

	DOCUMENT NUMBER	REVISION	
	DOC-1000295	A-0	
SUPPLEMENTARY PRODUCT DOCUMENTATION TL7-B2 COVER ASSEMBLY INSTRUCTIONS	ORIGINATOR ESTHER NAHOLOWAA	DATE 9/25/2018	PAGE 1

This instructional document is intended as a guide and supplement for assembling the cover onto the base for the TL7-B2 Twistlock. Reference top assembly drawing **1000123** and video **1000125**.

Parts List:

PART NUMBER	DESCR	QTY	NOTES
MOD028	BASE	1	
HDW075	COVER	1	
N/A	DOW CORNING MOLYKOTE 111 COMPOUND	APPROX.. 0.1 – 0.15 oz (or 3ml) PER BASE	NO SUBSTITUTIONS WITHOUT PRIOR APPROVAL FROM SYNAPSE ENGINEERING
N/A	60ML SYRINGE OR OTHER ACCEPTABLE SYRINGE SIZE	AS REQ'D	
N/A	DISPOSABLE PAIN BRUSH OR NYLON BRUSH	AS REQ'D	

Squeeze Molykote 111 Compound into syringe – fill approx.. 2/3 full. Insert plunger.

Apply a bead of compound to the red gasket, reference video file 1000125, file name 'GreaseBrushCoverInstallProcess.MOV'.

Using brush, smooth the compound evenly as shown in the video. Take care not to smear the compound onto the PCBA.

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Description: ASSEMBLY INSTRUCTIONS, COVER AND BASE, TL7-B2

Loosely attach cover to base – **IMPORTANT NOTE! Make sure to line up the arrow on top of cover (or the mold mark on bottom of cover) with the arrow on the bottom of base –**

Mold mark on the BOTTOM of the cover and arrow on the bottom of the base shown:



Mold mark on the TOP of the cover and arrow on the bottom of the base shown:



Set cover/base assembly onto the arbor press tool and gently press cover onto base as referenced in the video.