



INST-00105

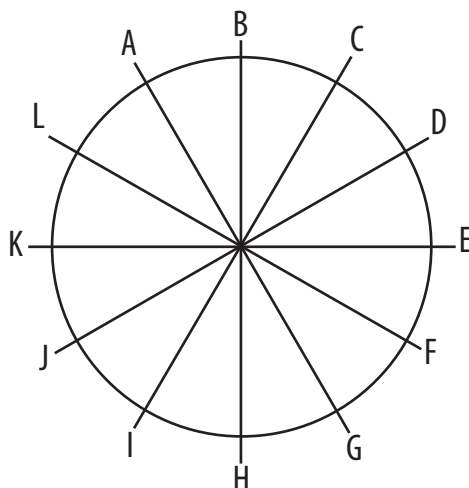
DEC. 2012 KAC Supplement to:
 ARMY TM 9-1005-319-23&P
 AIR FORCE TO 11W3-5-542

CLOCKING INSTRUCTIONS FOR URX SHIM SET PN 30229

CLOCKING INSTRUCTIONS

1. Assemble using the black shim (required) and add shims as necessary to achieve hand tightening at approximately position "A."
2. Apply torque between 60-140 ft. lbs. from position "A" to reach position "B."

Note: Adjust the amount of shims as needed to reach specified torque as the top rail reaches Top Dead Center (TDC) at position "B."

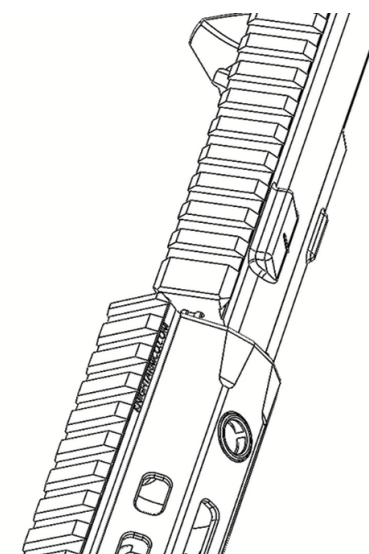


AS VIEW FROM MUZZLE

Hand Tightens at	Add	Suggested Shims
A	.000	Black Shim
B	.005	.005 Black Shim
C	.009	.005 + .002 + .002 Black Shim
D	.014	.010 + .002 + .002 Black Shim
E	.018	.016 + .002 Black Shim
F	.023	.016 + .005 + .002 Black Shim
G	.027	.025 + .002 Black Shim
H	.032	.025 + .005 + .002 Black Shim
I	.037	.025 + .010 + .002 Black Shim
J	.041	.025 + .016 Black Shim
K	.045	.025 + .016 + .002 + .002 Black Shim
L	.050	.025 + .016 + .002 + .002 Black Shim

Shim Identification	
Shim Thickness	Number of Notches
0.002	0
0.005	1
0.010	2
0.016	3
0.025	4

EXAMPLE OF POSITION A



Note:

30° of rotation requires +/- .004" and 60° requires .008".

In example A, add .008 to the .025 thickness (.033" total) to position at 11 o'clock hand tight. Do the math: .025+.005+.002=.032".

Use .032 and note torque at TDC. If less than 60 ft. lbs., add one more .002 to the shims for a total of .034" and re-torque as required: 60-140 ft. lbs. is optimal.



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