



REVISIONS					
ZONE	ECN	REV.	DESCRIPTION	DATE	APP'D
	12048	A	CREATED ON SOLIDWORKS	3-3-04	AB

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	16253		1
2	61449	METER CAP GEAR ASSY	1
	17711	SEAL, LIP	1
	15804-us	FRAME, GEAR	1
	13832	RETAINER, SEAL	1
3	13825	METER LEVEL CHANGE GEAR ASSY	1
4	16812		1
5	18595	SCREW, 6-32 X .375, RD. HD.	3
6	15312-us	PLATE, INTERMEDIATE, MACHINED	1
7	15707	O-RING, -236	1
8	BR40180	METER GEAR ASSY	1
9	BR11982	O-RING, -016	1
10	13510	GEAR, IDLER	6

NOTES:

- ASSEMBLE THE GEARS ITEMS 3, 4 AND 5 INTO ITEM 2.
- BOND THE 3 LEGS OF ITEM #2 FRAME INTO ITEM #6 PLATE PER WORK INSTRUCTION 41186-W01. INSTALL ITEM #8 O-RING.
- PRESS THE ASSEMBLED FRAME INTO ITEM 1 CAP.
- TEST BY DRIVING THE GEAR USING TESTER F1743 FOR 5 SECONDS MINIMUM. MOTION AND SOUND SHOULD BE UNIFORM. IF NOT, REPLACE GEARS AND REPEAT.
- INSTALL ITEM 7 O-RING.
- INSTALL ITEM 9 PLATE. INSTALL ITEM 10 SCREWS AND TORQUE TO 10-20 IN-LB. NO THREAD SEALER IS USED.

LAST SAVED IN SMARTEAM: 06/04/2004 08:48

CRITICALITY SYMBOLS PER QPSP-001.2

LEVEL I LEVEL II LEVEL III

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1. DO NOT SCALE DRAWING
 2. DIMENSIONS = INCH/[mm]
 3. TOLERANCES (UNLESS OTHERWISE SPECIFIED)

	INCH	[mm]
1	± 0.015	± 0.40
0.1	± 0.015	± 0.25
0.01	± 0.010	± 0.13
0.001	± 0.005	

ANGULAR ± 1°
 BREAK ALL EXPOSED SHARP CORNERS .010 [.25] X 45° MAX.

PARTS LIST			
THIS DRAWING MUST BE COMPARED TO THE ERP SYSTEM TO ENSURE CORRECT REVISION LEVEL PRIOR TO USE.			
THIRD ANGLE PROJECTION			
APPROVALS		DATE	
DRAWN		DATE	
CHECKED		DATE	
APPROVED		DATE	
TITLE		P.O. BOX 730 BROOKFIELD, WI 53008-0730	
METER CAP ASSY, 3900, STD			
SIZE	DWG NO.	REV	
B	16400	A	
SCALE	SOLIDWORKS FORMAT	SHEET 1 OF 1	
1:2			