



Production Control Units, Inc.

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SERVICE BULLETIN

for

Series 500 TQC Valved Couplers



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Production Control Units, Inc.-Coupler Products

2280 West Dorothy Lane, Dayton, Ohio 45439-1892 USA - Phone (937) 299-5594 - FAX: (937) 299-4843
PCU Web Site: www.pcuinc.com - E-mail: couplers@pcuinc.com

Coupler Application Data Inquiry

Company _____ Phone # _____

Contact _____ Fax # _____

Address _____ E-mail _____

City _____ State _____ Country _____ Zip _____

Type & brand name for current coupler _____

Customer product manufactured _____

Type of coupler required

Size and type of tube or port to be sealed _____

☐ Straight ☐ Swaged ☐ Expanded ☐ Other _____

Length of tube or port available for coupler _____

Quantity required _____

Delivery due date _____

How will the coupler be used?

Refrigerant processing

What type of refrigerant? (HFC-134a, HP62, R-22, etc.) _____

Oil processing

What type of oil (Mineral, Polyol Ester, PAG, etc.) _____ (Attach MSDS)

Leak Burst testing

Maximum pressure & type of test media? (Air, Helium, etc.) _____

Vacuum

What level of vacuum needs to be achieved? _____

What Oil be present during vacuum pump down? _____

If "yes", what type of oil? _____

Additional process information

Along with your request for quote, please provide (1) copy of print showing area to be sealed, and (3) quality sample parts.

NOTE: The Data Inquiry form is available in pdf format on our web site at

www.PCUInc.com



GENERAL DESCRIPTION

These tough, compact, lightweight PCU couplers utilize heat-treated parts for interchangeability and long life oxide and nickel finishes resist corrosion. They provide a large, unrestricted flow rate for a variety of production uses while minimizing process material loss during coupling/uncoupling.

The Production Control Units Series 500 TQC is designed for easy installation onto the end of straight tubing. Slide the coupler onto the tubing until seated and push down on the mechanical lock (lever) to make a positive seal. A cam locking device grips uniformly but gently – without damage to steel, copper, brass or plastic tubing.

COUPLER FEATURES

SAFE: Built in valve automatically vents system pressure before the connector can be removed from the tube for operator safety. Blow-off or loss of seal connection by accidental bumping is eliminated.

FLEXIBLE: Internal parts are quickly interchangeable allowing the same connector body to fit all four tube sizes.

MANY APPLICATIONS: Seal compounds can be easily changed for many uses with oils, refrigerants, water, air, vacuum, helium, etc...

The standard PCU couplers are assembled with neoprene seals and O-rings. We recommend the neoprene compound for use with compressed air, R-12, R-22 and HFC-134a refrigerants (when not being used simultaneously with lubricants). When oils are being used, please contact our Coupler/Tooling team for help in selection of the correct elastomer for your particular application.

OPERATION PROCEDURE

All TQC couplers are made to slip freely onto and off your process tube and will function well if the following procedures are followed:

- 1) Use the TQC size that fits your tubing.
- 2) Open toggle lever (bail handle) fully before fitting over the tube.
- 3) Press TQC snugly onto the tube until you feel the resistance of the spring, making sure toggle lever is completely closed before applying pressure.
- 4) To remove, open toggle fully. Do not pull TQC. Allow pressure to blow out through integral valve of the TQC.
- 5) With toggle lever still fully open, push TQC lightly against the end of the tube. This will release it so it will lift off easily. If the TQC does not slip off the tube, it has not been properly released, so repeat release procedure.

MAINTENANCE INSTRUCTIONS

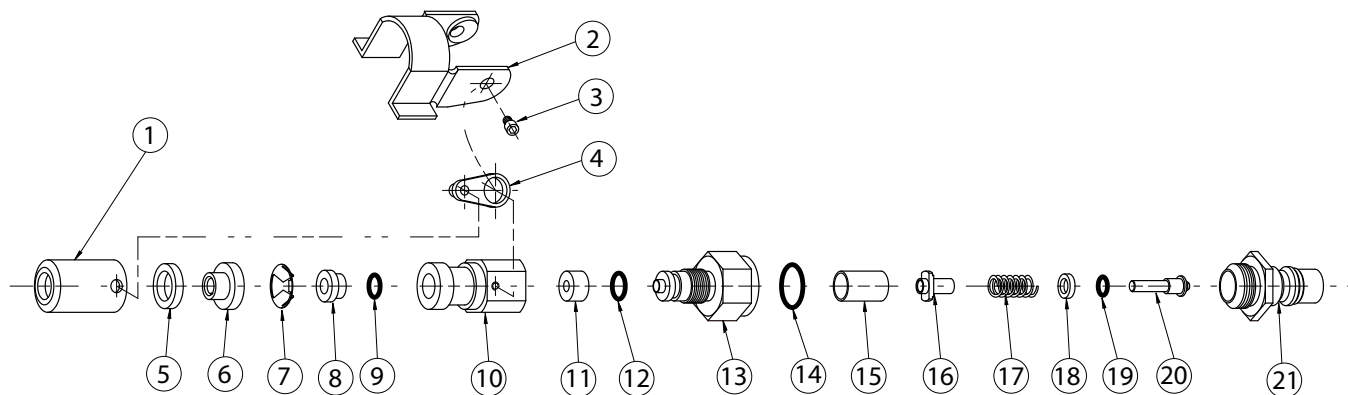
Coupler life is dependent upon a regular scheduled maintenance program. The application and its risk potential should determine frequency. PCU cannot determine a maintenance schedule due to the many factors involved: temperature, proper size selection, fluid compatibility, pressure, mechanical loads, user responsibility. User must establish a maintenance program based on previous service life. There are several factors that must be included when setting up a maintenance program: visual inspection for cracked, defective parts and excessively worn components; dirt or particle buildup in seal and clamping areas; thorough cleaning and proper lubrication; replace worn out and defective seals.

SPECIFICATIONS

Working Pressure	25 microns to 500 PSIG
Proof Pressure.....	4000 PSIG
Temperature Range.....	0 to 250° F
Tube Engagement.....	13/16 inches
Tube Out-of Roundness	2%

NEOPRENE SEALS

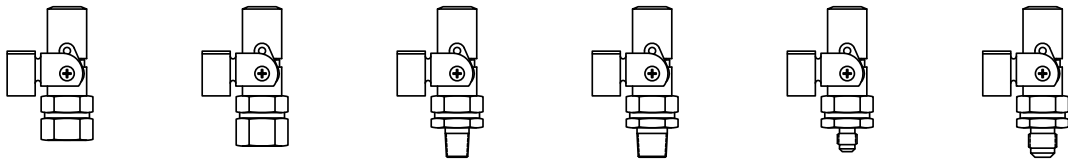
REPLACEMENT PARTS FOR "TQC" WITH SERIES 250 NIPPLE AS SHOWN



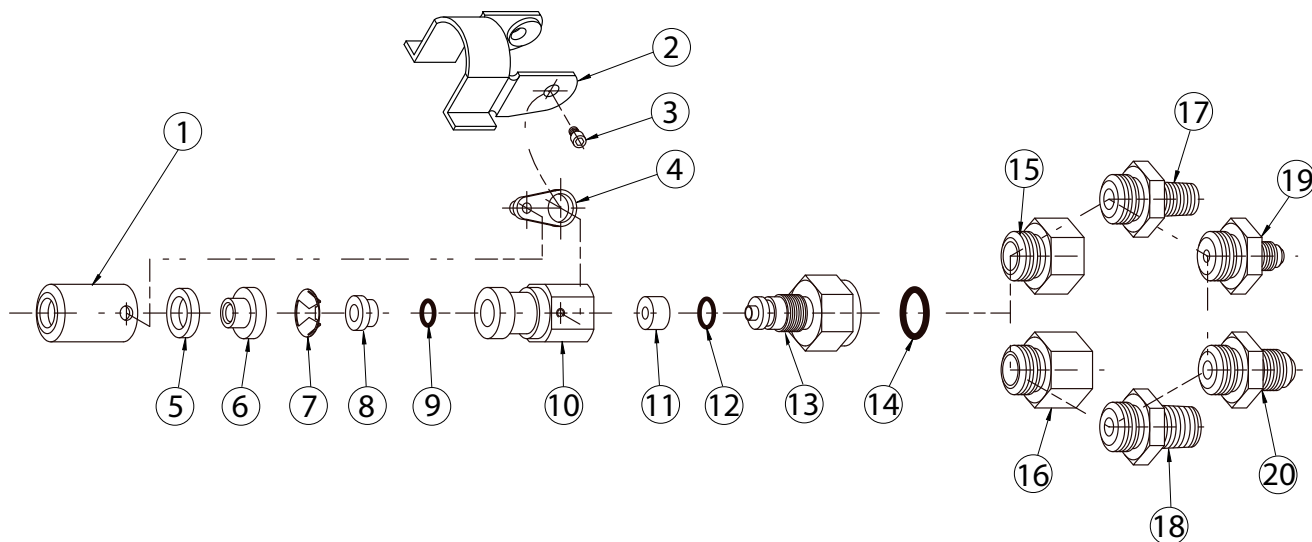
NEOPRENE SEALS				
Stock Assemblies	3/16" Tube Size 500661	1/4" Tube Size 500861	5/16" Tube Size 501061	3/8" Tube Size 501261
1. Barrel	57007			
2. Toggle Lever	57005			
3. Screw (2 req'd)	57046			
4. Link Arm (2 req'd)	57044			
5. Spring Washer	57006			
6. Collet Holder	53004	54004	55004	56004
7. Collet	53005	54005	55005	56005
8. Collar	53003	54003	55003	56011
9. Tube Seal O-ring	53012	54012	55012	56012
10. Tube Socket	53018	54018	55018	56018
11. Rubber Spring	57047	57047	57045	57045
12. Body O-ring	57026			
13. Body	57042			
14. End Cap O-ring	61822			
15. Spacer	61824			
16. Perch	61825			
17. Valve Spring	61804			
18. O-ring Retainer	61840			
19. Valve O-ring	61843			
20. Valve Stem	61844			
21. Nipple Body	61839			

NEOPRENE SEALS

SERIES 500 "TQC" WITH ALTERNATE END CAP ADAPTERS

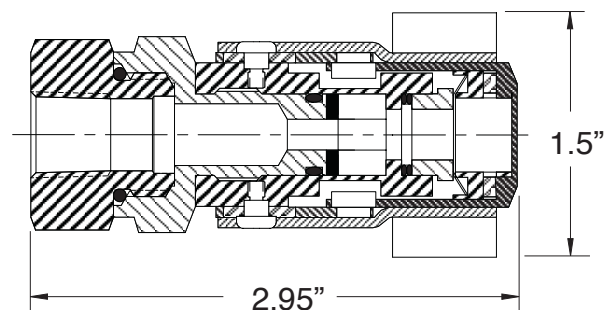


FOR USE ON TUBE WITH	1/4" FPT ADAPTER	3/8" FPT ADAPTER	1/4" MPT ADAPTER	3/8" MPT ADAPTER	1/4" SAE FLARE ADAPTER	3/8" SAE FLARE ADAPTER
3/16" OD	500611	500651	500631	500681	500621	500641
1/4" OD	500811	500851	500831	500881	500821	500841
5/16" OD	501011	501051	501031	501081	501021	501041
3/8" OD	501211	501251	501231	501281	501221	501241



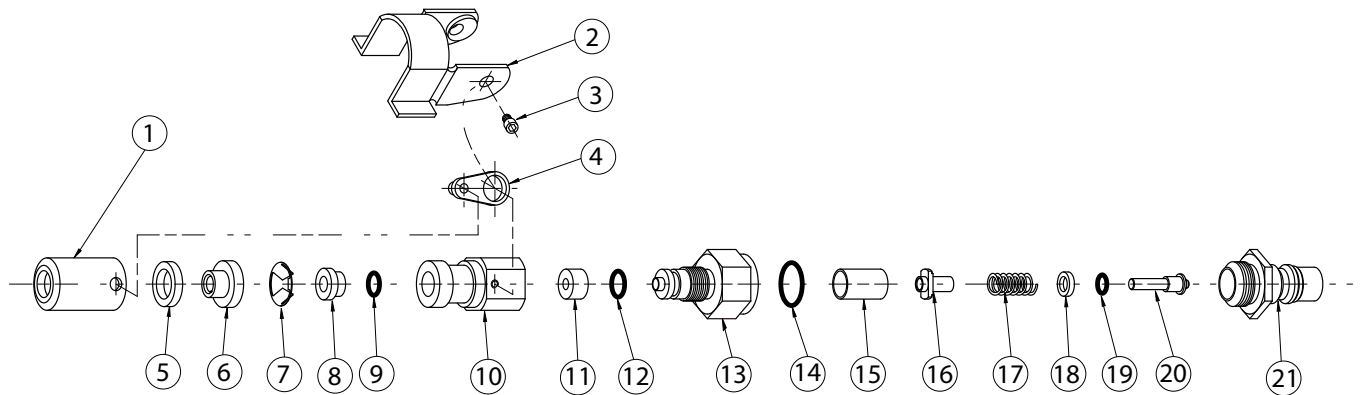
NEOPRENE SEALS	Tube Size			
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1. Barrel	57007			
2. Toggle Lever	57005			
3. Screw (2 req'd)	57046			
4. Link Arm (2 req'd)	57044			
5. Spring Washer	57006			
6. Collet Holder	53004	54004	55004	56004
7. Collet	53005	54005	55005	56005
8. Collar	53003	54003	55003	56011
9. Tube Seal O-ring	53012	54012	55012	56012
10. Tube Socket	53018	54018	55018	56018
11. Rubber Spring	57047	57047	57045	57045
12. Body O-ring	57026			
13. Body	57042			
14. End Cap O-ring	61822			

End Cap Adapters	
15. 86014 - 1/4" FPT	18. 57153 - 3/8" MPT
16. 57152 - 3/8" FPT	19. 57018 - 1/4" SAE FL
17. 57017 - 1/4" MPT	20. 57019 - 3/8" SAE FL



BUNA-N (NITRILE) SEALS

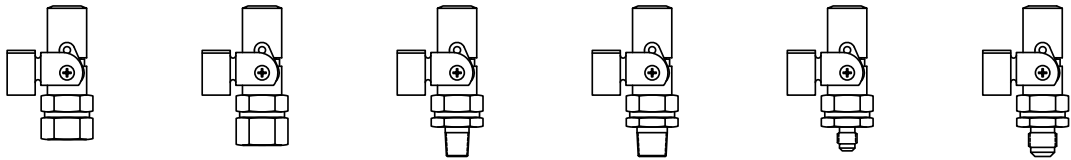
REPLACEMENT PARTS FOR "TQC" WITH SERIES 250 NIPPLE AS SHOWN



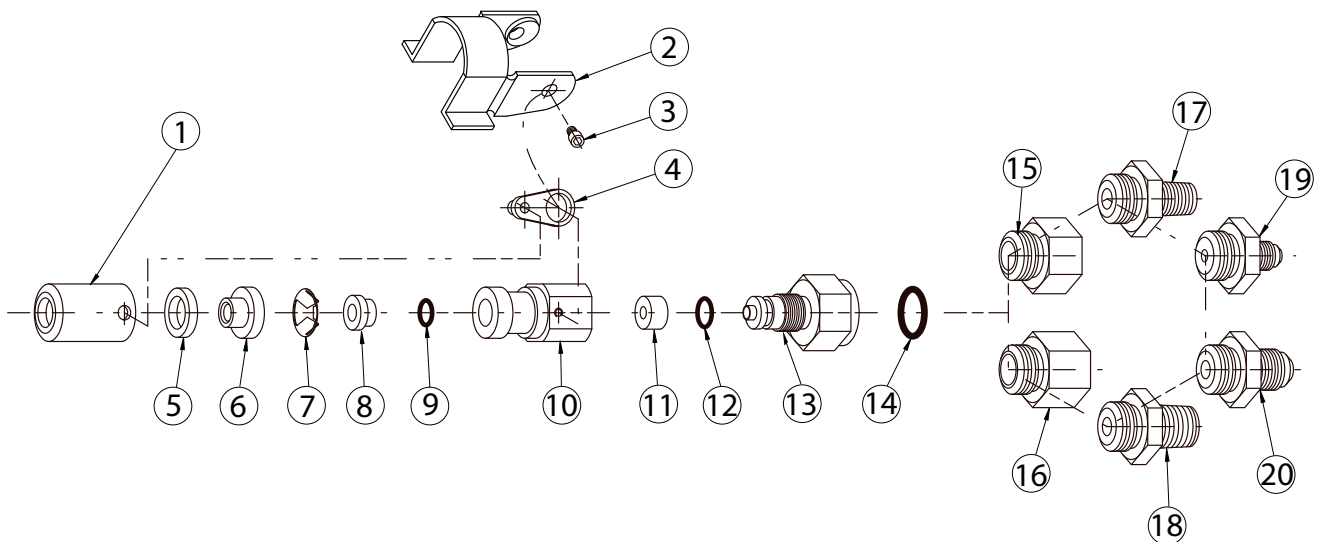
BUNA-N (NITRILE) SEALS				
Stock Assemblies	3/16" Tube Size 500662	1/4" Tube Size 500862	5/16" Tube Size 501062	3/8" Tube Size 501262
1. Barrel	57007			
2. Toggle Lever	57005			
3. Screw (2 req'd)	57046			
4. Link Arm (2 req'd)	57044			
5. Spring Washer	57006			
6. Collet Holder	53004	54004	55004	56004
7. Collet	53005	54005	55005	56005
8. Collar	53003	54003	55003	56011
9. Tube Seal O-ring	53013	54013	55013	56013
10. Tube Socket	53018	54018	55018	56018
11. Rubber Spring	57054	57054	57055	57055
12. Body O-ring	55013			
13. Body	57042			
14. End Cap O-ring	61846			
15. Spacer	61824			
16. Perch	61825			
17. Valve Spring	61804			
18. O-ring Retainer	61840			
19. Valve O-ring	61847			
20. Valve Stem	61844			
21. Nipple Body	61839			

BUNA-N (NITRILE) SEALS

SERIES 500 "TQC" WITH ALTERNATE END CAP ADAPTERS

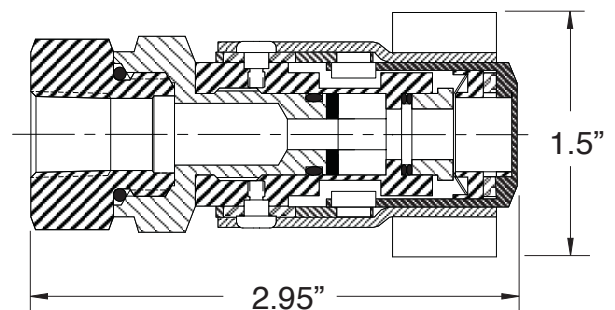


FOR USE ON TUBE WITH	1/4" FPT ADAPTER	3/8" FPT ADAPTER	1/4" MPT ADAPTER	3/8" MPT ADAPTER	1/4" SAE FLARE ADAPTER	3/8" SAE FLARE ADAPTER
3/16" OD	500612	500652	500632	500682	500622	500642
1/4" OD	500812	500852	500832	500882	500822	500842
5/16" OD	501012	501052	501032	501082	501022	501042
3/8" OD	501212	501252	501232	501282	501222	501242



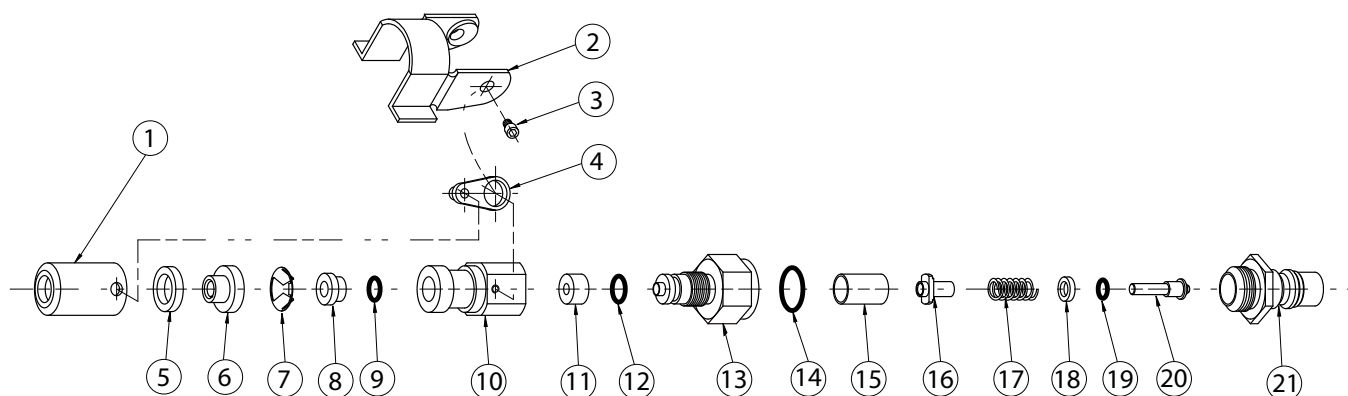
BUNA-N (NITRILE) SEALS	Tube Size			
	3/16"	1/4"	5/16"	3/8"
Replacement Parts				
1. Barrel	57007			
2. Toggle Lever	57005			
3. Screw (2 req'd)	57046			
4. Link Arm (2 req'd)	57044			
5. Spring Washer	57006			
6. Collet Holder	53004	54004	55004	56004
7. Collet	53005	54005	55005	56005
8. Collar	53003	54003	55003	56011
9. Tube Seal O-ring	53013	54013	55013	56013
10. Tube Socket	53018	54018	55018	56018
11. Rubber Spring	57054	57054	57055	57055
12. Body O-ring	55013			
13. Body	57042			
14. End Cap O-ring	61846			

End Cap Adapters	
15. 86014 - 1/4" FPT	18. 57153 - 3/8" MPT
16. 57152 - 3/8" FPT	19. 57018 - 1/4" SAE FL
17. 57017 - 1/4" MPT	20. 57019 - 3/8" SAE FL



FLUOROCARBON SEALS

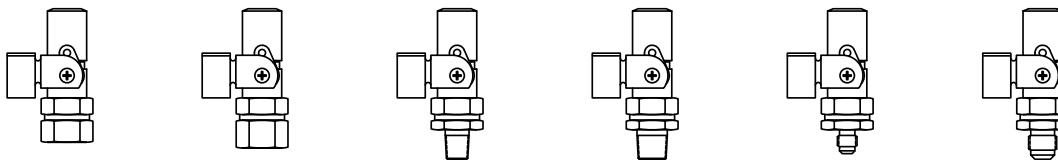
REPLACEMENT PARTS FOR "TQC" WITH SERIES 250 NIPPLE AS SHOWN



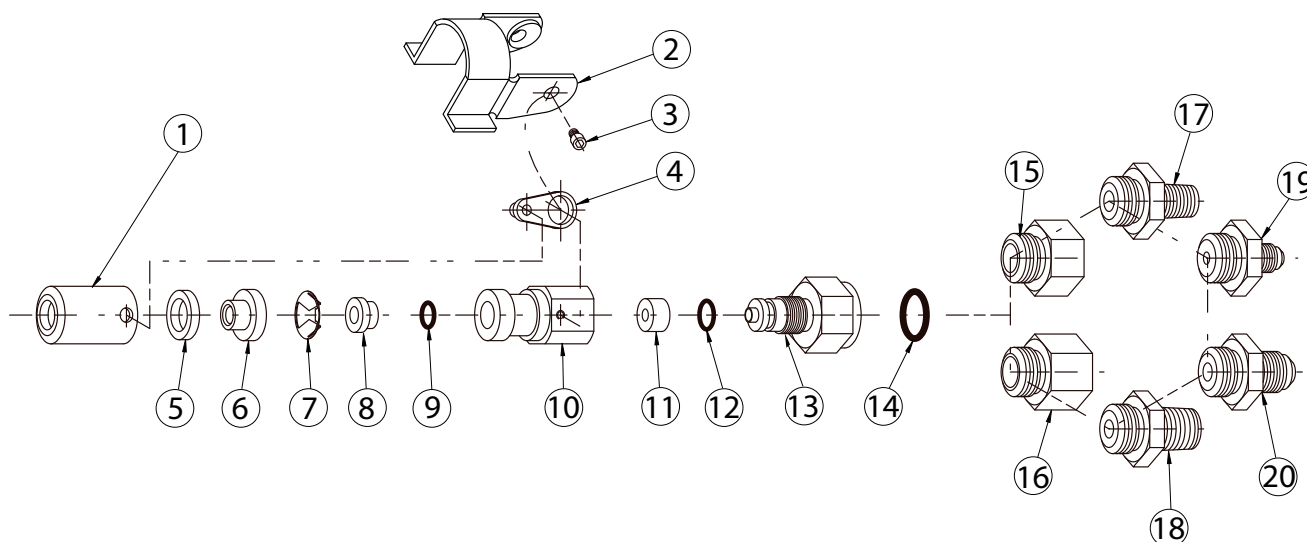
FLUOROCARBON SEALS				
Stock Assemblies	3/16" Tube Size 500663	1/4" Tube Size 500863	5/16" Tube Size 501063	3/8" Tube Size 501263
1. Barrel	57007			
2. Toggle Lever	57005			
3. Screw (2 req'd)	57046			
4. Link Arm (2 req'd)	57044			
5. Spring Washer	57006			
6. Collet Holder	53004	54004	55004	56004
7. Collet	53005	54005	55005	56005
8. Collar	53003	54003	55003	56011
9. Tube Seal O-ring	53014	54014	55014	56014
10. Tube Socket	53018	54018	55018	56018
11. Rubber Spring	57164	57164	57055	57045
12. Body O-ring	55014 or 57076			
13. Body	57042			
14. End Cap O-ring	61852			
15. Spacer	61824			
16. Perch	61825			
17. Valve Spring	61804			
18. O-ring Retainer	61840			
19. Valve O-ring	61853			
20. Valve Stem	61844			
21. Nipple Body	61839			

FLUOROCARBON SEALS

SERIES 500 "TQC" WITH ALTERNATE END CAP ADAPTERS

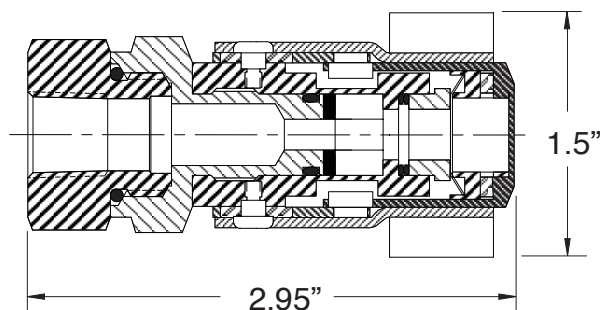


FOR USE ON TUBE WITH	1/4" FPT ADAPTER	3/8" FPT ADAPTER	1/4" MPT ADAPTER	3/8" MPT ADAPTER	1/4" SAE FLARE ADAPTER	3/8" SAE FLARE ADAPTER
3/16" OD	500613	500653	500633	500683	500623	500643
1/4" OD	500813	500853	500833	500883	500823	500843
5/16" OD	501013	501053	501033	501083	501023	501043
3/8" OD	501213	501253	501233	501283	501223	501243



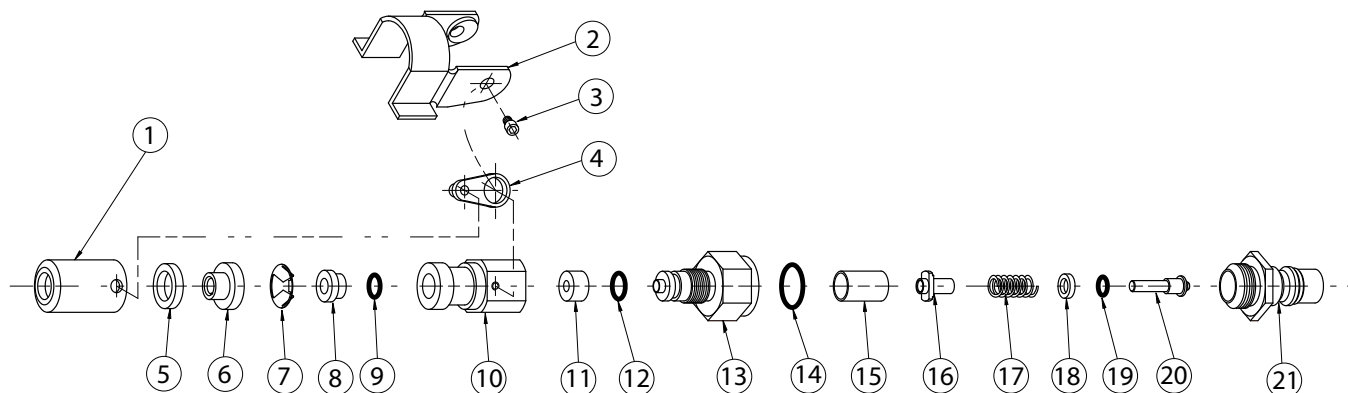
FLUOROCARBON SEALS		Tube Size			
Replacement Parts		3/16"	1/4"	5/16"	3/8"
1.	Barrel	57007			
2.	Toggle Lever	57005			
3.	Screw (2 req'd)	57046			
4.	Link Arm (2 req'd)	57044			
5.	Spring Washer	57006			
6.	Collet Holder	53004	54004	55004	56004
7.	Collet	53005	54005	55005	56005
8.	Collar	53003	54003	55003	56011
9.	Tube Seal O-ring	53014	54014	55014	56014
10.	Tube Socket	53018	54018	55018	56018
11.	Rubber Spring	57047	57047	57045	57045
12.	Body O-ring	55014 or 57076			
13.	Body	57042			
14.	End Cap O-ring	61852			

End Cap Adapters	
15. 86014 - 1/4" FPT	18. 57153 - 3/8" MPT
16. 57152 - 3/8" FPT	19. 57018 - 1/4" SAE FL
17. 57017 - 1/4" MPT	20. 57019 - 3/8" SAE FL



EPDM SEALS

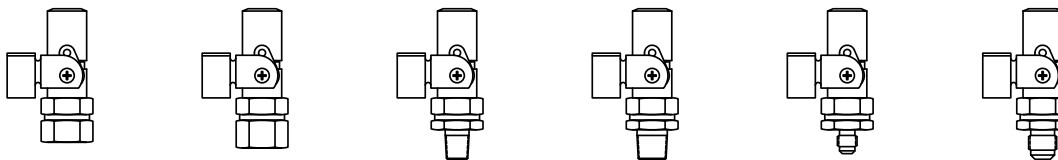
REPLACEMENT PARTS FOR "TQC" WITH SERIES 250 NIPPLE AS SHOWN



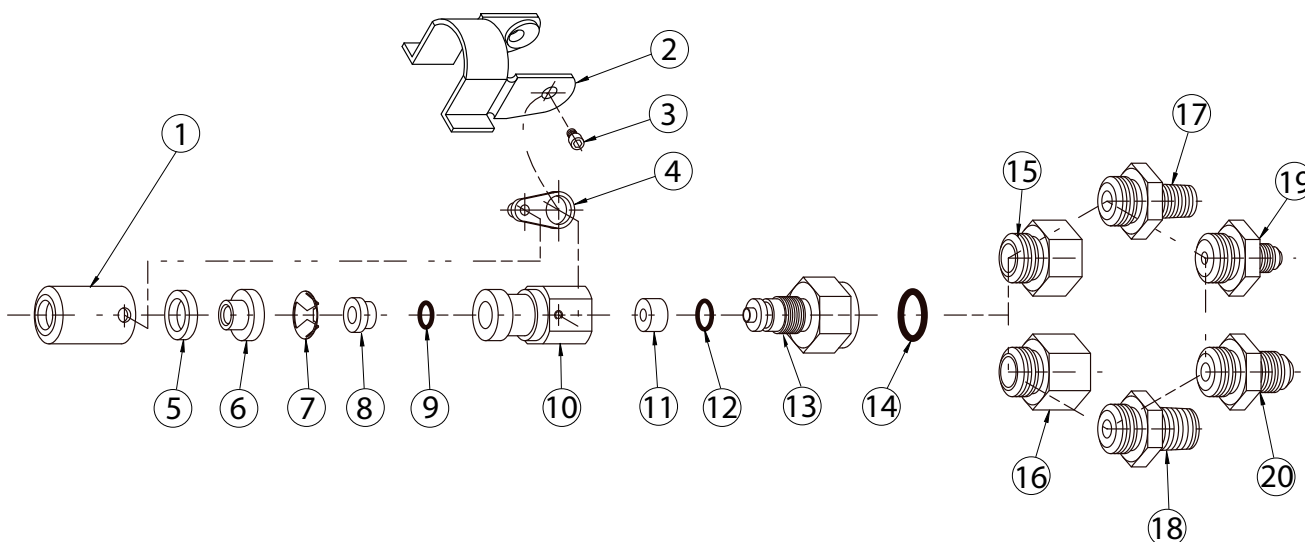
EPDM SEALS				
Stock Assemblies	3/16" Tube Size 500666	1/4" Tube Size 500866	5/16" Tube Size 501066	3/8" Tube Size 501266
1. Barrel	57007			
2. Toggle Lever	57005			
3. Screw (2 req'd)	57046			
4. Link Arm (2 req'd)	57044			
5. Spring Washer	57006			
6. Collet Holder	53004	54004	55004	56004
7. Collet	53005	54005	55005	56005
8. Collar	53003	54003	55003	56011
9. Tube Seal O-ring	61872	54007	55016	56007
10. Tube Socket	53018	54018	55018	56018
11. Rubber Spring	57056	57056	57166	57166
12. Body O-ring	55016			
13. Body	57042			
14. End Cap O-ring	61871			
15. Spacer	61824			
16. Perch	61825			
17. Valve Spring	61804			
18. O-ring Retainer	61840			
19. Valve O-ring	61873			
20. Valve Stem	61844			
21. Nipple Body	61839			

EPDM SEALS

SERIES 500 "TQC" WITH ALTERNATE END CAP ADAPTERS

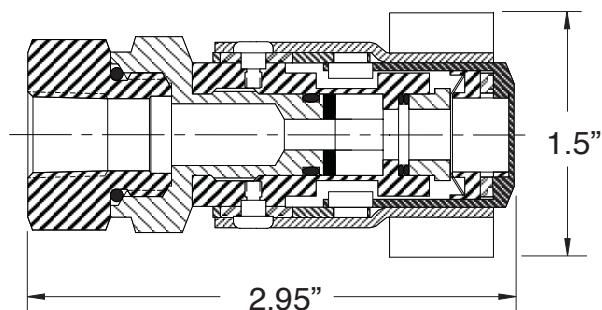


FOR USE ON TUBE WITH	1/4" FPT ADAPTER	3/8" FPT ADAPTER	1/4" MPT ADAPTER	3/8" MPT ADAPTER	1/4" SAE FLARE ADAPTER	3/8" SAE FLARE ADAPTER
3/16" OD	500616	500656	500636	500686	500626	500646
1/4" OD	500816	500856	500836	500886	500826	500846
5/16" OD	501016	501056	501036	501086	501026	501046
3/8" OD	501216	501256	501236	501286	501226	501246



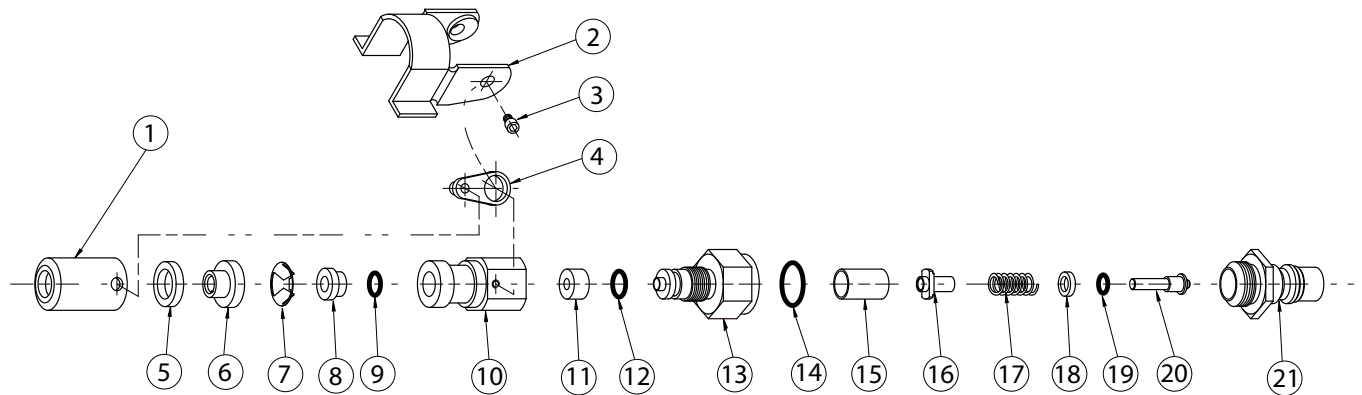
EPDM SEALS	Tube Size			
	3/16"	1/4"	5/16"	3/8"
1. Barrel	57007			
2. Toggle Lever	57005			
3. Screw (2 req'd)	57046			
4. Link Arm (2 req'd)	57044			
5. Spring Washer	57006			
6. Collet Holder	53004	54004	55004	56004
7. Collet	53005	54005	55005	56005
8. Collar	53003	54003	55003	56011
9. Tube Seal O-ring	61872	54007	55016	56007
10. Tube Socket	53018	54018	55018	56018
11. Rubber Spring	57054	57054	57055	57055
12. Body O-ring	55016			
13. Body	57042			
14. End Cap O-ring	61871			

End Cap Adapters	
15. 86014 - 1/4" FPT	18. 57153 - 3/8" MPT
16. 57152 - 3/8" FPT	19. 57018 - 1/4" SAE FL
17. 57017 - 1/4" MPT	20. 57019 - 3/8" SAE FL



HFC-134a SEALS

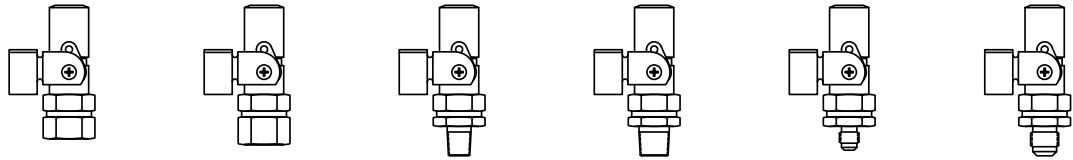
REPLACEMENT PARTS FOR "TQC" WITH SERIES 250 NIPPLE AS SHOWN



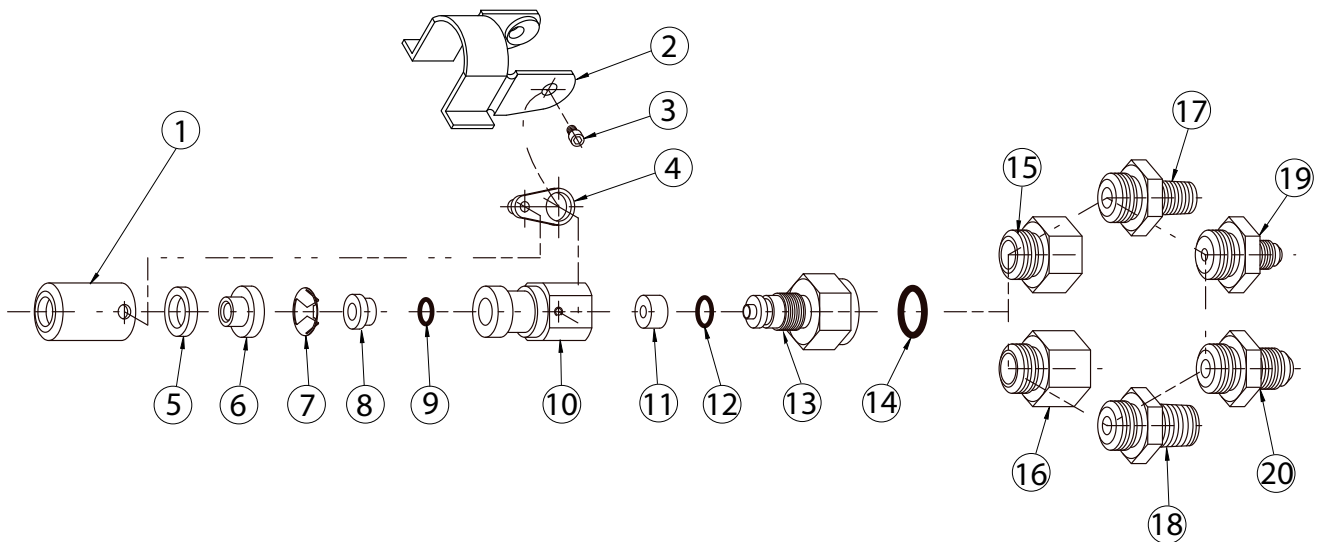
HFC-134a SEALS				
Stock Assemblies	3/16" Tube Size 500667	1/4" Tube Size 500867	5/16" Tube Size 501067	3/8" Tube Size 501267
1. Barrel	57007			
2. Toggle Lever	57005			
3. Screw (2 req'd)	57046			
4. Link Arm (2 req'd)	57044			
5. Spring Washer	57006			
6. Collet Holder	53004	54004	55004	56004
7. Collet	53005	54005	55005	56005
8. Collar	53003	54003	55003	56011
9. Tube Seal O-ring	53015	54015	55015	56015
10. Tube Socket	53018	54018	55018	56018
11. Rubber Spring	57054	57054	57055	57055
12. Body O-ring	57052			
13. Body	57042			
14. End Cap O-ring	61879			
15. Spacer	61824			
16. Perch	61825			
17. Valve Spring	61804			
18. O-ring Retainer	61840			
19. Valve O-ring	61880			
20. Valve Stem	61844			
21. Nipple Body	61839			

HFC-134a SEALS

SERIES 500 "TQC" WITH ALTERNATE END CAP ADAPTERS

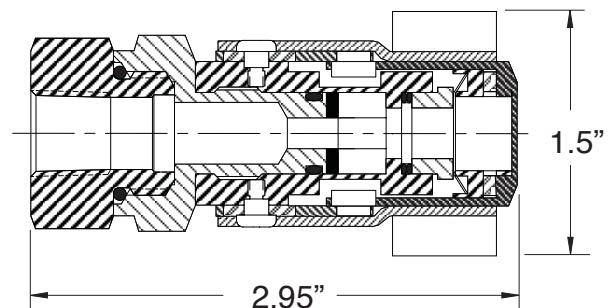


FOR USE ON TUBE WITH	1/4" FPT ADAPTER	3/8" FPT ADAPTER	1/4" MPT ADAPTER	3/8" MPT ADAPTER	1/4" SAE FLARE ADAPTER	3/8" SAE FLARE ADAPTER
3/16" OD	500617	500657	500637	500687	500627	500647
1/4" OD	500817	500857	500837	500887	500827	500847
5/16" OD	501017	501057	501037	501087	501027	501047
3/8" OD	501217	501257	501237	501287	501227	501247



HFC-134a SEALS		Tube Size			
Replacement Parts		3/16"	1/4"	5/16"	3/8"
1.	Barrel	57007			
2.	Toggle Lever	57005			
3.	Screw (2 req'd)	57046			
4.	Link Arm (2 req'd)	57044			
5.	Spring Washer	57006			
6.	Collet Holder	53004	54004	55004	56004
7.	Collet	53005	54005	55005	56005
8.	Collar	53003	54003	55003	56011
9.	Tube Seal O-ring	53015	54015	55015	56015
10.	Tube Socket	53018	54018	55018	56018
11.	Rubber Spring	57054	57054	57055	57055
12.	Body O-ring	57052			
13.	Body	57042			
14.	End Cap O-ring	61879			

End Cap Adapters	
15. 86014 - 1/4" FPT	18. 57153 - 3/8" MPT
16. 57152 - 3/8" FPT	19. 57018 - 1/4" SAE FL
17. 57017 - 1/4" MPT	20. 57019 - 3/8" SAE FL



DISASSEMBLY & REASSEMBLY INSTRUCTIONS

The basic Series 500 TQC coupler, less end cap adapter, consists of thirteen parts that must be assembled in correct order to assure proper functioning of the unit. Although all units are tested in our plant at 500 psig air and less than 50 microns vacuum, Production Control Units, Inc. cannot be responsible for any malfunction of the TQC coupler due to faulty servicing of the unit in the field by people other than PCU field engineers/technicians.

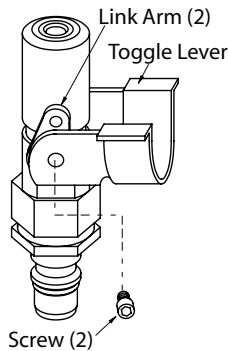


Figure 1

STORAGE

When the TQC is not in use, it should be stored with the toggle lever in the open position, with the lever 90 degrees from the coupler body (see Figure 1). If the coupler is stored with the toggle lever in the closed position, pressure is applied to the tube seal O-ring, squeezing it out into the tube channel of the coupler. If this condition is allowed to exist for any length of time, the tube seal O-ring tends to remain in its expanded condition for some length of time after the locking pressure has been removed. A tube being inserted into the coupler under these conditions will damage the tube seal O-ring as the tube is forced past it.

INITIAL DISASSEMBLY – Complete Unit
No special tools are required.

Set toggle lever 90 degrees from body of coupler. Using proper tool, remove screws, grasp toggle lever and pull out from coupler body so that both toggle lever and link arms are extending out 90 degrees from body. Grasp body of coupler with one hand, so pressure can be applied to link arms with thumb and forefinger, moving link arms in toward each other. Grasp toggle lever with other hand, thumb lying between lever arms. Spring arm out until the button on toggle lever arm disengages from 7.16 diameter hole in link arm. Repeat procedure with other link arm. After toggle lever has been removed, grasp link arms and pull out to disengage link arm pins from assembly. Remove link arms and set aside.

SUBASSEMBLY "A"

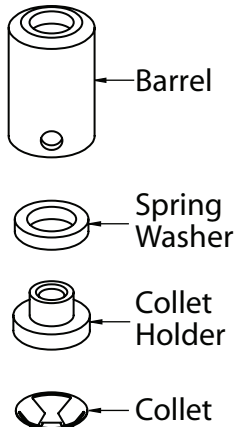


Figure 2

DISASSEMBLY – SUBASSEMBLY "A"

Hold the assembly in one hand with small diameter end up. Using 3/8" diameter x 3" long piece of CRS, or equivalent, push pilot of collet holder. Shove all parts out large diameter end of barrel. A visual inspection for excessive wear can now be made of parts, especially the spring washer and collet. The condition of these two parts is critical because excessive wear can cause coupler malfunction. They should be replaced if there is any doubt as to their functioning capabilities.

REASSEMBLY – SUBASSEMBLY "A"

Place spring washer over small end of collet holder. Fit collet into recess in end of collet holder, prongs extending out. Hold collet holder between thumb and middle finger with forefinger holding collet in place. Now holding barrel in other hand, insert parts into large end of barrel using forefinger to slide parts forward until small end of collet holder slips into small hole in barrel. Set aside with large diameter end of barrel up.

SUBASSEMBLY "B"

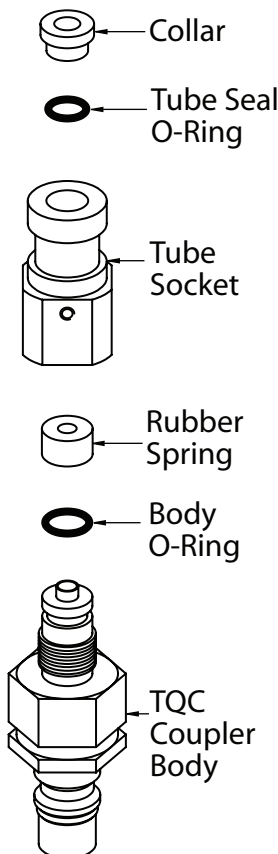


Figure 3

DISASSEMBLY – SUBASSEMBLY "B"

The three parts of this subassembly that could cause a malfunction are the tube seal O-ring, rubber spring, or the body O-ring and should be replaced if damaged in any way.

Remove collar from small end of assembly and set aside. Remove the tube seal O-ring from pocket of tube socket using a sharp pointed tool to pry seal ring up and out of pocket, being careful not to damage seal ring in the process. Place coupler body in a vise clamping on the hex end. Use a 7/8" open-end wrench on flats of tube socket. Loosen until tube socket can be removed by hand. Remove the rubber spring by inserting a 1/4" diameter x 3" long tool through small end of tube socket and shove rubber spring out through threaded end of tube socket. Inspect for damage and set aside. Next, inspect O-ring on coupler body, being careful not to damage O-ring or O-ring groove in coupler body in the process.

NOTE: Do not reassemble Subassembly "B" until after Subassembly "C" has been disassembled, repaired and reassembled.

DISASSEMBLY – SUBASSEMBLY "C"

SUBASSEMBLY "A"

REASSEMBLY – SUBASSEMBLY "B"

SUBASSEMBLY "C"

To disassemble Subassembly "C", place nipple body in a vise, clamping on the 1" hex. Use a 1" open-end wrench (or equivalent) on coupler body. Loosen until the coupler body can be removed by hand. Set coupler body aside. Remove nipple assembly from vise. Holding the nipple body with its related parts threaded end up, remove the spacer and set aside. Tilt nipple body down and slide out valve assembly (Note: Tap valve assembly loose if stuck). Check and remove perch, spring, O-ring retainer, and valve O-ring from valve stem. Discard O-rings

REASSEMBLY – SUBASSEMBLY "C"

After parts have been inspected, pick up valve stem in one hand and slide valve O-ring over stem and upon shouldered portion of the valve stem. Next, position the O-ring retainer behind the O-ring, making certain that the cupped portion of the O-ring retainer is next to the O-ring. Slide the valve spring over the valve stem until it comes in contact with the O-ring retainer. Slide the perch onto the valve stem, with its long end over the stem. Pick up the nipple body, holding it with the threaded end down, and slide the valve assembly up into the nipple body, valve stem first. As the valve assembly is slid into the nipple body, tilt the nipple body until the threaded end is pointing up to allow the valve assembly to drop into place. Holding the nipple body in that position, pick up spacer and slide it down into the nipple body until it comes in contact with the shoulders of the perch. Pick up the coupler body and screw the coupler body to the nipple body. Set home with wrench, using approximately 35 to 40 foot lbs torque.

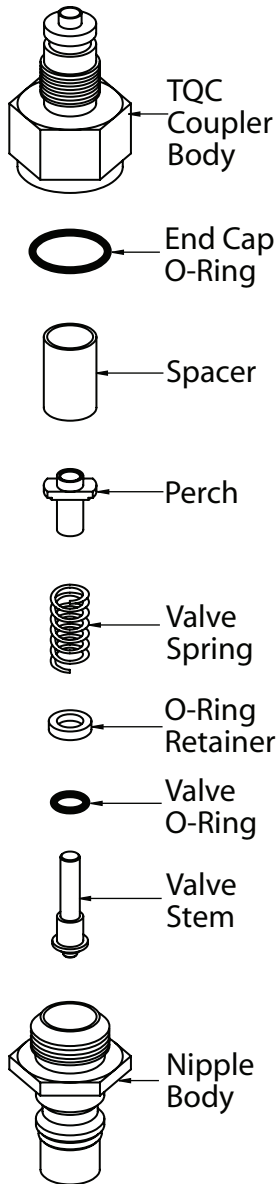


Figure 4

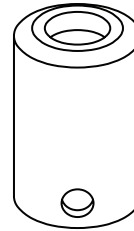


Figure 5

Ensure that O-ring is in place on coupler body. Next, insert rubber spring into threaded end of the tube socket until seated and screw tube socket onto coupler body, tightening with 7/8" open-end wrench with 1" hex of coupler body held in vise. Replace tube seal O-ring and set home with collar. Remove from vise and set aside.

FINAL ASSEMBLY – Complete Unit

Taking Subassembly "B"-"C" (Figure 6) in one hand (ensuring that collar is in place), pick up Subassembly "A" and slide over collar end of Subassembly "B", being careful that the collar and collet stay in their respective pockets, and rotate Subassembly "A" (Figure 5) until link pin holes line up with tapped holes in flats of Subassembly "B". Next, insert the link pins (57044) into the link pin holes until the link body seats against body of barrel. Position link arms so they extend about 90 degrees from body, holding unit with barrel end up. Press in on the link arms so arms move in toward each other. Pick up a toggle lever (57005) with other hand, holding it open side up. Slide it into the 7/16" diameter holes in link arms. (To do this, it may be necessary to spring out the arms on the toggle lever.) Next, shove the toggle lever and link arms up toward the flats on coupler body until the holes in the toggle lever line up with the tapped holes in the coupler body. Insert two screws in place and tighten with appropriate tool. (For ease of alignment of screw holes, toggle lever should be set at approximately 90-degree angle from centerline of body). This completes unit assembly.

SUBASSEMBLY "B"-"C"

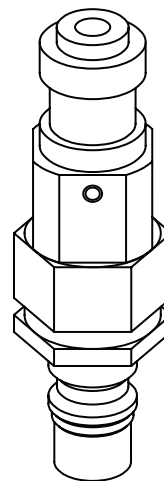
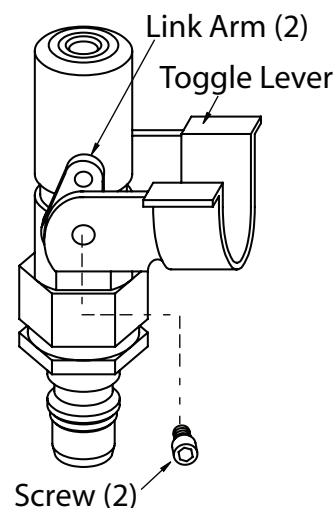


Figure 6





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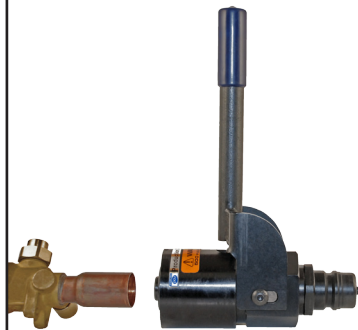
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