

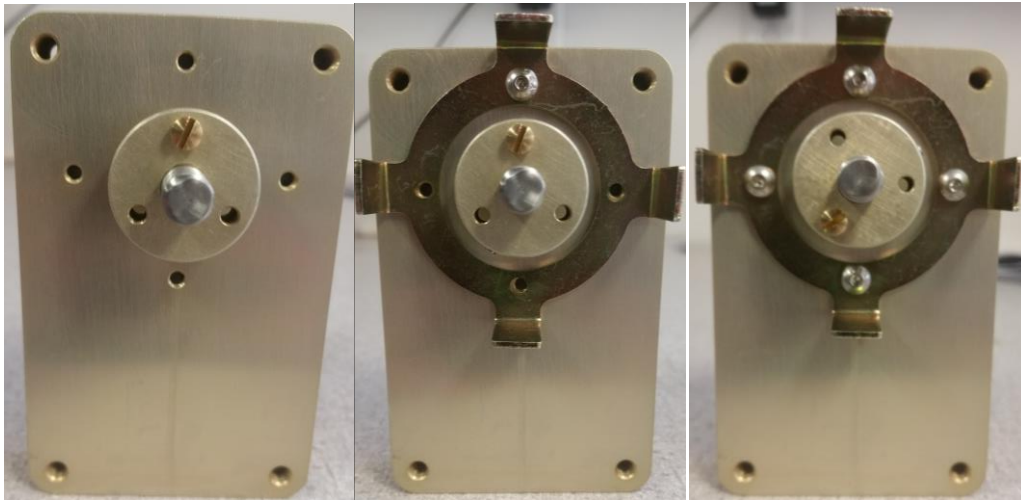
STANDARD SERVO OUTPUT DEVICE ATTACHMENT PROCEDURE

Procedure for attaching servo arm, torque enhancer, or capstan to DSP-B, DSP-C,
DSB-B, DSB-C, DSP-B-CAP,
DSP-C-CAP, DSB-B-CAP, DSB-C-CAP, BS-B, PS-B, BS-C, PS-C servos.

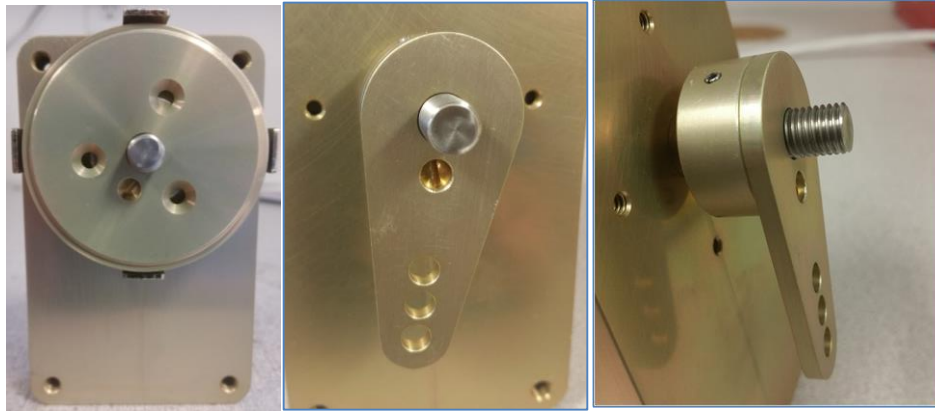
8100-006, 8100-011, 8100-034, 8100-039, 8100-007, 8100-012, 8100-035, 8100-040, 8100-070, 8100-071, 8100-072, 8100-073

Revision	Date	Description	Pages
IR	9/19/2017	Document created	2

1. Some aircraft installations may require the servo to be mounted prior to attaching the output device. For capstan installations place capstan guard against the servo gearbox or bracket and fasten using 4 ea. 6-32 x 1/4 Button Head Socket Cap Screw and 4 ea. #6 lock washers. Torque each fastener to 5-7 in-lb. Torque enhancer and arm installations proceed to step 2.



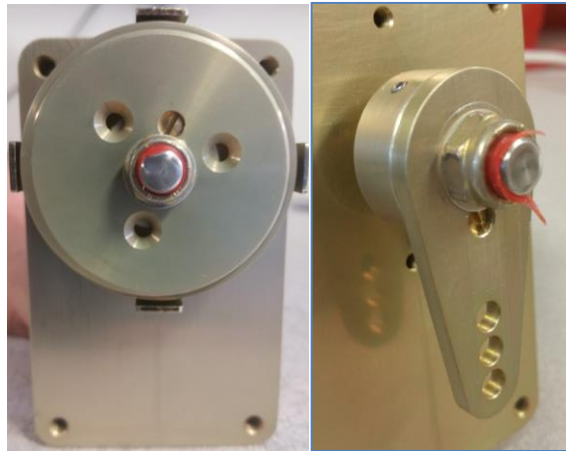
2. Place output device firmly against the servo output hub surface, taking care to align the shear screw with the hole in the attachment.



3. Place the NAS1149-D0516J 5/16 washer over the output shaft.



4. Electrically connect the servo to the autopilot controller and engage the servo. Thread the 5/15-24 thin fiber locking nut onto the shaft and torque to 40 in-lb.



5. Loosen the 5/16-24 thin fiber locking nut counterclockwise 1/8th turn or 45° +/- 10°. Disengage the autopilot controller.