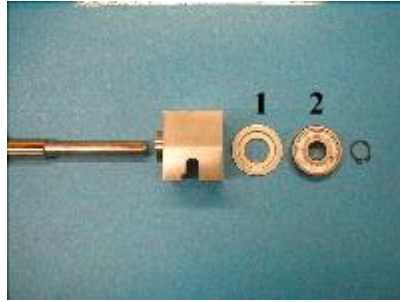


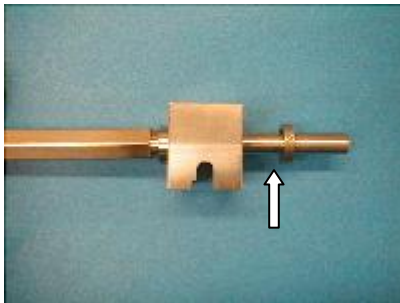
# Graphite Bushing Install



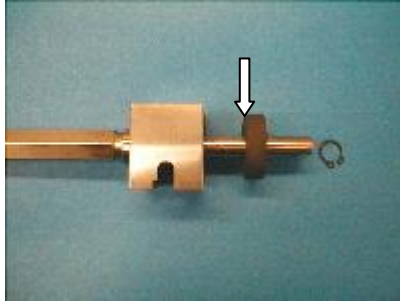
1. Remove smart wave from the solder pot and disassemble. Items 1 & 2 will no longer be used. Clean the shaft and bearing house.



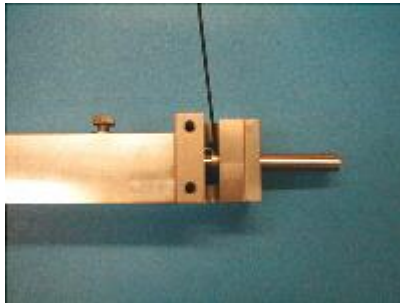
2. Use a piece of Scotch Brite pad to polish the surface of the shaft (at arrow) that will make contact with the bushing. If this surface is scarred and cannot be made smooth, replace the smart wave shaft.



3. Insert the smart wave shaft through the bearing house. Slide the Ring Adjustment, Part number 7-424425 (at arrow), on the shaft with the chamfered side towards the wave area. Do not tighten the set screw.



4. Slide the graphite bushing, part number 7-424424, on the shaft with the chamfered side towards the bearing house. Move the bushing completely into the bearing house and reinstall the “C” clip.



5. Reinstall the bearing house cover and attach the bearing houses and shaft to the main smart wave block. Turn the smart wave upside down and locate the ring adjustment. Move the ring adjustment as close to the bushings as possible and tighten the set screw. Reinstall the smart wave into the solder pot and flow the main solder wave to bring it to temperature. You should replace the carbon bushings every 2000 hours. Any questions please contact your nearest Vitronics Soltec office.