

Assembly of VXI Receiver onto Mainframe (for all C-Size Systems) — Section 4***P/Ns 310 113 147, 310 113 148, 310 113 149, 310 113 167******P/Ns 310 113 171, 310 113 198, 310 113 247, 310 113 249*****Part/Tools Required:**

- #1 Phillips Screwdriver
- #1 Straight Blade Screwdriver
- Allen Wrenches: 1/16, 3/32, 1/8
- Adapter Jigs (P/N 411 101 125)
- Putty Knife

Instructions:

1. Place mainframe on back (**Fig. A**). (Remove outer Mainframe shell on Tektronix Mainframe)
2. Remove standard flanges from VXI mainframe.
3. Install the two adapter jigs (P/N 411 101 125) into mainframe at positions 1 and 12 (note top of Adapter (See **Fig. B**). Fasten with the 2.5mm screws provided.
4. Place Receiver onto adapter jig pins, aligning pins with holes in innerframe. (See **Fig. C**) Latches will engage.
5. Loosen locking thumb screws on both sides of Receiver at latch until latch can be depressed.
6. Secure and locate one Flange at a time as follows:

After reading Liquid Steel Epoxy instructions thoroughly:

 - A. Dispense half of the two-part cartridge onto a clean surface and mix until a uniform color is obtained.
 - B. Using a putty knife, completely fill all the clearance holes on the flange.
 - C. Fill all threaded mounting screw locations on the Mainframe. (Make sure not to get epoxy inside the Mainframe. Wipe off excess if necessary).
 - D. Apply a thin layer of epoxy to the side of Mainframe opposite the inside area on Flange. (If using an HP Mainframe, remove plastic strip covering mounting screws, then apply epoxy to both sides of the thin metal shim stock supplied with the adapter kit. The shim is placed into the recess on each side of the Mainframe.)
 - E. Apply a thin layer of epoxy to the inside area of the Flange.
 - F. Using the 1/8" hex key wrench and the stainless steel shoulder screws, begin to install the VPC Flanges onto the VXI Mainframe. Place shoulder screw through the Rotation Block and thread two turns into the side of the Receiver. Engage latch catches and tighten locking thumb screws. Press the Flange against the Mainframe. Thread screws (with washers) two turns into the mounting holes. With all mounting screws threaded into holes two turns (and washers at head of screws), apply epoxy liberally around screws and into the clearance holes, filling any voids which may be present.

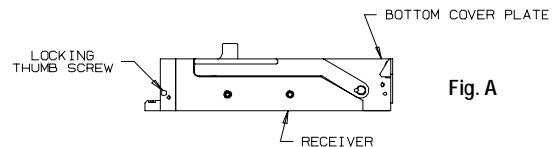


Fig. A

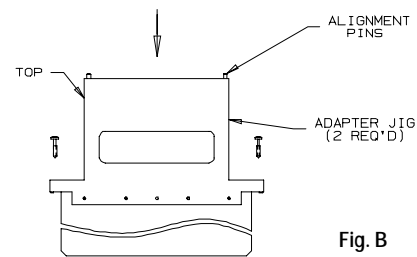


Fig. B

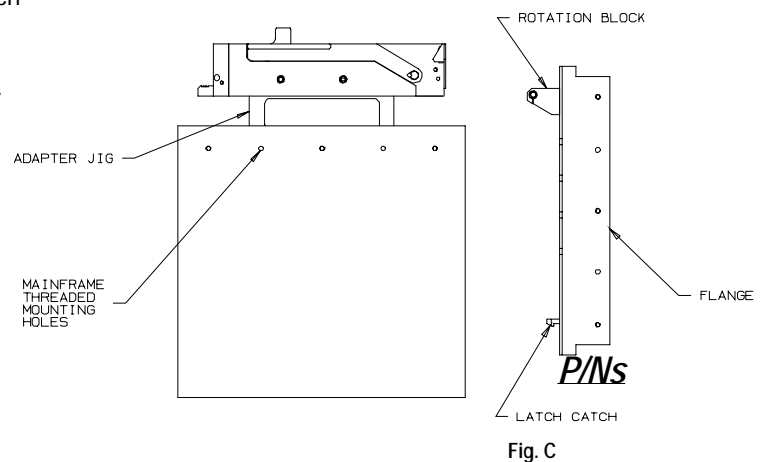


Fig. C

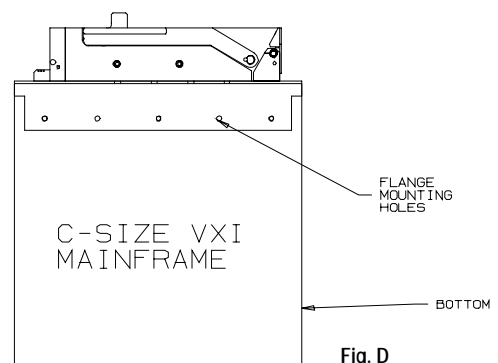


Fig. D

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6. G. Tighten the mounting screws of the Flange into the side of the Mainframe.
- H. Wipe off any excess epoxy from flange and Mainframe.
7. Repeat epoxy procedure (step 6) to the other Flange.
8. Let Receiver and Mainframe sit undisturbed for **24 hours** so epoxy will fully cure.
9. Using a 1/16" hex key, remove bottom cover plate. (**Fig. A**) Turn adjustment screws on each side at the bottom of the Receiver using a 3/32" hex key until tip of set screw touches Rotation Block. (See **Fig. E**)
10. Using 1/8" hex key, tighten shoulder screws through rotation blocks into side of Receiver.
11. Re-install bottom cover plate.
12. Remove Adapter Jigs and ship them back to VPC. (For refund if applicable.)
13. Place top cover bar on top of Receiver with bevel to front and secure with four 4-40 x .75 socket head cap screws using 3/32" hex key.
14. On Tektronix systems, re-install outer shell of Mainframe.

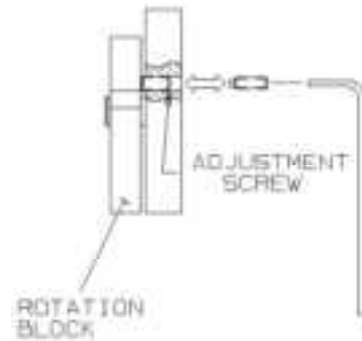


Fig. E

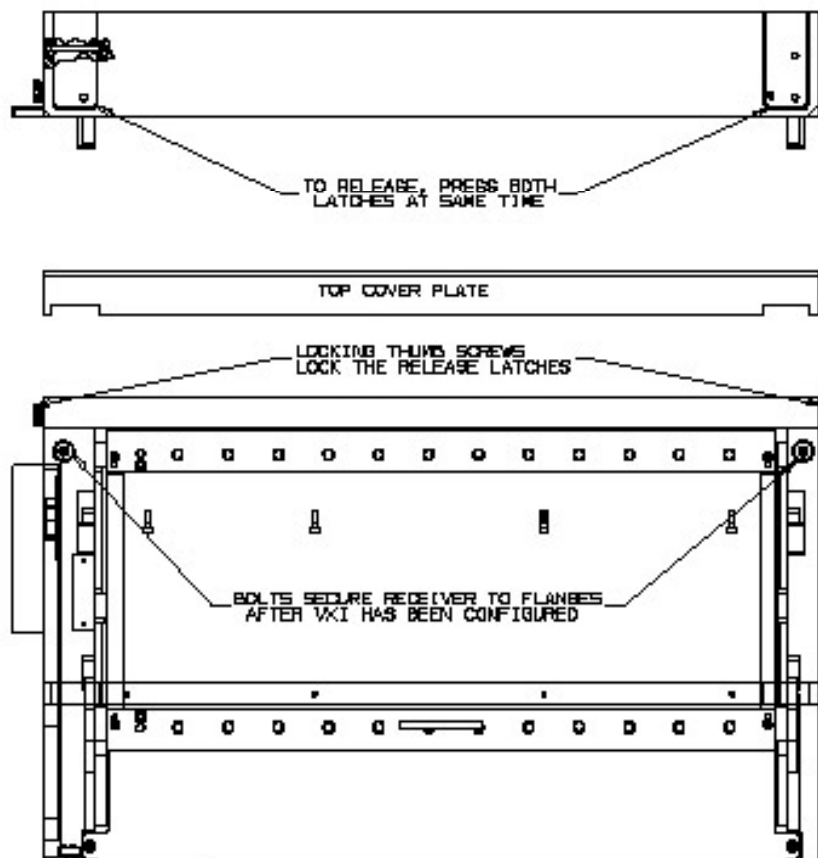


Fig. F