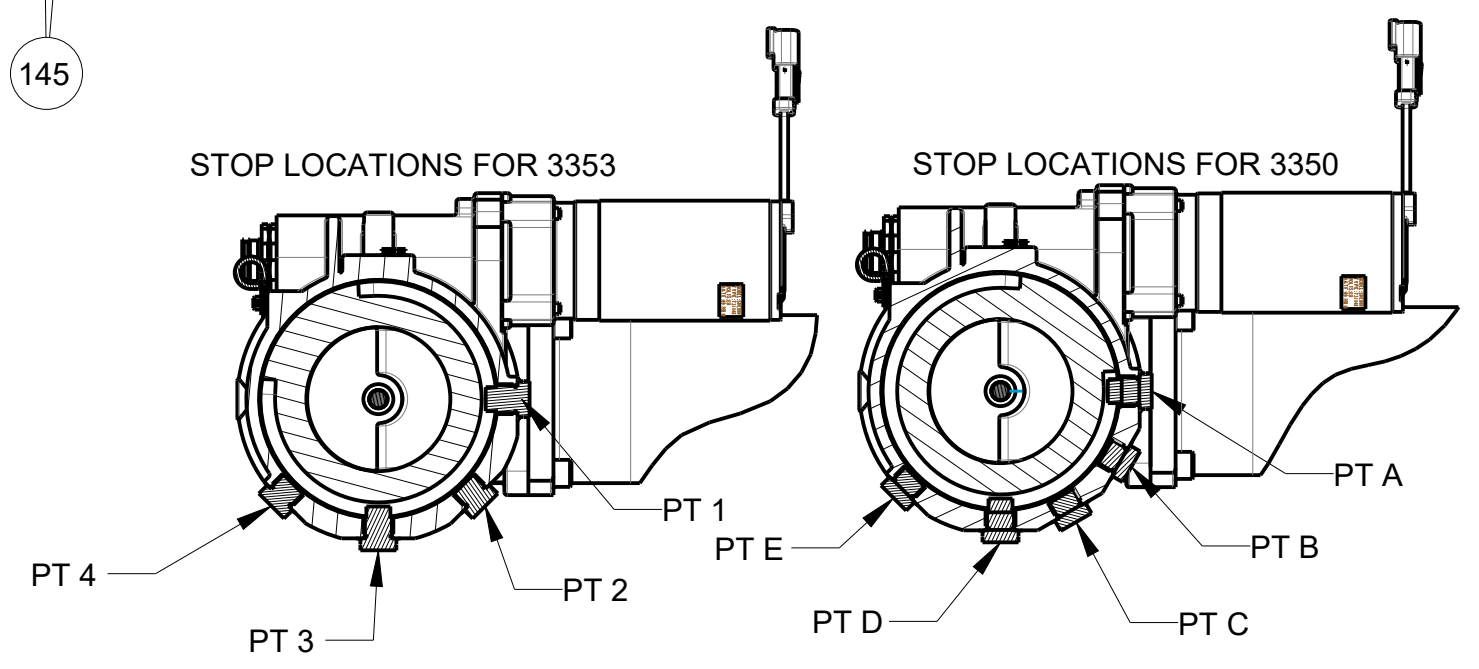



- ASSEMBLY NOTES:
- USE PARKER O-LUBE ON ALL O-RINGS AND MATING SURFACES UNLESS OTHERWISE NOTED.
- 1 USE PERMABOND LM113 OR LOCTITE 222.
  - 2 USE LUBRIPLATE LOW-TEMP GREASE.
  - 4 USE PERMABOND LH050 OR LOCTITE 592.
  - 5 INSTALL SENSOR WITH POTTED SIDE TOWARD WATERWAY.
  - 6 TORQUE SET SCREWS 11 IN-LBS.
  - 7 ALIGN TIMING DIMPLE ON BOTH JOINTS PRIOR TO INSTALLING POSITION SENSORS. ADJUST SENSOR OUTPUT TO 2.50± 0.01 V.
  - 8 ASSEMBLE WITH ROUNDED EDGES OF RETAINING RING TOWARDS WASHERS.
  - 9 USE PERMABOND HH120 OR LOCTITE 277.
  - 10 ASSEMBLE ROUNDED EDGES OF RETAINING RING TOWARDS WATERWAY.
  - 11 ALIGN TIMING MARK TO THE FLAT ON THE SHAFT.
  - 12 ALIGN THE FLAT ON THE SHAFT TOWARDS THE SLOT ON ITEM 3 AFTER THE TIMING MARKS ARE ALIGNED.
  - 13 THOROUGHLY COAT WITH NEVER SEEZ MARINERS CHOICE.
  - 14 AS SPECIFIED.
  - 15 ALIGN BALL IN HOLE TIGHTEN PLUG UNTIL TOUCHES BALL THEN BACK OUT PLUG 1/4-1/2 TURN.
  - 16 THOROUGHLY CLEAN THREADS OF PLUG AND MATING PART AND APPLY LOCTITE 425.
  - 17 SET SCREWS SUPPLIED WITH POSITION MARKER. USE LOCTITE 425.

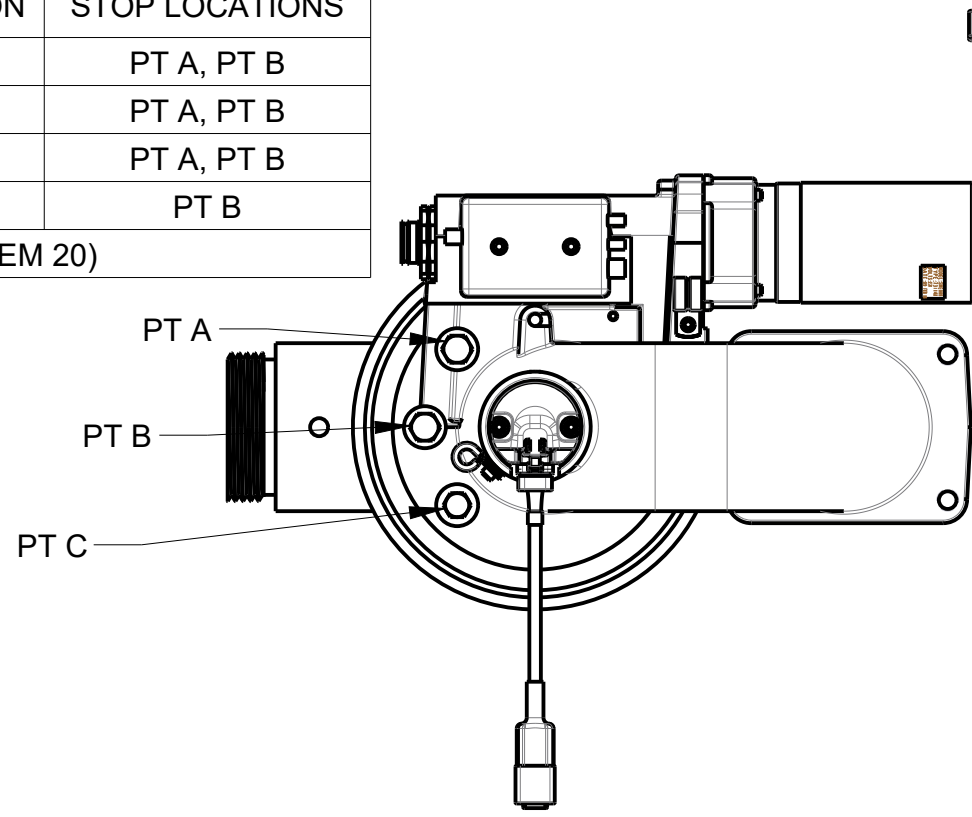
ROTATION STOP (ITEM 13) LOCATIONS 1		
ASSEMBLY NUMBER	ANGLE OF ROTATION	STOP LOCATIONS
33532005	± 90°	PT1, PT3
33532003	± 90°	PT1, PT3
33532000	± 90°	PT1, PT3
33502000	+0° , -180°	PTA, PTD
ALL OTHER LOCATIONS (ITEM 23)		



ELEVATION STOP (ITEM 21) LOCATIONS 

ASSEMBLY NUMBER	ANGLE OF ROTATION	STOP LOCATIONS
33532005	+90° , -45°	PT A, PT B
33532003	+90° , -45°	PT A, PT B
33532000	+90° , -45°	PT A, PT B
33502000	± 90°	PT B

ALL OTHER LOCATIONS (ITEM 20)

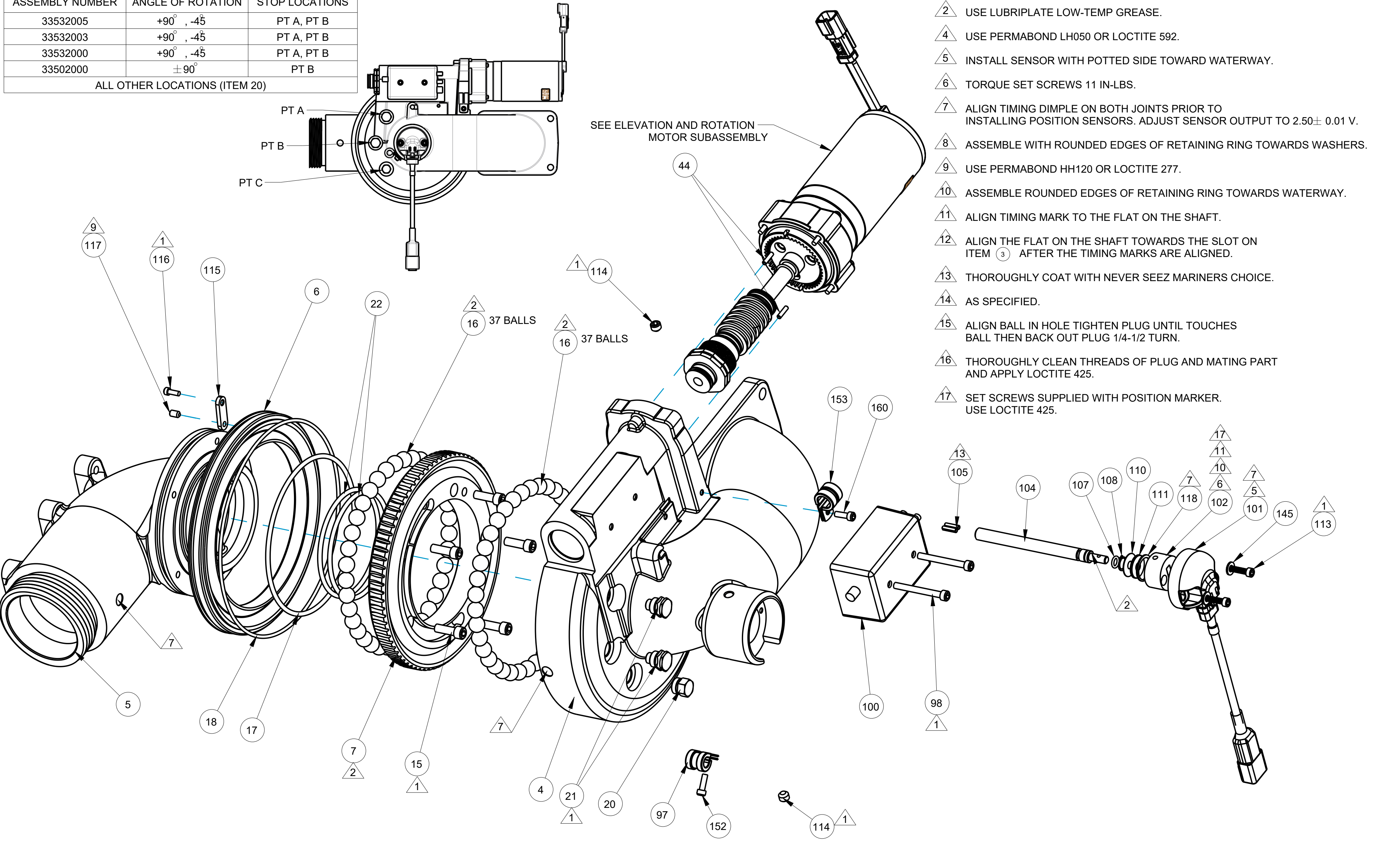


PT A

PT B


PT C

SEE ELEVATION AND ROTATION MOTOR SUBASSEMBLY




ASSEMBLY NOTES:


USE PARKER O-LUBE ON ALL O-RINGS AND MATING SURFACES UNLESS OTHERWISE NOTED.




USE PERMABOND LM113 OR LOCTITE 222.




USE LUBRIPLATE LOW-TEMP GREASE.




USE PERMABOND LH050 OR LOCTITE 592.




INSTALL SENSOR WITH POTTED SIDE TOWARD WATERWAY.




TORQUE SET SCREWS 11 IN-LBS.




ALIGN TIMING DIMPLE ON BOTH JOINTS PRIOR TO INSTALLING POSITION SENSORS. ADJUST SENSOR OUTPUT TO 2.50± 0.01 V.




ASSEMBLE WITH ROUNDED EDGES OF RETAINING RING TOWARDS WASHERS.




USE PERMABOND HH120 OR LOCTITE 277.





ASSEMBLE ROUNDED EDGES OF RETAINING RING TOWARDS WATERWAY.




ALIGN TIMING MARK TO THE FLAT ON THE SHAFT.




ALIGN THE FLAT ON THE SHAFT TOWARDS THE SLOT ON ITEM  AFTER THE TIMING MARKS ARE ALIGNED.




THOROUGHLY COAT WITH NEVER SEEZ MARINERS CHOICE.




AS SPECIFIED.



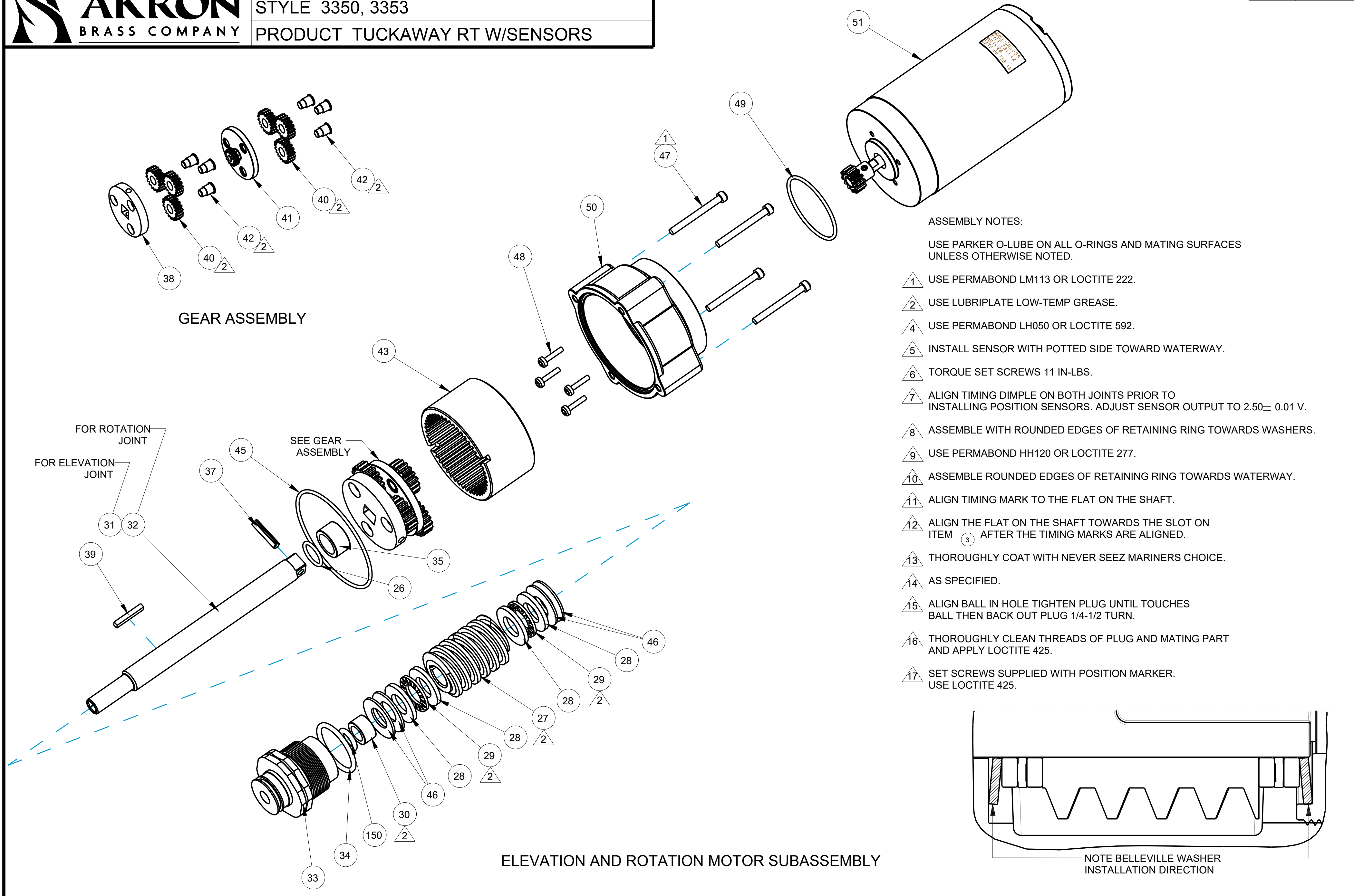
ALIGN BALL IN HOLE TIGHTEN PLUG UNTIL TOUCHES BALL THEN BACK OUT PLUG 1/4-1/2 TURN.



THOROUGHLY CLEAN THREADS OF PLUG AND MATING PART AND APPLY LOCTITE 425.



SET SCREWS SUPPLIED WITH POSITION MARKER. USE LOCTITE 425.





TECHNICAL SERVICE PARTS

STYLE 3350, 3353

PRODUCT TUCKAWAY RT W/SENSORS

IF AN ITEM IS NOTED AS "NOT FIELD REPAIRABLE", OR YOU WISH TO RETURN AN ITEM TO AKRON BRASS FOR SERVICE PLEASE GO ONLINE TO, **ONLINEREPAIR.AKRONBRASS.COM**

Chg.	Date
09	08-18
10	01-20

Find		Description	Item	3353 QTY	3350 QTY
1		PIPE INLET 3353	118586	1	-
1		PIPE INLET 3350	117692	-	1
2		BASE INLET 3353	122374	1	-
2		BASE INLET 3350	122556	-	1
3		ELBOW INLET 3353	127121	1	-
3		ELBOW INLET 3350	127124	-	1
4		ELBOW MIDDLE	122375	1	1
5		ELBOW OUTLET	122378	1	1
6		RING BALL RETAINER	117690	1	1
7		GEAR OUTLET	117689	1	1
8		O-RING 2-153	757327	1	1
9		SCREW SOCKET HEAD CAP 3/8 -16 X 1"	767047	1	1
10		O-RING 2-238	757036	2	2
11	A	BALL BRASS 3/8"	-	82	82
12		PLUG 1/2 -20 X 1/4"	742112	4	4
13		STOP VERTICAL	769596	2	2
14		O-RING 2-158	757326	1	1
15		SCREW SOCKET HEAD CAP 1/4 -20 X 3/4"	765030	5	5
16	B	BALL BRASS 1/2"	-	74	74
17		O-RING 2-249	757075	1	1
18		O-RING 2-166	757366	1	1
20		PLUG 1/2-20 X1/2"	744337	2	2
21		STOP	769498	1	1
22		O-RING 2-236	757035	2	2
23		PLUG ELEVATION 5/8-18	744397	2	2
24		SCREW SOCKET HEAD CAP 7/16-14 X 1-1/4	765207	4	4
25		O-RING 2-237	757081	1	1
26		O-RING 2-014	757041	2	2
27		GEAR WORM	718273	2	2
28		WASHER THRUST	784121	8	8
29		BEARING NEEDLE	703453	4	4
30		BEARING 3/8"ID	704393	2	2
31		SHAFT ELEVATION	770353	1	1
32		SHAFT ROTATION	770352	1	1
33		CAP BEARING	121467	2	2
34		O-RING 2-121	757329	2	2
35		BEARING ROLLER NEEDLE 1/2"ID	704395	2	2
37		PIN ROLL	744118	2	2
38	C	CARRIER OUTPUT	707455	2	2
39		KEY SPECIAL	727044	2	2
40	C	GEAR PLANET	718165	12	12
41	C	PLATE CARRIER	742119	2	2
42	C	RIVET SHORT	754052	12	12
43		GEAR INTERNAL ELEVATION	718164	2	2
44		PIN ROLL	744288	4	4
45		O-RING 2-036	757312	2	2

Find		Description	Item	3353 QTY	3350 QTY
46		SPRING BELLEVILLE	769276	8	8
47		SCREW SOCKET HEAD CAP 6-32 X 1 3/8"	767132	8	8
48		SCREW SOCKET HEAD CAP W/PATCH 6-32 X 1/2"	765052	8	8
49		O-RING 2-029	757056	2	2
50		HOUSING GEARBOX	109320	2	2
51		MOTOR 12V	34911013	2	2
94		TAG ID	773330	1	1
95		NAIL GRIP 3/16"DIA	736052	4	4
96		SCREW SOCKET HEAD CAP NYLON PATCH 8-32 X 3/8"	768058	2	2
97		CLAMP CABLE 5/16"	707548	2	2
98		SCREW SOCKET HEAD CAP 10-24 X 1 3/4"	767126	4	4
99		SCREW SOCKET HEAD CAP 3/8 -16 X 1 1/4"	765154	3	3
100		HARNESS WIRING 96"	721630	1	1
100		HARNESS WIRING 138" SPECIAL	721631	1	-
101		SENSOR MAGNETIC ROTARY ANGLE	60430006	2	2
102		MARKER POSITION MAGNET	731127	2	2
103		SHAFT ELEVATION FEEDBACK	770350	1	1
104		SHAFT ELEVATION FEEDBACK	770348	1	1
105		PIN ROLL	744078	2	2
106		PIN ROLL	744430	1	1
107		O-RING 2-010	757476	3	3
108		RING TRUARC	758247	2	2
110		SHIM .730 X .240 X .015	769887	2	2
111		WASHER .732 X .238 X .060	784192	2	2
113		SCREW SOCKET HEAD CAP 8-32 X 3/4"	765178	4	4
114		SCREW SOCKET HEAD CUP POINT SET 5/16-18 X 1/4"	765071	4	4
115		KEEPER	120137	1	1
116		SCREW SOCKET HEAD CAP 6-32 X 3/8	765175	1	1
117		SCREW SOCKET HEAD CUP POINT SET 10-24 X 5/16"	765040	1	1
118		RING RETAINING	758127	2	2
145		WASHER	784123	4	4
150		O-RING 2-110	757295	2	2
151		AUTO DRAIN	34670001	1	-
152		SCREW SOCKET HEAD CAP 10-24 X 3/8"	767029	3	3
153		CLAMP CABLE 7/16 ID	707975	4	4
160		SCREW SOCKET HEAD CAP 8-32 X 1/4"	765131	1	1
A		KIT OF 50 BALLS 3/8" BRASS	109342		
B		KIT OF 50 BALLS 1/2" BRASS	116252		
C		REPAIR KIT	33530029		

PHONE: 330.264.5678 or 800.228.1161 | FAX: 330.264.2944 or 800.531.7335 | [www.akronbrass.com](http://www.akronbrass.com)

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Parts List Sheet:

122380

D45588