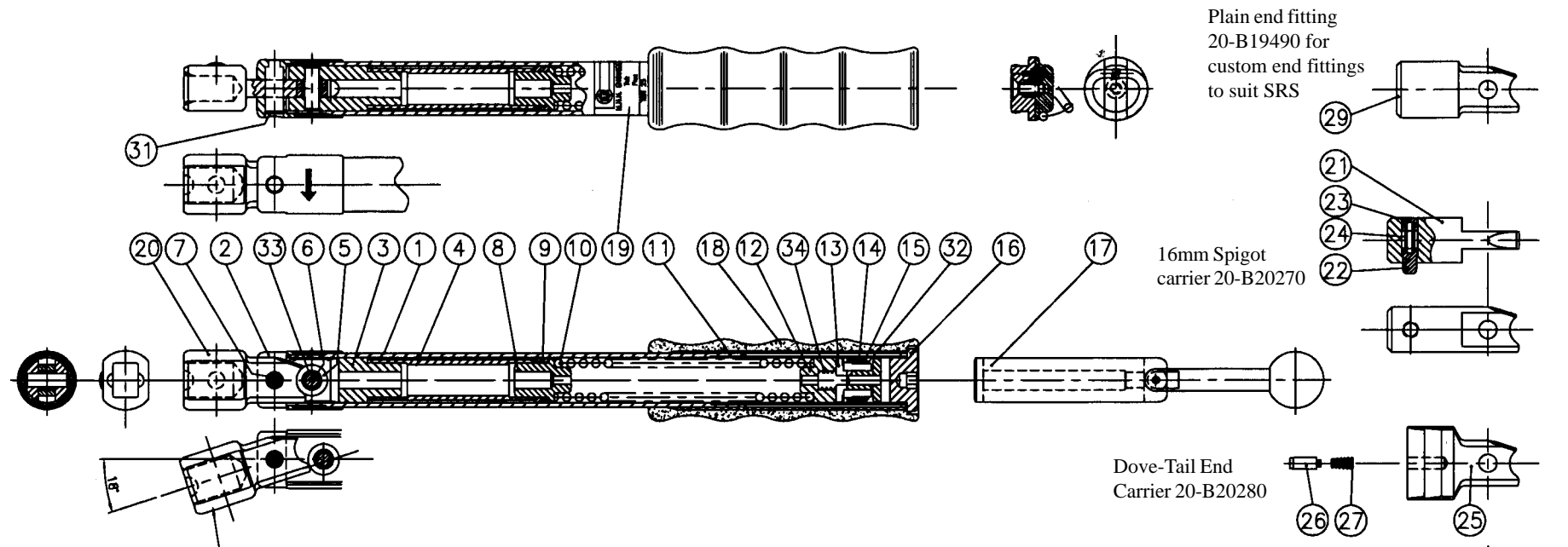


MTBN25 (w/M-Tald Adjusting Key)



1. Assemble handle tube (Item # 1) with the handle sleeve (Item # 11) using Loctite Grade 648. Ensure all surplus Loctite is removed from the slotted section & from the thread.
2. Assemble needle roller pins (Item # 33) into the bore of the bearing outer ring (Item # 5) using Grease to retain needle rollers in position.
3. Place the bearing outer ring in the slotted section of the sliding trunnion (Item # 3) & align the roller assembly with the in-line cross holes of the sliding trunnion. It will be noted that one of the cross holes is identified with a dimple denoting a slide fit for the bearing pin (item # 6), which should be passed through this hole & through the assembled needle rollers taking care not to dislodge any of the rollers. Once this achieved, the pin may be pressed into the second bore, ensuring that both ends are below the sliding surface of the sliding trunnion.
4. Assemble the rear axial bearing (Item # 9) between the spacer tube (Item # 4) and the end spigot (item # 8) & press together.
5. Apply Rocol ASP to the outer surface of the sliding trunnion & rear axial bearing before inserting into the front end (externally threaded end) of the handle tube, ensuring that the trunnion assembly slides freely.
6. Assemble body (item # 2) onto the handle tube using Loctite Grade 648, again ensuring all surplus Loctite is removed & is not allowed to contact any of the inner mechanism.
7. The spring (Item # 10) can now be assembled together with the adjusting screw assembly. The hand grip (Item # 18) may also be fitted.
8. Assembly of the carrier is as follows: Align the slot of the sliding trunnion with the slot of the body. Apply Rocol ASP to the cam form & cross hole of the carrier before inserting into the slot of the body to engage with the roller assembly. Ensure that the direction of operation matches the direction arrow marked on the body. Coat the surface of the pin with Rocol ASP & Assemble the pivot pin (Item # 7), so that the machined flats engage with the slotted section of the body. Secure the pin in position using the internal circlip (Item # 31) fitted to the groove machined in the start of the hole.

MTBM25 (w/M-Tald Adjusting Key)

Ref#	Part#	Qty	Description	Ref#	Part#	Qty	Description
1	20-B20140	1	Handle	19	-	1	Label
2	20-B20150	1	Body	20	20-B18940	1	Carrier 9x12
3	20-B20160	1	Sliding Trunnion	21	20-B20270	1	Carrier 16mm Spigot
4	20-A20170	1	Spacer Tube	22	20-A60110	1	Location Pin
5	20-A20180	1	Bearing – Outer Ring	23	20-A60120	1	Spring Cup
6	20-A20190	1	Bearing Pin	24	20-P11040	1	Spring
7	20-A20200	1	Captive Pin	25	20-B20280	1	Carrier (Dove Tail Type)
8	20-A20210	1	End Spigot	26	20-A10451	1	Plunger
9	20-A20220	1	Rear Axial Bearing	27	20-A10180	1	Conical Spring
10	20-A20230	1	Main Spring	28	20-B20290	1	Carrier "J" Type
11	20-A20240	1	Handle Sleeve	29	20-B19490	1	Carrier Blank End
12	20-A19900	1	Adjusting Screw	30	20-B20300	1	Carrier "SAM 12" Type
13	20-A19930	1	Sliding Lock	31	20-P26910	1	Circlip Internal
14	20-B19920	1	Lock Ring	32	20-P27230	1	Retaining Ring Spirolox
15	20-A19910	1	Support Ring	33	20-P27260	1	Needle Roller Pin
16	20-A20250	1	End Cap (Loop Type Optional)	34	20-P26650	1	Spring
17	20-A19220	1	Adjusting Key (M-Tald Adjusting Key)	Ref	20-A19940		Adjusting Screw Assembly
18	20-A19010	1	Hand Grip				