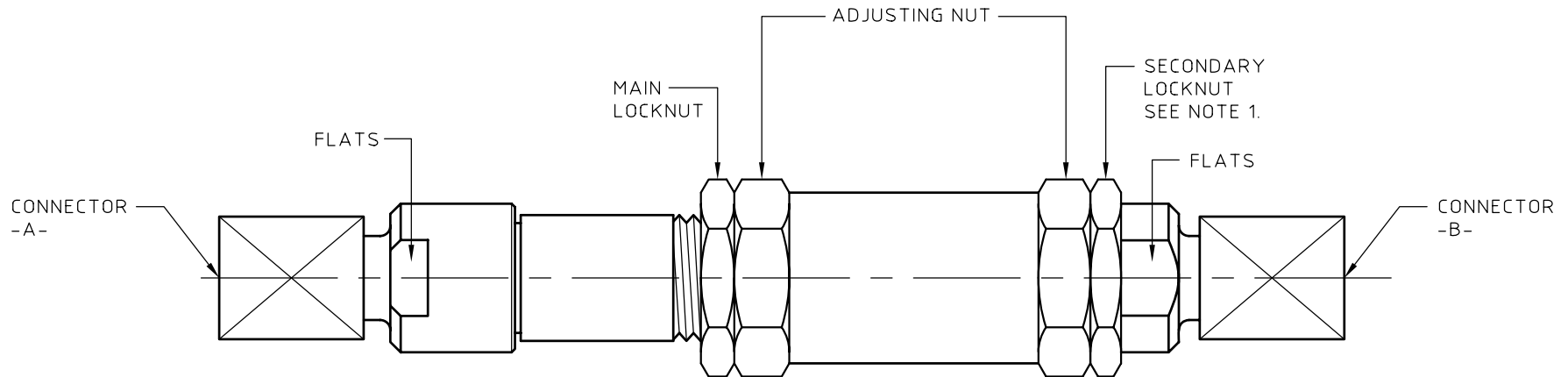


CONTROL DRAWING

400NNX-PAM

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PROPER PHASE ADJUSTMENT METHOD:

- 1.0 INSTALL UNIT
CONNECT BOTH ENDS OF UNIT TO THEIR RESPECTIVE MATING CONNECTORS.
USE THE PROVIDED FLATS TO HOLD UNIT STEADY AND THREAD AND TORQUE INTERFACE NUTS TO MIL-STD VALUES.

- 2.0 ADJUST PHASE
UNITS ARE DELIVERED BY ASTROLAB AT MID-RANGE $\pm 10\%$ OF TOTAL ADJUSTMENT.
VERIFY THAT THE LOCKNUT(S) ARE NOT INTERLOCKED AGAINST THE ADJUSTING NUT.
IF THAT IS THE CASE THEN HOLD UNIT STEADY BY HOLDING OVER THE ADJUSTING NUT AND ROTATE THE LOCKNUT(S) LOOSE.
ADJUST PHASE BY HOLDING UNIT STEADY AND ROTATING ADJUSTING NUT ONLY!

DO NOT ROTATE EITHER END OF UNIT!
BOTH ENDS OF UNIT MUST BE HELD STATIONARY DURING ADJUSTMENTS.

- 3.0 LOCK SETTINGS
FIX DESIRED PHASE SETTING BY INTERLOCKING LOCKNUTS AGAINST ADJUSTING NUT.
FIRST INTERLOCK THE SECONDARY LOCKNUT (IF PRESENT), TORQUE TO 20 ± 2 IN-LBS [$2.26 \pm .23$ Nm], THEN THREAD AND INTERLOCK MAIN LOCKNUT AGAINST ADJUSTING NUT, TORQUE TO 20 ± 2 IN-LBS [$2.26 \pm .23$ Nm].

NOTES

1. SECONDARY LOCKNUTS ARE NOT PRESENT ON ALL UNITS.

UNLESS OTHERWISE SPECIFIED
CONCENTRICITY .004 T.I.R.
CORNERS AND FILLETS .005
MAX. RADIUS OR CHAMFER.
SURFACE FINISH 63 RMS
MICROINCHES OR BETTER.

FRACTIONS	$\pm 1/16$
X	$\pm .030$
XX	$\pm .015$
XXX	$\pm .005$
ANGLES	$\pm 1'$
DO NOT SCALE DRAWING	

NAME	DATE
PREP. GSG	02/08/06
ELEC. RF	02/08/06
MECH. AW	02/08/06
Q.C.	



astrolab® INC.
WARREN, NJ

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TITLE	PHASE ADJUSTMENT METHOD, 400NNX SERIES		
THDS. TO BE IN ACCORD WITH U.S. DEPT. OF COMM. SCREW THD. STDS. FOR FEDERAL SERVICES 1950 SUPL. TO HANDBOOK H 28.	SCALE	CODE IDENT.	DWG NO.
	2:1	16301	400NNX-PAM
REV.			A

A	ECN No. 10689	03/01/06	GSG	
REV.	DESCRIPTION	DATE	BY	APPROVED