

## Supplement Sheet

Date: 6/16/2008

Subject: Service Replacement for the

17198A Segment Gear

Stabilizer Plate

Models N/A Affected:

PURPOSE: This supplement sheet is applicable ONLY when replacing a 17198A Segment Gear Stabilizer Plate. This sheet is NOT REQUIRED when replacing a 783-04644 Segment Gear Stabilizer Plate with the 783-04644 supplied.

This supplement sheet provides the instructions for modifying and installing the 783-04644 Segment Gear Stabilizer Plate supplied when replacing a 17198A Segment Gear Stabilizer Plate which is no longer available.

## MODIFYING INSTRUCTIONS:

1. When replacing the 17198A with the current production 783-04644, it is required to open up the middle .325/.320" diameter hole of the 783-04644 to .385/.380" diameter. See Figure 1.

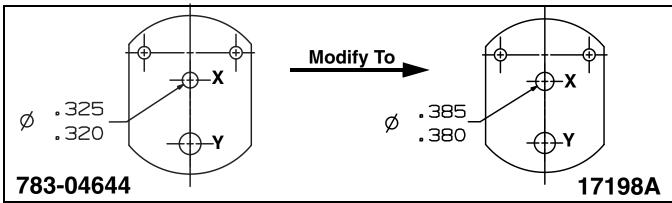
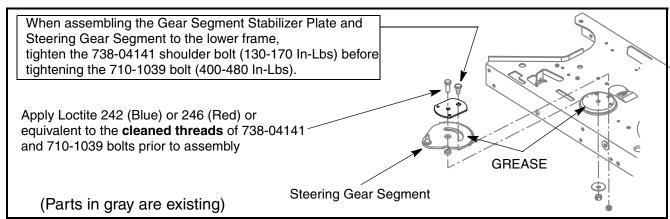


FIGURE 1

- 2. To maintain dimensional accuracy between the two mounting holes " $\mathbf{X}$ " and " $\mathbf{Y}$ ", it is strongly recommended that the 783-04644 be securely clamped in a drill press when opening the " $\mathbf{X}$ " hole to 3/8" diameter.
- 3. Center the "X" hole with respect to the drill press chuck center line. With the drill press OFF and a 5/16" (.3125") drill bit in the chuck, align the "X" hole by ensuring the 5/16" drill passes freely through the .325/.320" diameter "X" hole.
- 4. While keeping the 5/16" drill bit in the .325/.320" diameter hole, clamp the 783-04644 securely to the drill press table.
- 5. Remove the 5/16" drill bit and replace with a sharp 3/8" (.375") diameter drill bit (Optional = .386" (W) drill bit).
- 6. Open up the .325/.320" diameter hole to 3/8" diameter. Remove sharp edges around 3/8" hole. Use a rat tail file to open the 3/8" hole just enough to allow the 3/8" bolt to fit freely.

## **INSTALLATION:**



1 of 1 Form No. 769-04147