

Work Instruction – 7210687-001 revA

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Document Name: BMP Assembly Instructions

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Department: Manual Assembly

1.0 Scope

This document details the assembly procedure for the BMP Marker probe.

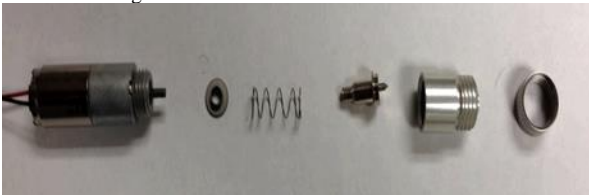
2.0 Associated Documents

3.0 Procedure Steps

3.1 Allocate Parts and Tools:

Parts (Shown Below):

- Gear Motor
- Spring Plate
- Spring
- Stylus Holder w/stylus
- Housing
- Press Ring



Tools:

Thin walled tubing: Approx.: .110"OD x .093"ID x 1.25" L. The exact diameter of the tubing is not critical as long as it slips inside

the hole in the housing easily with clearance and slips over the stylus easily as well.

3.2 Assembly Steps:

3.2.1: Insert Spring plate over motor shaft as shown below:



3.2.2: Slide spring over stylus holder and slide stylus holder over motor shaft as shown below:



3.2.3: Use tubing (shown above) to hold stylus holder against end of motor shaft while rotating stylus holder until the flat on the motor shaft engages inside the stylus holder. Once engaged, the small diameter on the stylus holder will slip inside the spring plate as shown below.



NOTE! DO NOT proceed to the next step until stylus holder is properly engaged with motor shaft! Failure to do so may result in damage to the gear motor!

3.2.4: While holding stylus holder all the way in, carefully slip the housing over the tubing as shown below.



3.2.5: Apply a small amount of Loctite 220 or 242 to threads on gear motor, then thread housing onto gear motor until finger tight as shown below.



BMP motor assembly is now complete. Check to make sure the stylus can be depressed easily without binding and that it snaps back when released. If binding occurs, check for proper assembly.

NOTE: For the purposes of creating this guide and ease of taking pictures, the gear motor is shown clamped in a mini-vise. This is NOT necessary in order to perform the assembly process. If a mini-vise or other clamp is used, special care must be followed in order not to damage the motor. Clamp the gear motor VERY lightly. Clamping the gear motor too tightly may result in damage to the gear motor!