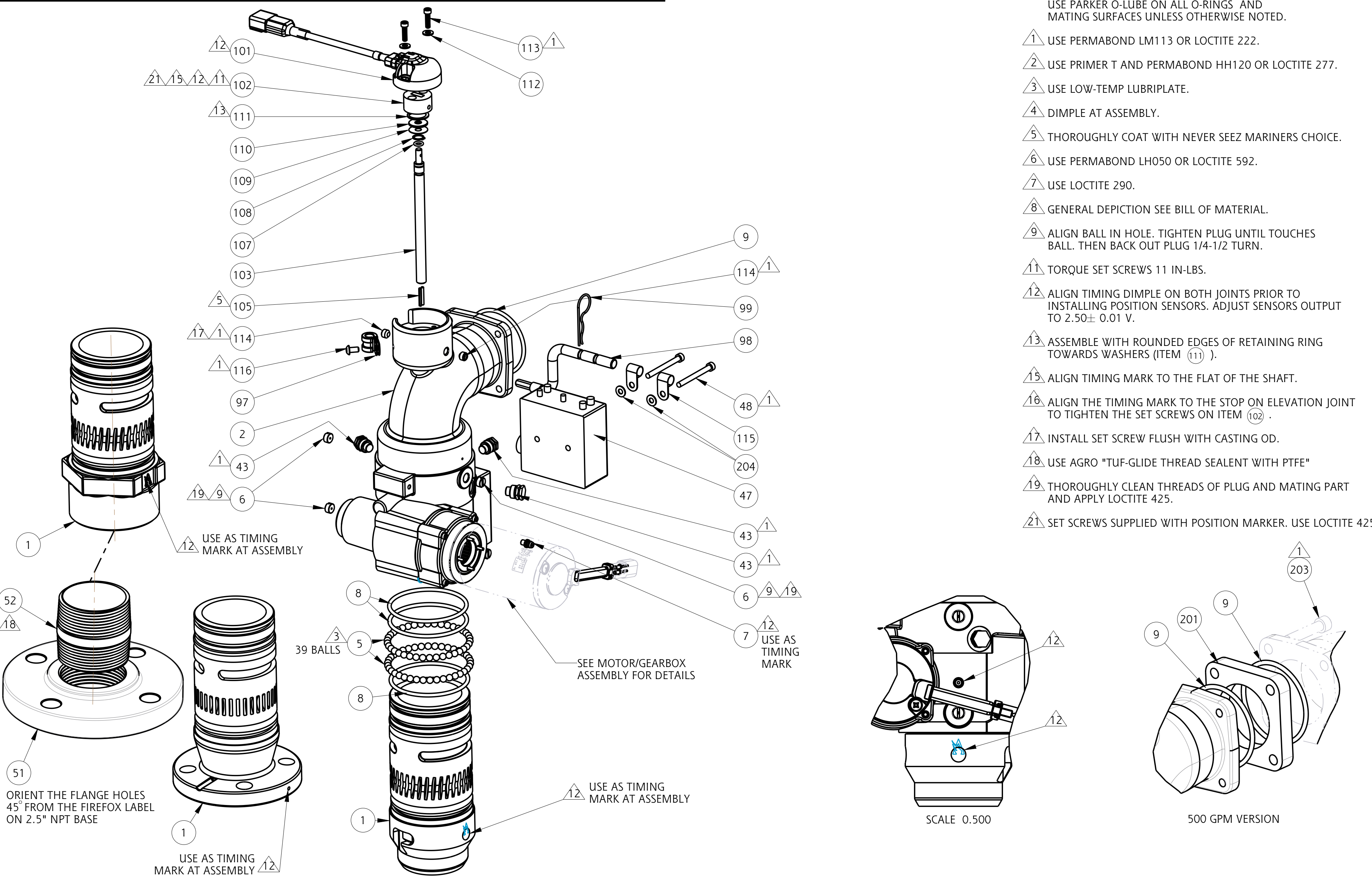




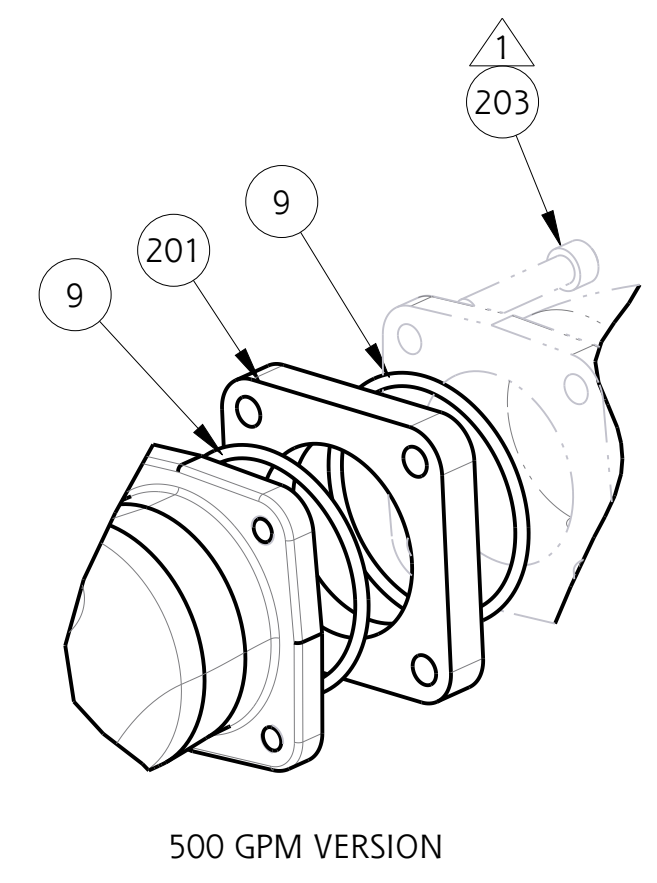
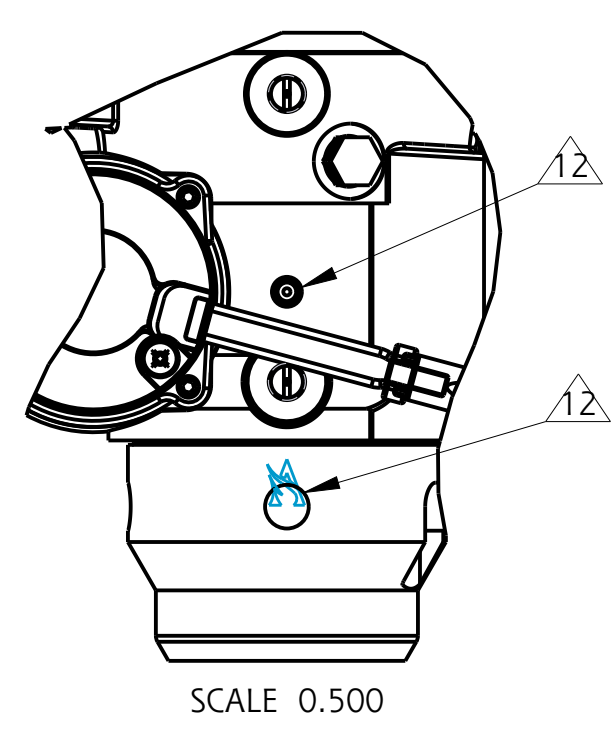
TECHNICAL SERVICE PARTS
STYLE 3463, 3563
PRODUCT FIREFOX 2" INLET W/POSITION SENSORS

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Chg.	Date
21	02-19
22	01-20



- ASSEMBLY NOTES:
- 1 USE PERMABOND LM113 OR LOCTITE 222.
 - 2 USE PRIMER T AND PERMABOND HH120 OR LOCTITE 277.
 - 3 USE LOW-TEMP LUBRIPLATE.
 - 4 DIMPLE AT ASSEMBLY.
 - 5 THOROUGHLY COAT WITH NEVER SEEZ MARINERS CHOICE.
 - 6 USE PERMABOND LH050 OR LOCTITE 592.
 - 7 USE LOCTITE 290.
 - 8 GENERAL DEPICTION SEE BILL OF MATERIAL.
 - 9 ALIGN BALL IN HOLE. TIGHTEN PLUG UNTIL TOUCHES BALL. THEN BACK OUT PLUG 1/4-1/2 TURN.
 - 11 TORQUE SET SCREWS 11 IN-LBS.
 - 12 ALIGN TIMING DIMPLE ON BOTH JOINTS PRIOR TO INSTALLING POSITION SENSORS. ADJUST SENSORS OUTPUT TO 2.50± 0.01 V.
 - 13 ASSEMBLE WITH ROUNDED EDGES OF RETAINING RING TOWARDS WASHERS (ITEM 111).
 - 15 ALIGN TIMING MARK TO THE FLAT OF THE SHAFT.
 - 16 ALIGN THE TIMING MARK TO THE STOP ON ELEVATION JOINT TO TIGHTEN THE SET SCREWS ON ITEM 102.
 - 17 INSTALL SET SCREW FLUSH WITH CASTING OD.
 - 18 USE AGRO "TUF-GLIDE THREAD SEALANT WITH PTFE"
 - 19 THOROUGHLY CLEAN THREADS OF PLUG AND MATING PART AND APPLY LOCTITE 425.
 - 21 SET SCREWS SUPPLIED WITH POSITION MARKER. USE LOCTITE 425.



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Parts List Sheet:
122445
 D45681



TECHNICAL SERVICE PARTS

STYLE 3463, 3563

PRODUCT FIREFOX 2" INLET W/POSITION SENSORS

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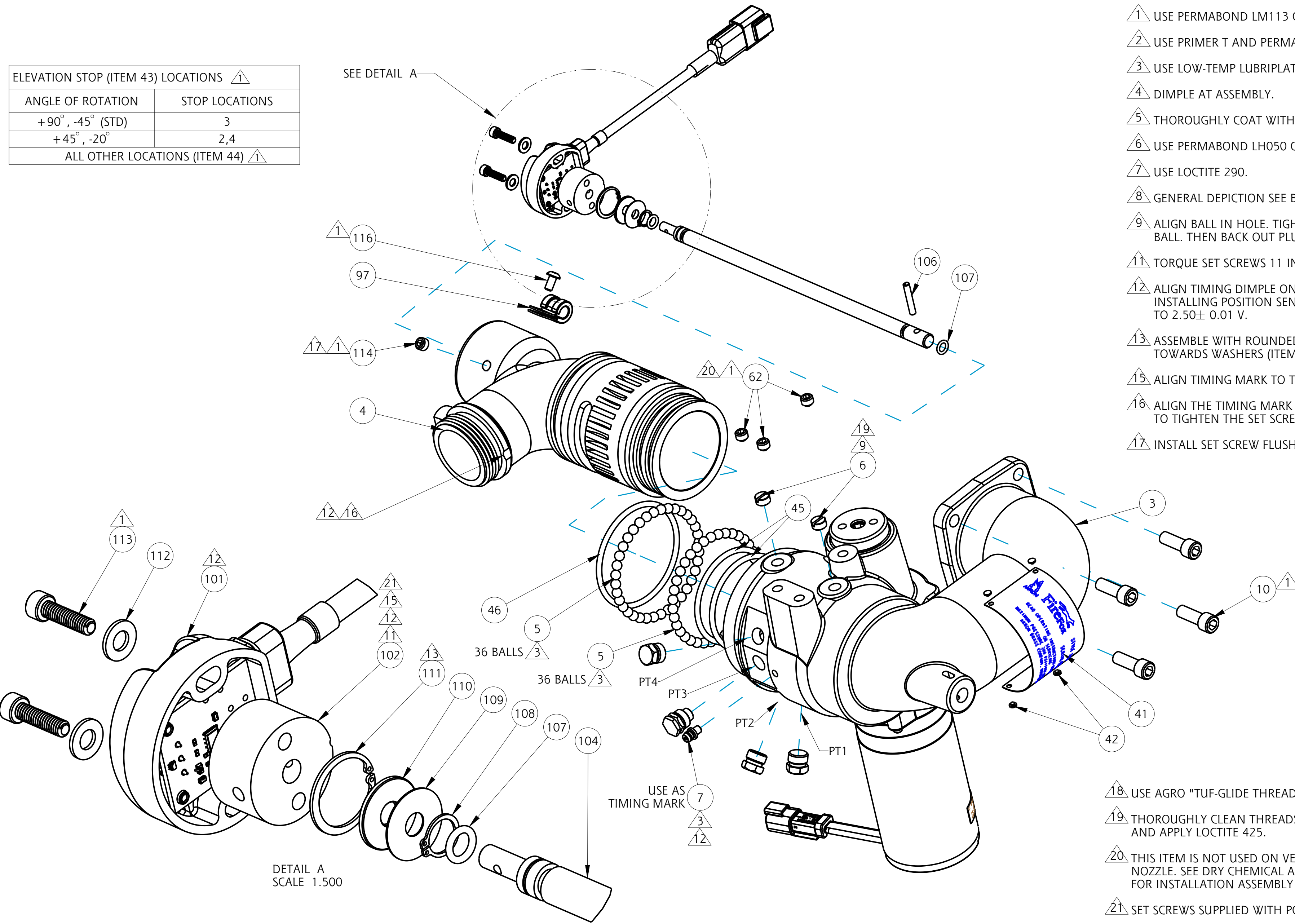
Chg.	Date
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ELEVATION STOP (ITEM 43) LOCATIONS ¹	
ANGLE OF ROTATION	STOP LOCATIONS
+90°, -45° (STD)	3
+45°, -20°	2,4
ALL OTHER LOCATIONS (ITEM 44) ¹	

ASSEMBLY NOTES:

USE PARKER O-LUBE ON ALL O-RINGS AND MATING SURFACES UNLESS OTHERWISE NOTED.

- ¹ USE PERMABOND LM113 OR LOCTITE 222.
- ² USE PRIMER T AND PERMABOND HH120 OR LOCTITE 277.
- ³ USE LOW-TEMP LUBRIPLATE.
- ⁴ DIMPLE AT ASSEMBLY.
- ⁵ THOROUGHLY COAT WITH NEVER SEEZ MARINERS CHOICE.
- ⁶ USE PERMABOND LH050 OR LOCTITE 592.
- ⁷ USE LOCTITE 290.
- ⁸ GENERAL DEPICTION SEE BILL OF MATERIAL.
- ⁹ ALIGN BALL IN HOLE. TIGHTEN PLUG UNTIL TOUCHES BALL. THEN BACK OUT PLUG 1/4-1/2 TURN.
- ¹¹ TORQUE SET SCREWS 11 IN-LBS.
- ¹² ALIGN TIMING DIMPLE ON BOTH JOINTS PRIOR TO INSTALLING POSITION SENSORS. ADJUST SENSORS OUTPUT TO 2.50± 0.01 V.
- ¹³ ASSEMBLE WITH ROUNDED EDGES OF RETAINING RING TOWARDS WASHERS (ITEM ¹¹).
- ¹⁵ ALIGN TIMING MARK TO THE FLAT OF THE SHAFT.
- ¹⁶ ALIGN THE TIMING MARK TO THE STOP ON ELEVATION JOINT TO TIGHTEN THE SET SCREWS ON ITEM ¹⁰².
- ¹⁷ INSTALL SET SCREW FLUSH WITH CASTING OD.



- ¹⁸ USE AGRO "TUF-GLIDE THREAD SEALANT WITH PTFE"
- ¹⁹ THOROUGHLY CLEAN THREADS OF PLUG AND MATING PART AND APPLY LOCTITE 425.
- ²⁰ THIS ITEM IS NOT USED ON VERSION WITH DRY CHEMICAL NOZZLE. SEE DRY CHEMICAL ASSEMBLY DRAWING (D-41621) FOR INSTALLATION ASSEMBLY DETAILS.
- ²¹ SET SCREWS SUPPLIED WITH POSITION MARKER. USE LOCTITE 425.

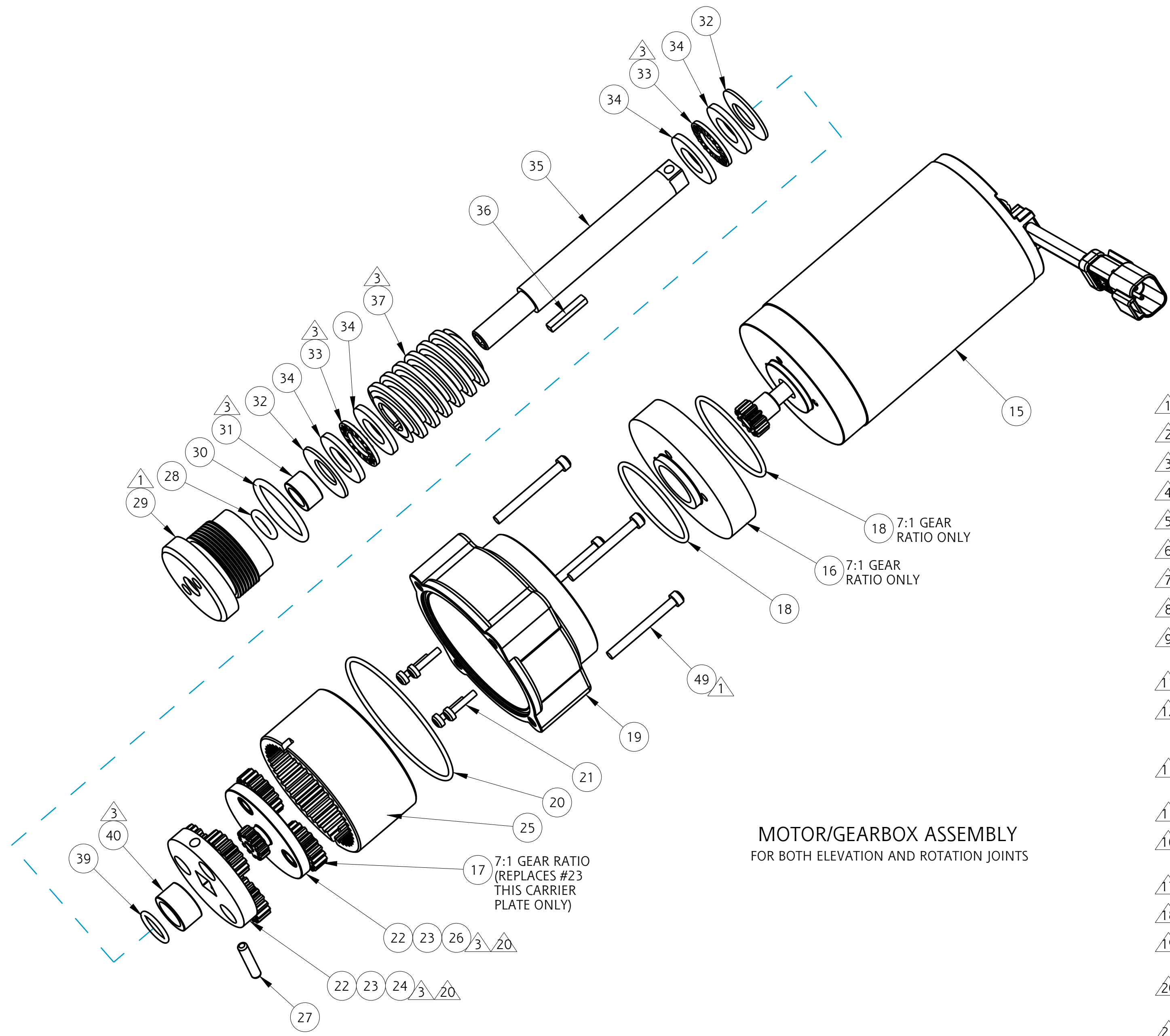
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MOTOR/GEARBOX ASSEMBLY
FOR BOTH ELEVATION AND ROTATION JOINTS

- ASSEMBLY NOTES:**
- USE PARKER O-LUBE ON ALL O-RINGS AND MATING SURFACES UNLESS OTHERWISE NOTED.
 - 1 USE PERMABOND LM113 OR LOCTITE 222.
 - 2 USE PRIMER T AND PERMABOND HH120 OR LOCTITE 277.
 - 3 USE LOW-TEMP LUBRIPLATE.
 - 4 DIMPLE AT ASSEMBLY.
 - 5 THOROUGHLY COAT WITH NEVER SEEZ MARINERS CHOICE.
 - 6 USE PERMABOND LH050 OR LOCTITE 592.
 - 7 USE LOCTITE 290.
 - 8 GENERAL DEPICTION SEE BILL OF MATERIAL.
 - 9 ALIGN BALL IN HOLE. TIGHTEN PLUG UNTIL TOUCHES BALL. THEN BACK OUT PLUG 1/4-1/2 TURN.
 - 10 TORQUE SET SCREWS 11 IN-LBS.
 - 11 ALIGN TIMING DIMPLE ON BOTH JOINTS PRIOR TO INSTALLING POSITION SENSORS. ADJUST SENSORS OUTPUT TO 2.50± 0.01 V.
 - 12 ASSEMBLE WITH ROUNDED EDGES OF RETAINING RING TOWARDS WASHERS (ITEM 111).
 - 13 ALIGN TIMING MARK TO THE FLAT OF THE SHAFT.
 - 14 ALIGN THE TIMING MARK TO THE STOP ON ELEVATION JOINT TO TIGHTEN THE SET SCREWS ON ITEM 102.
 - 15 INSTALL SET SCREW FLUSH WITH CASTING OD.
 - 16 USE AGRO "TUF-GLIDE THREAD SEALANT WITH PTFE"
 - 17 THOROUGHLY CLEAN THREADS OF PLUG AND MATING PART AND APPLY LOCTITE 425.
 - 18 QUANTITY OF 4 INSTEAD OF 3 AS SHOWN FOR HIGH SPEED GEAR UNITS.
 - 19 SET SCREWS SUPPLIED WITH POSITION MARKER. USE LOCTITE 425.

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TECHNICAL SERVICE PARTS

STYLE 3463, 3563

PRODUCT FIREFOX 2" INLET W/POSITION SENSORS

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Chg.	Date
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Find	Description	Item	QTY
1	STANDARD - BASE, 2" NPT THREADED INLET	122439	1
1	OPTIONAL - BASE, 2-1/2" NPT THREADED INLET	122441	1
1	OPTIONAL - BASE, 2" BSPT THREADED INLET	126250	1
1	OPTIONAL - BASE, 2-1/2" BSPT THREADED INLET	122981	1
1	OPTIONAL - BASE, 1-1/2" FLANGE	121064	1
2	ELBOW, INLET	122437	1
3	GOOSENECK	122440	1
4	ELBOW, OUTLET 1.5"	122438	1
4	ELBOW, OUTLET 2.5"	122563	1
5	A BALL, BRASS 1/4"OD	-	150
6	PLUG, SWIVEL CELCON 3/8-24 x 3/16"	742023	8
7	FITTING, 3/16 PRESSFIT GREASE	713191	2
8	O-RING 2-233	757065	3
9	* O-RING 2-230	757110	*
10	SCREW, SOCKET HEAD CAP 5/16-18 x 7/8"	767048	4
15	MOTOR, 12VDC (STD)	35982013	2
15	MOTOR, 24VDC (STD)	35982012	2
15	MOTOR, 12VDC (7:1 RATIO)	35982003	2
15	MOTOR, 24VDC (7:1 RATIO)	35982005	2
15	MOTOR, 12VDC (HIGH SPEED)	34620000	2
16	C PLATE SPACER (7:1 RATIO)	-	-
17	C GEAR PLANET (7:1 RATIO)	-	-
18	O-RING 2-029	757056	2
19	HOUSING, GEARBOX	109320	2
20	O-RING 2-036	757312	2
21	SCREW, SOCKET HEAD CAP W/PATCH 6-32 x 1/2"	765052	8
21	SCREW, SOCKET HEAD CAP W/PATCH 6-32 x 1" (7:1 RATIO)	765160	8
22	B,C,D RIVET, SHORT	-	-
23	B,C,D GEAR, PLANET	-	-
24	B,C,D CARRIER, OUTPUT	-	-
25	GEAR, INTERNAL ELEVATION	718164	2
26	B,C,D PLATE, CARRIER	-	-
27	B,D PIN 5/32" x 3/4"	-	-
28	O-RING 2-110	757295	2
29	CAP, ELEVATION BEARING	116465	2
30	O-RING 2-121	757329	2
31	BEARING, 3/8"ID	704393	2
32	SPRING, BELLEVILLE	769276	4
33	BEARING, TORRINGTON NEEDLE	703453	4
34	WASHER, THRUST	784121	8
35	SHAFT, ELEVATION	769697	2
36	KEY, SPECIAL	727044	2
37	GEAR, HARDENED WORM	718273	2
38	PIN, ROLL 1/8 X 1/2	744288	4
39	O-RING 2-014	757041	2
40	BEARING, NEEDLE ROLLER	704395	2
41	PLATE, ID - 3463, 12V	745125	1
41	PLATE, ID - 3463, 24V	745266	1
41	PLATE, ID - 3563	773395	1
42	NAIL, GRIP	736052	4

Find	Description	Item	QTY
43	STOP	769498	4
44	PLUG 1/2-20 x 1/2"	744337	3
45	O-RING 2-229	757205	2
46	O-RING 2-231	757126	1
47	HARNESS, 2' WIRING (OPTIONAL)	721669	1
47	HARNESS 8" WIRING	721622	1
48	SCREW, SOCKET HEAD CAP 10-24 X 2"	763077	2
49	SCREW, SOCKET HEAD CAP 6-32 X 1-3/8"	767132	8
51	*** OPTIONAL FLANGE 3" 150# FLAT FACE	712285	1
51	*** OPTIONAL FLANGE 2.5" 150# FLAT FACE	712283	1
52	*** OPTIONAL NIPPLE	735089	1
62	SCREW, SOCKET HEAD CUP POINT SET 5/16-18 x 1/4"	765071	3
77	SCREW, PAN HEAD CAP SCREW 10-24 x 1/2"	767147	1
97	CLAMP, 1/4" ID CABLE	707189	2
98	HANDLE, OVERRIDE	721291	1
99	CLIP, HAIRPIN COTTER	744339	1
100	SCREW, SOCKET HEAD CUP POINT SET 8-32 x 1/4"	765164	1
101	ASSEMBLY, SENSOR MAGNETIC ROTARY ANGLE	60430006	2
102	MARKER, MAGNET POSITION	731127	2
103	SHAFT, ROTATION FEEDBACK	769894	1
104	** SHAFT, ELEVATION FEEDBACK	-	1
105	PIN, ROLL	744078	1
106	PIN, ROLL	744430	2
107	O-RING 2-010	757476	3
108	RING, TRUARC	758247	2
109	SHIM	769887	2
110	WASHER	784192	2
111	RING, RETAINING TRUARC	758127	2
112	WASHER #8	784123	4
113	SCREW, SOCKET HEAD CAP 8-32 x 5/8"	765360	4
114	SCREW, SOCKET HEAD CUP POINT SET 5/16-18 x 1/4"	765071	4
115	CLAMP, CABLE	807139	2
116	SCREW, BUTTON HEAD CAP 10-24 x 3/8"	765143	2
201	SPACER, 2-1/2" OUTLET	118949	1
203	SCREW SOC HD CAP 5/16-18 x 1-1/2	765222	4
204	WASHER	784072	2
A	KIT OF 50 BALLS	109041	
B	STANDARD GEAR REPAIR KIT	34400209	
C	7:1 GEAR REPAIR KIT	34635142	
D	HIGH SPEED GEAR REPAIR KIT	35630019	

* QUANTITY OF 1 REQUIRED FOR 1-1/2" OUTLET.

QUANTITY OF 2 REQUIRED FOR 2-1/2" OUTLET.

** SHAFT 769895 REQUIRED FOR 1-1/2" OUTLET.

SHAFT 770365 REQUIRED FOR 2-1/2" OUTLET.

*** OPTIONAL PARTS FOR 3" FLANGE.

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