**LV JOYSTICK SUB-ASSY**

**PRINCE MANUFACTURING CORPORATION**
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**TOLERANCES:**

- ANGLES ±7°
- FRACTION +/-.075 [±.075]
- .000 ±.005 [±.013]

**DEBURR & BREAK ALL EDGES**

**DO NOT SCALE DRAWING**

**DIMENSIONS ARE IN INCHES OR MILLIMETERS**

**UNLESS OTHERWISE SPECIFIED**

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**ITEM** | **QTY** | **PART NO.** | **DESCRIPTION**
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1 | 1 | 671900084 | SPOOL STUD
2 | 1 | 671400252 | ROD END
3 | 1 | 671400267 | ADAPTER PLATE
4 | 3 | 170003094 | CAP SCREW (FINE THD)
5 | 2 | 660390016 | ROD END ASSY
6 | 3 | 220000125 | HEX NUT (FINE THD)
7 | 2 | 170003032 | CAP SCREW (1.25)
8 | 1 | 671400272 | CLEVIS HOUSING, SHORT
9 | 1 | 170003080 | CAP SCREW (.62)
10 | 1 | 670500026 | WASHER
11 | 1 | - | INSTRUCTION SHEET

**NOTE:**

1. CLEAN THESE THREADED PARTS WITH ALCOHOL, APPLY LOCTITE PRIMER T AND INSTALL WITH LOCTITE 680.
2. WHEN SHIPPED AS LOOSE PARTS, ADD A COPY OF THIS PRINT TO THE BAG CONTAINING THE PARTS.

**NOTE:**

1. PREASSEMBLE ROD ENDS AND ADAPTER PLATE USING SPECIAL FIXTURE. CLEAN THREADS WITH ALCOHOL, APPLY LOCTITE PRIMER T AND INSTALL WITH LOCTITE 680.

170-190 IN-LBS

**INSTALLATION PROCEDURE:**

PRE-ASSEMBLE ROD ENDS. ROTATE BOTH SPOOLS SO THE TANGS ON THE SPOOLS ARE ALIGNED WITH THE BRACKET TANG. LOOSELY INSERT THE STUDS ON THE ROD ENDS INTO THE BRACKET TANG AND SPOOL TANG. ROTATE 2ND SPOOL TANG 90°. INSERT SPOOL STUD INTO ROD END AND ROTATE THE ROD END ASSEMBLY SUCH THAT THE THREADED END OF THE SPOOL STUD CAN BE INSERTED INTO THE 2ND SPOOL TANG. APPLY LOCTITE AND TORQUE ALL FASTENERS AS INDICATED.