MTI 527 Parts and Service Manual
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Parts and Service Manual, MTI 527S and 527P Chairs



MTI Printed Circuit Board Replacement

Instructions for Chairs w/ Plastic Base Covers

1. If the lift is functional, raise the base all the way up, unplug the power cord, and lift the middle metal covers up inside the top plastic cover using a bungee cord, tape, or rope **(Figures 1-2)**. Skip onto Step 5.





Figures 1 & 2

2. If the lift is not functional, remove the patient's right hand side panel by the three attached screws and put the chair in full tilt. Remove the screws on top of the base cover, along with the other screws on the top and middle base covers **(Figure 3)**. Be careful when removing covers so that they do not fall on the ground. Skip to step 5.



Figure 3

3. If the chair is not functional, remove the patient's left hand side panel by the three attached screws. Remove the e-ring from the side of the clevis pin nearest the hole and insert a 1/4"-1/2" rod through the hole to push out the pin while supporting the chair seat **(Figure 4)**.

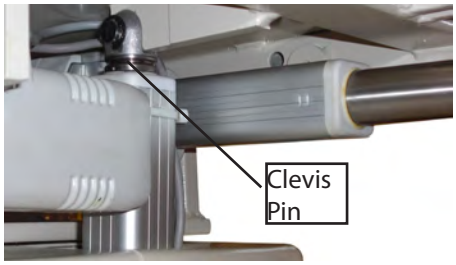
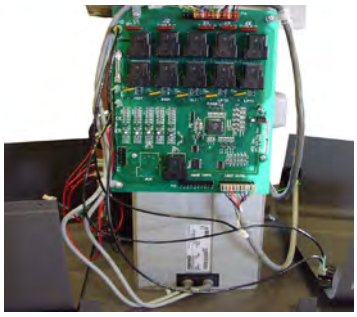


Figure 4

4. Once the pin is out, tilt the entire chair backward to get access to the two screws on top of the base cover. Remove the screws on top of the base cover, along with the other screws on the top and middle base covers **(Figure 3)**. Be careful when removing covers so that they do not fall on the ground.

5. Remove the (4) silver phillips screws and the (4) gray phillips screws from the bottom base cover. Lay the halves over, one on each side of the base **(Figure 5, 6)**.





Figures 5 & 6

6. Carefully handle both the replacement and original PC board and the plugs that will be moved from one board to the other. If it is possible, hold the replacement board in a position that the various plugs can be transferred from one board to the other to minimize confusion.

- *Note: Make sure that all plug bodies are transferred in the same direction, wires face to outside of board. Depending on model, both P1 and P2 may have a plug inserted in them.*

7. Remove the multi conductor control plug(s) P1 and/or P2 by grasping them at the sides and wiggling from side to side. Follow with the removal of P3, if used, (magnet control plug P3), then the red 24 volt power wire on spade terminal marked "VCC".

8. Next, remove the black ground wire attached to spade terminal marked "GND". If the chair is equipped with a safety lock-out switch, remove the two black wires from the spade terminals marked "Safety Jumper". Moving to the top of the board, remove the six conductor plug at the far right of the motor output plug P4, terminals 1-6. This is the output to the base lifting column.

9. Next, remove the six conductor plug on P4, terminals 7-12, which is the tilt and back motor output. If the particular chair is equipped with a foot motor, it is plugged into terminals 13-15 on P4 **(Figure 7)**.



Figure 7

10. Mount the new board in the same location with the same screws and spacers, making sure to reattach any cable ties or wire retainers and replace the metal lower and middle base cover halves.

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Lift Column Replacement Instructions for all MTI 527 Chairs



Figure 1

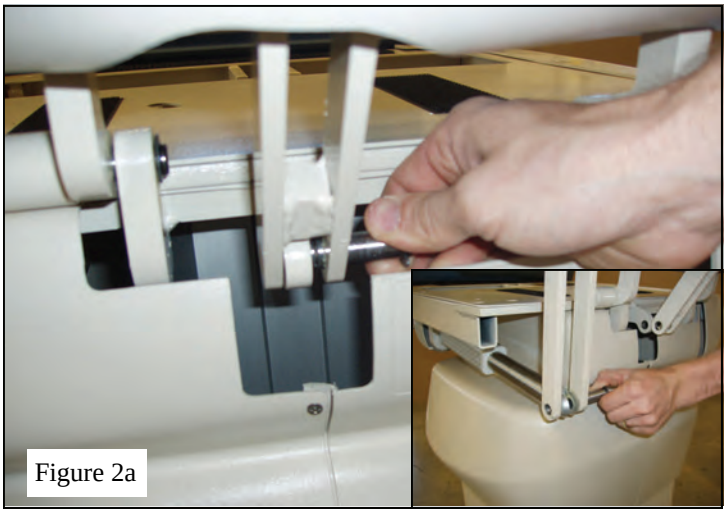


Figure 2a

Figure 2b

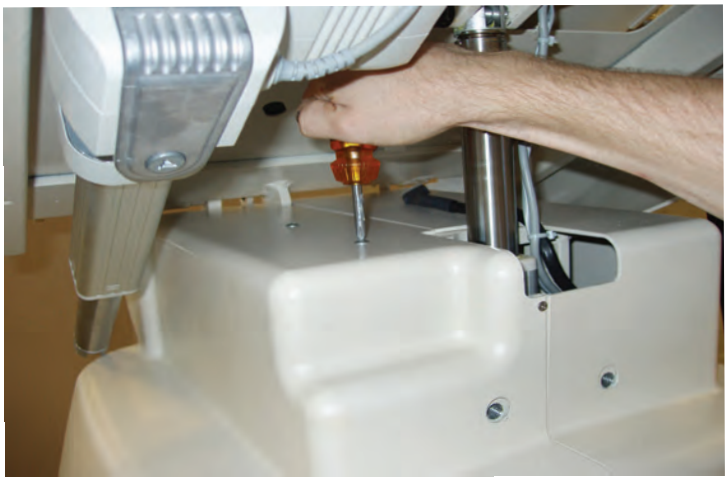


Figure 3

1) If the lift ***is*** functional, fully raise the base. If the lift *is not* functional, it does not matter. Remove the seat and back upholstery by firmly pulling up or out on the front edge of the seat or the top edge of the back upholstery. The upholstery is held in place with Velcro.
2) To gain access to the screws holding the plastic base covers, remove both the patients left and right molded side covers by removing the three screws holding each cover to the seat pan, (figure 1).
3) Remove the pin holding the arm linkage to the male seat clevis, (figure 2a). Remove the clevis pin that attaches the back motor to the back support clevis, (figure 2b). Lay the chair back down against the foot section. Cardboard or some other cushioning material may be needed to protect the upholstered foot section.
4) Using the foot or hand control, fully tilt the chair and remove the Phillips screws, top and bottom from the front and back of the cover set, and with a short Phillips screwdriver, remove the three screws holding the cover to the top of the base bracket, (figure 3). ***Disconnect the power cord from the power outlet at this point.***
5) After removal of the (2) screws in the front and back of the plastic cover they can be separated. The two base cover halves are held to each other via a tongue and groove system. Support the middle base cover from falling as you pull the two halves apart. Remove the patient's right side cover first. In order to remove the left hand plastic base cover. CAUTION, be sure to support the back motor gear tube during this stage. Remove the light colored metal middle base metal cover halves by removing the (4) phillips screws.
6) Remove the (8) phillips screws from the (2) darker colored bottom metal base cover halves and lay the halves over, one on each side of the base.
7) Noting and labeling all the positions of single wires and multi conductor plugs, remove all wires and plugs from the PC board, (figure 4). Using wire cutters, carefully cut the large plastic cable tie. Hold the PC board mounting plate and capacitor/rectifier mounting plate to the side of the lifting column, and with a flat blade screwdriver, pry up the two black plas-

(Continued on page 2)

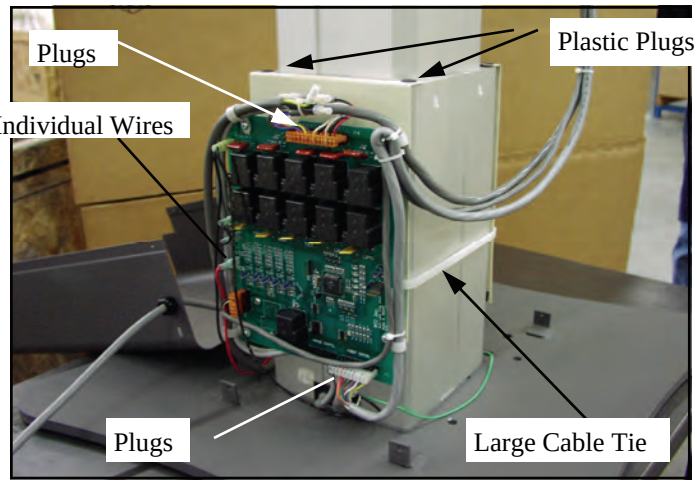


Figure4

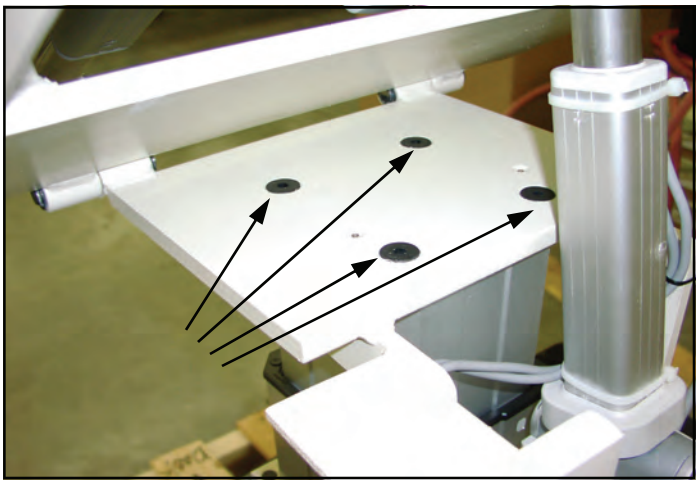


Figure 5

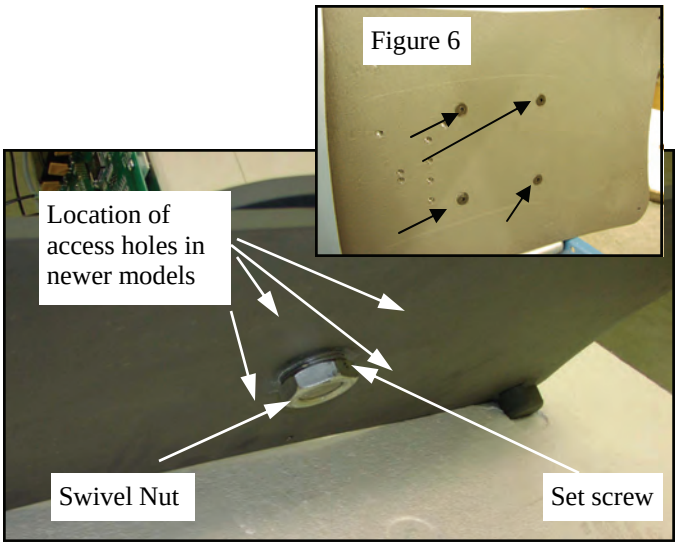


Figure 7

(Continued from page 1)

tic plugs holding the corner of each of the mounting brackets on the top of the first section of the lifting column and remove both brackets.

8) Using a ***6mm metric allen wrench***, remove the (4) 10mm x 40mm flat head screws holding the pivot plate asssy, (figure 5). *NOTE: If difficulty is experienced removing the flat head screws securing the top to the base or the lifting column to the base plate, a* ***impact driver*** *equipped with a 6mm allen wrench tip should be used to loosen the bolts.* Carefully remove the entire chair top and set it aside on a piece of carpet or soft material to cushion it.
9) For swivel base models, tip the base plate to the left or right side to expose the large swivel nut, figure 6. On s/n 030501001 and above, remove the (4) 10mm x 40mm flat head bolts recessed in the swivel plate ***through the access holes*** in the base plate then continue as per below, there is no need to remove the nut. On s/n 030430001 and below, loosen the 1/8" set screw, which locks the swivel nut travel, (figure 7). Hold the lifting column so it does not turn, and with a large adjustable wrench or large pipe wrench, rotate the nut counterclockwise. Tip the column upside down with the base plate up. Remove the thrust bearing pack under the nut and while supporting the lifting column, carefully lift the base plate off of the swivel plate and lifting column. Remove the (4) exposed 10mm x 40mm flat head screws with a 6mm metric allen head wrench or impact driver, (figure 6). As the last screw is removed, again support the lifting column. ***Note, the column orientation on the swivel plate before removal.***
10) Remove the (4) large phillips head screws from each end of the new replacement lifting column. **NOTE: These are shipping containment screws (10mm Phillips) on both ends placed in the column to avoid shipping damage and MUST be replaced into the original lifting column, BEFORE returning it to the factory for repair/credit.**
11) Position the replacement column in the same orientation as the old column and replace the (4) 10mm x 40mm flat head bolts. Tighten all flat head bolts to 22 foot pounds of torque. Tip the base plate upright on the floor and replace all components in the reverse order.
12) Return the original lifting column with the (4) large phillips head screws in place on both ends of the column and repack it in the original shipping container.

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Back Motor Replacement Instructions for all MTI 527 Chairs



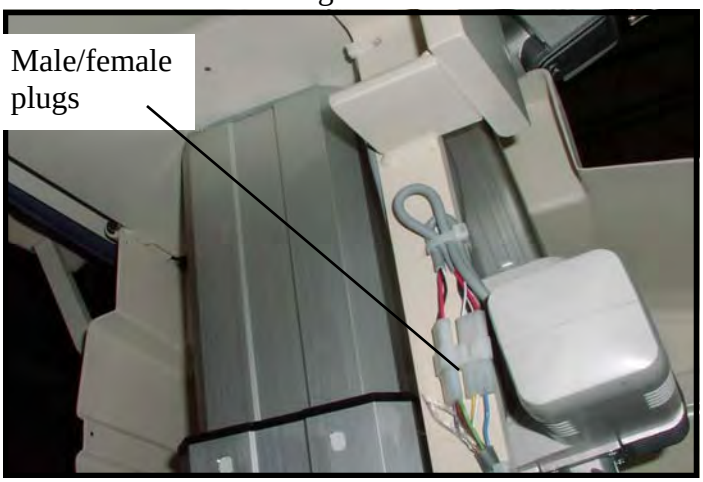
1) Remove the seat upholstery by pulling on the cushion until it detaches from the Velcro. Remove the (3) screws from the top of the seat panel on the patient's left hand side and remove the plastic side panel.

Figure 1



2) Put the chair in full tilt. Remove the three phillips head machine screws holding both of the chair side panels on, (figure 2). Remove the other (4) screws on the front and back of the cover the holds the two together. Take off the cover that is on the patient's right hand side.

Figure 2



3) Follow the power cord from the back motor down the side of the tilt chassis, (figure 3). Unplug the applicable male/female low voltage plug, and clip the cable ties holding the back actuator wiring harness in place.

Figure 3

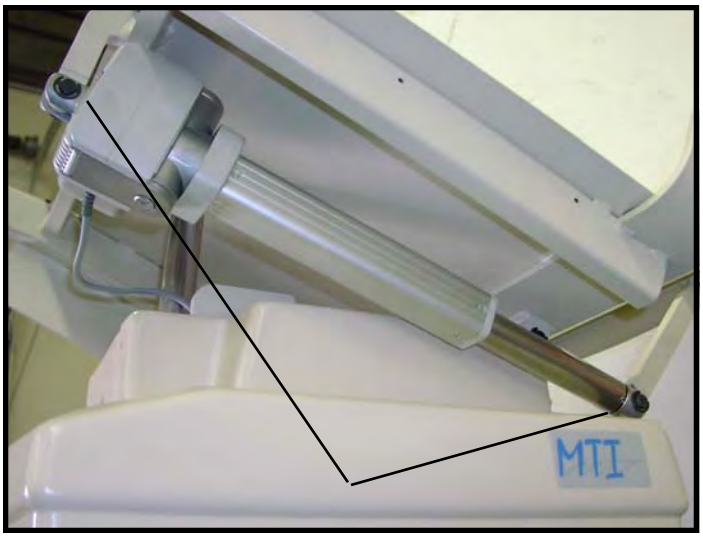


Figure 1

4) Tilt the chair back to bottom position. Remove one of the two E-rings on the 1/2” clevis pin holding the actuator at the motor shaft end (figure 4) and the arm actuator (figure5). Be careful not to drop anything in the chair base.



Figure 1

5) Support the chair back, push out the pin in the motor’s shaft end and in the arm actuator, and lay the back over on the seat. Remove the motor end pin, supporting the motor base at the same time. A hammer and soft metal rod may be needed to drive the pin out. Remove the motor from the mounting clevis.

6) Reverse the process to install the replacement motor, using new cable ties. When replacing the

MTI Model 527/526 Tilt Motor Replacement

Installation

1. Remove both side panels by removing the three Phillips head screws on each. If the tilt motor is functional, put the chair in full tilt **(Figure 1)**.



Figure 1

2. If it is not functional, reach up from the toe of the chair with a pair or needle nose pliers and remove the E-ring holding the horizontal pin at the end of the motor shaft.

3. Wiggle the footrest up and down as you push the pin out toward the patient's right side. If the pin does not move proceed to the patient's left side of the chair, where there is hole in the frame that you may use a 3/8" round rod to knock out the pin. After removal of the pin, tilt the chair top backward, using as assistant to hold the chair top from falling all the way back, or carefully fest the top of the chair on the floor using a cushion for protection.

4. Remove the three Phillips head screws holding both of the chair side panels. Remove the other (4) screws on the front and back of the cover the holds the two together. Take off the cover that is on the patient's right hand side **(Figure 2)**.

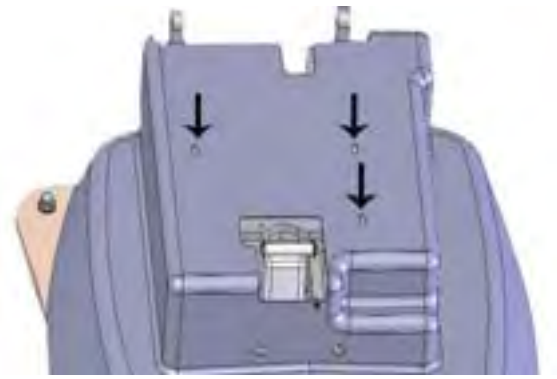


Figure 2

5. Follow the power cord from the tilt motor down the side of the tilt chassis. Unplug the applicable male/female low voltage plug, and clip the cable tie holding the tilt actuator power cord in place.

6. Remove one of the two E-rings on the 1/2" clevis pins holding the actuator at the base end of the motor. Remove the motor end pin supporting the motor at the same time. A hammer and soft metal rod may be needed to drive the pin out. Remove the motor from the mounting clevis. Reverse the process to install the replacement motor, using new cable ties **(Figure 3)**.



Figure 3

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DCN

MTI 527/526 Foot Section Replacement Instructions



Figure 1

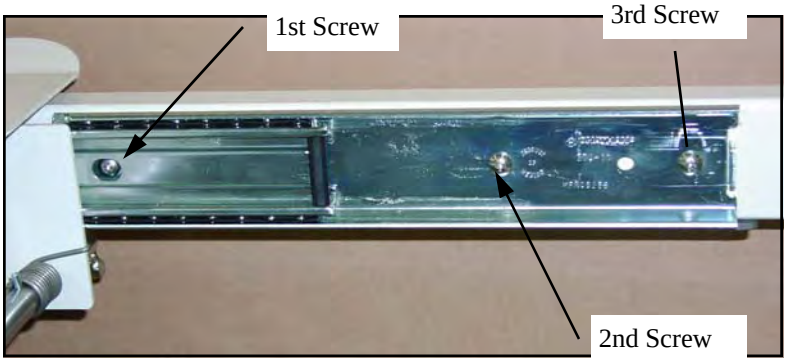


Figure 2

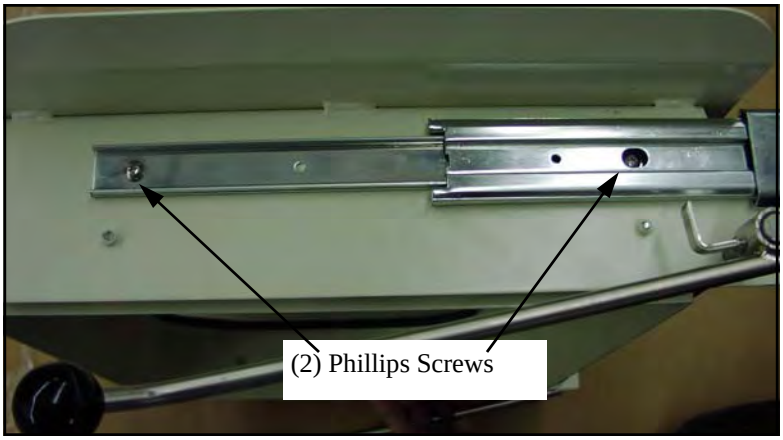


Figure 3

1) Remove foot section upholstery by grasping the cushion from the sides and pulling straight up. The cushion is held on with Velcro attachment, so a firm pulling motion is required.
2) Extend the footrest entirely. Move to the side of the chair and note the foot extension slides on the inside of each chair side rail, (Figure 1).
3) Using a Phillips screwdriver, only remove the 1st 8-32 x 3/8" Phillips head screw, which is the screw in the slide located closest to the rear of the foot section, (Figure 2), It helps to hold the slide against the rail on each set of slides.
4) Locate the middle screw holding the slide and remove that 2nd screw from both sets of slides, (Figure 2).
5) Finally remove the 3rd set of screws in each set of slides and while support the foot section so it does not drop, gently remove the foot section.
6) With the foot section off of the chair, remove the two Phillips head screws holding the slides on the outside of the foot section frame, (Figure 3).
7) Replace the slides on to the new foot section, using the (2) screws on each slide removed from the original.
8) Extend the slides rearward and position the new foot section back on the chair side rails. Align the 3rd set of holes in the slides with that of the chair side rails and fasten that set of screws only, (Figure 1).
9) Release the upward tension of the extension lock, (Figure 1), by pressing down on the knob and lifting the foot section to pivot holes and screws (1st and 2nd) into position for attachment.
10) Insert the remaining screws into proper position, do not over torque these attachment screws.

Arm Installation/Replacement for Models 527W/527/526

Installation

1. Take inventory on the following items **(Figure 1)**:

- A left and a right arm weldment
- (2) Black sliding arm assemblies
- (4) 3/8" shoulder bolts
- (8) 3/8" lock washers
- (7) 6 x 5/8" zinc plated self tapping screws.



Figure 1

2. To install the arms, first you need to remove the back section plastic cover. The back section plastic cover has (7) 6 x 5/8" zinc plated self tapping screws holding it on the back weldment **(Figure 2)**. Using a screwdriver to remove all seven screws. With both hands, pull one side of the plastic cover until the three screw tabs clear the metal back and then pull backward. Once cleared, pull the other side off the same way **(Figure 3)**.



Figure 2

◆ *Only use a hand held screw driver and not a screw gun.*



Figure 3

3. As seen in **Figure 3**, the left arm weldment (patient's left) is on the lift side and the right (patient's right) is on the right side. With both hands holding the right arm weldment, insert the greased arm shaft into the brass bushing found on the middle of the back weldment on the patient's right side **(Figure 4)**. Then with both hands, wiggle the arm weldment up and down while at the same time pushing inward until you line up the first two holes.



Figure 4

4. Insert the two 3/8" shoulder bolts into the two corresponding holes on the arm connector tube **(Figure 5)**. With a 3/16" socket allen wrench, tighten down the bolts.

5. Repeat steps 3 and 4 to install the left arm weldment **(Figure 6)**.



Figure 5



Figure 6

6. Repeat step 1 to replace the plastic back cover by inserting the three tabs on the left side over the sheet metal and then pulling the three tabs on the right side over the sheet metal. Make sure that all tabs clear the metal. Then with a hand held screw driver, screw down the (7) 6 x 5/8" zinc plated self tapping screws into the (7) screw tabs found on the back weldment **(Figure 2)**.

Removal

7. The back section plastic cover has (7) 6 x 5/8" zinc plated self tapping screws holding it on the back weldment **(Figure 2)**. Remove the back section plastic cover with a screwdriver.

8. With both hands, pull one side of the plastic cover until the three screw tabs clear the metal back and then pull backward. Once cleared, pull the other side off the same way **(Figure 3)**.

◆ *Only use a hand held screw driver and not a screw gun.*

9. With a 3/16" socket allyn wrench, remove the two 3/8" shoulder bolts from the arm connector tube **(Figure 5)**.

10. With both hands holding the right arm weldment, wiggle the arm weldment up and down while at the same time pull outward until the greased arm shaft is completely removed from the brass bushing found on the middle of the back weldment on the patient's right side.

11. Repeat steps 3 and 4 to remove the left arm weldment **(Figure 6)**.

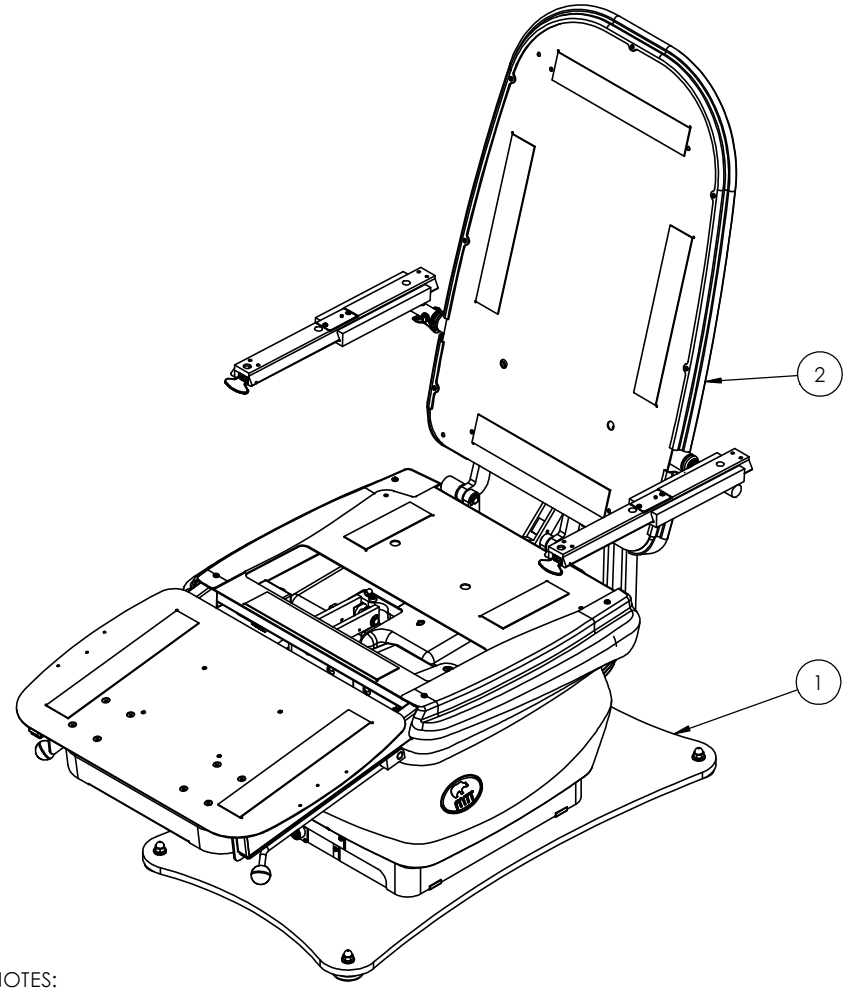
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DCN 07#### Rev A

DWG. NO.
5270001

REV.	DESCRIPTION	DATE	ENGR	EC#
ORG	INITIAL RELEASE.	10/15/2007	MTB	
A00	ADDED 5279069 HAND CONTROL WIRING HARNESS W/ HARDWARE.	2/27/2009	MTB	
B00	ON P/N 5279010 REV B HOLES WERE ADDED FOR THE LEG WRAP STIRUP.	7/29/2010	MTB	
C00	REPLACED 5279010 W/ 5279077 TO ADDED REMOVABLE FLOATING ARMS.	9/3/2010	MTB	
D00	CHG'S MADE TO 4309059 & 4309062 REV D CAUSED THIS REV TO ROLL.	12/16/2010	MTB	
E00	RPLC'D THE YELLOW FRICTION BRAKE & THE SPRING W/ AN ABS FRICTION BRAKE P/N 5271124 & SPRING P/N 038004. ADDED TWO #10 FLAT WASHERS P/N 045028. THESE CHANGES WERE MADE AT THE 5279004 FOOT SECT ASSEMBLY LEVEL.	3/21/2011	MTB	
E01	DATA MIGRATION REVIEW,REPLACED 032054 WITH 032052	7/31/2012	JVA	



NOTES:

1. APPLY WHITE GREASE, P/N 067019, TO THE SIDES OF THE FEMALE DOVE TAIL ARM SLIDE GUIDES. DO NOT APPLY GREASE TO THE BOTTOM SURFACE. MOVE THE ARM SLIDE, P/N 5279021, IN AND OUT SEVERAL TIMES TO DISTRIBUTE THE GREASE. THEN WIPE OFF THE EXCESS GREASE.
2. APPLY WHITE GREASE TO ALL THE PINS/HOLES BEFORE ASSEMBLY.

ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
1	5279011	1	BASE ASSY, 527, 115V
2	5279077	1	CHAIR TOP ASSY, 526/527
3	4001092	1	MACHINED PIN, 1/2 X 2.063
4	046014	2	E-CLIP, 1/2 BLACK
5	5279069	1	WIRING HARNESS, HAND CONTROL F/CHC526-1 & CHC527-1
6	1009312	1	GERMICIDAL WIPE & POWER CORD KIT
E01 7	032052	2	PHP SCREW, 8-32 x 3/8 ZINC
8	051039	1	SURGE CUBE, 885 JOULES
9	073059	1	USER MANUAL, 527P/S, 527W & 526
10	4001206	1	LABEL, SERIAL TAG, 4 X 2

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TOLERANCES:
FRACTIONAL ± 1/16
ANGLE: MACH ± 1/2° BEND ±1°
TWO PLACE DECIMAL ±.015
THREE PLACE DECIMAL ±.005

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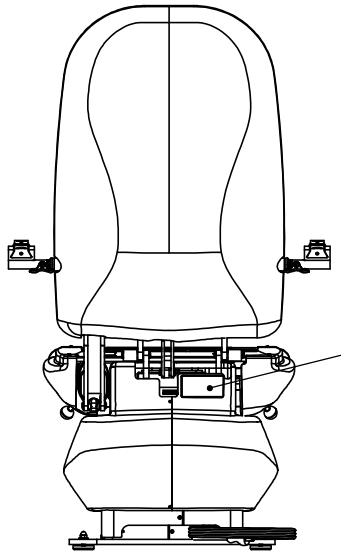
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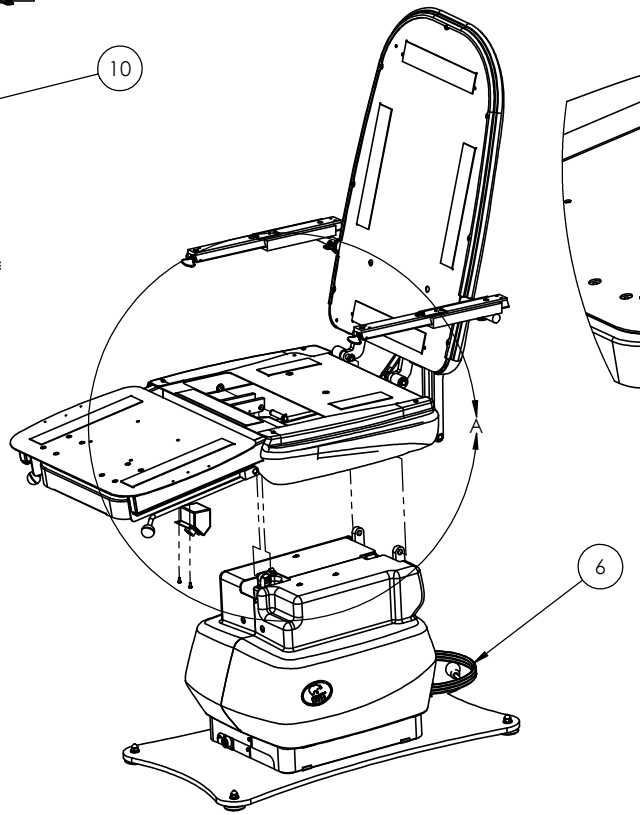
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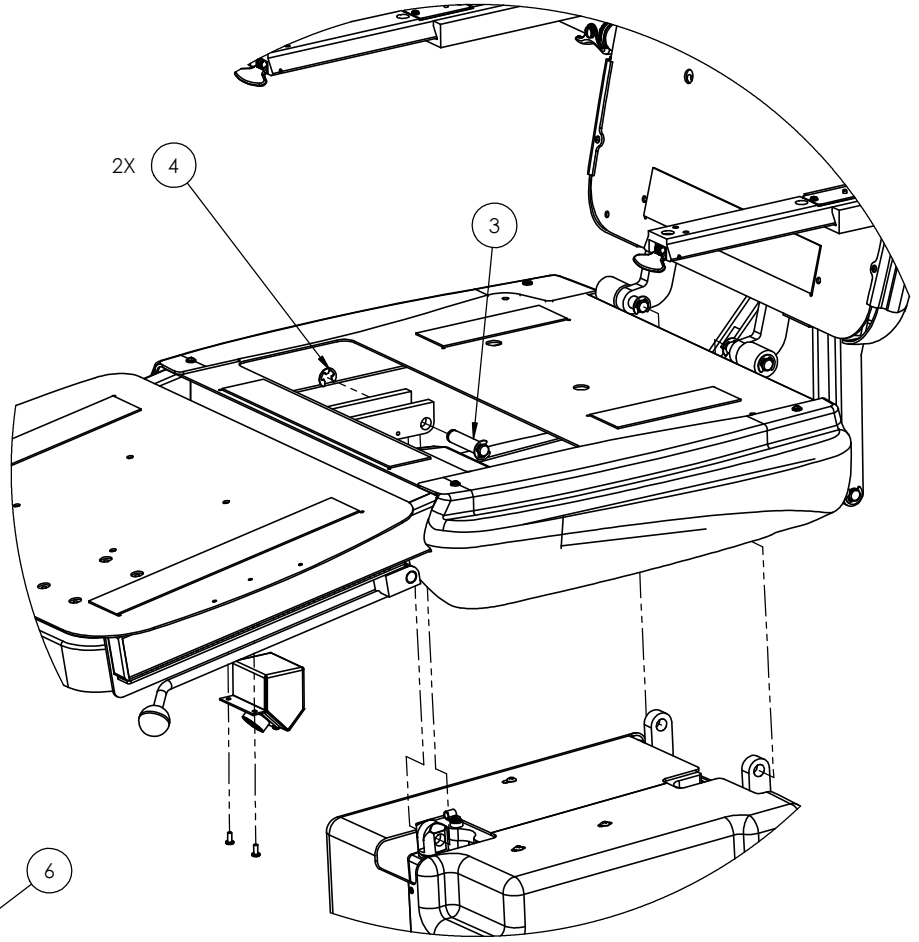
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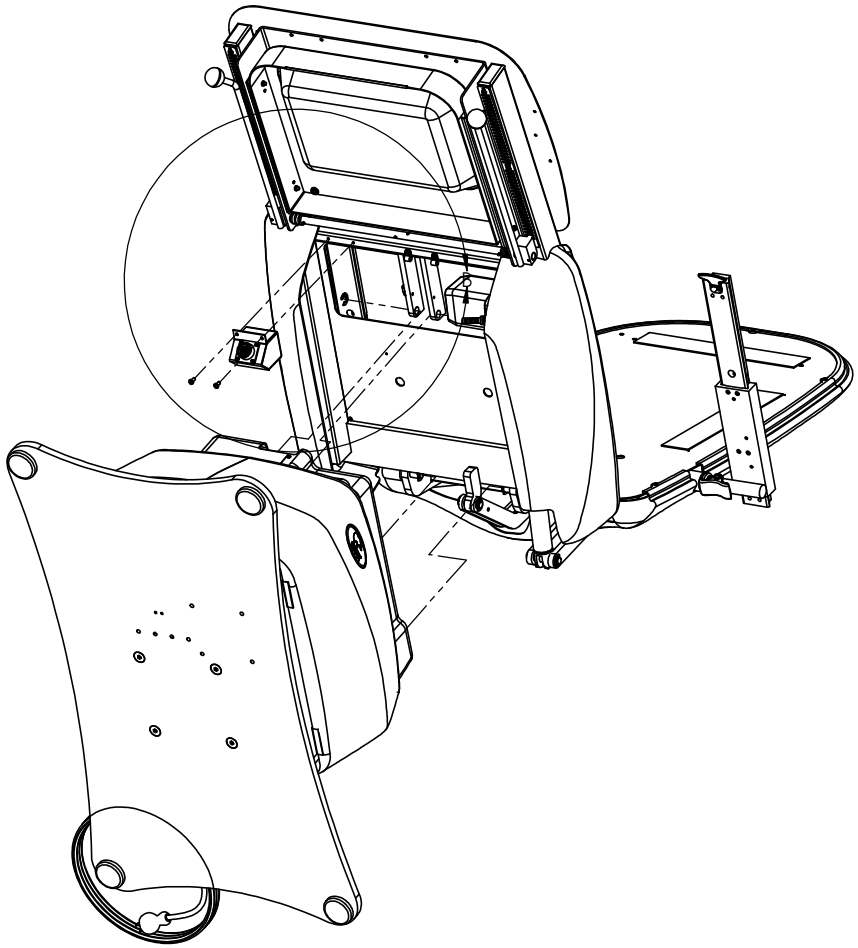
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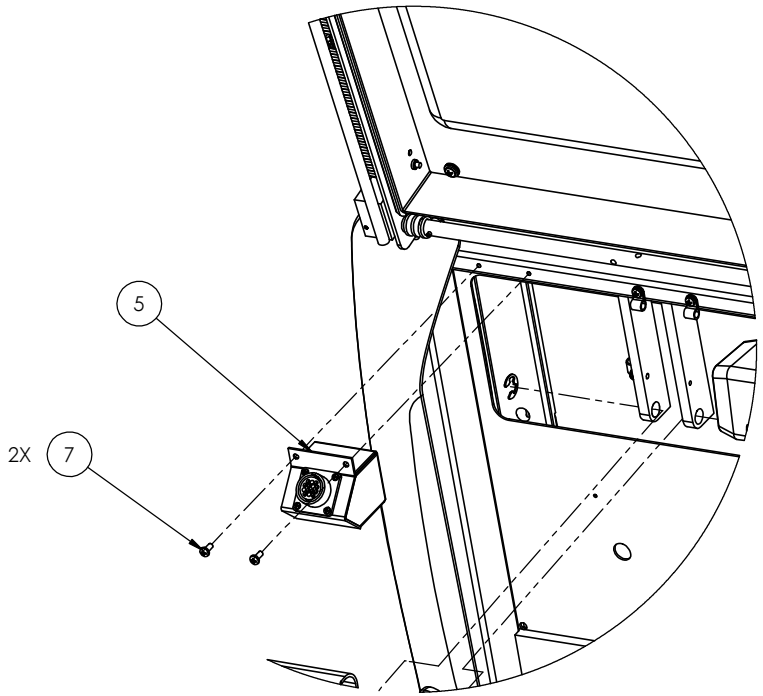
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DWG. NO.
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DETAIL B
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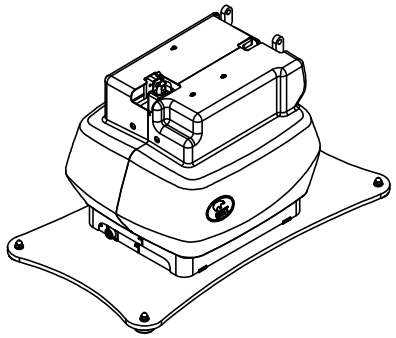
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DWG. NO.
5279011

ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
1	5279018	1	BASE PLATE WLD
2	5279017	1	LIFTING COLUMN ASSY, 500MM STROKE, AX SPINDLE
3	029494	8	FHC SCREW, M10 X 1.5 X 40 BLACK
4	4001082	1	MTG BRACKET, CIRCUIT BOARD
5	4001118	1	MTG BRACKET, TRANSFORMER
6	1001249	1	CIRCUIT BOARD, DC CHAIR
7	047014	5	NYLON SPACER, .171 ID X .50 OD X .188 THK
8	047015	2	NYLON SPACER, .171 ID X .375 OD X .062 THK
9	051077	2	CABLE CLAMP, 3/8 ID X 3/8 W X .203 HOLE PLASTIC
10	032054	5	PHP SCREW, 8-32 x 1/2 ZINC
11	061005	12	BUMP-ON, SQUARE 1/2 X 1/2 X .25 HIGH
12	051042	1	CAPACITOR, 50 VDC 18000UF
13	051040	1	CONDUIT BRACKET, 1-1/2" EMT (CAPACITOR MOUNT)
14	032067	2	PHP SCREW, 10-24 x 1/2 ZINC
15	051041	1	BRIDGE RECTIFIER
16	031044	1	FHP SCREW, 10-24 x 3/4 ZINC
17	1009188	1	TRANSFORMER ASSY, 115V
18	032098	4	PHP SCREW, 1/4-20 x 1/2 ZINC
19	051107	1	CABLE CLAMP, 3/8 ID X 1/2 W X 1/4 HOLE W/VINYL
20	045128	1	EXTERNAL STAR WASHER, 1/4, ZINC
21	032097	3	PHP SCREW, 1/4-20 x 3/8 ZINC
22	1001469	1	TERMINAL BLOCK (BLOCK OF 4)
23	031031	1	FHP SCREW, 8-32 x 3/4 ZINC
24	5279009	1	PIVOT PLATE WLD
25	4309017	1	MOTOR ASSY, BACK, 150MM STROKE, C SPINDLE
26	5001090	1	MACHINED PIN, 1/2 X 1.125
27	046014	2	E-CLIP, 1/2 BLACK
28	5271050	1	BASE COVER, 527 INSIDE, LH
29	5271049	1	BASE COVER, 527 INSIDE, RH
30	045201	4	INTERNAL STAR WASHER, 8 ZINC
31	032364	4	PHP SCREW, 8-32 x 3/8 BLACK
32	032463	8	PHP SEMS SCREW, 6-32 X 3/16 W/INTERNAL STAR WASHER
33	051084	1	RECEPTACLE, IEC W/FUSE DRAWER F/(2) 5MMX20MM FUSES
34	1001298	2	SCREW, POWER CORD RETAINER
35	1001299	1	RETAINER CLIP, POWER CORD
36	051088	2	FUSE, GLASS SLOW BLOW 4 AMP 5MM X 20MM
37	032022	4	PHP SCREW, 4-40 x 1/2 ZINC
38	048018	1	TOGGLE SWITCH, SPDT 15 AMP 115V W/.250 TABS
39	5271051	1	BASE COVER, 527 MIDDLE, LH
40	5271052	1	BASE COVER, 527 MIDDLE, RH
41	1001301	4	TRIM, 1" LG BLACK EDGE
42	033352	8	HEX HEAD BOLT, 8-32 X 1/2 PLASTIC
43	040022	8	HEX NUT, 8-32 PLASTIC

REV.	DESCRIPTION	DATE	ENGR	EC#
ORG	INITIAL RELEASE	6/21/2007	MTB	
A00	ADDED HAND CONTROL WIRING HARNESS, P/N 5279069.	3/6/2009	MTB	
A01	DATA MIGRATION REVIEW, MOVED HAND CONTROL HARNESS TO CHAIR TOP ASSEMBLY, AND CREATED BASE COVER ASSY W/ ANTI-FRICTION KIT.	4/30/2012	JVA	



NOTES ARE ON SHEET 2

ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
44	5279092	1	BASE COVER ASSY, MOLDED, 527 OUTSIDE
45	035026	3	TRUSS HEAD PHILIPS SCREW, 8-32 x 3/8 ZINC
46	1001671	4	FHP SHEET METAL SCREW, 6 X 1/2 ZINC PAINTED #52836
47	1001184	1	LABEL, ELECTRICAL LOCKOUT
48	1001183	1	LABEL, GROUND SYMBOLS
49	056012	4	LEVELING GLIDE, 3/8-16 X 1
50	045032	8	SAE WASHER, 3/8 ZINC
51	040089	4	ACORN NUT, 3/8-16
52	051076	1	CABLE CLAMP, 1/4 ID X 3/8 W X .203 HOLE PLASTIC
53	051189	1	CLOSED END CONNECTOR, MEDIUM (MAX. (3) 16 AWG)
54	051094	1	CABLE TIE, 33"
55	051091B	5	CABLE TIE, 7-1/2"
56	051090	11	CABLE TIE, 3-1/2"
57	4309048	1	WIRING HARNESS, POWER SUPPLY
58	4359008	1	WIRE ASSY CAPACITOR TO CIRCUIT BOARD, RED
59	4359010	1	WIRE ASSY CAPACITOR TO CIRCUIT BOARD, BLACK
60	4359013	1	WIRE ASSY CAPACITOR TO RECTIFIER, RED
61	4359014	1	WIRE ASSY CAPACITOR TO RECTIFIER, BLACK
62	7009020	1	WIRING HARNESS, 2 OUTPUTS
63	4309015	1	WIRING HARNESS, FOOT/HAND CONTROL TO PC BOARD
64	4359015	2	WIRE ASSY LOCK OUT SWITCH TO CIRCUIT BOARD, BLACK
65	5309009	1	WIRING HARNESS, ELECTRICAL OUTLET BASE

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MATERIAL: SEE BOM

THIRD ANGLE PROJECTION

	NAME	DATE
DRAWN	MTB	06/20/2007
ENGINEER	MTB	06/20/2007
CHECKED		

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/16
ANGLE: MACH ± 1/2° BEND ±1°
TWO PLACE DECIMAL ±.015
THREE PLACE DECIMAL ±.005

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TITLE:

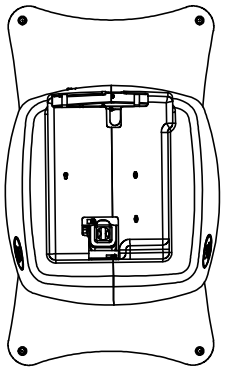
BASE ASSY, 527, 115V

SIZE	DWG. NO.	REV
B	5279011	A01

SCALE: 1:12 UNLESS NOTED | SHEET 1 OF 7

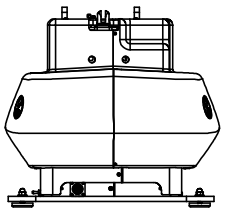
DWG. NO.
5279011

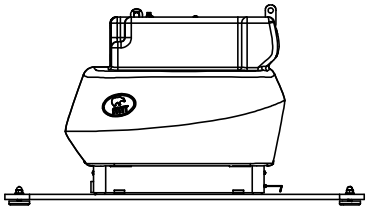
REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-

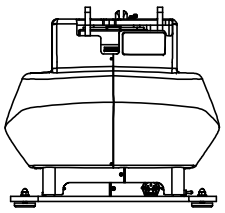


NOTES:

1. SOME COMPONENTS NOT SHOWN FOR CLARITY IN MOST VIEWS.
2. REMOVE THE BLACK PLASTIC BEZEL FROM THE TOP OF THE LARGEST SECTION OF THE LIFTING COLUMN.
3. REMOVE THE EIGHT PHP SHIPPING SCREWS FROM THE TOP AND BOTTOM OF THE COLUMN.
4. ATTACH ITEMS (5) AND (4) USING THE PLASTIC PLUGS THAT HOLD THE BLACK PLASTIC BEZEL TO THE TOP OF THE LARGEST SECTION OF THE LIFTING COLUMN.
5. 7-1/2" CABLE TIES ARE USED TO ATTACH THE PC BOARD OUTPUT CABLE AND MOTOR CABLES TO THE PIVOT PLATE. (NOT SHOWN).
6. APPLY WHITE GREASE TO HOLES BEFORE ASSEMBLY.
7. APPLY WHITE GREASE TO BOLT HEADS BEFORE ASSEMBLY. TIGHTEN BOLTS WITH TORQUE WRENCH (SET AT 25 FT*LBS).
8. ITEM (54) TO CAPTURE ITEMS (4) AND (5) AFTER ASSEMBLY.
9. THE PLASTIC BASE COVER IS MADE OF TWO HALVES.
10. THE 14 PIN CONNECTOR IS PART OF THE FOOT CONTROL WIRING HARNESS.





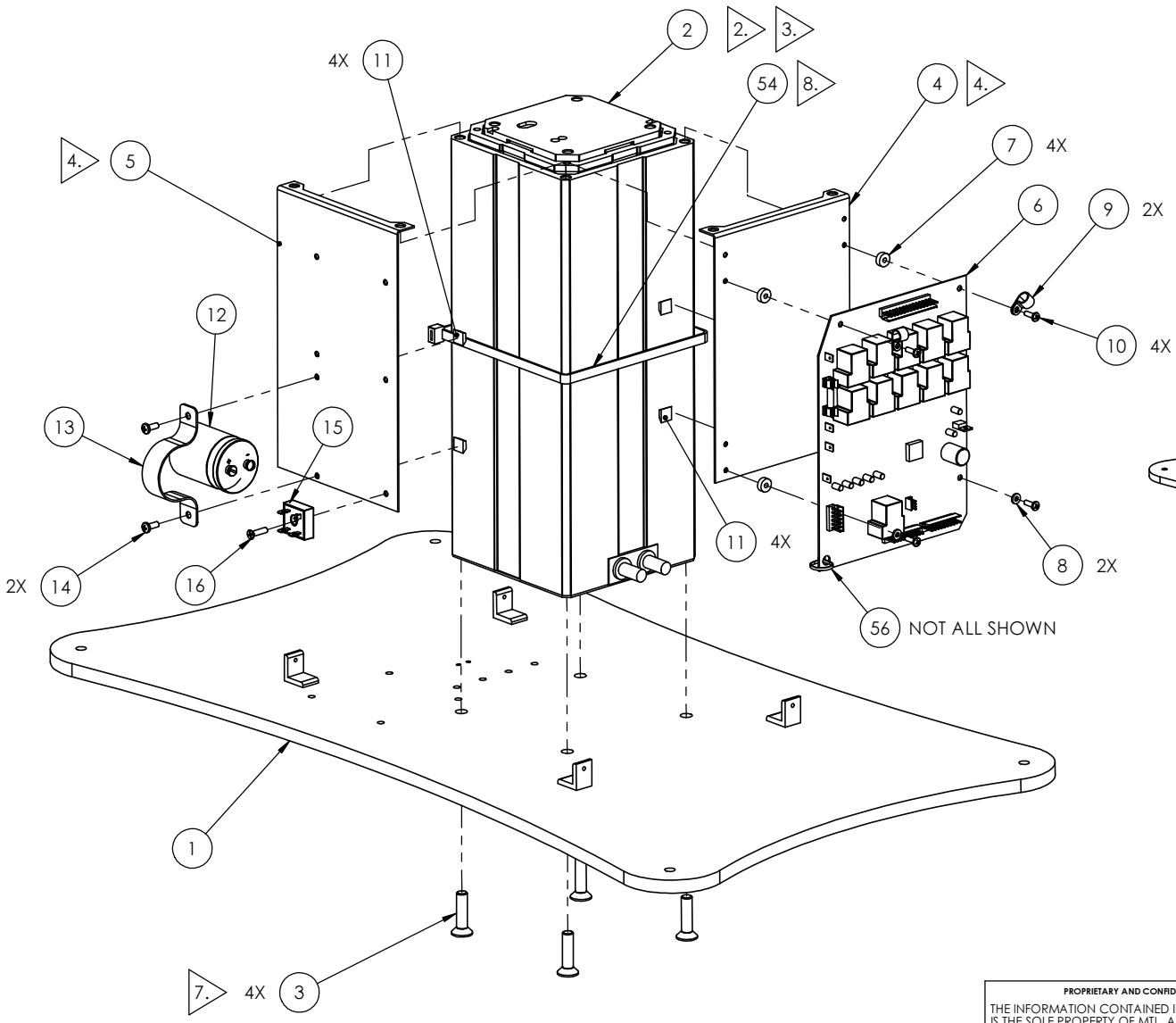


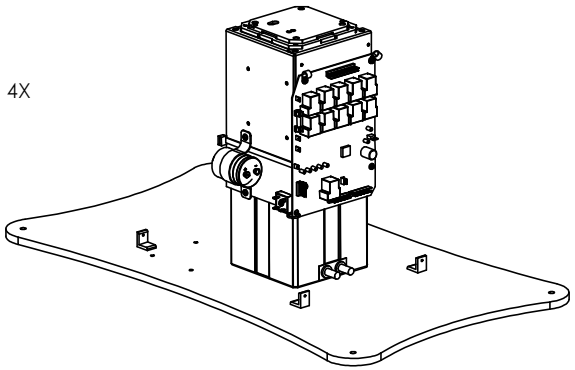
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SIZE	DWG. NO.	REV
B	5279011	A01
SCALE: 1:4 UNLESS NOTED		SHEET 2 OF 7

DWG. NO.
5279011

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-





ASSEMBLED VIEW
SCALE: 1:8

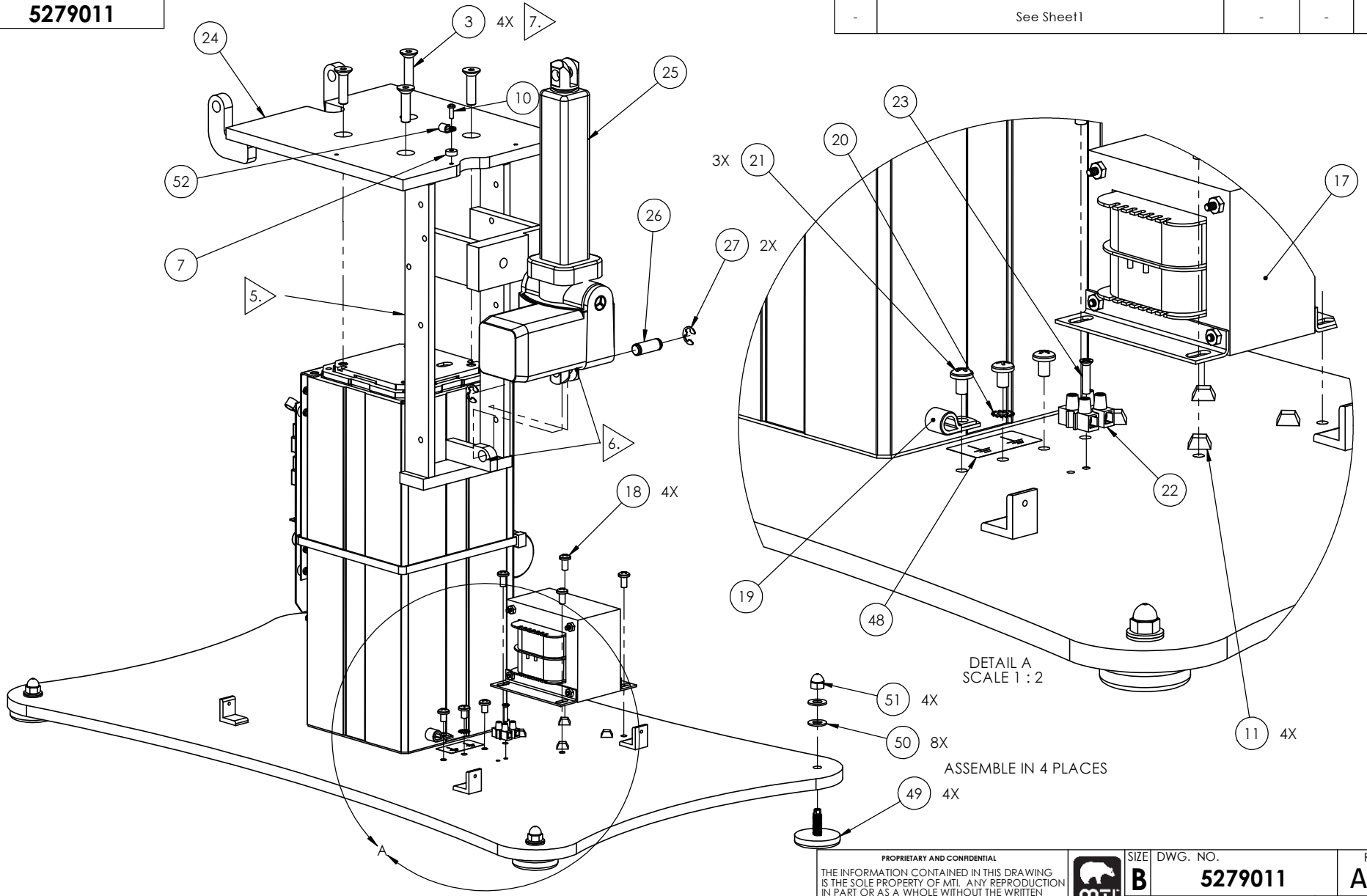
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SIZE	DWG. NO.	REV
B	5279011	A01
SCALE: 1:4 UNLESS NOTED		SHEET 3 OF 7

DWG. NO.
5279011

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-



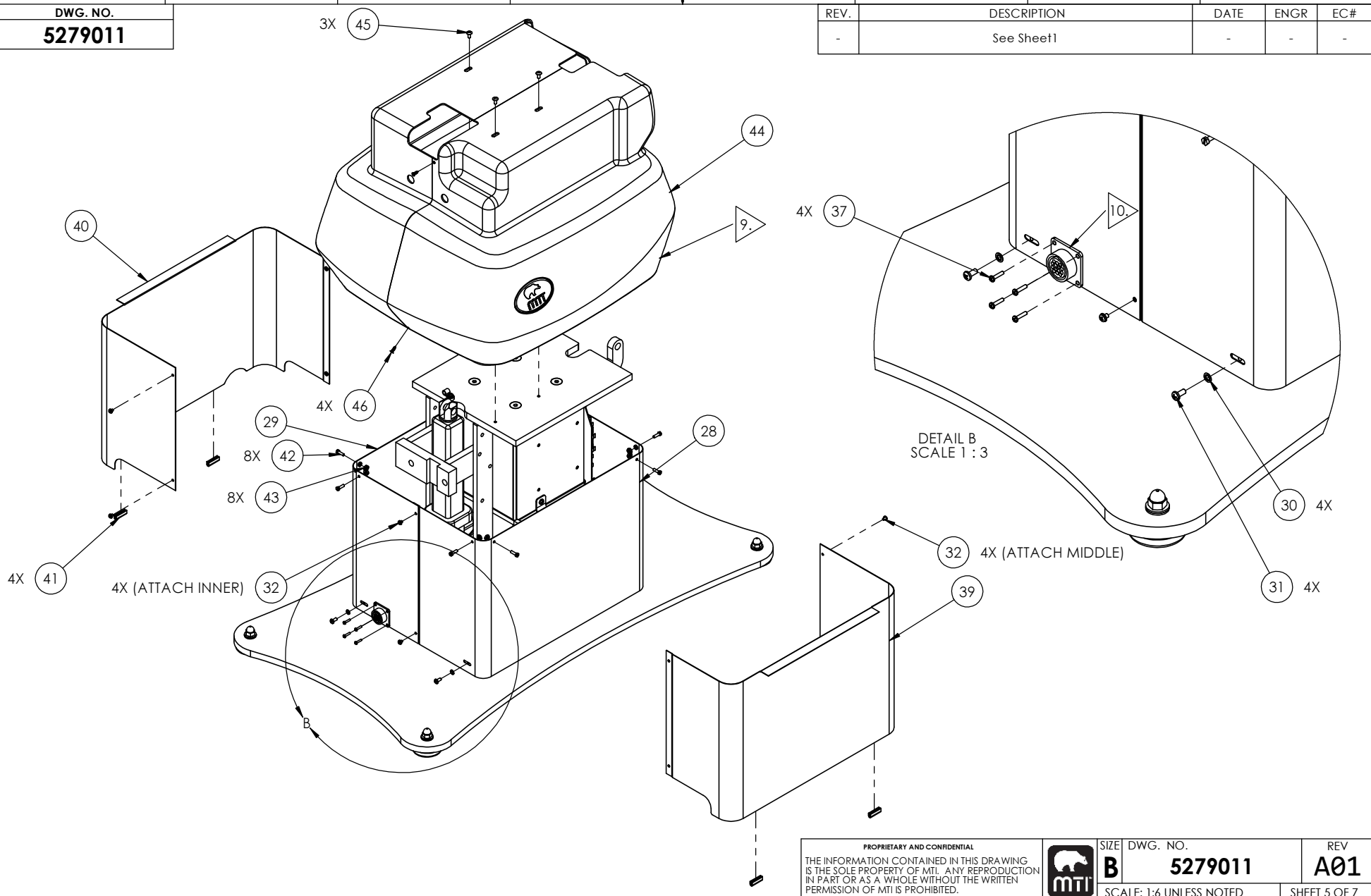
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SIZE	DWG. NO.	REV
B	5279011	A01
SCALE: 1:4 UNLESS NOTED		SHEET 4 OF 7

DWG. NO.
5279011

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-



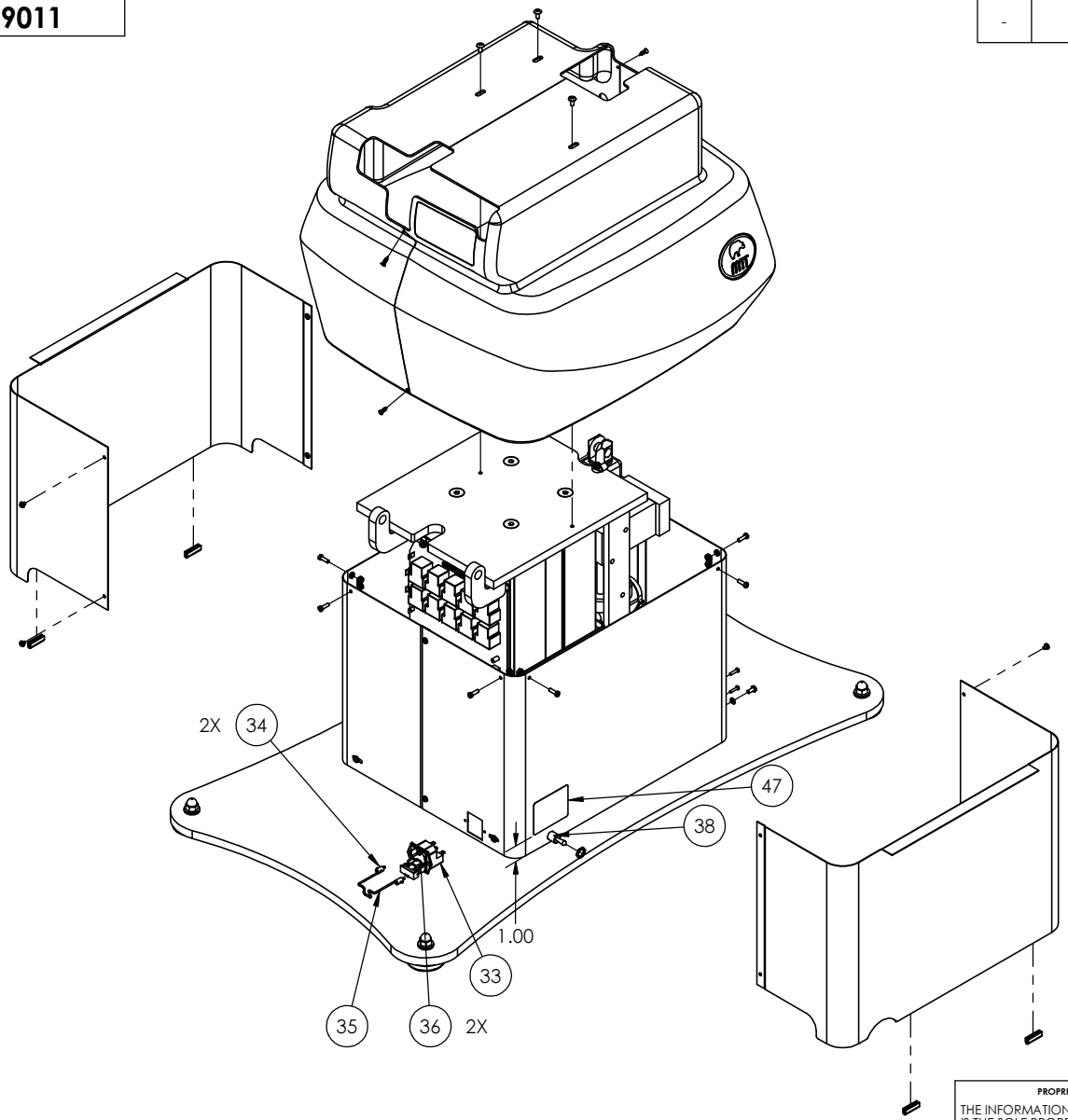
PROPRIETARY AND CONFIDENTIAL

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SIZE	DWG. NO.	REV
B	5279011	A01
SCALE: 1:6 UNLESS NOTED		SHEET 5 OF 7

DWG. NO.
5279011

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-



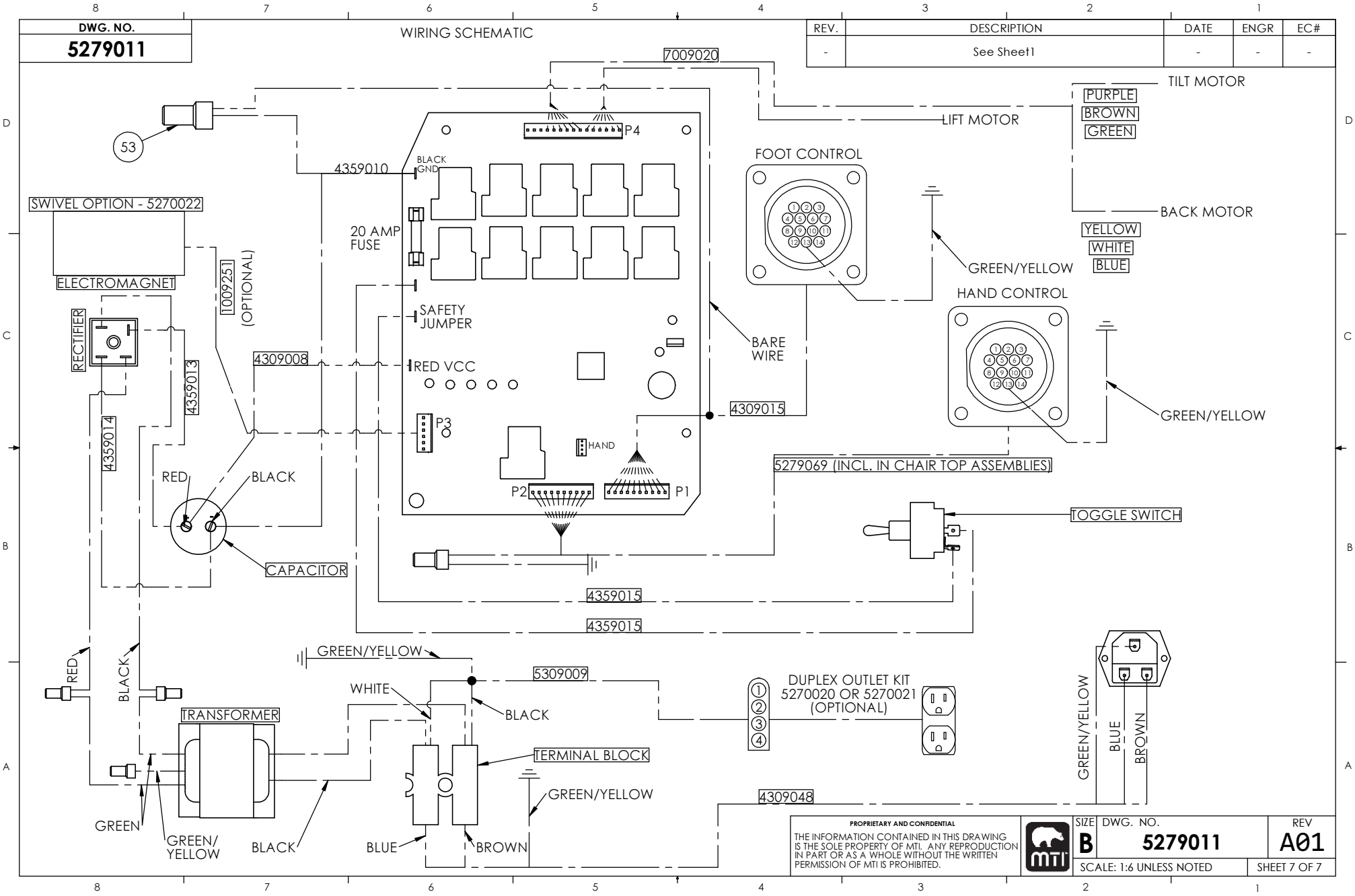
PROPRIETARY AND CONFIDENTIAL

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SIZE	DWG. NO.	REV
B	5279011	A01
SCALE: 1:6 UNLESS NOTED		SHEET 6 OF 7

DWG. NO.	WIRING SCHEMATIC
5279011	

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-



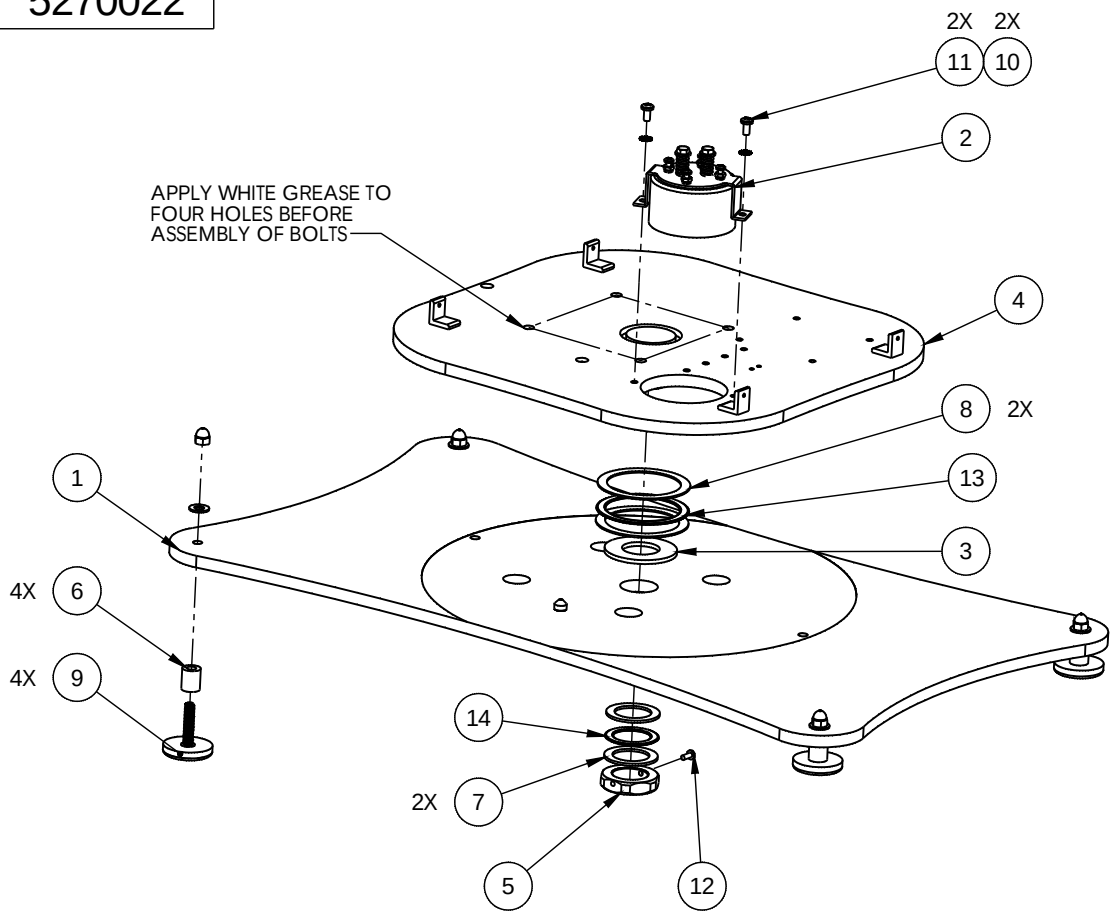
PROPRIETARY AND CONFIDENTIAL

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SIZE	DWG. NO.	REV
B	5279011	A01
SCALE: 1:6 UNLESS NOTED		SHEET 7 OF 7

DWG. NO.
5270022

REV.	DESCRIPTION	DATE	ENGR	EC#
ORG	INITIAL RELEASE	12/10/2002	MTB	
A01	DATA MIGRATION REVIEW	2/15/2012	NBK	



ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
1	5259016	1	BASE PLATE WLD, SWIVEL
2	4009080	1	ELECTROMAGNET ASSY
3	5251033	1	BEARING LOCATING RING, SWIVEL BASE
4	5279029	1	SWIVEL BASE WLD
5	4001100	1	SWIVEL LOCK NUT
6	5251037	4	SPACER, SWIVEL BASE LEVELING GLIDE
7	043141	2	THRUST WASHER, 1-1/2 ID X .094 THK
8	043145	2	THRUST WASHER, 3 ID X .062 THK
9	056013	4	LEVELING GLIDE, 3/8-16 X 1-3/4
10	045128	2	EXTERNAL STAR WASHER, 1/4, ZINC
11	032098	2	PHP SCREW, 1/4-20 x 1/2 ZINC
12	032067	1	PHP SCREW, 10-24 x 1/2 ZINC
13	043144	1	THRUST BEARING, 3 ID x 3.75 OD x .078 THK
14	043140	1	THRUST BEARING, 1-1/2 ID X 2.187 OD X .0781 THK
15	1009251	1	WIRING HARNESS, SWIVEL BASE MAGNET
16	045032	-4	SAE WASHER, 3/8 ZINC
17	056012	-4	LEVELING GLIDE, 3/8-16x1"
18	7009009	-1	BASE PLATE WLD

PROPRIETARY AND CONFIDENTIAL

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MATERIAL: SEE BOM

THIRD ANGLE PROJECTION

	NAME	DATE
DRAWN	MTB	12/10/2002
ENGINEER	MTB	12/10/2002
CHECKED	JVA	12/12/2012

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/16
ANGLE: MACH ± 1/2° BEND ±1°
TWO PLACE DECIMAL ±.015
THREE PLACE DECIMAL ±.005

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TITLE:

SWIVEL BASE OPTION F/527 SERIES

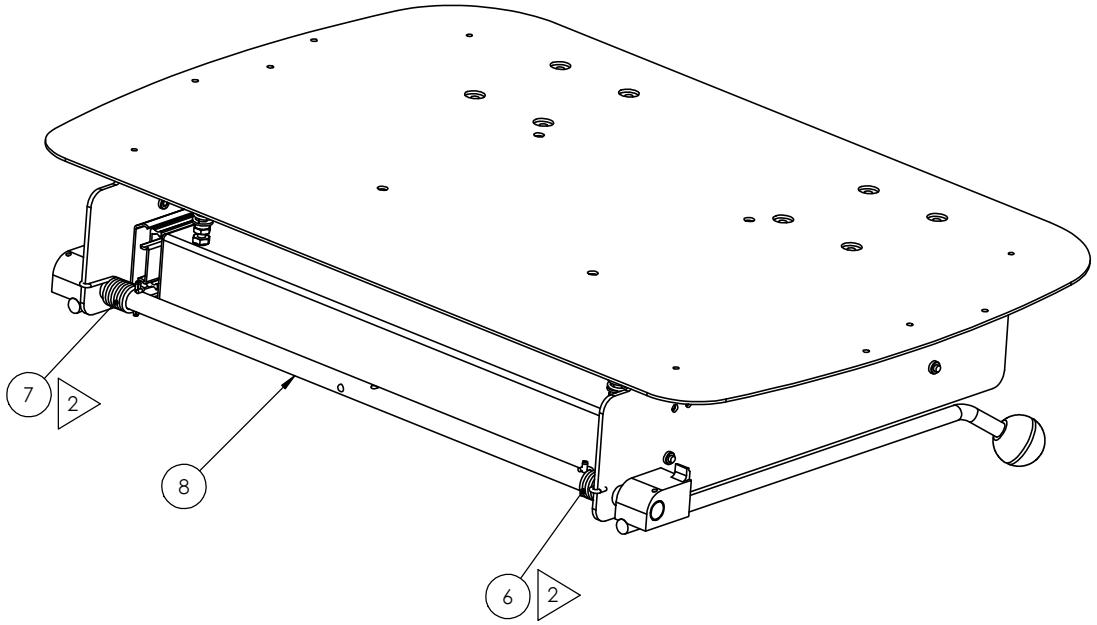
SIZE	DWG. NO.	REV
B	5270022	A01

SCALE: 1:5 UNLESS NOTED

SHEET 1 OF 1

DWG. NO.
5279004

REV.	DESCRIPTION	DATE	ENGR	EC#
ORG	INITIAL RELEASE.	3/2/2007	MTB	
A00	AT ITEM 8 REPLACED P/N 042022 W/ P/N 042021.	2/5/2008	MTB	
B00	REPLACED P/N 038002 W/ 038055.	6/3/2009	MTB	
C00	REPLACED TWO NUTS, 040007 W/ TWO WASHERS, 045028.	1/5/2010	MTB	
D00	REPLACED 032071 W/ 032072A	4/22/2010	MTB	
E00	REPLACED YELLOW URETHANE RUBBER FRICTION BRAKE P/N 038055 W/ ABS FRICTION BRAKE P/N 5271124. REPLACED 5271070 W/ P/N 038004. ADDED #10 FLAT WASHER P/N 045028.	3/21/2011	MTB	
F00	DELETED P/N 053001 FROM BOM	10/7/2011	MTB	
F01	DATA MIGRATION REVIEW. ADDED NOTE 2	1/17/2012	NBK	
F02	UPDATED ASSY TO REFLECT REVISED 5001054	11/5/2012	NBK	0071
F03	UPDATED ASSY WITH LATEST VERSION OF THE SLIDE ASSY, FIXED MATE ERRORS ON THE SLIDE ASSY, CORRECTED CALLOUT OF ITEM 12	3/21/2013	NBK	0118



ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
1	5279003	1	FOOT SECTION WLD, 527
2	5271001	1	DEBRIS TRAY HOLDER, 527
3	5279007	1	FOOT SECTION LOCK WLD, LH
4	5279008	1	FOOT SECTION LOCK WLD, RH
5	5271124	2	FRICTION BRAKE
6	5251014	1	SPRING, FOOT SECTION, RH
7	5251013	1	SPRING, FOOT SECTION, LH
8	5271011	1	LOCK ROD, FOOT SECTION
9	044005	2	SLIDE, PODIATRY FOOT SECTION, 11.14"
10	038004	2	COMPRESSION SPRING, .515 OD X .062 WIRE X .78 LG
11	037009	2	BALL KNOB, 1-1/4 OD PRESS-ON BLACK
12	042021	4	SLOTTED SPRING PIN, 1/8 x 7/8 ZINC
13	040036	2	NYLON INSERT HEX NUT, 10-24 GR2 ZINC
14	040007	2	HEX NUT, 10-24 GR 2 ZINC
15	032072A	2	PHP SCREW, 10-24 x 1-3/4 ZINC
16	045028	6	SAE WASHER, 10 ZINC
17	031356	8	UNDERCUT FHP SCREW, 8-32 x 3/8 ZINC
18	045202	2	INTERNAL STAR WASHER, 10 ZINC

NOTES:

1. ADJUST THE LOCK NUT, 040036, SO THERE IS A MINIMUM OF 1/8" BETWEEN IT AND THE JAM NUT 040007.
2. SPRING SHOULD BE WOUND 2-1/2 TIMES BEFORE INSTALLING THE SPRING PIN

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MATERIAL: SEE BOM

THIRD ANGLE PROJECTION

	NAME	DATE
DRAWN	MTB	11/10/2006
ENGINEER	MTB	11/10/2006
CHECKED	DDW	04/04/2013

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/16
ANGLE: MACH ± 1/2° BEND ±1°
TWO PLACE DECIMAL ±.015
THREE PLACE DECIMAL ±.005

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TITLE:

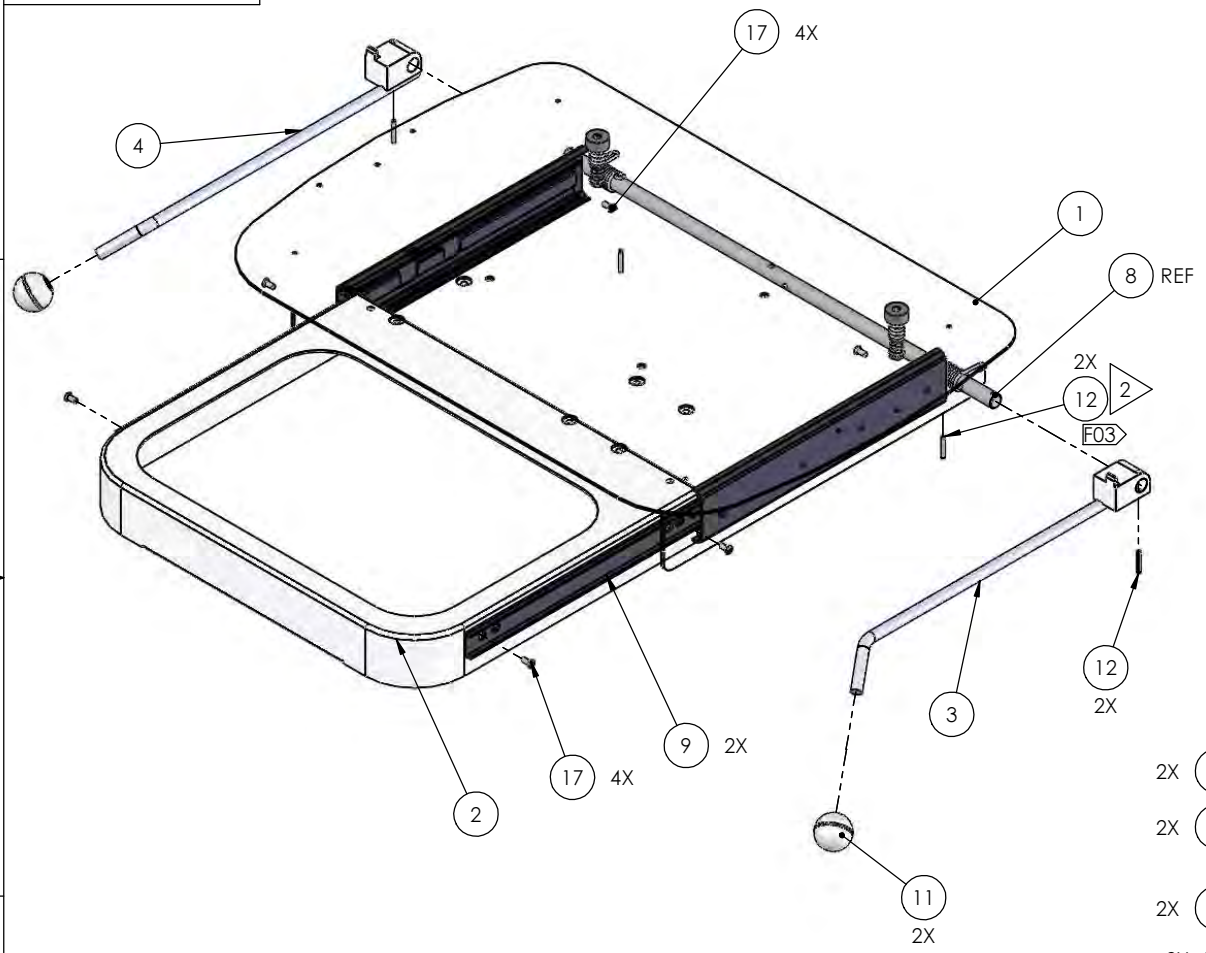
FOOT SECTION ASSY, 527

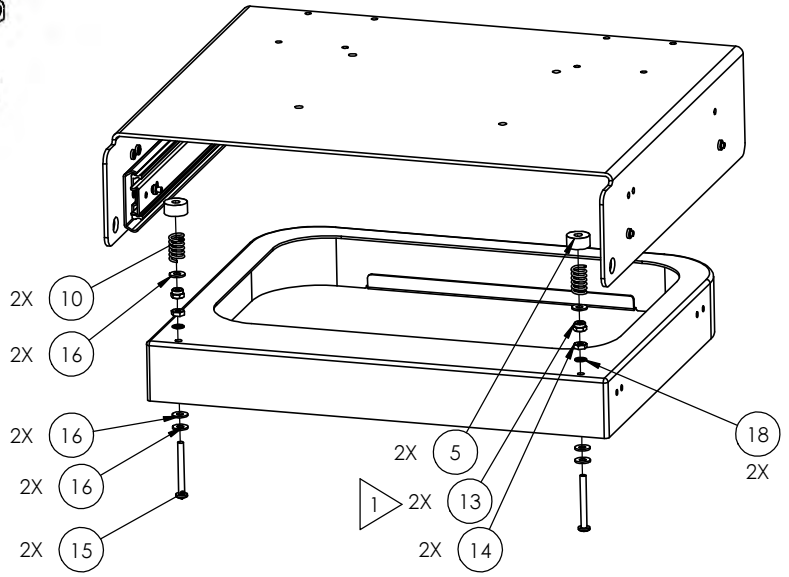
SIZE	DWG. NO.	REV
B	5279004	F03

SCALE: 1:3 UNLESS NOTED

DWG. NO.
5279004

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-





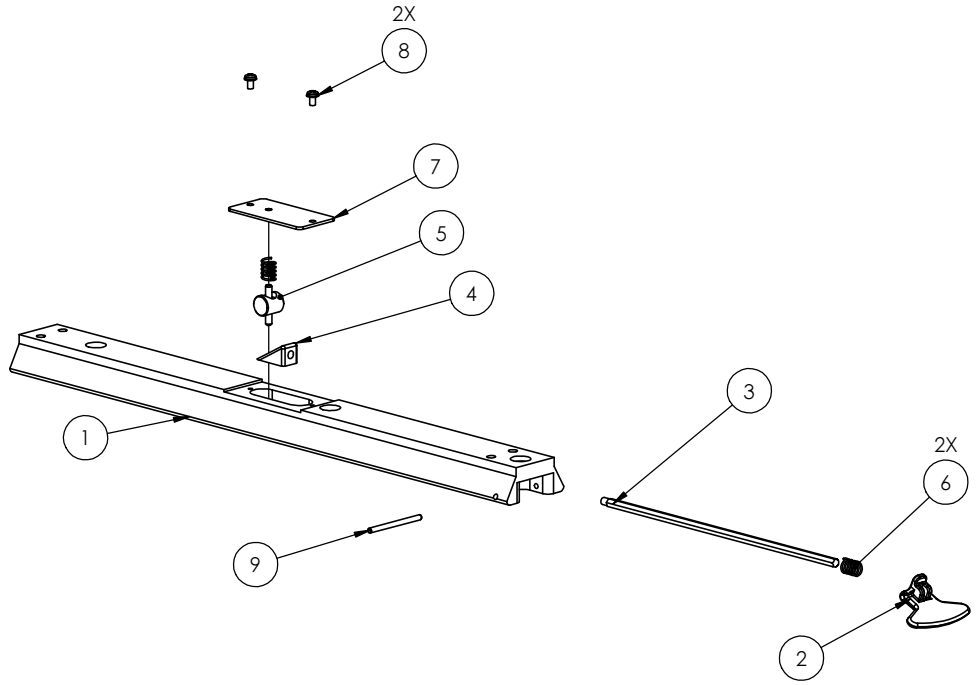
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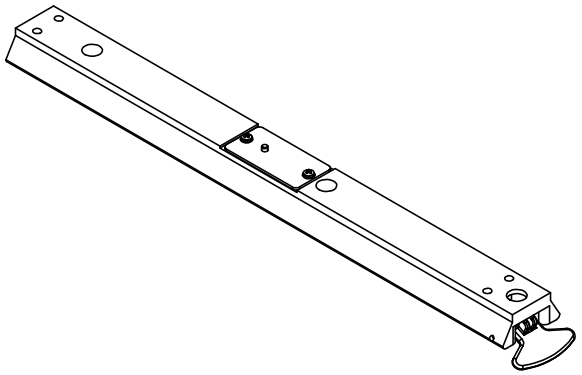
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SIZE	DWG. NO.	REV
B	5279004	F03
SCALE: 1:4 UNLESS NOTED		SHEET 2 OF 2

DWG. NO.
5279021

REV.	DESCRIPTION	DATE	ENGR	EC#
ORG	INITIAL RELEASE	10/09/2006	MTB	
A01	DATA MIGRATION REVIEW	1/4/2012	NBK	





ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
1	5271036	1	SLIDE, ARM
2	5271002	1	RELEASE, ARM LOCK
3	5271045	1	RELEASE ROD, ARM
4	5271075	1	RAMP, ARM RELEASE
5	5279071	1	ARM LKG BODY ASSY
6	5271070	2	COMPRESSION SPRING, .365 OD X .032 WIRE X .52 LG
7	5271057	1	PLATE, ARM LOCK ACCESS
8	032464	2	PHP SEMS SCREW, 6-32 X 1/4 W/INTERNAL STAR WASHER
9	042188	1	DOWEL PIN, 1/8 x 1-3/4 STEEL

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MATERIAL: SEE BOM

THIRD ANGLE PROJECTION

	NAME	DATE
DRAWN	MTB	10/09/2006
ENGINEER	MTB	10/09/2006
CHECKED	JVA	03/27/2012

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/16
ANGLE: MACH± 1/2° BEND±1°
TWO PLACE DECIMAL ±.015
THREE PLACE DECIMAL ±.005

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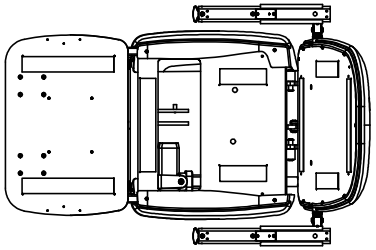
TITLE:
SLIDE ASSY, ARM

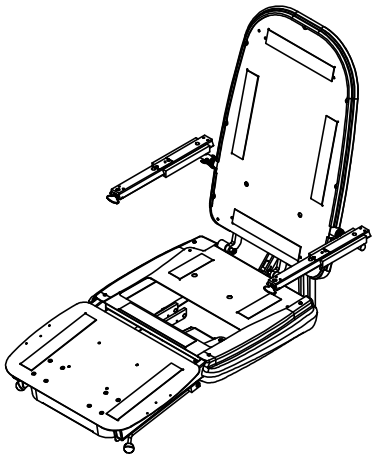
SIZE	DWG. NO.	REV
B	5279021	A01
SCALE: 1:3 UNLESS NOTED		SHEET 1 OF 1

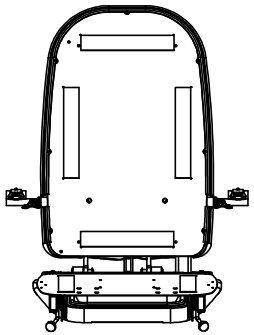
DWG. NO.
5279077

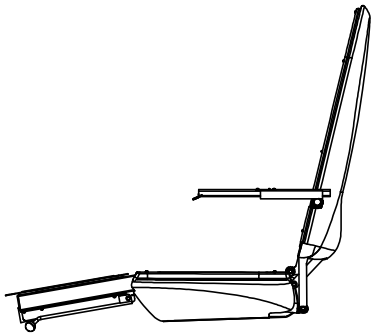
ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
1	5279002	1	SEAT SECTION WLD, 527
2	5279038	1	BACK SECTION WLD
3	5279004	1	FOOT SECTION ASSY, 527
4	5279022	1	MOTOR ASSY, 150MM STROKE, A SPINDLE
5	5271044	1	BACK COVER, 527
6	5001090	1	MACHINED PIN, 1/2 X 1.125
7	4001092	1	MACHINED PIN, 1/2 X 2.063
8	4301056	2	MACHINED PIN, 1/2 X 1.310
9	5271068	2	MACHINED PIN, 1/2 X 2.500
10	5271043	1	SIDE COVER, MOLDED, 527, LH
11	5271042	1	SIDE COVER, MOLDED, 527, RH
12	1001382	7	HOOK VELCRO, 2" X 12" PSA
13	1001381	2	HOOK VELCRO, 2" X 6" PSA
14	055001	2	PLUG, 1 X 2 END CAP
15	044005	2	SLIDE, PODIATRY FOOT SECTION, 11.14"
16	5279021	2	SLIDE ASSY, ARM
17	5251012	2	RAIL, FOOT SECTION LOCK
18	4309069	1	REMOVABLE SLIDE ARM, LH
19	4309070	1	REMOVABLE SLIDE ARM, RH
20	4309060	2	REMOVABLE ARM MOUNT, 7.17" F/430 FLOATING ARM
21	5279074	1	ARM LINKAGE WLD, 527 SERIES
22	5279075	1	ARM CONNECTION TUBE WLD, 527
23	1009301	1	DEBRIS TRAY ASSY
24	016018	11	PHP SHEET METAL SCREW, 6 X 5/8 ZINC
25	031031	2	FHP SCREW, 8-32 x 3/4 ZINC
26	051076	2	CABLE CLAMP, 1/4 ID X 3/8 W X .203 HOLE PLASTIC
27	051078	1	CABLE CLAMP, 1/2 ID X 3/8 W X .203 HOLE PLASTIC
28	046014	12	E-CLIP, 1/2 BLACK
29	032054	7	PHP SCREW, 8-32 x 1/2 ZINC
30	031356	10	UNDERCUT FHP SCREW, 8-32 x 3/8 ZINC
31	030030	4	SHOULDER BOLT, 3/8 x 3/4, 5/16-18 THREAD, ALLOY
32	045150	8	LOCK WASHER, 3/8, ZINC
33	045026	4	SAE WASHER, 6 ZINC
34	047015	6	NYLON SPACER, .171 ID X .375 OD X .062 THK

REV.	DESCRIPTION	DATE	ENGR	EC#
A00	INITIAL RELEASE.	9/16/2010	MTB	
B00	CHG'S MADE TO P/N'S 4309059 & 4309062 REV D CAUSED THIS REV TO ROLL.	12/13/2010	MTB	
C00	RPLC'D THE YELLOW FRICTION BRAKE & SPRING W/ AN ABS FRICTION BRAKE P/N 5271124 & SPRING P/N 038004. ADDED TWO #10 FLAT WASHERS P/N 045028. THESE CHANGES WERE DONE AT THE 5279004 FOOT SECT ASSEMBLY LEVEL.	3/21/2011	MTB	
C01	DATA MIGRATION REVIEW, UPDATED BOM	3/1/2012	NBK	









NOTES:

1. APPLY WHITE GREASE, P/N 067019, TO THE SIDES OF THE FEMALE DOVE TAIL ARM SLIDE GUIDES. DO NOT APPLY GREASE TO THE BOTTOM SURFACE. MOVE THE ARM SLIDE, P/N 5279021, IN AND OUT SEVERAL TIMES TO DISTRIBUTE THE GREASE. THEN WIPE OFF THE EXCESS GREASE.
2. SOME WELDMENT COMPONENTS ARE NOT SHOWN IN SOME VIEWS FOR CLARITY
3. APPLY WHITE GREASE TO ALL THE PINS/HOLES BEFORE ASSEMBLY

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MATERIAL: SEE BOM

THIRD ANGLE PROJECTION

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/16
ANGLE: MACH ± 1/2° BEND ±1°
TWO PLACE DECIMAL ±.015
THREE PLACE DECIMAL ±.005

	NAME	DATE
DRAWN	MTB	09/16/2010
ENGINEER	MTB	09/16/2010
CHECKED	JVA	03/28/2013

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TITLE:

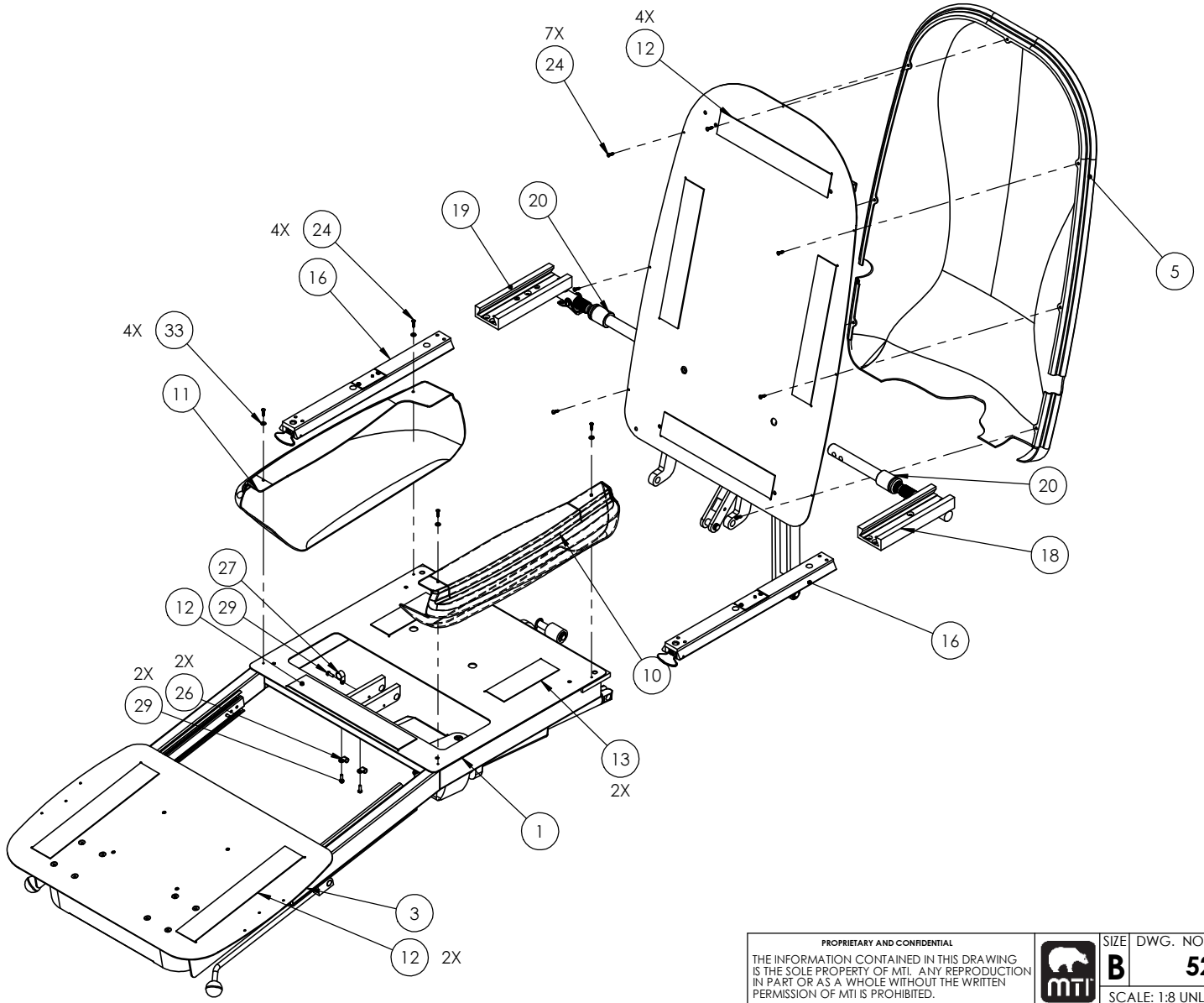
CHAIR TOP ASSY, 526/527

SIZE	DWG. NO.	REV
B	5279077	C01

SCALE: 1:16 UNLESS NOTED | SHEET 1 OF 4

DWG. NO.
5279077

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-



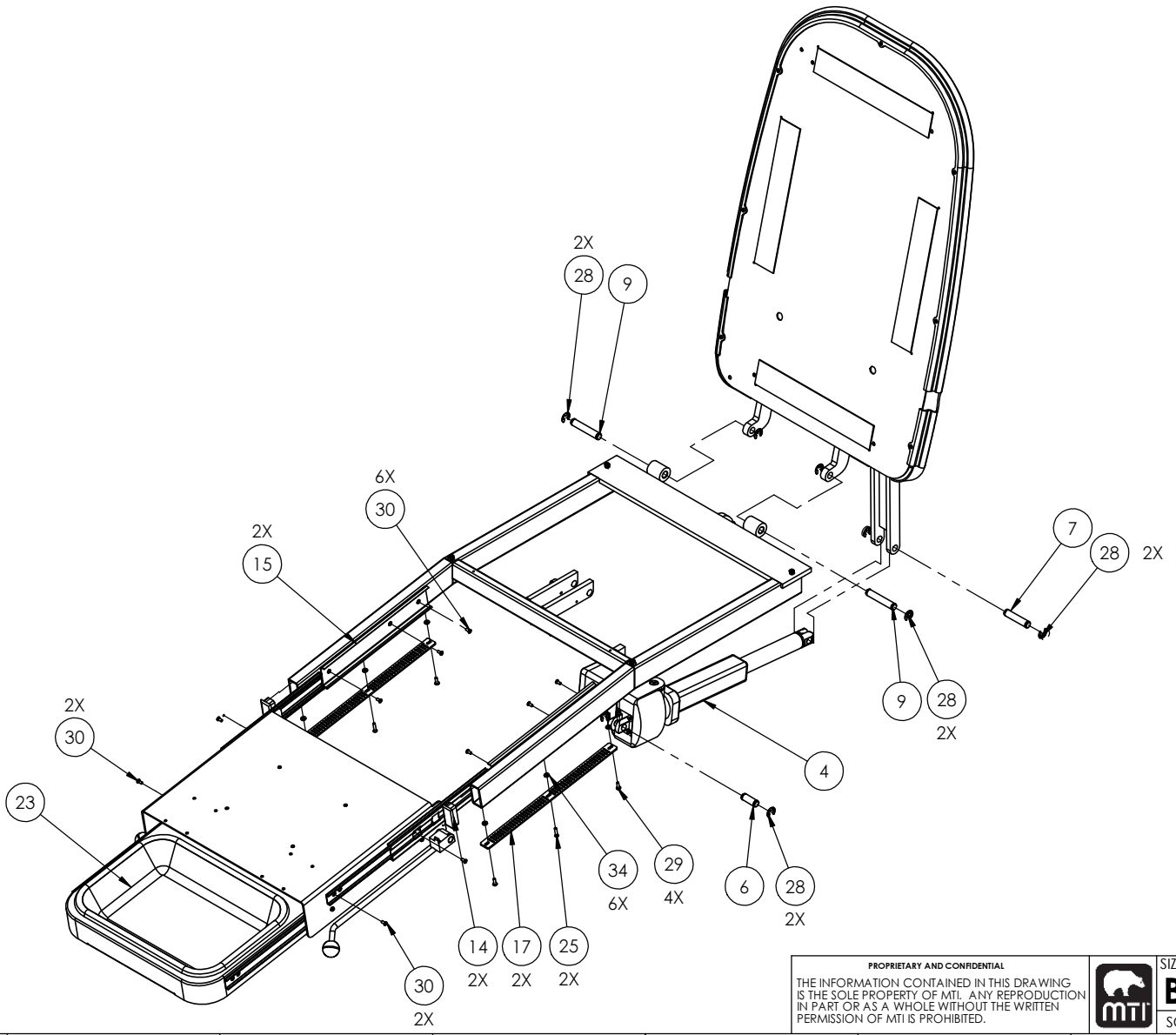
PROPRIETARY AND CONFIDENTIAL

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SIZE	DWG. NO.	REV
B	5279077	C01
SCALE: 1:8 UNLESS NOTED		SHEET 2 OF 4

DWG. NO.
5279077

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-



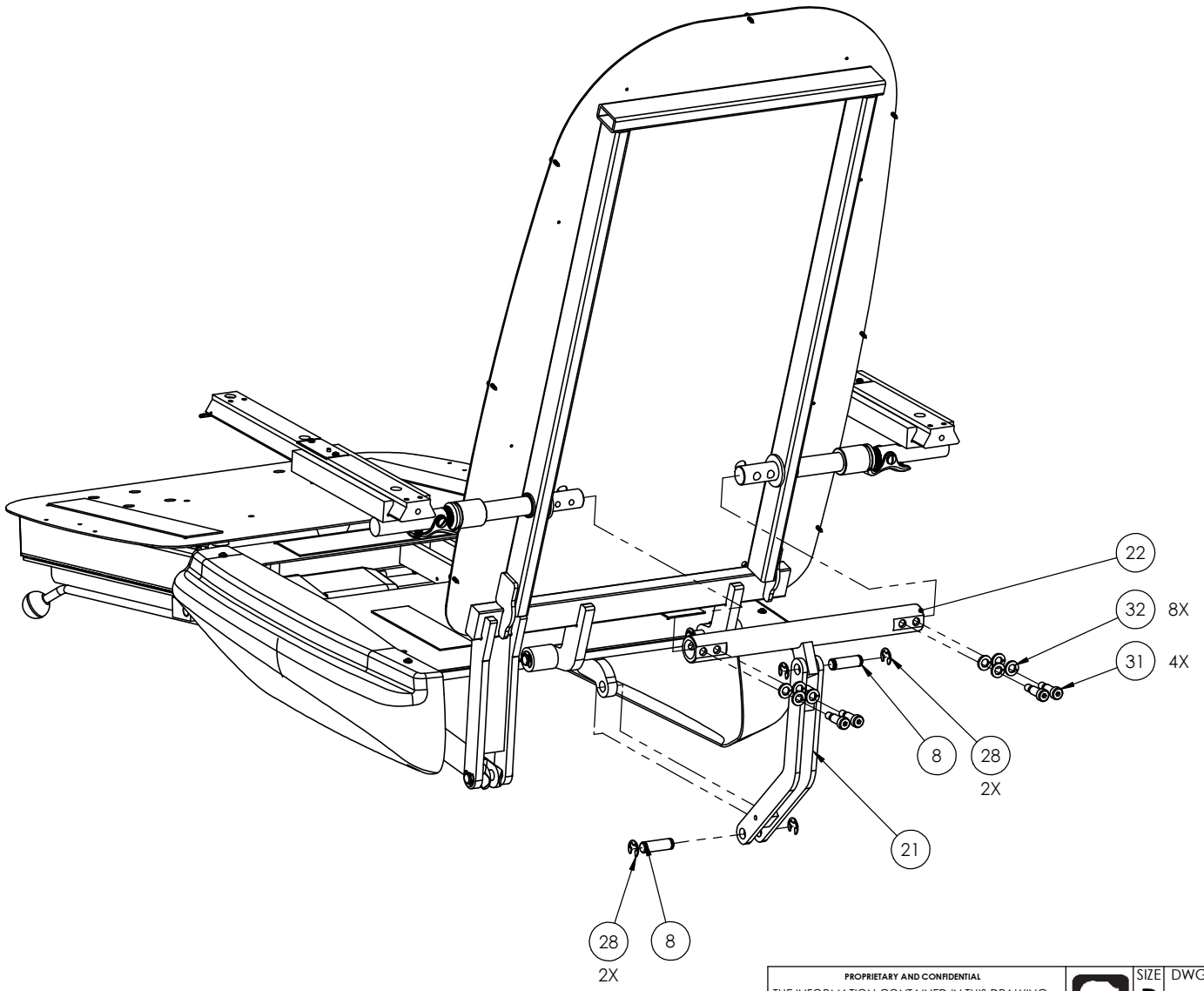
PROPRIETARY AND CONFIDENTIAL

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SIZE	DWG. NO.	REV
B	5279077	C01
SCALE: 1:8 UNLESS NOTED		SHEET 3 OF 4

DWG. NO.
5279077

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-



PROPRIETARY AND CONFIDENTIAL

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SIZE	DWG. NO.	REV
B	5279077	C01
SCALE: 1:5 UNLESS NOTED		SHEET 4 OF 4

DWG. NO.
FC3-NS0PRS-LBT-P

REV.	DESCRIPTION	DATE	ENGR	EC#
ORG	INITIAL RELEASE	07/18/2006	MTB	
A00	REPLACED 7001092 W/7009013 & 051003, 050053, 051001 W/1001548	12/17/2009	MTB	
C00	CONVERTED TO SOLIDWORKS, UPDATED BOM, REPLACED 1001548 W/1009306, 036080 W/036094, CHANGED GAUGE OF THE JUMPERS FROM 18 TO 22 AWG, CHANGED SIZE OF BUTT & END CONNECTORS	07/10/2012	NBK	0016
C01	CORRECTED P/N 050024BLA WAS 050024BLK	10/5/2012	NBK	0061



ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
1	7001093	1	FOOT CONTROL BASE, TRI W/SB2PRS
2	4121069	3	FOOT SWITCH, SPDT (EACH SIDE) MOMENTARY, PAINTED
3	1009306	1	HARNESS ASSY, COILED CORD, FOOT CONTROL
4	036094	1	STRAIN RELIEF, PG-13, CABLE DIA .19-.35
5	036087	1	STRAIN RELIEF NUT, PG13.5 NYLON
6	7001117	1	WIRE ACCESS COVER, 3 FUNC FOOT CONTROL
7	1001308	4	PAD, NON-SKID
8	054007	1	LABEL, 2 X 1 WHITE POLYESTER
9	1001174	1	LABEL, FOOT CONTROL TILT
10	1001175	1	LABEL, FOOT CONTROL BACK
11	1001176	1	LABEL, FOOT CONTROL LIFT
12	1001461	1	LABEL, TRI FOOT CONTROL, TRI NON PRGM F/527S
13	048023	1	PUSH BUTTON SWITCH, DPST MOMENTARY-NO W/LEADS
14	048010	2	PUSH BUTTON SWITCH, SPST MOMENTARY-NO W/LEADS
15	040115	3	HEX NUT, 15/32-32 X 9/16 AF X 3/32 THK NICKEL
16	047014	3	NYLON SPACER, .171 ID X .50 OD X .188 THK
17	1001536	3	WIRE SLEEVE F/FOOT CONTROL
18	051145	1	RING TERMINAL, RED #10 22-18 AWG
19	051127	12	PUSH-ON TERMINAL, FEMALE PART INSUL .187 22-18 AWG
20	051120	1	BUTT CONNECTOR, VINYL INSUL. RED 22-18 AWG
21	051189	8	CLOSED END CONNECTOR, MEDIUM (MAX. (3) 16 AWG)
22	055008	1	HOLE PLUG, 1/2 BLACK
23	032039	3	PHP SCREW, 6-32 x 1/2 ZINC
24	031011	6	FHP SCREW, 6-32 x 1/4 ZINC

ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
25	050024BLU	27.25"	STANDARD WIRE, 22AWG BLUE, STYLE 1007
C01 26	050024BLA	3.25"	STANDARD WIRE, 22AWG BLACK, STYLE 1007
27	050024ORA	19"	STANDARD WIRE, 22AWG ORANGE, STYLE 1007
28	050024PUR	7"	STANDARD WIRE, 22AWG PURPLE, STYLE 1007
29	050024WHI	25.25"	STANDARD WIRE, 22AWG WHITE, STYLE 1007
30	050024YEL	12"	STANDARD WIRE, 22AWG YELLOW, STYLE 1007

NOTES:

1. STRIP WIRES SUFFICIENT TO FULLY ENGAGE CONNECTORS. AFTER ASSEMBLY, ALL STRIPPED SECTIONS OF WIRE TO REMAIN FLUSH OR BELOW CONNECTOR PROTECTIVE SLEEVE.
2. SOME COMPONENTS IN THE DETAILED VIEWS ARE NOT SHOWN FOR CLARITY
3. APPLY LABEL WITH DESCRIPTION " FC3-NS0PRS-LBT-P FOOT CONTROL W/ LBT, POSITION, AUTO RETURN & STOP"
4. ITEM 17 SHOULD BE INSTALLED IN A WAY THAT IT BRIDGES THE GAP BETWEEN THE PEDAL AND THE FOOT CONTROL BASE
5. CAP OFF THE UNUSED WIRES OF THE COIL CORD SEPARATELY WITH CLOSED END CONNECTORS

PROPRIETARY AND CONFIDENTIAL
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MATERIAL: SEE BOM

THIRD ANGLE PROJECTION

	NAME	DATE
DRAWN	MTB	08/07/2006
ENGINEER	MTB	08/07/2006
CHECKED	DDW	10/08/2012

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/16
ANGLE: MACH ± 1/2° BEND ±1°
TWO PLACE DECIMAL ±.015
THREE PLACE DECIMAL ±.005

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TITLE:

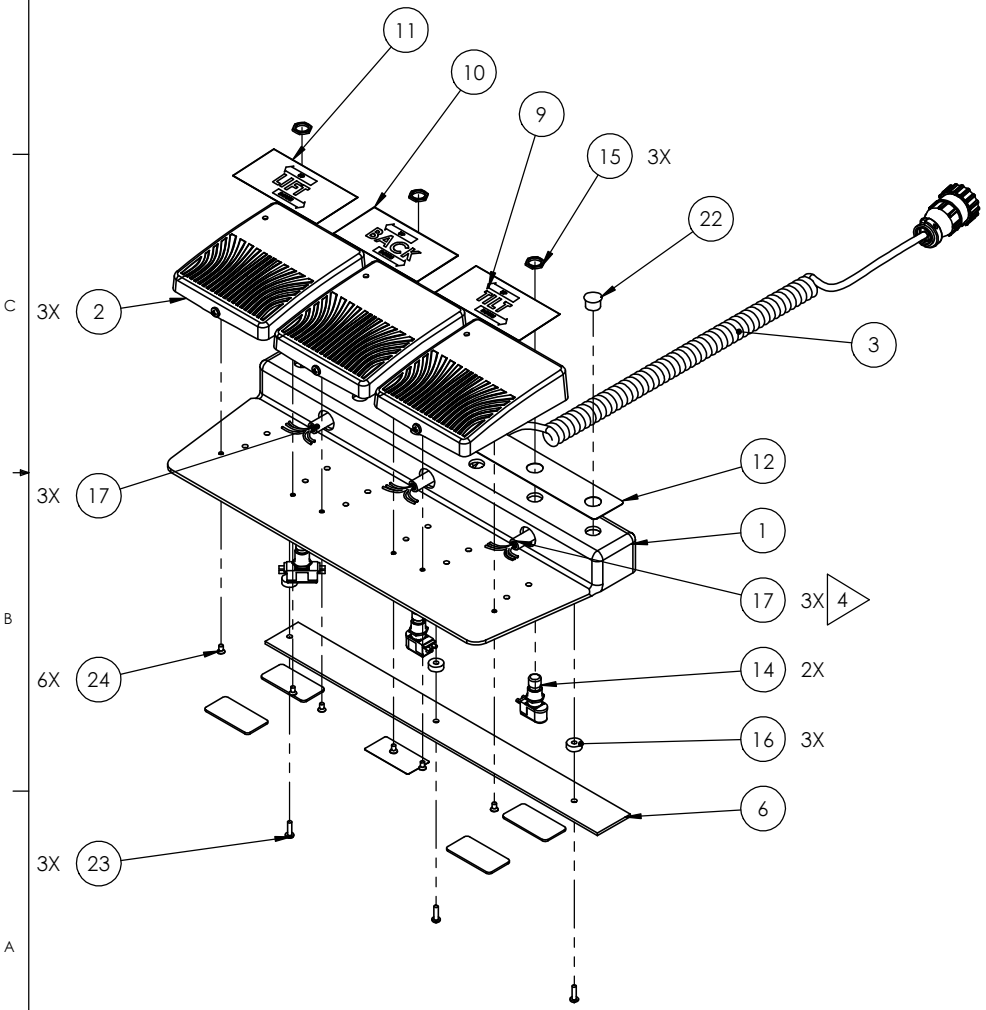
FOOT CONTROL W/LBT, POSITION SWITCH

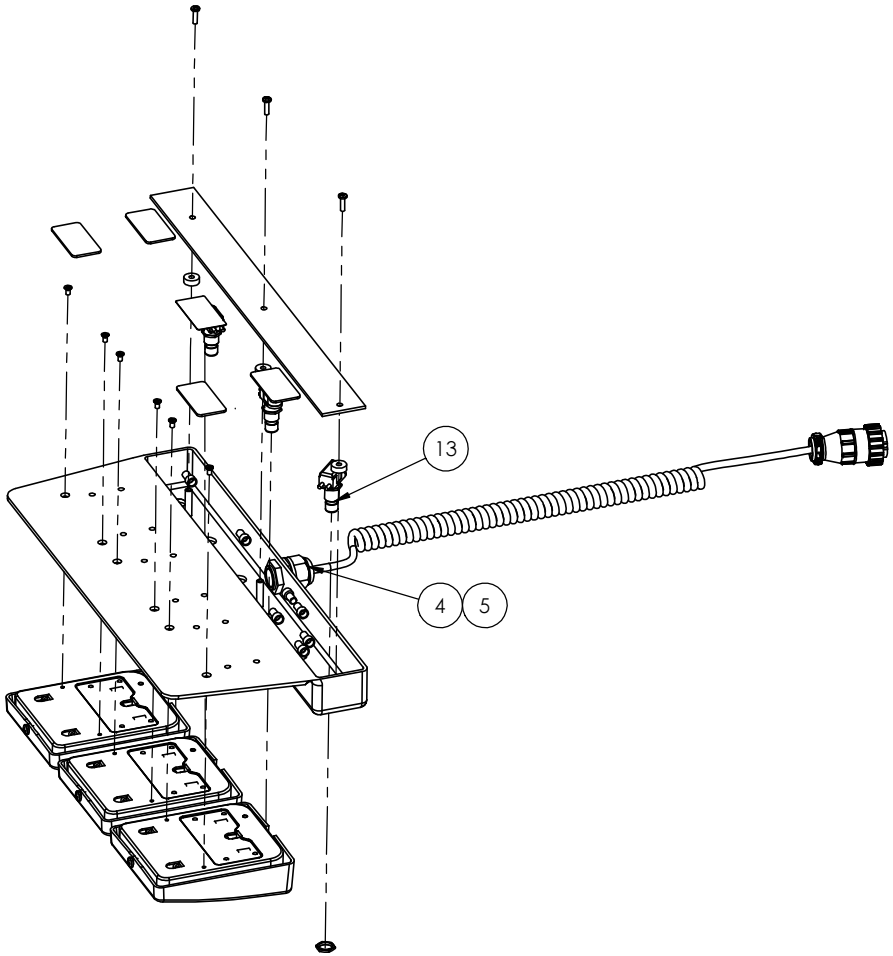
SIZE	DWG. NO.	REV
B	FC3-NS0PRS-LBT-P	D00

SCALE: 1:3 UNLESS NOTED | SHEET 1 OF 7

DWG. NO.
FC3-NS0PRS-LBT-P

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-





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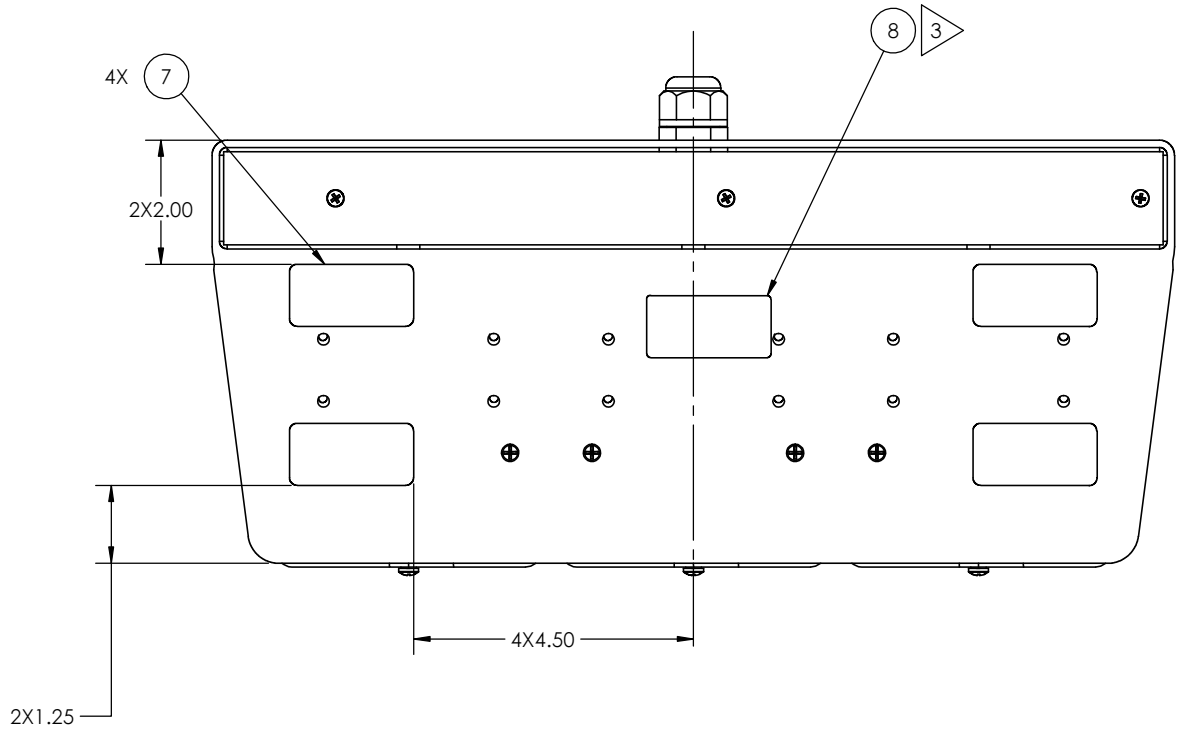
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SIZE	DWG. NO.	REV
B	FC3-NS0PRS-LBT-P	D00
SCALE: 1:4 UNLESS NOTED		SHEET 2 OF 7

DWG. NO.
FC3-NS0PRS-LBT-P

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-

LOCATION OF NON-SKID PADS



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SIZE	DWG. NO.	REV
B	FC3-NS0PRS-LBT-P	D00
SCALE: 1:2 UNLESS NOTED		SHEET 3 OF 7

DWG. NO.
FC3-NS0PRS-LBT-P

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-

WIRE	DETAIL
BLACKJUMPER 1	DETAIL A SHT 5
BLUE JUMPER 1	DETAIL B SHT 6
BLUE JUMPER 2	DETAIL B SHT 6
BLUE JUMPER 3	DETAIL B SHT 6
ORANGE JUMPER 1	DETAIL A SHT 5
ORANGE JUMPER 2	DETAIL A SHT 5
PURPLE JUMPER 1	DETAIL A SHT 5
WHITE JUMPER 1	DETAIL B SHT 6
WHITE JUMPER 2	DETAIL B SHT 6
WHITE JUMPER 3	DETAIL B SHT 6
YELLOW JUMPER 1	DETAIL A SHT 5
BLACK WIRE OF COIL CORD	DETAIL A SHT 5
BLUE WIRE OF COIL CORD	DETAIL B SHT 6
BROWN WIRE OF COIL CORD	DETAIL A SHT 5
GRAY WIRE OF COIL CORD	DETAIL B SHT 6
GREEN WIRE OF COIL CORD	DETAIL A SHT 5
ORANGE WIRE OF COIL CORD	DETAIL A SHT 5
PURPLE WIRE OF COIL CORD	DETAIL A SHT 5
RED WIRE OF COIL CORD	DETAIL A SHT 5
WHITE WIRE OF COIL CORD	DETAIL B SHT 6
YELLOW WIRE OF COIL CORD	DETAIL A SHT 5
DRAIN WIRE OF COIL CORD	DETAIL C SHT 7

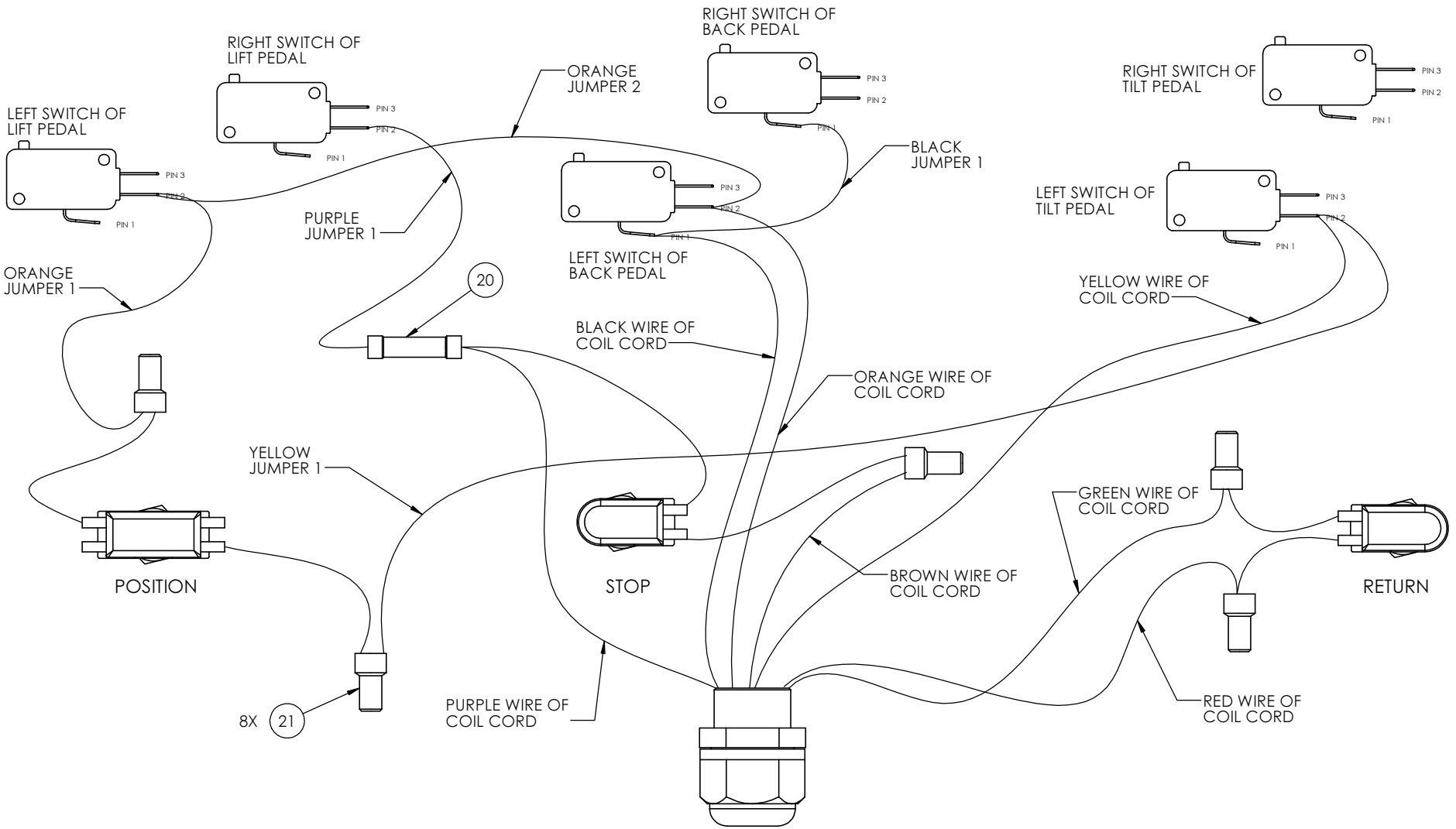
WIRE LENGTH TABLE		
COLOR	JUMPER NO.	LENGTH IN INCHES
BLACK	1	3.25
BLUE	1	12
BLUE	2	12
BLUE	3	3.25
ORANGE	1	7
ORANGE	2	12
PURPLE	1	7
WHITE	1	7
WHITE	2	15
WHITE	3	3.25
YELLOW	1	12

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SIZE	DWG. NO.	REV
B	FC3-NS0PRS-LBT-P	D00
SCALE: 1:2 UNLESS NOTED		SHEET 4 OF 7

DWG. NO.
FC3-NS0PRS-LBT-P

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-



DETAIL A
CONNECTOR DETAILS

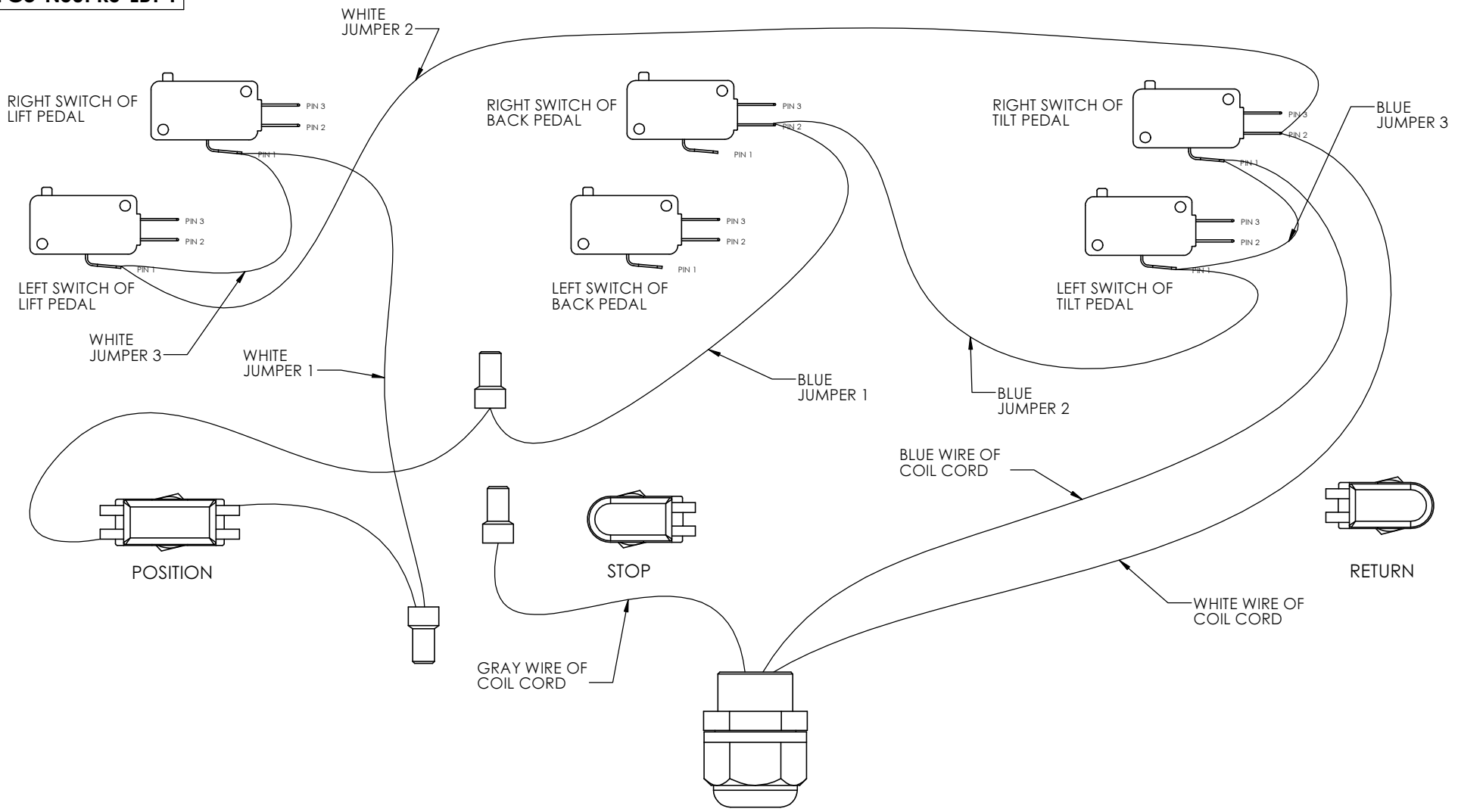
PROPRIETARY AND CONFIDENTIAL

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SIZE	DWG. NO.	REV
B	FC3-NS0PRS-LBT-P	D00
SCALE: 1:2 UNLESS NOTED		SHEET 5 OF 7

DWG. NO.
FC3-NS0PRS-LBT-P

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-



DETAIL B

PROPRIETARY AND CONFIDENTIAL

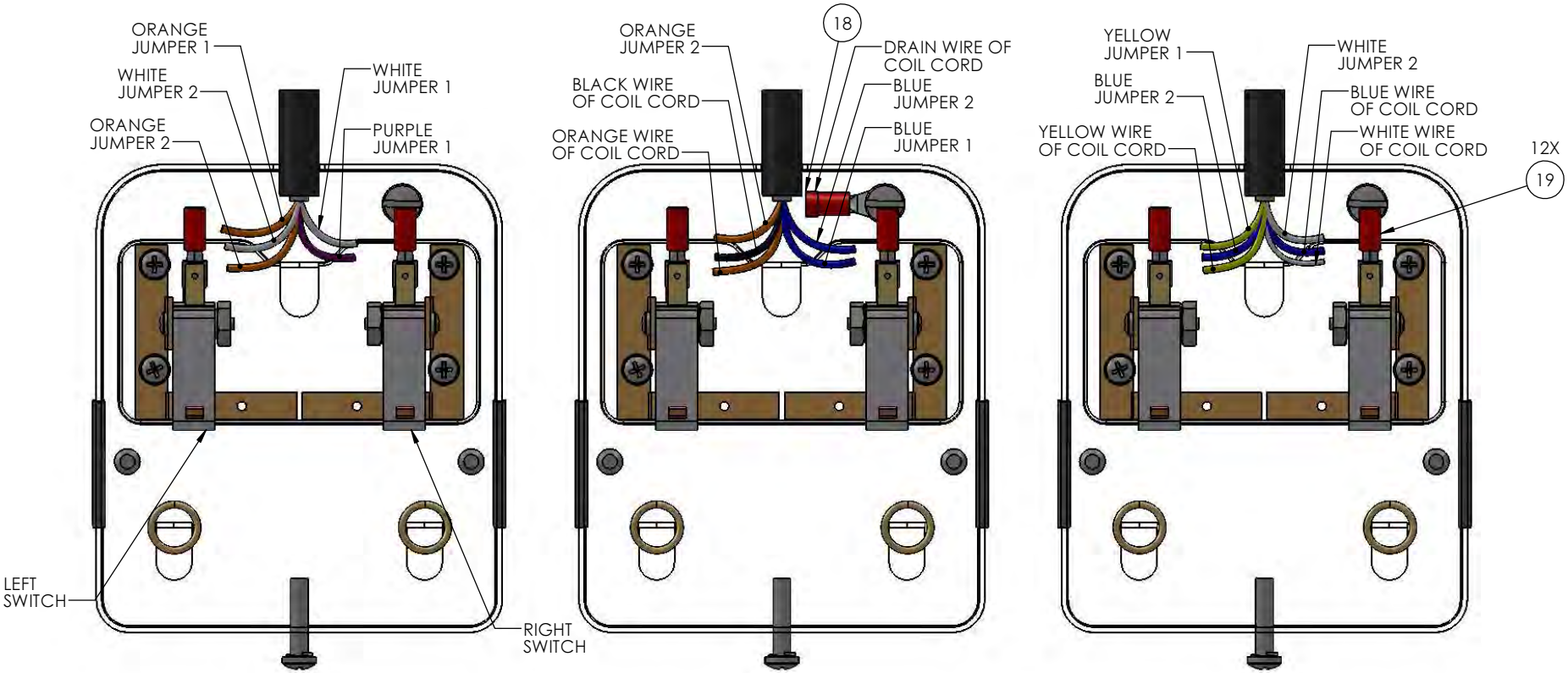
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SIZE	DWG. NO.	REV
B	FC3-NS0PRS-LBT-P	D00
SCALE: 1:2 UNLESS NOTED		SHEET 6 OF 7

DWG. NO.
FC3-NS0PRS-LBT-P

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-

LOCATION OF GROUND WIRE
REFERENCE OF WIRES ENTERING EACH PEDAL/SWITCH



DETAIL C

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SIZE	DWG. NO.	REV
B	FC3-NS0PRS-LBT-P	D00
SCALE: 1:1 UNLESS NOTED		SHEET 7 OF 7

DWG. NO.
FC3-NS2PRS-LBT

REV.	DESCRIPTION	DATE	ENGR	EC#
ORG	INITIAL RELEASE	07/18/2006	MTB	
A00	REPLACED 1001179 W/1001460, 7001089 W/7001093, ADDED HOLE PLUG 055008	08/07/2006	MTB	
B00	REPLACED 051003, 050053, 051001 W/1001547	12/17/2009	MTB	
C00	CONVERTED TO SOLIDWORKS, UPDATED BOM, REPLACED 1001548 W/1009306, 036080 W/036094, CHANGED GAUGE OF THE JUMPERS FROM 18 TO 22 AWG, CHANGED SIZE OF BUTT & END CONNECTORS	07/13/2012	NBK	0016
C01	CORRECTED P/N 050024BLA WAS 050024BLK	10/5/2012	NBK	0061



ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
1	7001093	1	FOOT CONTROL BASE, TRI W/SB2PRS
2	4121069	3	FOOT SWITCH, SPDT (EACH SIDE) MOMENTARY, PAINTED
3	1009306	1	HARNESS ASSY, COILED CORD, FOOT CONTROL
4	036094	1	STRAIN RELIEF, PG-13, CABLE DIA .19-.35
5	036087	1	STRAIN RELIEF NUT, PG13.5 NYLON
6	7001117	1	WIRE ACCESS COVER, 3 FUNC FOOT CONTROL
7	1001308	4	PAD, NON-SKID
8	054007	1	LABEL, 2 X 1 WHITE POLYESTER
9	1001174	1	LABEL, FOOT CONTROL TILT
10	1001175	1	LABEL, FOOT CONTROL BACK
11	1001176	1	LABEL, FOOT CONTROL LIFT
12	1001460	1	LABEL, FOOT CONTROL, TRI W/ PRGM
13	048010	5	PUSH BUTTON SWITCH, SPST MOMENTARY-NO W/LEADS
14	040115	5	HEX NUT, 15/32-32 X 9/16 AF X 3/32 THK NICKEL
15	047014	3	NYLON SPACER, .171 ID X .50 OD X .188 THK
16	1001536	3	WIRE SLEEVE F/FOOT CONTROL
17	051145	1	RING TERMINAL, RED #10 22-18 AWG
18	051127	12	PUSH-ON TERMINAL, FEMALE PART INSUL .187 22-18 AWG
19	051120	4	BUTT CONNECTOR, VINYL INSUL. RED 22-18 AWG
20	051189	1	CLOSED END CONNECTOR, MEDIUM (MAX. (3) 16 AWG)
21	051190	1	CLOSED END CONNECTOR, LARGE (MAX. (3) 14 AWG)
22	055008	1	HOLE PLUG, 1/2 BLACK
23	032039	3	PHP SCREW, 6-32 x 1/2 ZINC
24	031011	6	FHP SCREW, 6-32 x 1/4 ZINC

ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
C01 25	050024BLA	3.25"	STANDARD WIRE, 22 AWG BLACK, STYLE 1007
26	050024BLU	15.25"	STANDARD WIRE, 22 AWG BLUE, STYLE 1007
27	050024ORA	19"	STANDARD WIRE, 22 AWG ORANGE, STYLE 1007
28	050024PUR	7"	STANDARD WIRE, 22 AWG PURPLE, STYLE 1007
29	050024WHI	18.25"	STANDARD WIRE, 22 AWG WHITE, STYLE 1007

NOTES:

1. STRIP WIRES SUFFICIENT TO FULLY ENGAGE CONNECTORS. AFTER ASSEMBLY, ALL STRIPPED SECTIONS OF WIRE TO REMAIN FLUSH OR BELOW CONNECTOR PROTECTIVE SLEEVE.
2. SOME COMPONENTS IN THE DETAILED VIEWS ARE NOT SHOWN FOR CLARITY
3. APPLY LABEL WITH DESCRIPTION " FC3-NS2PRS-LBT FOOT CONTROL W/ LBT, (2) PRGMS, AUTO RETURN & STOP "
4. ITEM 16 SHOULD BE INSTALLED IN A WAY THAT IT BRIDGES THE GAP BETWEEN THE PEDAL AND THE FOOT CONTROL BASE
5. CAP OFF THE UNUSED WIRES OF THE COIL CORD SEPARATELY WITH CLOSED END CONNECTORS

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MATERIAL: SEE BOM

THIRD ANGLE PROJECTION

	NAME	DATE
DRAWN	MTB	07/18/2006
ENGINEER	MTB	07/18/2006
CHECKED	DDW	10/08/2012

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/16
ANGLE: MACH ± 1/2° BEND ±1°
TWO PLACE DECIMAL ±.015
THREE PLACE DECIMAL ±.005

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TITLE:

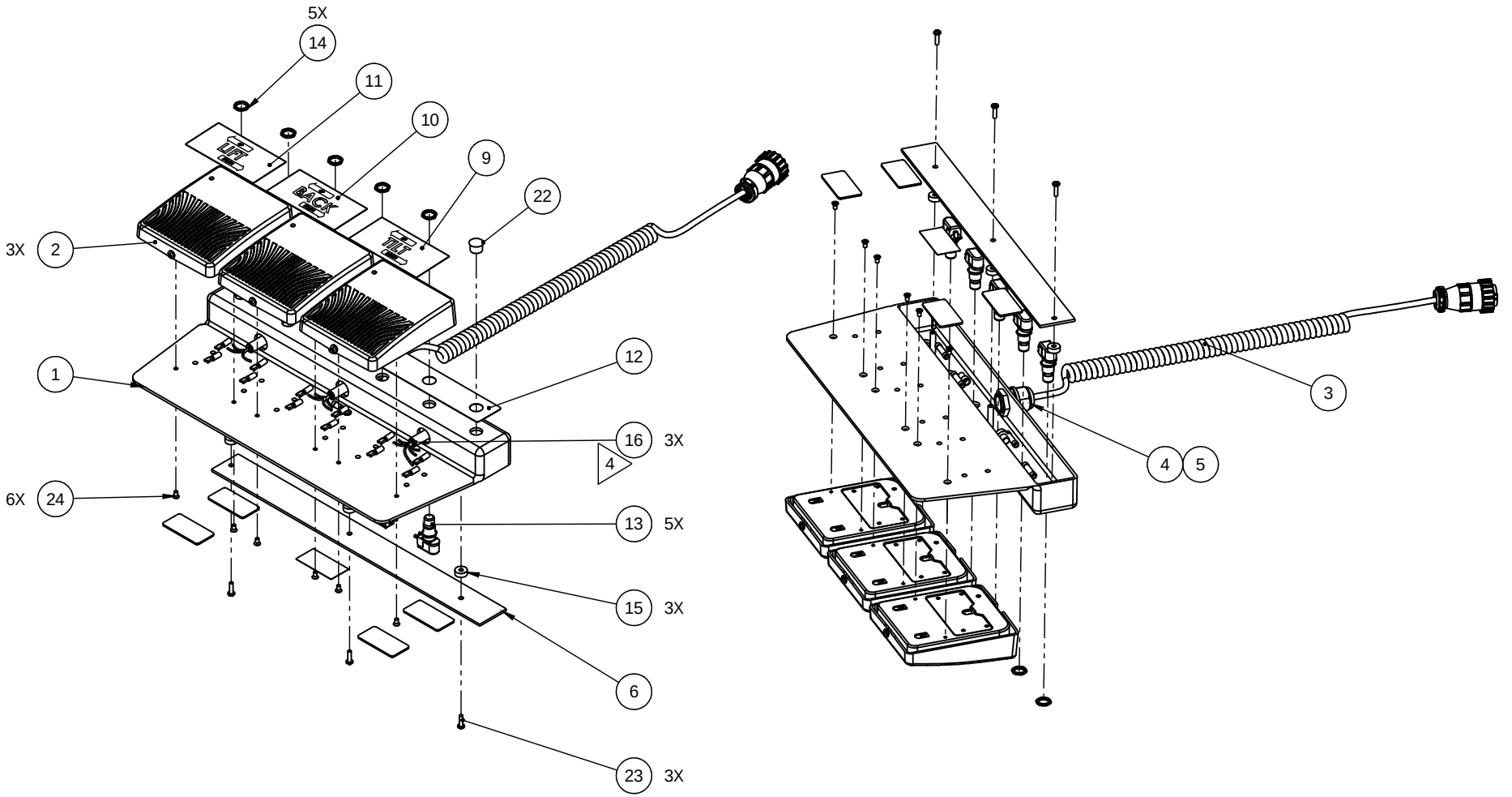
FOOT CONTROL w/LBT, (2) PRGMS,AUTO RETURN & STOP

SIZE	DWG. NO.	REV
B	FC3-NS2PRS-LBT	D00

SCALE: 1:3 UNLESS NOTED | SHEET 1 OF 7

DWG. NO.
FC3-NS2PRS-LBT

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-



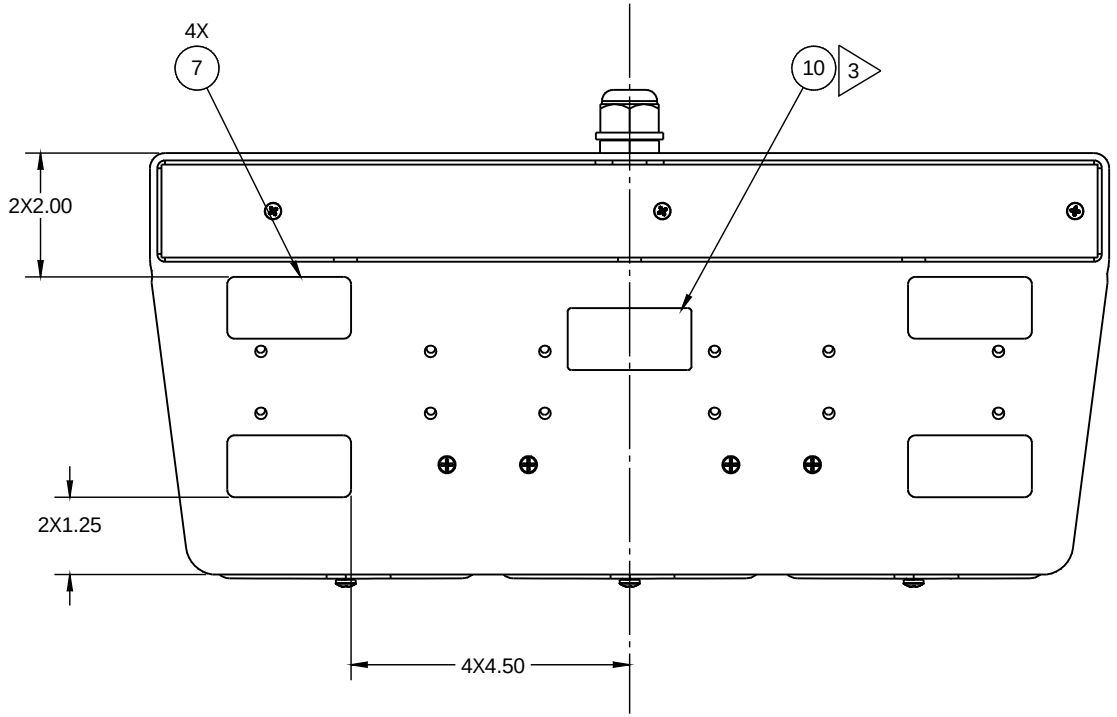
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SIZE	DWG. NO.	REV
B	FC3-NS2PRS-LBT	D00
SCALE: 1:4 UNLESS NOTED		SHEET 2 OF 7

DWG. NO.
FC3-NS2PRS-LBT

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-

LOCATION OF NON-SKID PADS



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SIZE	DWG. NO.	REV
B	FC3-NS2PRS-LBT	D00
SCALE: 1:2 UNLESS NOTED		SHEET 3 OF 7

DWG. NO.
FC3-NS2PRS-LBT

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-

WIRE	STARTING POINT
BLACKJUMPER 1	DETAIL B SHT6
BLUE JUMPER 1	DETAIL B SHT6
BLUE JUMPER 2	DETAIL B SHT6
ORANGE JUMPER 1	DETAIL A SHT 5
ORANGE JUMPER 2	DETAIL A SHT 5
PURPLE JUMPER 1	DETAIL A SHT 5
WHITE JUMPER 1	DETAIL B SHT6
WHITE JUMPER 2	DETAIL B SHT6
BLACK WIRE OF COIL CORD	DETAIL B SHT6
BLUE WIRE OF COIL CORD	DETAIL B SHT6
BROWN WIRE OF COIL CORD	DETAIL B SHT6
GRAY WIRE OF COIL CORD	DETAIL B SHT6
GREEN WIRE OF COIL CORD	DETAIL A SHT 5
ORANGE WIRE OF COIL CORD	DETAIL A SHT 5
PURPLE WIRE OF COIL CORD	DETAIL A SHT 5
RED WIRE OF COIL CORD	DETAIL A SHT 5
WHITE WIRE OF COIL CORD	DETAIL B SHT6
YELLOW WIRE OF COIL CORD	DETAIL A SHT 5
DRAIN WIRE OF COIL CORD	DETAIL C SHT 7

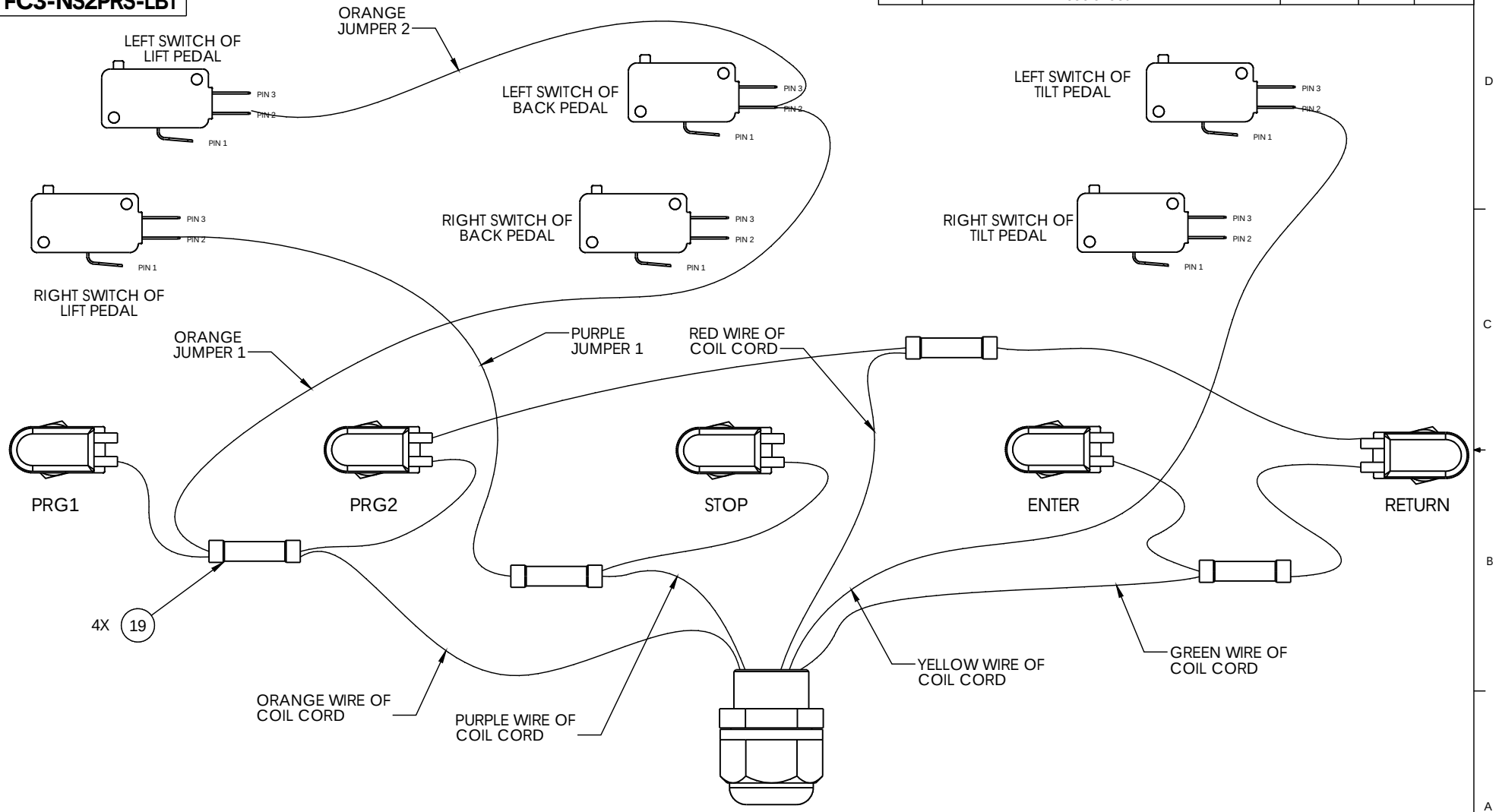
WIRE LENGTH TABLE		
COLOR	JUMPER NO.	LENGTH IN INCHES
BLACK	1	3.25
BLUE	1	12
BLUE	2	3.25
ORANGE	1	7
ORANGE	2	12
PURPLE	1	7
WHITE	1	15
WHITE	2	3.25

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SIZE	DWG. NO.	REV
B	FC3-NS2PRS-LBT	D00
SCALE: 1:2 UNLESS NOTED		SHEET 4 OF 7

DWG. NO.
FC3-NS2PRS-LBT

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-



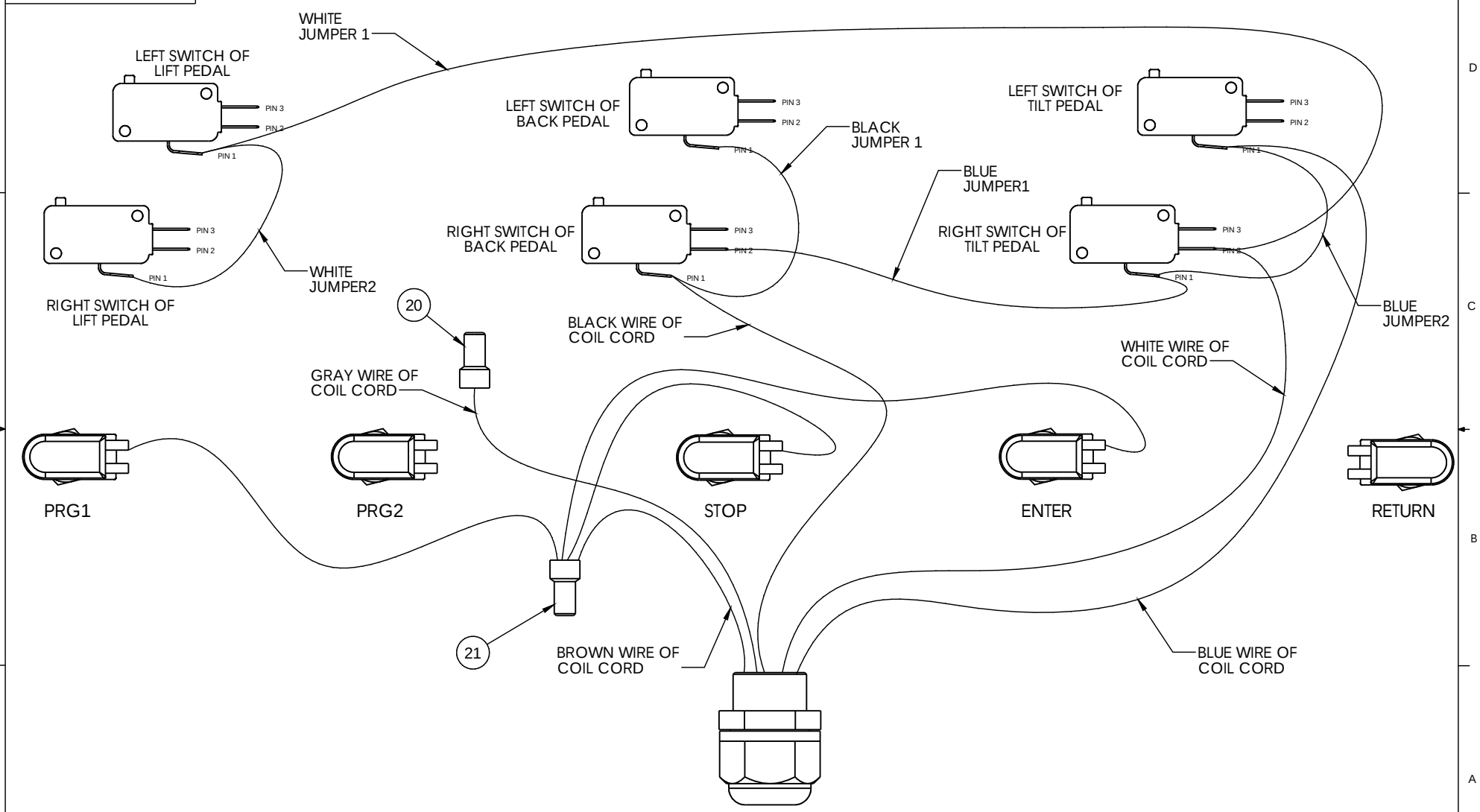
DETAIL A

PROPRIETARY AND CONFIDENTIAL
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SIZE	DWG. NO.	REV
B	FC3-NS2PRS-LBT	D00
SCALE: 1:2 UNLESS NOTED		SHEET 5 OF 7

DWG. NO.
FC3-NS2PRS-LBT

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-



DETAIL B

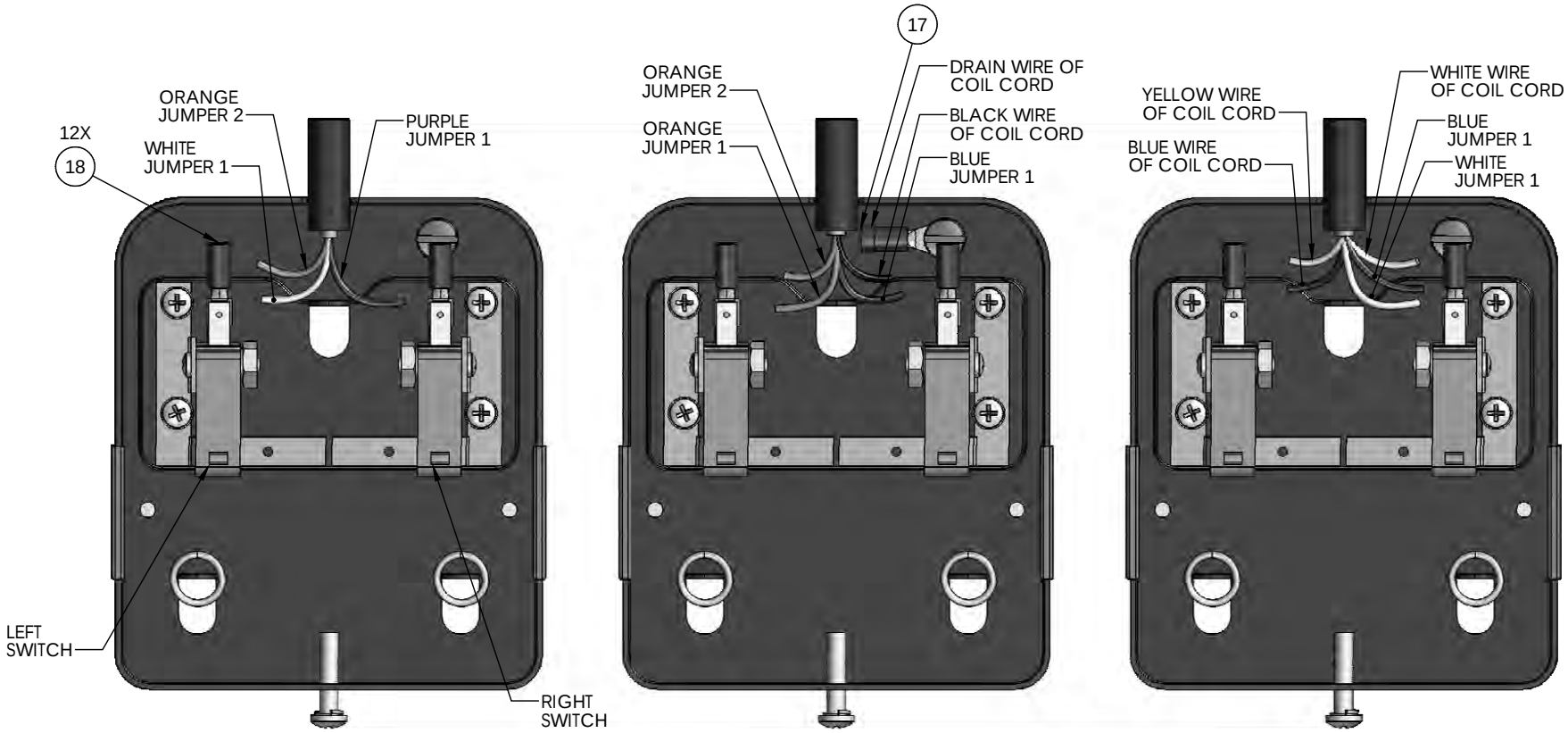
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SIZE	DWG. NO.	REV
B	FC3-NS2PRS-LBT	D00
SCALE: 1:2 UNLESS NOTED		SHEET 6 OF 7

DWG. NO.
FC3-NS2PRS-LBT

REV.	DESCRIPTION	DATE	ENGR	EC#
-	See Sheet1	-	-	-

LOCATION OF GROUND WIRE
REFERENCE OF WIRES ENTERING EACH PEDAL/SWITCH



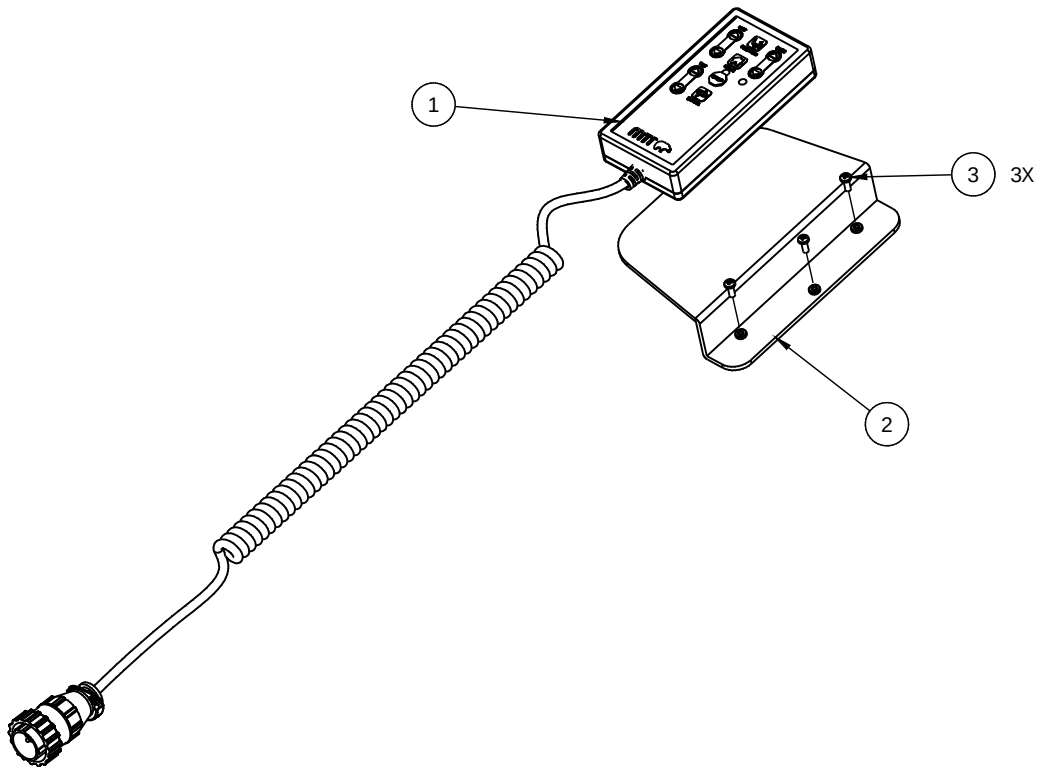
DETAIL C

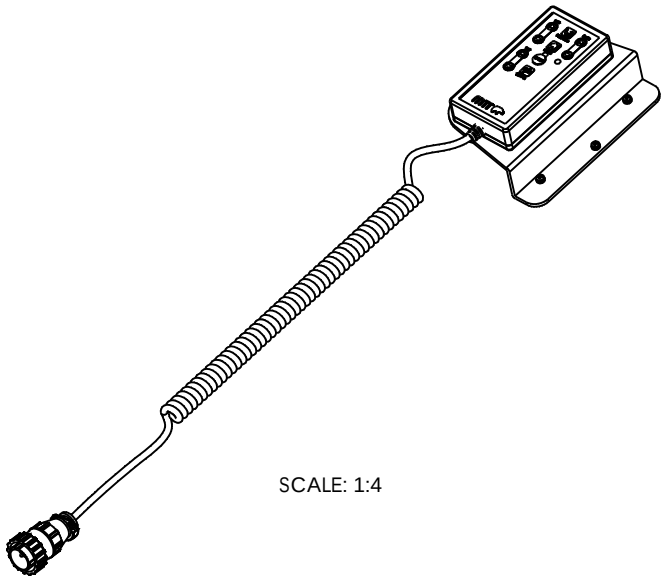
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SIZE	DWG. NO.	REV
B	FC3-NS2PRS-LBT	D00
SCALE: 1:1 UNLESS NOTED		SHEET 7 OF 7

DWG. NO.
5270044

REV.	DESCRIPTION	DATE	ENGR	EC#
A00	INITIAL RELEASE	03/09/2009	MTB	
A01	DATA MIGRATION REVIEW	4/13/2012	NBK	
A02	THE CHANGE REFLECTS THE NEW COILED CORD ASSY	5/31/2012	NBK	0015





SCALE: 1:4

ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
1	5279068	1	HAND CONTROL BOX ASSY w/POSITION f/CHC527S-1
2	5271067	1	CADDY, HAND CONTROL, 527
3	032037	3	PHP SCREW, 6-32 x 3/8 ZINC
4	073058	1	IOI, CHC526-1, CHC527S-1, & CHC527P-1
5	059008	1	BAG, ZIP-LOCK 8 x 10, 2 MIL

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MATERIAL: SEE BOM

THIRD ANGLE PROJECTION

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/16
ANGLE: MACH ± 1/2° BEND ±1°
TWO PLACE DECIMAL ±.015
THREE PLACE DECIMAL ±.005

	NAME	DATE
DRAWN	MTB	03/09/2009
ENGINEER	MTB	03/09/2009
CHECKED	DDW	06/04/2012

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TITLE:

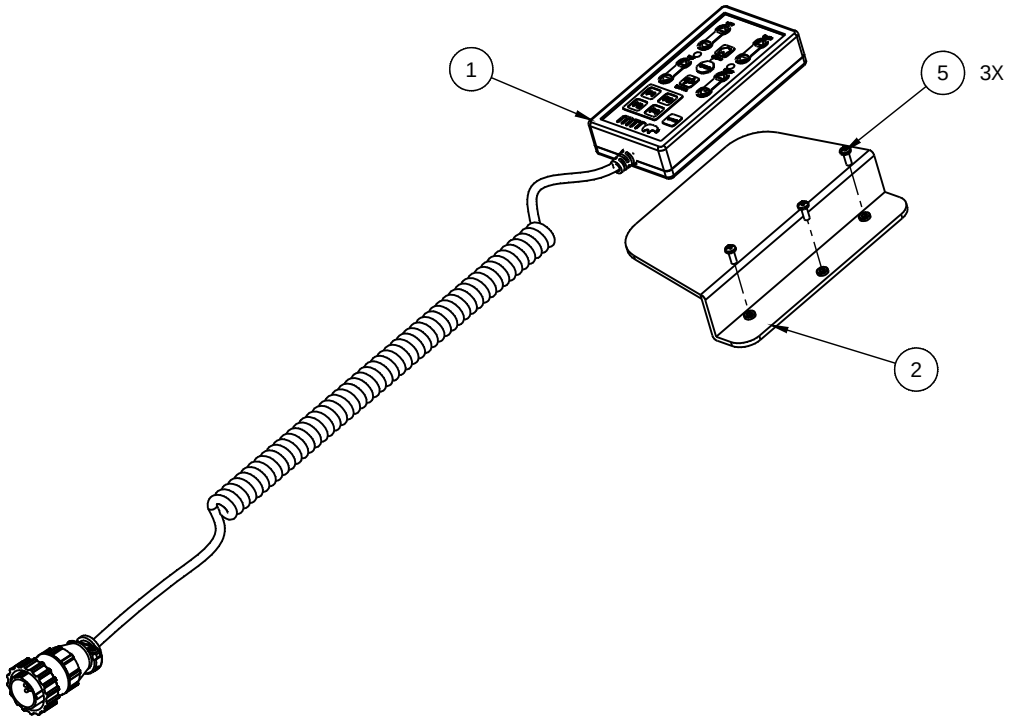
CORDED HAND CONTROL KIT W/CADDY F/527S

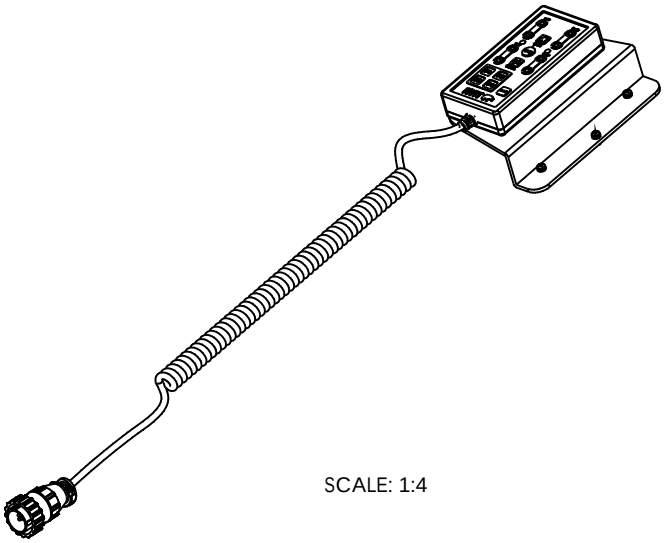
SIZE	DWG. NO.	REV
B	5270044	A02

SCALE: 1:3 UNLESS NOTED | SHEET 1 OF 1

DWG. NO.
5270045

REV.	DESCRIPTION	DATE	ENGR	EC#
A00	INITIAL RELEASE	03/09/2009	MTB	
A01	DATA MIGRATION REVIEW	4/13/2012	NBK	
A02	THE CHANGE REFLECTS THE NEW COILED CORD ASSY	5/31/2012	NBK	0015





SCALE: 1:4

ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
1	5279070	1	HAND CONTROL BOX ASSY f/CHC527P-1
2	5271067	1	CADDY, HAND CONTROL, 527
3	073058	1	IOI, CHC526-1, CHC527S-1, & CHC527P-1
4	059008	1	BAG, ZIP-LOCK 8 x 10, 2 MIL
5	032037	3	PHP SCREW, 6-32 x 3/8 ZINC

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MATERIAL: SEE BOM

THIRD ANGLE PROJECTION

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/16
ANGLE: MACH ± 1/2° BEND ±1°
TWO PLACE DECIMAL ±.015
THREE PLACE DECIMAL ±.005

	NAME	DATE
DRAWN	MTB	03/09/2009
ENGINEER	MTB	03/09/2009
CHECKED	DDW	06/04/2012

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www.mti.net

TITLE:

CORDED HAND CONTROL KIT W/CADDY & 4 PRGMS F/527P

SIZE	DWG. NO.	REV
B	**5270045**	A02

SCALE: 1:3 UNLESS NOTED | SHEET 1 OF 1



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