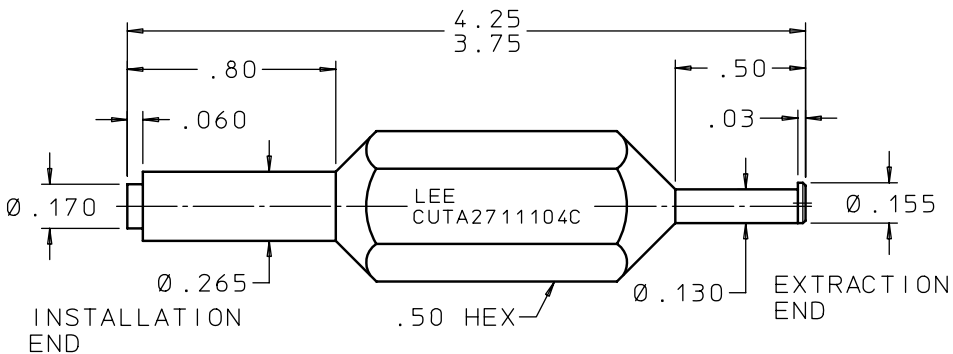


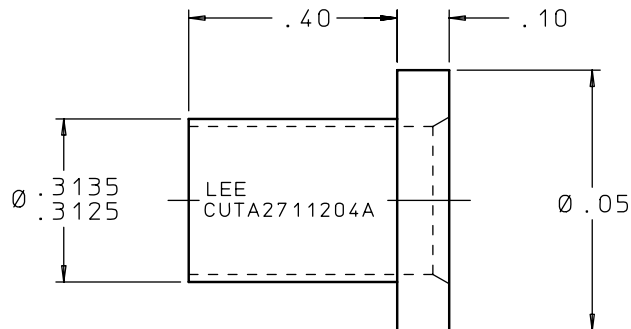
CUTA2711004C

REV	DATE	BY	DESCRIPTION
A	12-28-93	BR	INITIAL RELEASE
2	03-11-94	BR	ADDED INSTALLATION SLEEVE, NOTES AND SET TO TITLE
3	08-08-94	BR	DELETED PASSIVATION



INSTALLATION PROCEDURE

- LUBRICATE THE MICROJET O-RING WITH FLUOROSILICONE COMPATIBLE LUBRICANT. THE LUBRICANT PROTECTS THE O-RING FROM CUTS AND ABRASIONS DURING INSTALLATION.
- INSERT THE MICROJET NOSE FIRST INTO THE SLEEVE, PART NUMBER CUTA2711204A, FROM THE FLANGE-END. BE SURE THE MICROJET IS PRESSED INTO THE SLEEVE SQUARELY TO PREVENT THE O-RING FROM BEING PINCHED.
- INSERT THE SLEEVE SMALL END FIRST, WITH THE MICROJET IN IT, INTO THE INSTALLATION HOLE. THE SLEEVE WILL BOTTOM OUT ON THE OUTSIDE OF THE 30 DEGREE CHAMFER LEADING INTO THE MICROJET INSTALLATION AREA.
- USING THE INSTALLATION END OF TOOL PART NUMBER CUTA2711004C, GENTLY PRESS THE MICROJET THROUGH THE SLEEVE AND INTO ITS INSTALLATION AREA UNTIL IT BOTTOMS OUT.
- REMOVE THE TOOL AND SLEEVE.



EXTRACTION PROCEDURE:

- INSERT THE EXTRACTION TOOL PART NUMBER CUTA2711004C, INTO THE I.D. OF THE MICROJET.
- ENGAGE THE RAISED LIP OF THE TOOL INTO THE UNDER CUT IN THE I.D. OF THE MICROJET BODY.
- GENTLY PULL THE MICROJET WITH THE TOOL FROM ITS INSTALLATION HOLE.

PROPRIETARY ITEM

This document contains proprietary information and is submitted upon the express condition that the information contained herein will not be used directly or indirectly in any way detrimental to the interests of The Lee Company, and/or in violation of regulation DAR 7-104.9(a)(1 July 1974), et seq.

CUTD0406490

REFERENCE

DWG NO: CUTA2711104C	NOTES AND DIMENSIONS SHOWN HERE ON ARE FOR INSPECTION IDENTIFICATION ONLY. ALL MANUFACTURING RIGHTS RESERVED.	DRAWN BY: B R	03-11-94	LEE MICRO JET INSTALLATION AND EXTRACTION TOOL SET	
	EXTERNAL CORNER RAD: INTERNAL FILLET RAD:	CHK'D BY: L B	03-14-94	THE LEE COMPANY WESTBROOK, CT 06498	
	SURFACE FINISH ✓ ALL OVER DIMENSIONS ARE IN INCHES	APPD BY: B B	03-15-94		
	TOLERANCES 2 PLACES ±.015 3 PLACES ±.005 ANGLES ±5°	MAT: 300 SERIES CRES	H.T.:	SIZE: B	CAGE CODE: 92555
	FINISH:		DWG SCALE: NONE		REV: A
			SHEET 1 OF 1		