



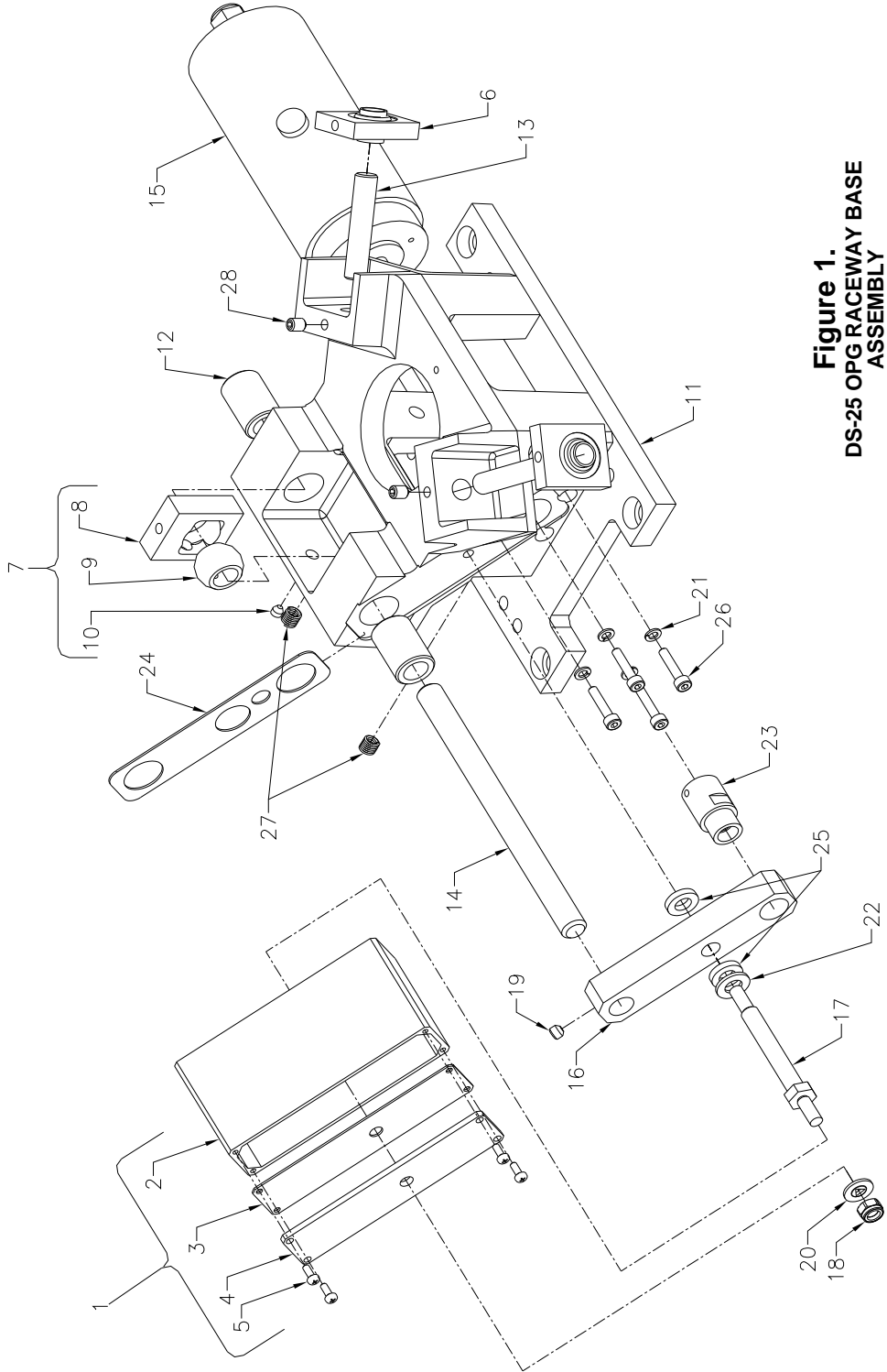
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**MAINTENANCE INSTRUCTIONS**  
**DS-25 OFFSET PIVOT GUIDE**  
**RACEWAY BASE ASSEMBLY**

**DS-25**  
**OFFSET PIVOT GUIDE**

**NOTES:**

1. Lubricate O.D. of item 9 (spherical bearing) with molybdenum disulfide antiseize lubricant at assembly.
2. See Figure Sheet 3-323 for disassembly of spherical bearing and carrier block.
3. When Removing item 23 (ball nut) from the item 15 (motor). Place a 7mm [0.246 in] shaft concentric to and in-line with the ball screw shaft. Unthread ballnut onto shaft such that ball bearings do not fall out of the ballnut.
3. At assembly, lubricate the ball screw (part of item 8), pack the linear ball bearings (item 5) and lubricate to the ends of the ball nut (item 16) on the ball screw with sunaplex multipurpose grease #991 ep or equal.



**Figure 1.**  
**DS-25 OPG RACEWAY BASE**  
**ASSEMBLY**



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## MAINTENANCE INSTRUCTIONS DS-25 OFFSET PIVOT GUIDE RACEWAY BASE ASSEMBLY

### Parts List

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ITEM NO	PART DESCRIPTION	PART NUMBER	ITEM QTY
1	Cover Assembly	201001-XXX	1
2	Cover Extrusion	200980-XXX	1
3	Cover Gasket	200937-001	1
4	Cover Lid	200985-XXX	1
5	Cheese Head Screw, M3 X 8 LG	92442-008	4
6	Carrier Block Assembly, Entry	201007-XXX	2
7	Carrier Block Assembly, Exit	201006-XXX	1
8	Carrier Block, Exit	200991-001	1
9	Spherical Bearing	201000-001	1
10	Hex Socket Set Screw, Cup Point, M5 X 5 LG	78610-001	1
11	Base Machining	200930-XXX	1
12	Linear Ball Bearing	92379-001	2
13	Race Rod, Entry	92380-XXX	2
14	Race Rod, Exit	92378-XXX	1
15	Motor Assembly	201015-001	1
16	Thrust Block	200977-001	1
17	Thrust Block Stop	200978-001	1
18	Nylon Insert Locknut, M6	27608-004	1
19	Hex Socket Set Screw, Cup Point, M6 X 5 LG	41153-012	1
20	Seal Washer, Thread Fixing, M6	92381-006	1
21	Lock Washer, M4	91552-002	4
22	Flat Washer, M8	91688-006	1
23	Ball Nut	92383-001	1
24	Cover/Base Gasket	200936-001	1
25	Urethane Washer	92382-001	2
26	Socket Head Cap Screw, M4 X 20 LG	92015-006	4
27	Helicoil Insert, M6 X 9 LG	92398-002	2
28	Hex Socket Set Screw, Cup Point, M6 X 8 LG	92443-008	2

Items are indented in the bill of material to indicate their relationship to a higher assembly. All Items belonging to an assembly will be listed directly under that assembly and will be indented one column to the right.