

NOTE: UNLESS OTHERWISE SPECIFIED

1. PRIOR TO ASSEMBLY, REMOVE COVERING FROM GASKET (ITEM 3) TO EXPOSE ADHESIVE AND PRESS ONTO UNDERSIDE OF COVER (ITEM 2). CARE MUST BE TAKEN TO ENSURE THAT HOLE PATTERNS LINE UP.

2. INSTALL PLUG (ITEM 5) IN COVER (ITEM 2) IN LOCATION SHOWN. PLUG MUST NOT EXTEND BEYOND TOP SURFACE OF COVER.

3. TO LOAD HEADS ONTO DISK (ITEM 4) SLIDE HEAD LOADING TOOL BETWEEN UPPER AND LOWER ARMS TO GENTLY FORCE HEADS APART, ROTATE ARM ASSY UNTIL HEADS ARE OVER DISK AND CAREFULLY REMOVE HEAD LOADING TOOL. HEADS ARE NOW PROPERLY POSITIONED ON DISK.

4. INSTALL SHIMS (ITEMS 15 THRU 21) AS REQUIRED IN LOCATION SHOWN TO ACHIEVE THE INDICATED GAP BETWEEN BOTTOM SURFACE OF SCALE (ITEM 8) AND TOP SURFACE OF RETICLE.

5. TORQUE SCREWS (ITEM 11) TO 10.0 IN/LBS.

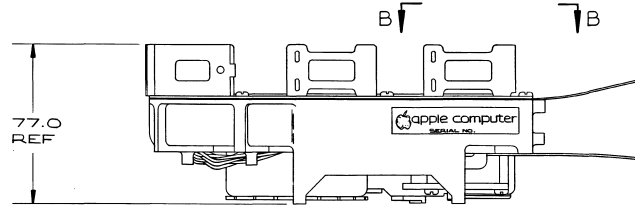
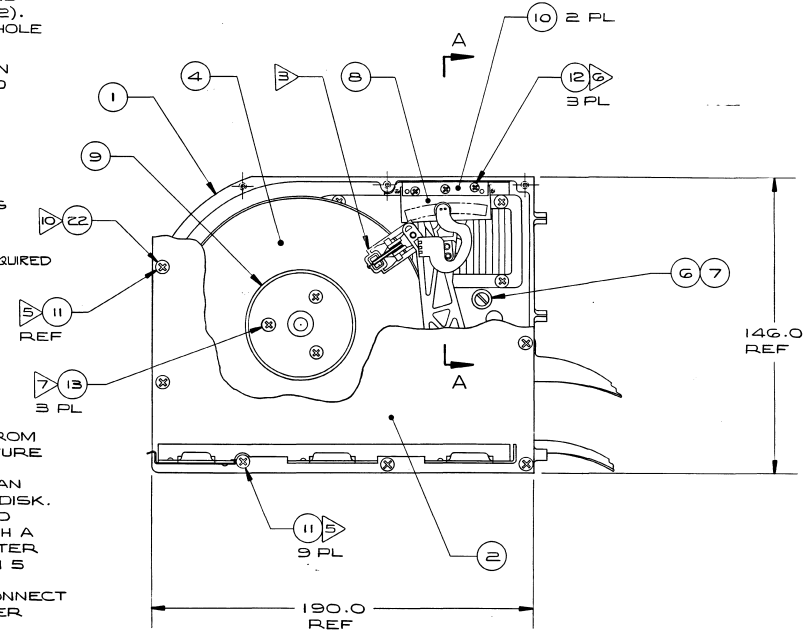
6. TORQUE SCREWS (ITEM 12) TO 3.0 IN/LBS.

7. TORQUE SCREWS (ITEM 13) TO 5.0 IN/LBS.

8. PARTICLE COUNT PROCEDURE:  
AFTER ASSY, REMOVE PLUG (ITEM 5) FROM COVER AND INSERT AIR SAMPLING FIXTURE FROM PARTICLE COUNTER INTO HOLE. CONNECT SPINDLE MOTOR HARNESS TO AN EXTERNAL POWER SUPPLY TO ROTATE DISK. PARTICLE COUNT READING SHOULD BE 50 PARTICLES PER CUBIC FT OR LESS WITH A MAX PARTICLE SIZE OF .3 MICRONS AFTER RUNNING THE UNIT FOR NO MORE THAN 5 MINUTES. AFTER TEST IS COMPLETED, INSTALL PLUG PER NOTE 2 AND DISCONNECT SPINDLE MOTOR HARNESS FROM POWER SUPPLY. DO NOT MOVE CHASSIS UNTIL SPINDLE MOTOR HAS STOPPED ROTATING.

9. AFTER PARTICLE COUNT TESTING PER NOTE 8, POSITION LABEL (ITEM 14) OVER PLUG APPROXIMATELY AS SHOWN.

10. AFTER COVER IS IN PLACE AND ALL SCREWS (ITEM 11) ARE PROPERLY TORQUED PER NOTE 5, APPLY TORQUE SEAL (ITEM 22) TO SCREW HEAD TO PREVENT TAMPERING (ONE PLACE ONLY IN LOCATION SHOWN).



REV	ZONE	ECO #	REVISION	APPD
A		PG20	INITIAL RELEASE (SK-W175-04)	gfa

SEE SEPARATE BILL OF MAT'L G77-6000

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DATE	DESIGNED BY	DATE	DESIGNED BY
1977	ANDERSON	1977	ANDERSON
FILE NO.	REV. NO.	FILE NO.	REV. NO.
977	1	977	1
DRAWN BY	CHKD BY	DRAWN BY	CHKD BY
W.A.	M.S.D.	W.A.	M.S.D.
QUANTITY	SCALE	QUANTITY	SCALE
FULL	1:1	FULL	1:1
PART NO. G77-6000-A		REV. 1/E	

G77-6000-A 1/E