

NO.: 10

DATE: June 15, 1991

APPLICATION  SERVICE

### SUBJECT: ASSEMBLY OF FLANGE TO ALTRONIC III UNITS

The recommended procedure for installing the flange on the Altronic III units has been revised:

1. The flange assembly (360 403-x or 360 459) should be heated to 185-221° F. (85-105° C.) for one hour.  
NOTE: This maintains a higher back-off torque for the flange screws during subsequent heating/cooling cycles in normal operation.
2. Carefully position the flange over the shaft into position against the housing; note the correct orientation of the flange corresponding to the part number on the label of the unit.
3. Using a 5/32" hex socket key, install the four screws and tighten loosely in a crossing pattern sequence (1-2-3-4) as shown below; then torque all screws using the same crossing pattern sequence to 10-12 ft.-lbs. (1.4-1.7 kgm).

