



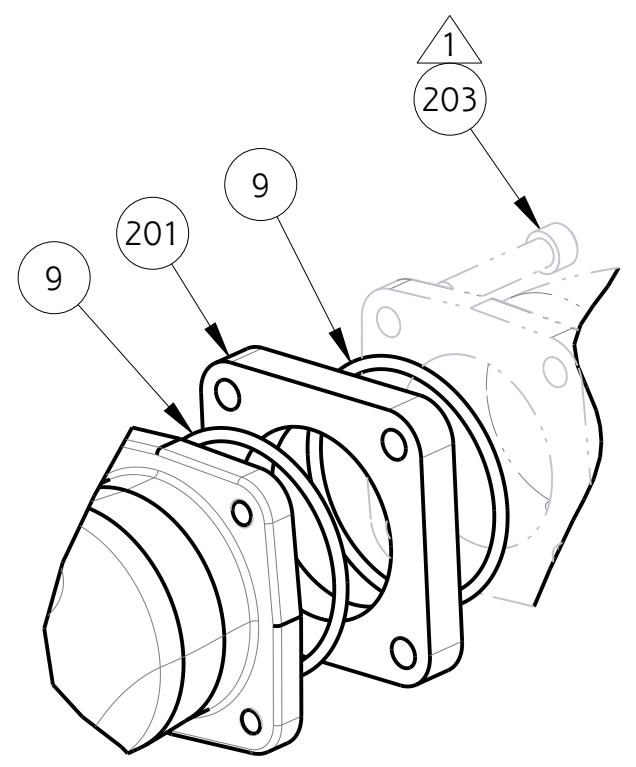
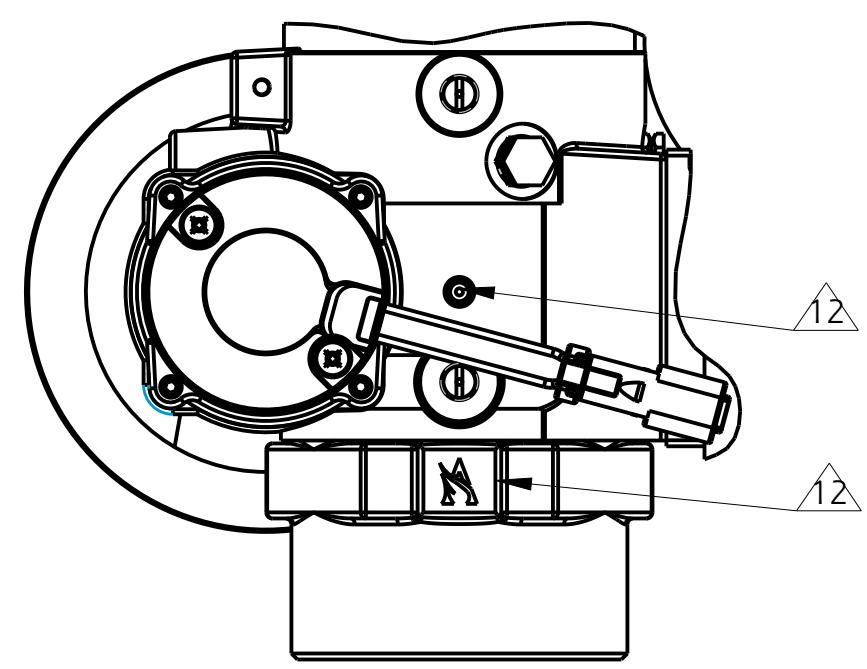
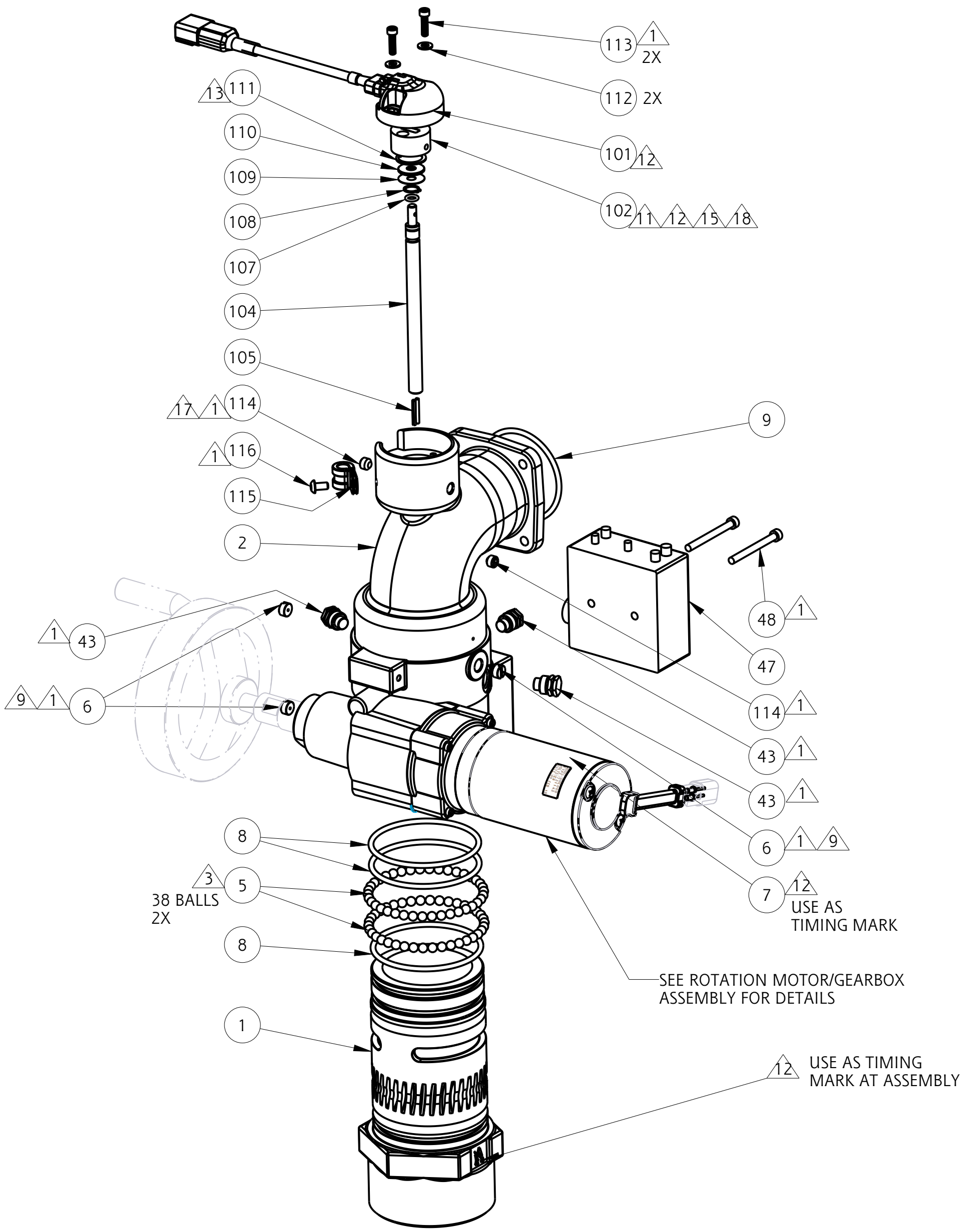
**TECHNICAL SERVICE PARTS**

STYLE 3463

PRODUCT FIREFOX 2.5" INLET W/POSITION SENSORS

IF AN ITEM IS NOTED AS "NOT FIELD REPAIRABLE", OR YOU WISH TO RETURN AN ITEM TO AKRON BRASS FOR SERVICE PLEASE GO ONLINE TO, [ONLINEREPAIR.AKRONBRASS.COM](http://ONLINEREPAIR.AKRONBRASS.COM)

Chg.	Date
04	06-18
05	01-20



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  $2.50 \pm 0.01$  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 SET SCREWS SUPPLIED WITH POSITION MARKER. USE LOCTITE 425.

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Parts List Sheet:  
**124124**

D47117



**TECHNICAL SERVICE PARTS**  
**STYLE 3463**  
**PRODUCT FIREFOX 2.5" INLET W/POSITION SENSORS**

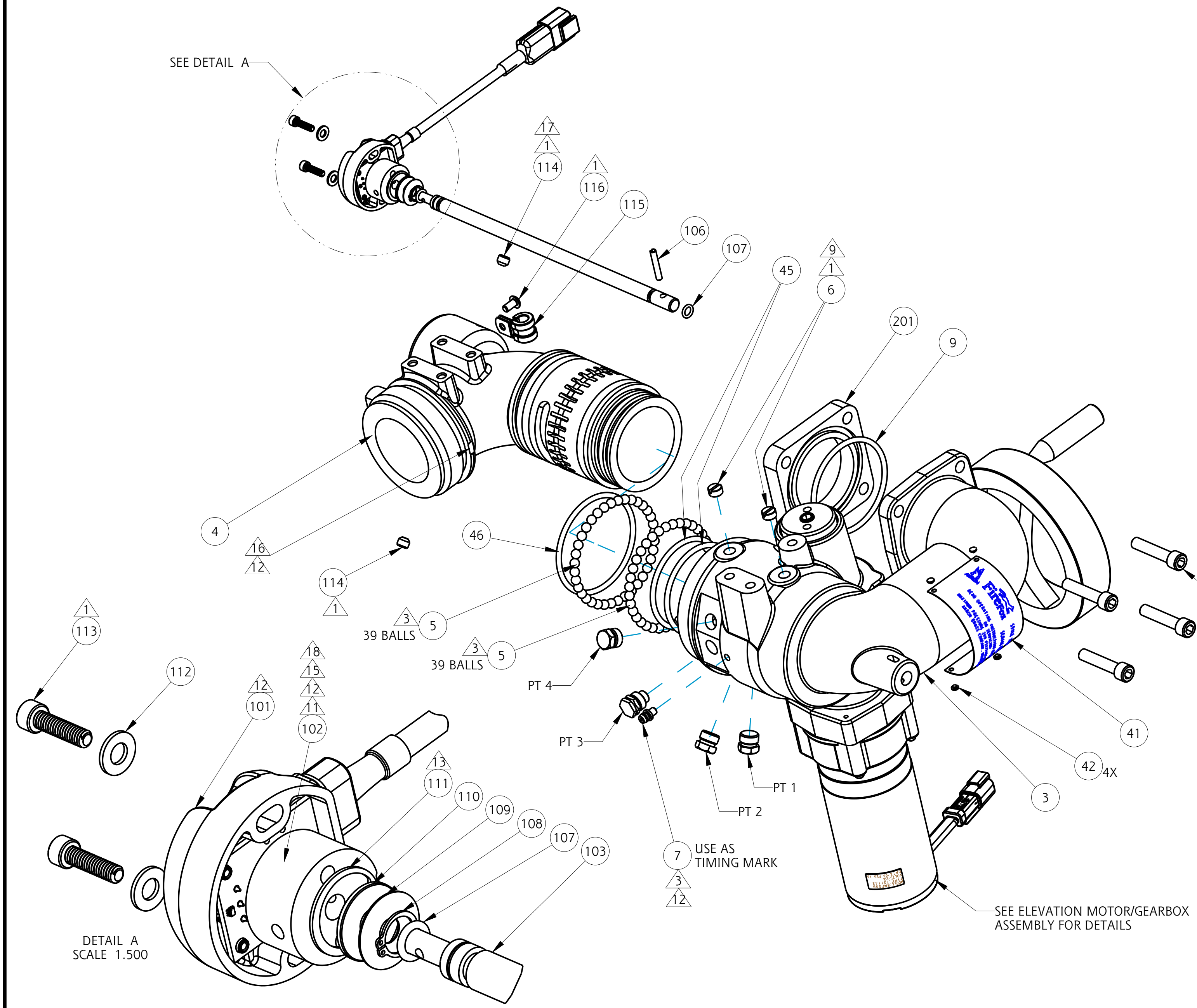
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ELEVATION STOP (ITEM 43) LOCATIONS 1	
ANGLE OF ROTATION	STOP LOCATIONS
+90°, -45° (STD)	3
+45°, -20°	2,4
ALL OTHER LOCATIONS (ITEM 44) 1	

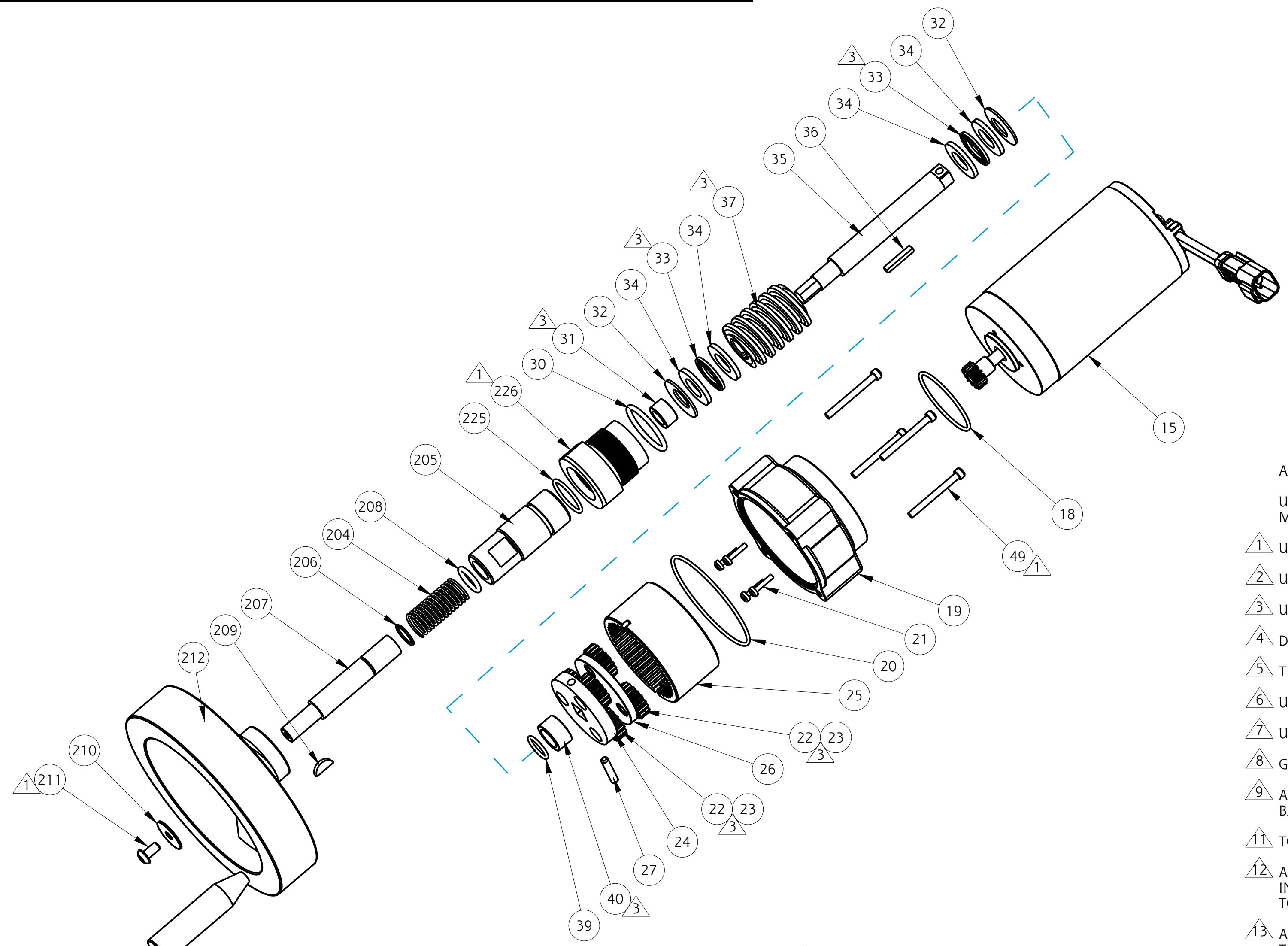
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**MOTOR/GEARBOX ASSEMBLY  
FOR ROTATION JOINT**

- ASSEMBLY NOTES:**
- USE PARKER O-LUBE ON ALL O-RINGS AND MATING SURFACES UNLESS OTHERWISE NOTED.
  - 1 USE PERMABOND LM113 OR LOCTITE 222.
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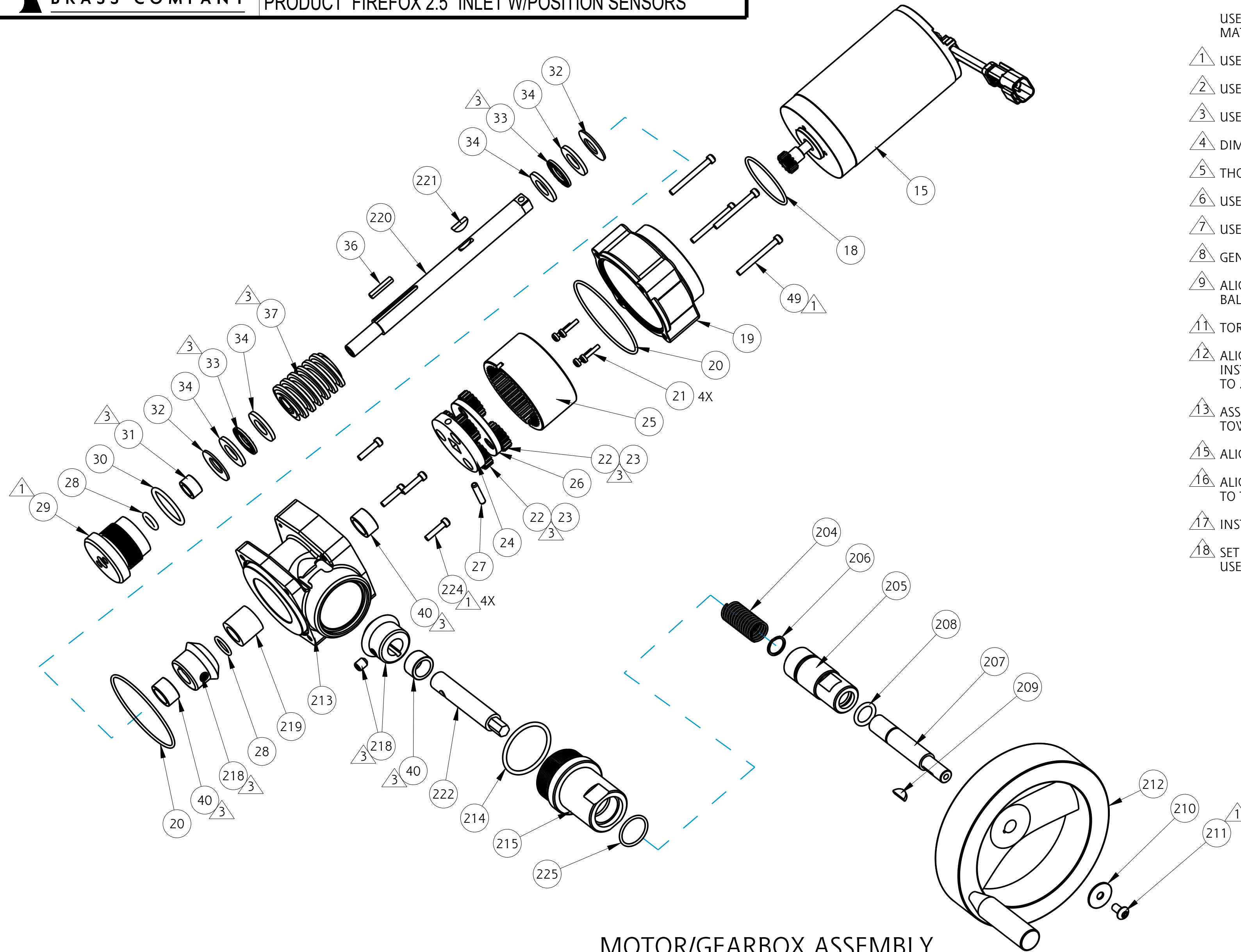
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MOTOR/GEARBOX ASSEMBLY  
ELEVATION JOINT

ASSEMBLY NOTES:

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**STYLE 3463**  
**PRODUCT FIREFOX 2.5" INLET W/POSITION SENSORS**

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Chg.	Date
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Find	Description	Item	QTY
1	STANDARD - BASE, 2" THREADED INLET	122439	1
1	OPTIONAL - BASE, 2-1/2" NPT THREADED INLET	122441	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	122563	1
5	A BALL, BRASS 1/4"OD	-	148
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	-
15	MOTOR, 12VDC	35982013	2
15	MOTOR, 24VDC	35982012	2
18	O-RING 2-029	757056	2
19	HOUSING, GEARBOX	109320	2
20	O-RING 2-036	757312	3
21	SCREW, SOCKET HEAD CAP W/PATCH 6-32 x 1/2"	765052	8
22	B RIVET, SHORT	754052	12
23	B GEAR, PLANET	718165	12
24	B CARRIER, OUTPUT	707455	2
25	GEAR, INTERNAL ELEVATION	718164	2
26	B PLATE, CARRIER	742119	2
27	B PIN 5/32" x 3/4"	741056	2
28	O-RING 2-018	757295	1
29	CAP, ELEVATION BEARING	116465	1
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, ROTATION	769924	1
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	4
41	PLATE, ID	745266	1
42	NAIL, GRIP	736052	4
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

Find	Description	Item	QTY
51	*** OPTIONAL FLANGE	712285	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
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, ELEVATION FEEDBACK	769894	1
104	SHAFT, ROTATION FEEDBACK	770365	1
105	PIN, ROLL	744078	2
106	PIN, ROLL	744430	1
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, 5/16" CABLE	707548	2
116	SCREW, BUTTON HEAD CAP 10-24 x 3/8"	765143	2
201	SPACER, 2-1/2" OUTLET	118949	1
203	SCREW 5/16-18 X 1-1/2	765222	4
204	SPRING	768435	2
205	SHAFT ROTATION CAP	122714	2
206	RETAINING RING	758311	2
207	HANDWHEEL SHAFT	769925	2
208	O-RING 2-112	757313	2
209	KEY HANDWHEEL	727026	2
210	FLAT WASHER	784168	2
211	BTTN HEAD SCREW 10-24 X 3/8	765143	2
212	HANDWHEEL	721608	2
213	OVERRIDE HOUSING	118598	1
214	O-RING 2-126	757311	1
215	GEARBOX ADAPTER	123046	1
218	GEAR W/ SET SCREW	718185	2
219	CELCON COLLAR	707433	1
220	ELEVATION SHAFT	769926	1
221	WOODRUFF KEY	727025	1
222	STUB SHAFT	770380	1
224	SCREW 6-32 X 5/8	765179	4
225	O-RING 2-018	757042	2
226	CAP-BEARING	123047	1
A	KIT OF 50 BALLS	109041	
B	GEAR REPAIR KIT	34400209	

\* Quantity of 1 required for 1-1/2" outlet.  
Quantity of 2 required for 2-1/2" outlet.

\*\*\* Optional parts for 3" flange.  
Use with 122441 base only (Not shown).

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