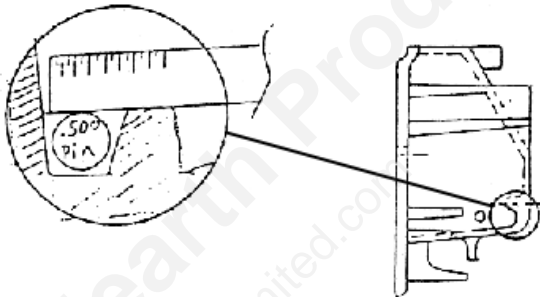
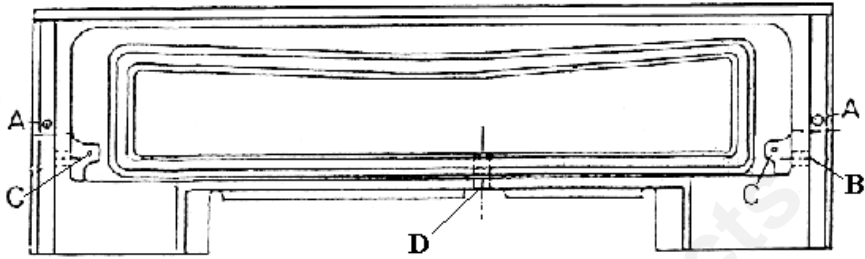


**REVISIONS**

LTR	DESCRIPTION	APPROVAL	DATE
A	"B" Hole Made Larger	DCO 1817	6/30/1992
B	Spec. updated for warranty.	DCO 2832	2/17/1995
C	Shifted "D" hole.	ECN 3003243	#####



**Cleaning:**

Pangborn  
**Inside Face Down**  
 6 Per pallet maximum

**Grinding:**

Perimeter

**In-Line Setup**

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**Fixture Location**

B - 5	1 - Machine
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**Drilling:**

Hole	Qty	Drill	Tap	Comments
A	2	13/64 Thru	1/4-20 Thru	
B	1	13/32 Thru		Use Fixture (Save fixture for warranty.)
C	2	13/64 X 1/2	1/4-20 X 5/16	
D	1	13/64 Thru	1/4-20 Thru	Use Fixture (Save fixture for warranty.)

**QC:**

- Non-Cosmetic
- To gauge maximum softpack in damper hinge cradle, place a .500" pin in cradle. A straightedge placed across the top of the boss should clear the pin. See diagram. Gauge both sides, 3 parts every

Use 129-8630 for Source Part.

**VERMONT CASTINGS**

P/N: 130-8624 Model: Encore '91  
 Name: Upper Fireback Date: 4/12/1991