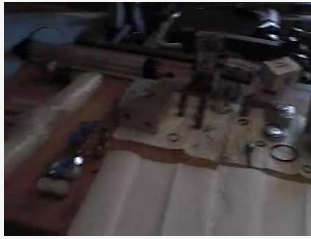




Ariel Dynamics Inc. Media Library - Video

Output Pack Assembly



Code	adi-vid-01182
Title	Output Pack Assembly
Subject	Activities
Duration	00:59:01
URL	https://arielweb.com/videos/play/adi-vid-01182
Date	2010-02-06 00:00:00
Label	Approved
Privacy	Public

Video Synopsis

The video is a detailed tutorial on the assembly of a hydraulic valve system. The speaker explains the process step by step, emphasizing the importance of cleanliness, precision, and the correct use of tools and materials.

The assembly process includes:

1. Ensuring all parts are free of burrs from machining.
2. Pressing a pin into a hole on the top face of the valve body.
3. Installing check valves and a cone spring.
4. Inserting a retaining ring with the sharp edge facing upward.
5. Installing O-rings in specific grooves.
6. Preparing the valve stem, which should be free from the thread and able to go through a gauge of a 440.
7. Applying a job of lock tight, a red color strong but not permanent adhesive.
8. Inserting the valve stem into the valve body.
9. Preparing the mounting block for the motor, ensuring it's clean and free of burrs.
10. Installing more O-rings and backup rings in specific locations.
11. Assembling the spool and sleeve, ensuring they are paired correctly.
12. Installing a brass fitting check valve plug.
13. Installing a hydraulic plug.
14. Installing a nipple and an elbow for the pressure transducer.

The speaker also provides tips and tricks to avoid common mistakes, such as ensuring the O-rings are properly lubricated to prevent leakage and using the correct amount of Teflon tape on the threads of the fittings.

Video Synopsis

The video is a detailed guide on how to assemble and adjust a hydraulic valve system. The speaker provides step-by-step instructions on how to assemble the parts, emphasizing the importance of cleanliness and precision.







Key steps include:

1. Assembling the elbow and ensuring it is tight but not overly so.
2. Preparing the parts by cleaning them and avoiding touching the grease.
3. Inserting the parts carefully, paying attention to the orientation of the holes.
4. Applying lock tight and adjusting the flange.
5. Adjusting the spool and ensuring it is not too far in.
6. Assembling the motor and attaching the ground wire.
7. Assembling the accumulator and ensuring it is on the correct side.

8. Installing the hydraulic cylinder and attaching the fittings.
9. Filling the system with oil and attaching the linear transducer.

The speaker also provides tips on how to troubleshoot potential issues, such as adjusting the spool if it is too far in, and the importance of never forcing parts into place. The video ends with the speaker demonstrating how to install the final parts and fill the system with oil.

Audio transcription

Frame	#	Time	Spoken text
	0.	00:00:00	<i>This is how it works, how it is supposed to be.</i>
	1.	00:00:04	<i>Right, of course, it goes to some oil and it'll be fine.</i>
	2.	00:00:12	<i>We'll talk more about those kind of things.</i>
	3.	00:00:16	<i>This is where we get to learn.</i>
	4.	00:00:18	<i>One, we assume all parts are made to print.</i>
	5.	00:00:24	<i>Inspected QCL is to print.</i>
	6.	00:00:26	<i>All parts are free of bird from machining.</i>
	7.	00:00:30	<i>No edge, sharp edge sticking out, especially the bow body.</i>
	8.	00:00:34	<i>At any cutting corner, you should not have any bird hanging or any niche hanging around.</i>
	9.	00:00:42	<i>That will damage the bow and will damage the function of the bow.</i>
	10.	00:00:50	<i>Nice, dude.</i>
	11.	00:01:12	<i>So you have policy for one puck.</i>
	12.	00:01:20	<i>No, tell me what I need with you.</i>
	13.	00:01:50	<i>What I need to do is press this little pin, column pin into this hole.</i>
	14.	00:02:00	<i>This is the top face.</i>
	15.	00:02:02	<i>This is the bottom face.</i>
	16.	00:02:04	<i>The top face has a counter ball.</i>
	17.	00:02:06	<i>Now which face is that, you said?</i>
	18.	00:02:08	<i>When you mount the motor.</i>
	19.	00:02:12	<i>The motor.</i>
	20.	00:02:14	<i>What you call it, the motor face?</i>
	21.	00:02:16	<i>The first thing you press the pin in.</i>
	22.	00:02:20	<i>Why you put the pin there?</i>
	23.	00:02:22	<i>We do the whole size because they cannot get a smaller drill to get in.</i>
	24.	00:02:28	<i>I see.</i>
	25.	00:02:30	<i>To do an extra step.</i>
	26.	00:02:36	<i>This is what we got right now.</i>
	27.	00:02:40	<i>Here.</i>
	28.	00:02:42	<i>Do you know something like this?</i>
	29.	00:02:44	<i>Yeah.</i>
	30.	00:02:54	<i>Let me see the motor.</i>



#	Time	Spoken text
31.	00:02:58	Let me see it.
32.	00:03:10	Okay.
33.	00:03:28	Press this pin in.
34.	00:03:30	Okay.



35.	00:03:56	Make sure, where did you put the pins?
36.	00:03:58	It has to be flush.
37.	00:04:00	Okay.
38.	00:04:01	These are the check valves.
39.	00:04:02	Check valve.



40.	00:04:04	On this end, where the ball goes in.
41.	00:04:06	Jump in.
42.	00:04:08	Hold on to this.
43.	00:04:09	Make sure the ball can release it.
44.	00:04:12	Okay.



45.	00:04:13	Then you get a spring cone spring.
46.	00:04:17	A small end of the cone going in first.
47.	00:04:21	Okay.
48.	00:04:23	That's the spring.
49.	00:04:25	Let's sit like that.









50.	00:04:27	And the retaining ring.
51.	00:04:29	There's two sides.
52.	00:04:30	You look closely.
53.	00:04:31	One has a round edge.
54.	00:04:33	One has a sharp edge.



55.	00:04:35	The sharp edge is the edge facing upward.
56.	00:04:45	Let me.
57.	00:04:56	Okay.
58.	00:04:58	The retaining ring will go to the goo.
59.	00:05:01	Make sure it goes to the goo.

60.	00:05:03	Okay.
61.	00:05:05	Get a screwdriver.
62.	00:05:07	Here.

Frame	#	Time	Spoken text
	63.	00:05:16	Sure.
	64.	00:05:18	They go in.
	65.	00:05:19	Make sure they don't go further in too far in.
	66.	00:05:23	Make sure they're just in the goo.
	67.	00:05:25	Okay.
	68.	00:05:26	Now everything should be there.
	69.	00:05:28	Okay.
	70.	00:05:29	And you can get something like a pencil that decides soft.
	71.	00:05:34	Let me.
	72.	00:05:41	Something like this.
	73.	00:05:42	Soft material.
	74.	00:05:44	Push on the ball.
	75.	00:05:45	And you can see it bouncing.
	76.	00:05:47	Okay.
	77.	00:05:49	There are four of them like several.
	78.	00:05:51	Okay.
	79.	00:05:52	Now.
	80.	00:05:54	This is number 16 O-ring.
	81.	00:06:00	Number 16.
	82.	00:06:04	Okay.
	83.	00:06:06	The whole ring goes on this groove.
	84.	00:06:08	Make sure it's clean.
	85.	00:06:09	Make sure no burr, no soft edge.
	86.	00:06:11	Go over that.
	87.	00:06:13	Number 16.
	88.	00:06:15	Number 16.
	89.	00:06:17	Make sure it goes into the groove.
	90.	00:06:21	All right.
	91.	00:06:24	All right.
	92.	00:06:48	Okay.
	93.	00:06:52	All four of them.



#	Time	Spoken text
94.	00:06:53	Now.
95.	00:06:54	Next thing.
96.	00:06:56	Prepare the valve stem.
97.	00:06:58	This one should be prefabricated.
98.	00:07:01	It's like this.
99.	00:07:10	Okay.



100.	00:07:11	All the solder should be free from the thread.
101.	00:07:14	Very clean.
102.	00:07:15	So the thread should be able to go through a gauge of a 440 through it.
103.	00:07:21	I mean, all of this thread are perfect.
104.	00:07:26	Okay.



105.	00:07:27	Then you put a job of lock tight.
106.	00:07:30	Red color.
107.	00:07:32	It's a strong, but it's not permanent.
108.	00:07:36	Screw it in until you leave around one thread.
109.	00:07:40	This one you can tell is almost one half,



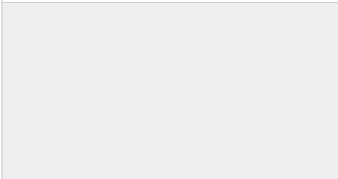
110.	00:07:43	but you can next time go into like one to one and a half maximum in.
111.	00:07:48	Okay.
112.	00:07:49	Now with this.
113.	00:07:51	We'll make sure.
114.	00:07:53	Anyway, there's a small end.



115.	00:07:55	It's already machined without any thread.
116.	00:07:58	You insert that in.
117.	00:08:00	If you look at it, there's a little flat spot.
118.	00:08:03	The flat spot fits in this side.
119.	00:08:05	Okay.



120.	00:08:06	This little hole is a 440,
121.	00:08:08	corner inch long screw on the table.
122.	00:08:13	It's like this.
123.	00:08:16	Okay.
124.	00:08:17	Show it to me again.



125.	00:08:18	Okay.
126.	00:08:19	I have it on the table.
127.	00:08:20	That's okay.
128.	00:08:21	One minute.



#	Time	Spoken text
129.	00:08:22	Where is your hand?
130.	00:08:23	I'm going so close.
131.	00:08:25	Okay.
132.	00:08:26	Here it is.
133.	00:08:28	Okay.
134.	00:08:29	So this screw is doing what?



135.	00:08:30	It's holding the any thread rod into this puppet.
136.	00:08:38	Okay.
137.	00:08:39	Then just get a wrench.
138.	00:08:44	Okay.
139.	00:08:45	Out in the wrench, just screw it in tight.



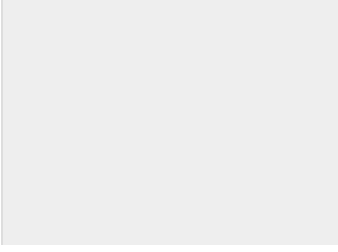
140.	00:08:51	And you screw it in turn around.
141.	00:08:54	That's holding what?
142.	00:08:55	Holding this section.
143.	00:08:57	I see.
144.	00:08:58	Okay.








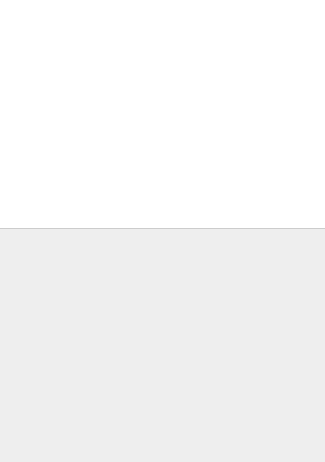
145.	00:08:59	Fine.
146.	00:09:00	Okay.
147.	00:09:01	When you screw it in, use this sort and tighten it.
148.	00:09:03	So even though it's screwed in, you still have to hold it with a pin.
149.	00:09:07	No.



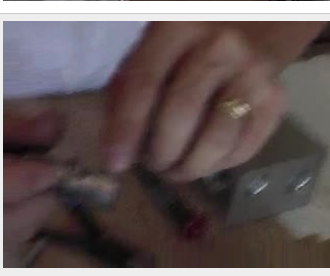

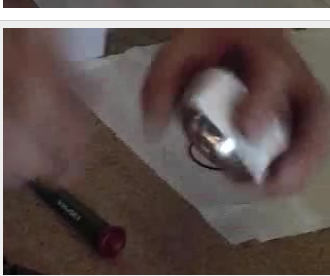
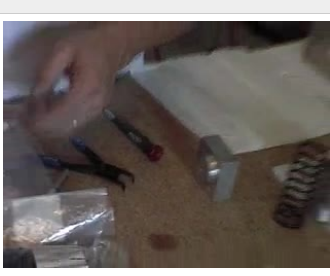

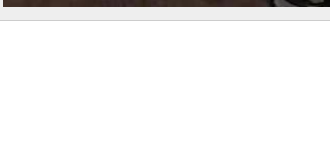





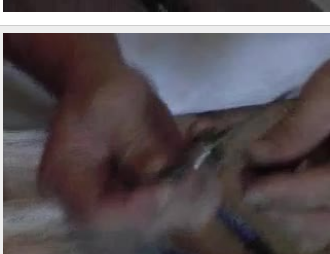


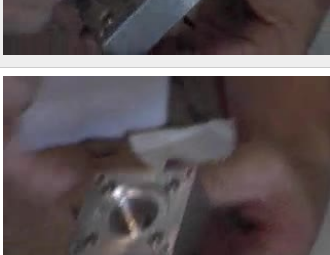
150.	00:09:08	When you screw it in, this, this set screw will wrap on there.
151.	00:09:12	Oh, there is no, there is no thread on the other side.
152.	00:09:15	No.
153.	00:09:16	Okay.
154.	00:09:17	Now this is done.








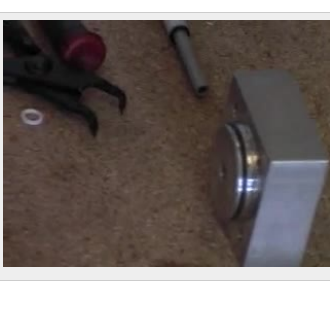


155.	00:09:20	All right.
156.	00:09:28	Now to prepare this, this should be coming when it's finished from home and home.
157.	00:09:32	When it's finished from home and lab, this should be a complete set.
158.	00:09:37	Okay.

Frame	#	Time	Spoken text
	159.	00:09:38	The preferred clearing area between the oldie of the spool and the sleeve should be somewhere
	160.	00:09:46	around four or three thousand, ten of a thousand per side.
	161.	00:09:53	For me, it's Greek, but it's okay.
	162.	00:09:55	We don't understand.
	163.	00:09:56	Yeah.
	164.	00:09:58	For me, it worked great.
	165.	00:10:00	It's somewhere around eight to one thousand, eight-tenth of a thousand to one thousand.
	166.	00:10:05	Okay.
	167.	00:10:06	This one, Jerry has, it's around two-tenth of a thousand.
	168.	00:10:09	Two and a half-tenth of a thousand.
	169.	00:10:12	But I think it's okay.
	170.	00:10:13	It's a little tight, but it's still okay.
	171.	00:10:17	Okay.
	172.	00:10:18	Now.
	173.	00:10:20	Next thing we're prepared is putting the o-ring in here.
	174.	00:10:24	Oh, yeah.
	175.	00:10:25	This is the one that was missing?
	176.	00:10:26	Yes.
	177.	00:10:27	Okay.
	178.	00:10:28	This is number eighteen o-ring.
	179.	00:10:30	Two of them.
	180.	00:10:32	Okay.
	181.	00:10:33	I see.
	182.	00:10:34	Okay.
	183.	00:10:35	I see now.
	184.	00:10:37	Two o-ring.
	185.	00:10:38	One.
	186.	00:10:39	The second one goes to the second goof.
	187.	00:10:44	This side doesn't have o-ring goof.
	188.	00:10:47	Doesn't need o-ring goof.

Frame	#	Time	Spoken text
	189.	00:10:49	<i>It will go into this body from the top and first.</i>
	190.	00:10:55	<i>Line up this goof right here along with this hull.</i>
	191.	00:11:01	<i>Line him up.</i>
	192.	00:11:02	<i>Okay.</i>
	193.	00:11:03	<i>Okay.</i>
	194.	00:11:04	<i>You line up what?</i>
	195.	00:11:05	<i>The goof.</i>
	196.	00:11:06	<i>Okay.</i>
	197.	00:11:07	<i>This goof right here.</i>
	198.	00:11:08	<i>Up the sleeve.</i>
	199.	00:11:09	<i>Okay.</i>
	200.	00:11:10	<i>The valve out in this hull.</i>
	201.	00:11:11	<i>Okay.</i>
	202.	00:11:12	<i>Okay.</i>
	203.	00:11:13	<i>But we don't do that.</i>
	204.	00:11:14	<i>We do our next step operation for the mounting block motor.</i>
	205.	00:11:18	<i>Yes.</i>
	206.	00:11:19	<i>First thing, make sure everything clean.</i>
	207.	00:11:21	<i>No burr.</i>
	208.	00:11:22	<i>Especially the o-ring goof inside there.</i>
	209.	00:11:25	<i>Okay.</i>
	210.	00:11:26	<i>This one is number twenty eight o-ring.</i>
	211.	00:11:30	<i>Yes.</i>
	212.	00:11:31	<i>Okay.</i>
	213.	00:11:32	<i>Number twenty eight o-ring goof.</i>
	214.	00:11:36	<i>Number twenty eight o-ring.</i>
	215.	00:11:38	<i>Just snap it in.</i>
	216.	00:11:40	<i>Right.</i>
	217.	00:11:41	<i>This one Jerry already pressed in.</i>
	218.	00:11:43	<i>There's a tool as a guy.</i>
	219.	00:11:45	<i>You must use the tool.</i>
	220.	00:11:47	<i>You must use the tool.</i>
	221.	00:11:48	<i>Because the tool, laminate the mount across.</i>
	222.	00:11:51	<i>Go in.</i>
	223.	00:11:52	<i>What is it?</i>

Frame	#	Time	Spoken text
	224.	00:11:53	<i>It's a tool that you drop.</i>
	225.	00:11:55	<i>No, no.</i>
	226.	00:11:56	<i>What do you press in?</i>
	227.	00:11:57	<i>What is it?</i>
	228.	00:11:58	<i>This two pin.</i>
	229.	00:11:59	<i>Two pins.</i>
	230.	00:12:00	<i>Okay.</i>
	231.	00:12:01	<i>That's the pins.</i>
	232.	00:12:02	<i>Two pins.</i>
	233.	00:12:03	<i>Two pins.</i>
	234.	00:12:04	<i>Two pins.</i>
	235.	00:12:05	<i>Two pins.</i>
	236.	00:12:06	<i>Two pins.</i>
	237.	00:12:07	<i>Two pins.</i>
	238.	00:12:08	<i>Two pins.</i>
	239.	00:12:09	<i>Two pins.</i>
	240.	00:12:10	<i>Two pins.</i>
	241.	00:12:11	<i>Two pins.</i>
	242.	00:12:12	<i>Two pins.</i>
	243.	00:12:13	<i>Two pins.</i>
	244.	00:12:14	<i>Two pins.</i>
	245.	00:12:15	<i>Two pins.</i>
	246.	00:12:17	<i>Okay.</i>
	247.	00:12:18	<i>So without turning.</i>
	248.	00:12:19	<i>Okay.</i>
	249.	00:12:20	<i>Yeah.</i>
	250.	00:12:21	<i>I remember that.</i>
	251.	00:12:22	<i>Now, the next step is put in the o-ring.</i>
	252.	00:12:26	<i>Number ten.</i>
	253.	00:12:27	<i>With two.</i>
	254.	00:12:28	<i>Number ten backup.</i>
	255.	00:12:29	<i>Oh boy.</i>
	256.	00:12:30	<i>That's more cool.</i>
	257.	00:12:31	<i>Where is the groove?</i>
	258.	00:12:32	<i>I cannot believe it.</i>

Frame	#	Time	Spoken text
	259.	00:12:33	<i>It's inside.</i>
	260.	00:12:34	<i>That's the one.</i>
	261.	00:12:35	<i>That's the one that will stop the oil coming from the screw out.</i>
	262.	00:12:39	<i>Right.</i>
	263.	00:12:40	<i>Okay.</i>
	264.	00:12:41	<i>Two backup.</i>
	265.	00:12:43	<i>What number is this?</i>
	266.	00:12:46	<i>Number ten backup and number ten.</i>
	267.	00:12:48	<i>Okay.</i>
	268.	00:12:49	<i>Two backup and one o-ring.</i>
	269.	00:12:50	<i>That's a standard number ten.</i>
	270.	00:12:52	<i>Right.</i>
	271.	00:12:53	<i>Yeah.</i>
	272.	00:12:54	<i>Okay.</i>
	273.	00:12:55	<i>Oh yeah.</i>
	274.	00:12:56	<i>Oh, you need both of them.</i>
	275.	00:12:57	<i>Okay.</i>
	276.	00:12:58	<i>Oh, it's a one that is cut in the middle of something?</i>
	277.	00:13:00	<i>It's called a scar cut.</i>
	278.	00:13:01	<i>Okay.</i>
	279.	00:13:02	<i>They already cut it for you.</i>
	280.	00:13:03	<i>When you bought it.</i>
	281.	00:13:04	<i>The scar cut.</i>
	282.	00:13:05	<i>I didn't have this on the old pocket.</i>
	283.	00:13:07	<i>No, the other one.</i>
	284.	00:13:08	<i>You use a seal.</i>
	285.	00:13:09	<i>That seal is difficult to get.</i>
	286.	00:13:10	<i>Yes.</i>
	287.	00:13:11	<i>And it's more difficult to in place it without backing it up.</i>
	288.	00:13:15	<i>Yeah.</i>
	289.	00:13:16	<i>That's the Thomas secrets.</i>
	290.	00:13:18	<i>Yeah.</i>



#	Time	Spoken text
291.	00:13:19	<i>Number ten o-ring.</i>
292.	00:13:21	<i>So.</i>
293.	00:13:22	<i>Oh.</i>
294.	00:13:23	<i>I might have a hole there.</i>



295.	00:13:25	<i>Yeah, there is.</i>
296.	00:13:26	<i>I don't want to cut the big hole in the floor on the floor.</i>
297.	00:13:29	<i>Then you cannot use it anymore.</i>
298.	00:13:30	<i>Because the backup does.</i>
299.	00:13:32	<i>Then the panel ring, the pickup does.</i>



300.	00:13:34	<i>Okay.</i>
301.	00:13:35	<i>Let's just throw away.</i>
302.	00:13:36	<i>Okay.</i>
303.	00:13:37	<i>So you put two of them though.</i>
304.	00:13:40	<i>You put one backup in first.</i>



305.	00:13:42	<i>Yeah.</i>
306.	00:13:43	<i>Then you put the o-ring.</i>
307.	00:13:44	<i>Oh, the first one was not an o-ring.</i>
308.	00:13:46	<i>The first one is a backup.</i>
309.	00:13:47	<i>Okay.</i>






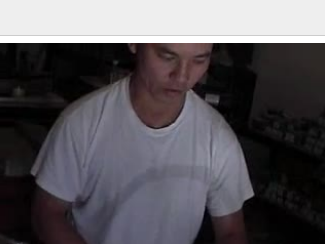



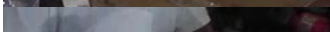





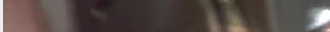
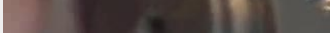
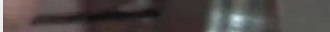
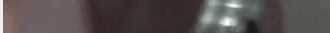

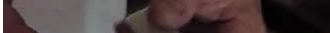











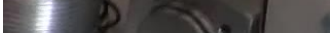







310.	00:13:48	<i>And the o-ring.</i>
311.	00:13:49	<i>Okay.</i>
312.	00:13:50	<i>The backup.</i>
313.	00:13:51	<i>Two backups sandwiched the o-ring.</i>
314.	00:13:52	<i>I see.</i>




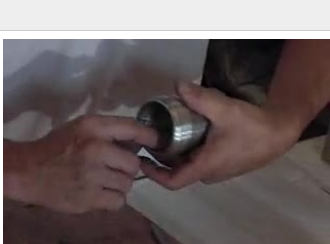


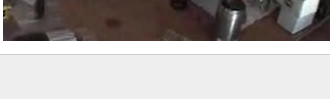


315.	00:13:53	<i>Inside the hole.</i>
316.	00:13:54	<i>So it's a backup o-ring backup.</i>
317.	00:13:56	<i>Very good.</i>
318.	00:13:57	<i>Very good.</i>
319.	00:13:58	<i>If you look carefully.</i>


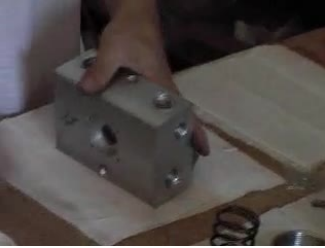





320.	00:13:59	<i>There's a backup right inside first.</i>
321.	00:14:02	<i>The first layer.</i>
322.	00:14:03	<i>That's something new.</i>
323.	00:14:04	<i>That's not on the old valve.</i>








Frame	#	Time	Spoken text
	324.	00:14:05	No.
	325.	00:14:06	The second one is an o-ring.
	326.	00:14:08	Now another backup.
	327.	00:14:10	Yeah.
	328.	00:14:11	Oh, wow, wow, wow.
	329.	00:14:12	Okay.
	330.	00:14:13	And you make sure it goes to the last area where the o-ring is.
	331.	00:14:18	Okay.
	332.	00:14:19	So we make sure there's sandwich.
	333.	00:14:21	Okay.
	334.	00:14:22	Very important.
	335.	00:14:24	There's sandwich.
	336.	00:14:25	I can see.
	337.	00:14:26	And where the scar cut.
	338.	00:14:27	Make sure they go back.
	339.	00:14:28	They come like this at an angle.
	340.	00:14:30	Make sure they go back like that.
	341.	00:14:32	Not flip it over.
	342.	00:14:33	Oh, show it to me on your hands.
	343.	00:14:35	Save it in.
	344.	00:14:36	Okay.
	345.	00:14:37	Oh, ring.
	346.	00:14:38	They cut at an angle like that.
	347.	00:14:40	Make sure when you put it back.
	348.	00:14:42	They go in the same area.
	349.	00:14:44	Okay.
	350.	00:14:45	Not the opposite.
	351.	00:14:46	Then they're cock eye.
	352.	00:14:47	Okay.
	353.	00:14:48	I hope you understand it.
	354.	00:14:49	I don't.
	355.	00:14:50	Okay.
	356.	00:14:51	Okay.
	357.	00:14:52	Now.
	358.	00:14:53	How do you ask you?







Frame	#	Time	Spoken text
	359.	00:14:56	You use a silicone.
	360.	00:14:57	Silicone grease.
	361.	00:14:58	Yeah.
	362.	00:14:59	Okay.
	363.	00:15:00	Make sure you apply silicone grease.
	364.	00:15:03	Okay.
	365.	00:15:05	Doesn't need to be that much.
	366.	00:15:10	All right.
	367.	00:15:13	And apply it a little.
	368.	00:15:15	So when it goes in, it doesn't grab on any sharp edge.
	369.	00:15:20	And it got cut on the o-ring.
	370.	00:15:22	Then it becomes a leakage.
	371.	00:15:25	At this point you might as well apply some.
	372.	00:15:29	Okay.
	373.	00:15:30	So this is prepared.
	374.	00:15:32	And in fact.
	375.	00:15:33	What do you call this piece?
	376.	00:15:35	This one is a mounting block for the motor.
	377.	00:15:37	Okay.
	378.	00:15:38	Mounting block.
	379.	00:15:39	And in fact, when you gather enough o-ring for 10 set.
	380.	00:15:44	Okay.
	381.	00:15:45	Yeah.
	382.	00:15:46	So that in the little part, separate them, pump some oil, put some hydraulic oil that we use
	383.	00:15:51	and wow.
	384.	00:15:52	That will lubricate it.
	385.	00:15:53	That way you can, for sure, you already lubricate it.
	386.	00:15:57	You don't need to put grease.
	387.	00:15:58	Okay.
	388.	00:15:59	Yes.
	389.	00:16:00	I mean, next thing is number 28.
	390.	00:16:04	O-ring.

Frame	#	Time	Spoken text
	391.	00:16:05	<i>Actually, number 32 O-ring.</i>
	392.	00:16:09	<i>Number 32, not 28.</i>
	393.	00:16:11	<i>Not 28.</i>
	394.	00:16:12	32.
	395.	00:16:13	<i>It goes into a hydraulic accumulator piston.</i>
	396.	00:16:18	<i>Mm-hmm.</i>
	397.	00:16:19	<i>Required two of them.</i>
	398.	00:16:20	<i>Make sure this thing is nice and shine.</i>
	399.	00:16:23	<i>Good finish.</i>
	400.	00:16:24	<i>Three of her.</i>
	401.	00:16:25	<i>This is also new.</i>
	402.	00:16:26	<i>Right?</i>
	403.	00:16:27	<i>We didn't have this.</i>
	404.	00:16:28	<i>This is old.</i>
	405.	00:16:29	<i>Yeah.</i>
	406.	00:16:30	<i>Okay.</i>
	407.	00:16:31	<i>All right.</i>
	408.	00:16:32	<i>This one is prepared for the reservoir.</i>
	409.	00:16:34	<i>Right.</i>
	410.	00:16:35	<i>Now, vegetable, make sure the ID, it's clean.</i>
	411.	00:16:40	<i>No burr, low niche.</i>
	412.	00:16:43	<i>Good finish.</i>
	413.	00:16:44	<i>Right.</i>
	414.	00:16:45	<i>When you can run through, your hand can detect a 16 finish.</i>
	415.	00:16:48	<i>It needs a 16th plus finish.</i>
	416.	00:16:50	<i>I mean, a 16 by 8 or 4 or 6 cannot be anything greater than 16.</i>
	417.	00:16:59	<i>Michael.</i>
	418.	00:17:00	<i>That inches.</i>
	419.	00:17:01	<i>Okay.</i>
	420.	00:17:02	<i>We're done with that.</i>
	421.	00:17:04	<i>This is a thing.</i>
	422.	00:17:06	<i>We leave behind.</i>
	423.	00:17:07	<i>Now, we started with this.</i>
	424.	00:17:09	<i>First, we drop check valve in.</i>
	425.	00:17:12	<i>Since we increase our check valve in.</i>

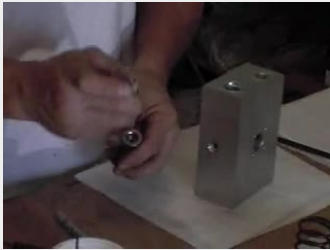
Frame	#	Time	Spoken text
	426.	00:17:16	<i>Since we don't have oil on the O-ring, we apply some grease.</i>
	427.	00:17:20	<i>Okay.</i>
	428.	00:17:21	<i>The ball angle in first.</i>
	429.	00:17:23	<i>You just drop it in.</i>
	430.	00:17:24	<i>Yes.</i>
	431.	00:17:26	<i>Press it in.</i>
	432.	00:17:27	<i>You just feel the sound.</i>
	433.	00:17:29	<i>Yes.</i>
434.	00:17:30	<i>Second one.</i>	
	435.	00:17:32	<i>Apply some grease.</i>
	436.	00:17:36	<i>Drop it in.</i>
	437.	00:17:39	<i>Push.</i>
	438.	00:17:40	<i>I didn't hear the click.</i>
439.	00:17:43	<i>Not yet.</i>	
	440.	00:17:44	<i>I didn't get to push it.</i>
	441.	00:17:46	<i>I need something to push it.</i>
	442.	00:17:49	<i>Thanks.</i>
	443.	00:17:52	<i>I need something to push it in.</i>
444.	00:17:55	<i>Okay.</i>	
	445.	00:17:56	<i>This one got a little harder.</i>
	446.	00:17:58	<i>Hold on.</i>
	447.	00:17:59	<i>You know what I'm thinking.</i>
	448.	00:18:12	<i>You felt that it didn't click.</i>
449.	00:18:13	<i>That's why you avoid.</i>	
	450.	00:18:14	<i>Right?</i>
	451.	00:18:15	<i>Yes.</i>
	452.	00:18:16	<i>After a look, make sure there's not a sharp corner.</i>
	453.	00:18:18	<i>Okay.</i>
454.	00:18:19	<i>Okay.</i>	
	455.	00:18:20	<i>Let's try it again.</i>
	456.	00:18:22	<i>Yes.</i>
	457.	00:18:23	<i>Got it.</i>
	458.	00:18:24	<i>Got it.</i>

Frame	#	Time	Spoken text
	459.	00:18:25	<i>Two more.</i>
	460.	00:18:26	<i>Yeah.</i>
	461.	00:18:27	<i>Same thing.</i>
	462.	00:18:28	<i>Same procedure.</i>
	463.	00:18:29	<i>Okay.</i>
	464.	00:18:30	<i>Great.</i>
	465.	00:18:31	<i>Good.</i>
	466.	00:18:32	<i>All right.</i>
	467.	00:18:33	<i>Okay.</i>
	468.	00:18:34	<i>Next thing.</i>
	469.	00:18:36	<i>Great.</i>
	470.	00:18:44	<i>Good.</i>
	471.	00:18:45	<i>All right.</i>
	472.	00:18:47	<i>Okay.</i>
	473.	00:18:48	<i>Next thing is you clunk everything around.</i>
	474.	00:18:51	<i>No, no, it doesn't go with the tripod.</i>
	475.	00:18:54	<i>Yeah.</i>
	476.	00:18:55	<i>Because I have to adjust all the time when you move it.</i>
	477.	00:18:57	<i>Okay.</i>
	478.	00:18:58	<i>Okay.</i>
	479.	00:18:59	<i>What do you need?</i>
	480.	00:19:00	<i>Teflon tape is tape.</i>
	481.	00:19:07	<i>Teflon tape.</i>
	482.	00:19:09	<i>Teflon tape.</i>
	483.	00:19:10	<i>Okay.</i>
	484.	00:19:11	<i>Teflon tape.</i>
	485.	00:19:12	<i>All the plug.</i>
	486.	00:19:15	<i>Okay.</i>
	487.	00:19:16	<i>These are the plugs on the outside that before we had the leak, right?</i>
	488.	00:19:19	<i>Is that the one?</i>
	489.	00:19:20	<i>So we had the liquid?</i>








Frame	#	Time	Spoken text
	490.	00:19:21	No, that's one of them.
	491.	00:19:22	It's right here in the back.
	492.	00:19:23	Okay.
	493.	00:19:24	But it's a similar one.
	494.	00:19:25	Yeah.
	495.	00:19:26	Yeah.
	496.	00:19:27	It's a similar one.
	497.	00:19:29	This round, we're going to put Teflon tape.
	498.	00:19:32	All the plug.
	499.	00:19:33	I mean, the MPT plug.
	500.	00:19:35	Okay.
	501.	00:19:36	Let me put Teflon tape.
	502.	00:19:37	You can try now.
	503.	00:19:38	The groove is open.
	504.	00:19:40	The tap it deeper.
	505.	00:19:42	So you put six, what do you call six rounds or something?
	506.	00:19:44	Six round Teflon tape.
	507.	00:19:45	Six round Teflon tape.
	508.	00:19:47	Only for this particular part because the tap it a little too deep.
	509.	00:19:52	Uh-huh.
	510.	00:19:53	So this one, six, the other one will be four.
	511.	00:19:55	Four will be fine.
	512.	00:19:56	Now the future blocks we're making, we can make this all the same.
	513.	00:19:59	So they all will be four or something.
	514.	00:20:01	I think this one will be difficult because it's not standard.
	515.	00:20:05	Okay.
	516.	00:20:06	You need to go all the way, otherwise you cannot mount it against the hydraulic cylinder.
	517.	00:20:10	Okay.
	518.	00:20:11	It's in the drawing, right?
	519.	00:20:12	Yes.
	520.	00:20:13	So Jerry, you know this particular thing.
	521.	00:20:15	Yes.
	522.	00:20:16	The next time if you tap regular tap, if you buy this, you don't need to go deeper.
	523.	00:20:21	You buy this, but that will be fine.
	524.	00:20:25	So what it costs, another 10 cents, 50 cents more.








Frame	#	Time	Spoken text
	525.	00:20:28	<i>You don't have a headache.</i>
	526.	00:20:35	<i>You know this is shorter, right?</i>
	527.	00:20:36	<i>This plug?</i>
	528.	00:20:37	<i>Oh, yeah.</i>
	529.	00:20:38	<i>The hydraulic.</i>
	530.	00:20:39	<i>Yeah.</i>
	531.	00:20:40	<i>That's shorter.</i>
	532.	00:20:46	<i>So I'm going to say it.</i>
	533.	00:20:47	<i>We need tape on all the MP3, which means the tape.</i>
	534.	00:20:50	<i>MP3.</i>
	535.	00:20:52	<i>Because it's tapered down and the one which are straight, we don't.</i>
	536.	00:20:55	<i>But what?</i>
	537.	00:20:56	<i>Pipe thread.</i>
	538.	00:20:57	<i>They call it pipe thread.</i>
	539.	00:20:58	<i>Pipe thread.</i>
	540.	00:20:59	<i>If we put it on the straight one, it's not going to hurt.</i>
	541.	00:21:00	<i>No, not good.</i>
	542.	00:21:01	<i>Not good.</i>
	543.	00:21:02	<i>I see.</i>
	544.	00:21:03	<i>Okay.</i>
	545.	00:21:04	<i>Don't put it on the straight one.</i>
	546.	00:21:05	<i>Okay.</i>
	547.	00:21:06	<i>Go to engineering school.</i>
	548.	00:21:08	<i>But you missed me there.</i>
	549.	00:21:17	<i>Yeah.</i>
	550.	00:21:18	<i>Okay.</i>
	551.	00:21:19	<i>I see the elbow.</i>
	552.	00:21:22	<i>The elbow is necessary for the transducer here.</i>
	553.	00:21:25	<i>Yeah.</i>
	554.	00:21:26	<i>Pressure.</i>
	555.	00:21:27	<i>Pressure.</i>
	556.	00:21:28	<i>Otherwise the pressure transducer will be sticking out.</i>
	557.	00:21:30	<i>Okay.</i>







Frame










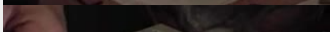


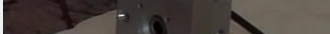
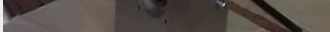

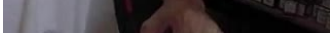

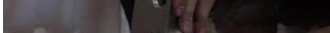



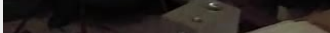









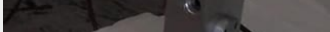







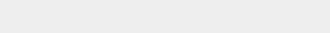
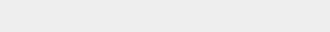
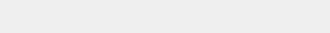
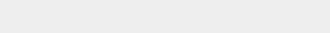
#	Time	Spoken text
558.	00:21:31	Yeah.
559.	00:21:32	Okay.
560.	00:21:33	This thing.
561.	00:21:34	Okay.
562.	00:21:36	Okay.
563.	00:21:37	Next step.
564.	00:21:38	Okay.
565.	00:21:39	Put it in the sleeve.
566.	00:21:41	Take out the spool, but very careful.
567.	00:21:44	Put it in the clean area.
568.	00:21:46	Don't drop.
569.	00:21:47	Don't do anything to it.
570.	00:21:49	And don't mix it with any other because they are hung and lapped to fit in pair.
571.	00:21:54	The main part.
572.	00:21:56	Okay.
573.	00:21:57	Oh, oh.
574.	00:21:58	So each spool going with particular sleeve.
575.	00:22:00	Yes.
576.	00:22:01	You cannot mix them up.
577.	00:22:02	Yeah.
578.	00:22:03	Don't mix them up.
579.	00:22:04	Wow.
580.	00:22:05	Okay.
581.	00:22:06	Now that one has no o-ring with the groove.
582.	00:22:08	Yes.
583.	00:22:09	Please in this point.
584.	00:22:10	Going down.
585.	00:22:11	Shake it a little.
586.	00:22:12	I understand.
587.	00:22:13	That's the confusion that was the one that he said no o-rings.
588.	00:22:16	Mm-hmm.
589.	00:22:17	Was interpreted as no o-rings on the whole thing.
590.	00:22:20	Yeah.
591.	00:22:21	Is that possible?

Frame	#	Time	Spoken text
	592.	00:22:22	Yes.
	593.	00:22:23	Next time when you say no o-rings.
	594.	00:22:26	Stay there in the fur.
	595.	00:22:27	Thomas said no o-rings, but don't forget the other two o-rings.
	596.	00:22:31	Okay.
	597.	00:22:32	I'm going to get some purpose for the tape.
	598.	00:22:34	You can put it together.
	599.	00:22:35	Okay.
	600.	00:22:36	Want to clean it?
	601.	00:22:37	It's a little.
	602.	00:22:39	Oh, it's a little dirt or something?
	603.	00:22:45	A piece of metal.
	604.	00:22:53	No kidding.
	605.	00:22:54	Yeah.
	606.	00:22:55	A small one can give you a hard time to push it in.
	607.	00:22:57	Then you should not use it for your pain.
	608.	00:22:59	Also it can make it stuck later on.
	609.	00:23:01	Yeah.
	610.	00:23:02	So how you push it one minute, let me see.
	611.	00:23:07	Just with your fingers.
	612.	00:23:09	Mm-hmm.
	613.	00:23:10	Is it pushed already all the way?
	614.	00:23:12	No.
	615.	00:23:13	No.
	616.	00:23:14	Not yet.
	617.	00:23:15	Trying to.
	618.	00:23:16	Something is not straight.
	619.	00:23:19	Give me one minute.
	620.	00:23:23	Okay.
	621.	00:23:24	Okay.
	622.	00:23:25	Okay.
	623.	00:23:26	Your run now is too great.
	624.	00:23:27	Huh?
	625.	00:23:28	Someone run now is too great.
	626.	00:23:30	The orange is too big?
627.	00:23:32	No, no, no.	

Frame	#	Time	Spoken text
	628.	00:23:33	The OD of the school or the parties, there's a run now is too great.
	629.	00:23:41	I can get it too.
	630.	00:23:43	Okay.
	631.	00:23:44	Oh, we got it.
	632.	00:23:45	Okay.
	633.	00:23:46	In fact, it's good.
	634.	00:23:47	It wasn't a bit tough.
	635.	00:23:48	Right.
	636.	00:23:49	Now, it goes through this one.
	637.	00:23:51	Yes.
	638.	00:23:52	It's about flush.
	639.	00:23:53	It's okay.
	640.	00:23:54	Yes.
	641.	00:23:55	Okay.
	642.	00:23:56	This side is flush.
	643.	00:23:57	Yes.
	644.	00:23:58	With the school.
	645.	00:23:59	Okay.
	646.	00:24:00	Now flip it all over.
	647.	00:24:01	Stand them up.
	648.	00:24:02	It's stick out on the other side.
	649.	00:24:03	Yeah.
	650.	00:24:04	Stick out.
	651.	00:24:05	This one.
	652.	00:24:06	No. 18.
	653.	00:24:07	Or ring.
	654.	00:24:08	Yes.
	655.	00:24:09	Wrap around it.
	656.	00:24:10	Whoa.
	657.	00:24:11	That's new.
	658.	00:24:12	Okay.
	659.	00:24:13	That's important.

Frame	#	Time	Spoken text
	660.	00:24:15	<i>This is important.</i>
	661.	00:24:17	<i>Yeah.</i>
	662.	00:24:18	<i>You forgot that one too?</i>
	663.	00:24:20	<i>Okay.</i>
	664.	00:24:21	<i>Say what it is.</i>
	665.	00:24:22	<i>Wrap around this sleeve.</i>
	666.	00:24:25	<i>Now the bottom cap.</i>
	667.	00:24:28	<i>This.</i>
	668.	00:24:29	<i>One minute.</i>
	669.	00:24:30	<i>I have to see.</i>
	670.	00:24:31	<i>All the washer.</i>
	671.	00:24:32	<i>Okay.</i>
	672.	00:24:33	<i>Okay.</i>
	673.	00:24:34	<i>Yeah.</i>
	674.	00:24:35	<i>Yeah.</i>
	675.	00:24:36	<i>Facing going in.</i>
	676.	00:24:37	<i>Okay.</i>
	677.	00:24:38	<i>Facing going in.</i>
	678.	00:24:41	<i>What is that means?</i>
	679.	00:24:43	<i>Okay.</i>
	680.	00:24:44	<i>Or concave in.</i>
	681.	00:24:45	<i>Okay.</i>
	682.	00:24:46	<i>Okay.</i>
	683.	00:24:47	<i>In.</i>
	684.	00:24:48	<i>The center.</i>
	685.	00:24:49	<i>Okay.</i>
	686.	00:24:50	<i>In.</i>
	687.	00:24:51	<i>Go in.</i>
	688.	00:24:52	<i>Okay.</i>
	689.	00:24:53	<i>I see.</i>
	690.	00:24:55	<i>Now.</i>
	691.	00:24:56	<i>Just.</i>

Frame	#	Time	Spoken text
	692.	00:24:57	Line them up.
	693.	00:24:59	Oh, I put that.
	694.	00:25:00	You know I put it in the inside of the part first.
	695.	00:25:02	Oh, it doesn't matter.
	696.	00:25:04	Oh.
	697.	00:25:05	Hey.
	698.	00:25:06	It doesn't matter.
	699.	00:25:07	Okay.
	700.	00:25:08	Now we're going to screw it in.
	701.	00:25:10	Yep.
	702.	00:25:15	This is number 1024 half inch socket set screw.
	703.	00:25:20	I mean socket screw.
	704.	00:25:23	Okay.
	705.	00:25:24	Using the wrench 532nd wrench.
	706.	00:25:26	Go in.
	707.	00:25:27	Give it a little.
	708.	00:25:28	1024.
	709.	00:25:29	1024.
	710.	00:25:30	Half inch.
	711.	00:25:31	Half inch.
	712.	00:25:32	Give it a little twist.
	713.	00:25:37	Okay.
	714.	00:25:44	Okay.
	715.	00:25:45	What is now, Thomas?
	716.	00:25:47	Put in the.
	717.	00:25:50	The next thing plucking it.
	718.	00:25:52	Plucking it.
	719.	00:25:53	What is plucking?
	720.	00:25:54	Plucking.
	721.	00:25:55	Plucking.
	722.	00:25:56	Plucking.
	723.	00:25:57	Okay.

Frame	#	Time	Spoken text
	724.	00:25:58	You said plucking.
	725.	00:25:59	I don't know.
	726.	00:26:00	That's Chinese for me.
	727.	00:26:01	Pluck.
	728.	00:26:02	You do plucking.
	729.	00:26:03	Okay.
	730.	00:26:04	Now.
	731.	00:26:05	Okay.
	732.	00:26:06	It's better than Hebrew.
	733.	00:26:07	Don't get insulted.
	734.	00:26:08	No.
	735.	00:26:09	Let's do a drop.
	736.	00:26:11	It's better than the holy language.
	737.	00:26:13	Okay.
	738.	00:26:14	Hold on.
	739.	00:26:15	I have all the dust like here.
	740.	00:26:16	I took cleaning.
	741.	00:26:19	A check valve plug is this tight.
	742.	00:26:21	Okay.
	743.	00:26:28	Okay.
	744.	00:26:29	The check valve plug is.
	745.	00:26:31	What type?
	746.	00:26:32	What's the name?
	747.	00:26:33	A brass.
	748.	00:26:34	It's a metal.
	749.	00:26:36	They call it a brass fitting.
	750.	00:26:39	Three quarter inch.
	751.	00:26:41	Pass fitting.
	752.	00:26:42	A check valve only.
	753.	00:26:44	Yeah.
	754.	00:26:45	Check valve.
	755.	00:26:46	Choose two of them.
	756.	00:26:48	And the front face.
	757.	00:26:49	I mean on this face.
	758.	00:26:50	Okay.



#	Time	Spoken text
759.	00:26:51	<i>This one.</i>
760.	00:26:52	<i>It just pull it.</i>
761.	00:26:53	<i>It will stop because it's metal to metal.</i>
762.	00:26:54	<i>You can not go further.</i>
763.	00:26:55	<i>Even if you break your hand it will not go further.</i>
764.	00:26:56	<i>You can strip it.</i>



765.	00:26:57	<i>This one.</i>
766.	00:26:58	<i>Please.</i>
767.	00:26:59	<i>It's important to put grease all the time.</i>
768.	00:27:00	<i>For me it's it.</i>
769.	00:27:01	<i>Because if I can avoid stripping.</i>



770.	00:27:02	<i>I see.</i>
771.	00:27:03	<i>I can avoid a lot of other misunforter.</i>
772.	00:27:07	<i>All right.</i>
773.	00:27:10	<i>Now.</i>
774.	00:27:11	<i>What is all that stuff?</i>








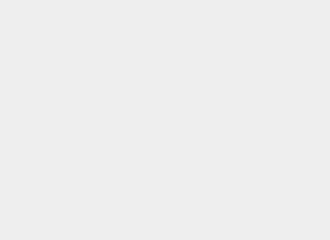
775.	00:27:15	<i>It's important to put grease all the time.</i>
776.	00:27:17	<i>I can avoid stripping.</i>
777.	00:27:18	<i>I can avoid a lot of others.</i>
778.	00:27:20	<i>Misunforter.</i>
779.	00:27:23	<i>All right.</i>



780.	00:27:30	<i>Now.</i>
781.	00:27:31	<i>Now.</i>
782.	00:27:32	<i>Plug this hole.</i>
783.	00:27:37	<i>And.</i>
784.	00:27:43	<i>Put this hole.</i>



785.	00:27:44	<i>Now.</i>
786.	00:27:45	<i>This hole.</i>
787.	00:27:46	<i>What?</i>
788.	00:27:47	<i>This hole.</i>

Frame	#	Time	Spoken text
	789.	00:27:48	<i>We just use a regular MPT.</i>
	790.	00:27:49	<i>We'll be fine.</i>
	791.	00:27:50	<i>Regular MPT.</i>
	792.	00:27:51	<i>Regular MPT.</i>
	793.	00:27:52	<i>We'll be fine.</i>
	794.	00:27:53	<i>What happened in this hole?</i>
	795.	00:27:54	<i>Why this hole exist?</i>
	796.	00:27:55	<i>This hole is to drill the hole as a passage.</i>
	797.	00:27:59	<i>After you drill the hole, you have to plug it.</i>
	798.	00:28:01	<i>It creates a passage.</i>
	799.	00:28:02	<i>Okay.</i>
	800.	00:28:03	<i>Connect the valve.</i>
	801.	00:28:04	<i>This tube valve together to center where the outlet is.</i>
	802.	00:28:06	<i>I see.</i>
	803.	00:28:07	<i>Okay.</i>
	804.	00:28:08	<i>Turn it.</i>
	805.	00:28:16	<i>This one, you might want to put somewhere around 68.</i>
	806.	00:28:20	<i>62 to 68.</i>
	807.	00:28:22	<i>Each panel.</i>
	808.	00:28:24	<i>An inch mark.</i>
	809.	00:28:26	<i>You have a transducer in your muscle?</i>
	810.	00:28:31	<i>Okay.</i>
	811.	00:28:32	<i>The next.</i>
	812.	00:28:33	<i>This one.</i>
	813.	00:28:34	<i>This side.</i>
	814.	00:28:35	<i>Okay.</i>
	815.	00:28:39	<i>This fitting.</i>
	816.	00:28:40	<i>You use up the.</i>
	817.	00:28:42	<i>Oh, yeah.</i>
	818.	00:28:43	<i>Get another one.</i>



#	Time	Spoken text
819.	00:28:44	Yeah.
820.	00:28:45	If you use up, you have to buy at oils.
821.	00:28:46	You have to fit and end it up without.
822.	00:28:48	You know what happened?
823.	00:28:49	That was what I was saying.
824.	00:28:50	I didn't know that you could use them again.



825.	00:28:53	Yeah.
826.	00:28:54	I don't use that again.
827.	00:28:55	As long as you use the same tube.
828.	00:28:57	Okay.
829.	00:28:58	Now, that's on top of the other shack valves up and down.



830.	00:29:02	Where's the nut?
831.	00:29:03	At least you have to get a whole new assembly.
832.	00:29:07	Okay.
833.	00:29:08	But anyway, get whatever.
834.	00:29:10	Put it that way.




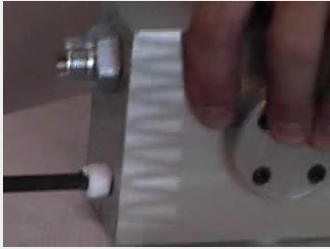




835.	00:29:13	Okay.
836.	00:29:15	This one, let me get the wrench.
837.	00:29:18	Because the metal to metal, it will not go anywhere.
838.	00:29:23	It's already sealed anyway.
839.	00:29:25	So it was sealed.











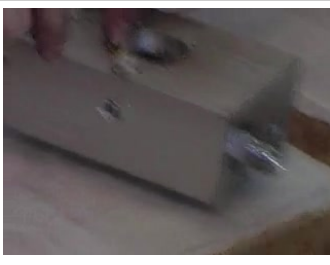

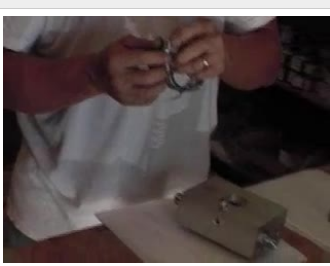
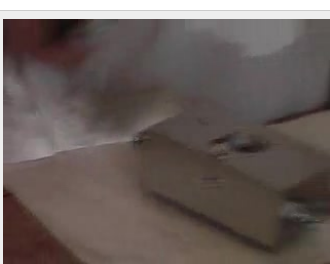

840.	00:29:27	All right.
841.	00:29:30	Now, this end, I believe is.
842.	00:29:33	So now you have the shack valves in.
843.	00:29:35	You have the spooler in.
844.	00:29:36	You have the sleeve in.







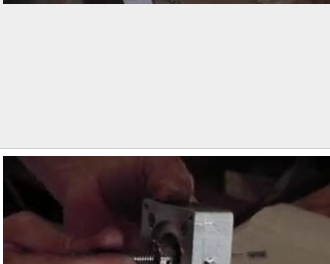


845.	00:29:37	It's almost there.
846.	00:29:39	Okay.
847.	00:29:40	Actually, the spooler you don't have yet.
848.	00:29:42	I mean, the.








Frame	#	Time	Spoken text
	849.	00:29:43	<i>The school you don't have yet.</i>
	850.	00:29:45	<i>This is so good.</i>
	851.	00:29:46	<i>All right.</i>
	852.	00:29:47	<i>You too.</i>
	853.	00:29:48	<i>Let's do it.</i>
	854.	00:29:49	<i>And quickly and continue with it.</i>
	855.	00:29:51	<i>That's the one on the bottom, huh?</i>
	856.	00:29:53	<i>Yeah.</i>
	857.	00:29:54	<i>This is on the bottom side.</i>
	858.	00:29:56	<i>These are all tapered, the screws, huh?</i>
	859.	00:29:59	<i>Yeah.</i>
	860.	00:30:00	<i>That's why you put.</i>
	861.	00:30:01	<i>You have a fun tape?</i>
	862.	00:30:05	<i>Yeah.</i>
	863.	00:30:06	<i>Yeah.</i>
	864.	00:30:07	<i>Yeah.</i>
	865.	00:30:08	<i>That's loaded on top of that.</i>
	866.	00:30:16	<i>It's loaded on top of the other shack valve.</i>
	867.	00:30:20	<i>Mm-hmm.</i>
	868.	00:30:47	<i>All right.</i>
	869.	00:30:49	<i>Now, bump up this face.</i>
	870.	00:30:51	<i>Ready on this face?</i>
	871.	00:30:53	<i>Now, this face.</i>
	872.	00:30:55	<i>This one is a hydraulic plug that's shorter.</i>
	873.	00:30:59	<i>Okay.</i>
	874.	00:31:00	<i>Hydraulic valve and shorter on this side.</i>
	875.	00:31:02	<i>Hydraulic plug.</i>
	876.	00:31:03	<i>Yeah.</i>
	877.	00:31:04	<i>Yeah, high pressure.</i>
	878.	00:31:05	<i>This MPT plug is shorter.</i>
	879.	00:31:08	<i>Mm-hmm.</i>
	880.	00:31:09	<i>Okay.</i>








Frame	#	Time	Spoken text
	881.	00:31:10	<i>That's because this hood one is going against.</i>
	882.	00:31:12	<i>Yeah.</i>
	883.	00:31:13	<i>Put six to eight round of tough one tape.</i>
	884.	00:31:17	<i>And this one, you have to turn until the plug flush bottom.</i>
	885.	00:31:23	<i>All right.</i>
	886.	00:31:24	<i>Cannot fit into.</i>
	887.	00:31:31	<i>One second, I have to record.</i>
	888.	00:31:33	<i>Okay.</i>
	889.	00:31:34	<i>What is next?</i>
	890.	00:31:35	<i>The top of it.</i>
	891.	00:31:36	<i>Now, this face, it's prepared.</i>
	892.	00:31:38	<i>This one, you leave it next because you put the,</i>
	893.	00:31:41	<i>the accumulator into this hole.</i>
	894.	00:31:44	<i>Yes.</i>
	895.	00:31:45	<i>So, this one done, prepare.</i>
	896.	00:31:46	<i>This one done, done, prepare.</i>
	897.	00:31:48	<i>This one is finished preparing.</i>
	898.	00:31:49	<i>This one is finished.</i>
	899.	00:31:51	<i>Okay.</i>
	900.	00:31:52	<i>This one is finished.</i>
	901.	00:31:53	<i>Now, this face.</i>
	902.	00:31:54	<i>That's the most important one.</i>
	903.	00:31:55	<i>Okay.</i>
	904.	00:31:56	<i>Nipple.</i>
	905.	00:31:57	<i>Mm-hmm.</i>
	906.	00:31:58	<i>Not like a woman.</i>
	907.	00:32:00	<i>This one has two sides.</i>
	908.	00:32:01	<i>For me, it's the same.</i>
	909.	00:32:04	<i>Oh.</i>
	910.	00:32:09	<i>All right.</i>
	911.	00:32:10	<i>Seven, six, ten.</i>
	912.	00:32:17	<i>There you go.</i>







Frame	#	Time	Spoken text
	913.	00:32:24	Okay.
	914.	00:32:25	Now, put this nipple in.
	915.	00:32:28	I'm not going to tie it because you have to put in your elbow.
	916.	00:32:31	Otherwise, it's different over here than your elbow.
	917.	00:32:34	You tie this with an elbow.
	918.	00:32:36	The elbow is the one that Jerry showed him.
	919.	00:32:39	Yes.
	920.	00:32:40	You already are.
	921.	00:32:41	That's for the pressure that we do so.
	922.	00:32:42	Uh-huh.
	923.	00:32:43	Now, with the transducer, I'm not going to put this,
	924.	00:32:50	because this one I can show you.
	925.	00:32:52	You don't have to put one.
	926.	00:32:53	Okay.
	927.	00:32:54	Put teflon tape over here.
	928.	00:32:56	Okay.
	929.	00:32:57	Teflon tape over this thing.
	930.	00:33:01	Make sure you put teflon tape, because this one is a 17-4 stainless steel.
	931.	00:33:06	Plus, all the high pressure is there.
	932.	00:33:08	Yeah.
	933.	00:33:09	Uh-huh.
	934.	00:33:10	So, make sure you have teflon tape around four rounds is good enough.
	935.	00:33:14	Okay.
	936.	00:33:16	And this one ties into this high pressure fitting.
	937.	00:33:20	Okay.
	938.	00:33:21	For adapter.
	939.	00:33:22	And then you have an elbow.
	940.	00:33:24	Yeah.
	941.	00:33:26	Call it inch amputee.
	942.	00:33:27	Uh-huh.
	943.	00:33:28	So, one eighth amputee.
	944.	00:33:30	There is a female female elbow.
	945.	00:33:32	You tie this into this tight.
	946.	00:33:36	Make sure don't grab on any of this.
	947.	00:33:38	Use a wrench to grab on this hex flash service.
	948.	00:33:42	And this hex flash service to tighten it.

Frame	#	Time	Spoken text
	949.	00:33:45	<i>Let me show you.</i>
	950.	00:33:47	<i>Okay.</i>
	951.	00:33:49	<i>Okay.</i>
	952.	00:33:56	<i>Don't use a vise to grab on this thing.</i>
	953.	00:34:02	<i>Of course.</i>
	954.	00:34:03	<i>Okay.</i>
	955.	00:34:04	<i>Use a vise to grab on the fitting, not the transducer.</i>
	956.	00:34:08	<i>No, I haven't.</i>
	957.	00:34:10	<i>And you have this.</i>
	958.	00:34:11	<i>Okay.</i>
	959.	00:34:12	<i>Yeah.</i>
	960.	00:34:13	<i>Now, next step.</i>
	961.	00:34:14	<i>Talk again about the elbow.</i>
	962.	00:34:15	<i>I lost it on the other thing.</i>
	963.	00:34:16	<i>Okay.</i>
	964.	00:34:17	<i>Make sure this.</i>
	965.	00:34:18	<i>Mound into the elbow first before you're down in this.</i>
	966.	00:34:20	<i>Yes.</i>
	967.	00:34:21	<i>Once you're down in the butt, make sure it's tight.</i>
	968.	00:34:23	<i>Yes.</i>
	969.	00:34:24	<i>Yes.</i>
	970.	00:34:25	<i>This one.</i>
	971.	00:34:26	<i>Don't go too tight.</i>
	972.	00:34:27	<i>It's only a quarter inch.</i>
	973.	00:34:28	<i>I mean, one eighth amputee.</i>
	974.	00:34:29	<i>Yes.</i>
	975.	00:34:30	<i>As soon as you see the hex right here.</i>
	976.	00:34:32	<i>Yes.</i>
	977.	00:34:33	<i>It's not touching.</i>
	978.	00:34:34	<i>It should be good enough.</i>
	979.	00:34:35	<i>Okay.</i>
	980.	00:34:36	<i>A quarter turn have a turn should be enough.</i>
	981.	00:34:38	<i>Okay.</i>
	982.	00:34:39	<i>Because the one eighth amputee is only take like around 28 to 32 inch pound.</i>

Frame	#	Time	Spoken text
	983.	00:34:43	Okay.
	984.	00:34:44	Same thing right here.
	985.	00:34:45	Tight it in.
	986.	00:34:46	Then that will be it.
	987.	00:34:48	Now, next step.
	988.	00:34:50	Important step.
	989.	00:34:51	Very important.
	990.	00:34:52	After this, prepare.
	991.	00:34:54	All right.
	992.	00:34:55	This, prepare.
	993.	00:34:56	Be careful.
	994.	00:34:57	Try to avoid touching the grease on this.
	995.	00:35:00	Because you're going to apply a lock tight with grease if it doesn't feel good.
	996.	00:35:05	Make sure you clear the center where there's no grease.
	997.	00:35:10	Before you insert in, pay attention.
	998.	00:35:12	This hole facing this port so it can be served in the future.
	999.	00:35:18	So, insert in carefully through the center.
	1000.	00:35:23	Okay.
	1001.	00:35:24	Mmm.
	1002.	00:35:25	Okay.
	1003.	00:35:26	Two little hole match it.
	1004.	00:35:28	Mmm.
	1005.	00:35:29	What else?
	1006.	00:35:30	Yes.
	1007.	00:35:31	Right here.
	1008.	00:35:32	All the grease.
	1009.	00:35:33	Wipe it off.
	1010.	00:35:34	Apply the back around.
	1011.	00:35:36	Okay.
	1012.	00:35:37	I'm not going to put the.
	1013.	00:35:42	I'm not going to put the.
	1014.	00:35:45	Spoon.

Frame	#	Time	Spoken text
	1015.	00:35:46	<i>No.</i>
	1016.	00:35:47	<i>A lot tight.</i>
	1017.	00:35:48	<i>So, you can see.</i>
	1018.	00:35:49	<i>I can do it twice.</i>
	1019.	00:35:50	<i>So, you can see how this.</i>
	1020.	00:35:52	<i>After you put this.</i>
	1021.	00:35:54	<i>Everything nice and clean.</i>
	1022.	00:35:56	<i>No dust.</i>
	1023.	00:35:57	<i>You screw this in.</i>
	1024.	00:35:59	<i>The through hole.</i>
	1025.	00:36:01	<i>Go in.</i>
	1026.	00:36:02	<i>It's crucial.</i>
	1027.	00:36:03	<i>How far do you go?</i>
	1028.	00:36:04	<i>Okay.</i>
	1029.	00:36:06	<i>I can tell the thread is not pulling right.</i>
	1030.	00:36:09	<i>It's full thread.</i>
	1031.	00:36:10	<i>It's like this.</i>
	1032.	00:36:11	<i>You need a queen.</i>
	1033.	00:36:12	<i>Yeah.</i>
	1034.	00:36:13	<i>You need to buy extra long.</i>
	1035.	00:36:16	<i>Yeah.</i>
	1036.	00:36:26	<i>Okay.</i>
	1037.	00:36:27	<i>So, it's very important that something will be very clean.</i>
	1038.	00:36:29	<i>In the future, never do this process last.</i>
	1039.	00:36:34	<i>Because whatever.</i>
	1040.	00:36:36	<i>If this.</i>
	1041.	00:36:37	<i>Banding.</i>
	1042.	00:36:38	<i>Two ten of a thousand.</i>
	1043.	00:36:40	<i>Your history.</i>
	1044.	00:36:41	<i>Because the clearing area is only two ten of a thousand.</i>
	1045.	00:36:44	<i>Yeah.</i>
	1046.	00:36:45	<i>Okay.</i>
	1047.	00:36:46	<i>Never.</i>
	1048.	00:36:47	<i>Grab on this with a plier.</i>
	1049.	00:36:49	<i>You grab by your hand.</i>

Frame	#	Time	Spoken text
	1050.	00:36:50	<i>That's why you need a longer one in order to clean it.</i>
	1051.	00:36:52	<i>Yeah.</i>
	1052.	00:36:53	<i>Good.</i>
	1053.	00:36:54	<i>Okay.</i>
	1054.	00:36:55	<i>Now, next process.</i>
	1055.	00:36:56	<i>Okay.</i>
	1056.	00:36:57	<i>Yes.</i>
	1057.	00:36:58	<i>In this case, I don't sew lock tight.</i>
	1058.	00:36:59	<i>In the future case, once you're comfortable,</i>
	1059.	00:37:01	<i>you put one job of lock tight about the center.</i>
	1060.	00:37:04	<i>Not right here.</i>
	1061.	00:37:05	<i>Not at the end.</i>
	1062.	00:37:06	<i>About the center.</i>
	1063.	00:37:07	<i>Okay.</i>
	1064.	00:37:08	<i>Now, the end.</i>
	1065.	00:37:10	<i>Long.</i>
	1066.	00:37:11	<i>Flange.</i>
	1067.	00:37:12	<i>Move first.</i>
	1068.	00:37:13	<i>Doesn't have thread.</i>
	1069.	00:37:15	<i>We go further in.</i>
	1070.	00:37:17	<i>And turn.</i>
	1071.	00:37:18	<i>Yeah.</i>
	1072.	00:37:19	<i>I remember that.</i>
	1073.	00:37:20	<i>But how far it.</i>
	1074.	00:37:21	<i>No.</i>
	1075.	00:37:22	<i>I'm going to tell you.</i>
	1076.	00:37:23	<i>You need to add your measurement.</i>
	1077.	00:37:25	<i>Okay.</i>
	1078.	00:37:26	<i>Yes.</i>
	1079.	00:37:28	<i>Okay.</i>
	1080.	00:37:29	<i>Yes.</i>
	1081.	00:37:30	<i>You see?</i>
	1082.	00:37:31	<i>You can see that set screw.</i>
	1083.	00:37:34	<i>Only one thread away.</i>
	1084.	00:37:36	<i>Yes.</i>
	1085.	00:37:37	<i>At that point, you can stop.</i>

Frame	#	Time	Spoken text
	1086.	00:37:39	<i>In this case, that last thread, it got stuck.</i>
	1087.	00:37:44	<i>Yeah.</i>
	1088.	00:37:45	<i>But it's okay.</i>
	1089.	00:37:47	<i>Now.</i>
	1090.	00:37:48	<i>So that's how you're going all the way.</i>
	1091.	00:37:50	<i>All the way.</i>
	1092.	00:37:51	<i>Okay.</i>
	1093.	00:37:52	<i>With my valve, the old one, you didn't go all the way.</i>
	1094.	00:37:55	<i>I'll tell you.</i>
	1095.	00:37:56	<i>I knew what happened.</i>
	1096.	00:37:57	<i>That's very important.</i>
	1097.	00:37:58	<i>Okay.</i>
	1098.	00:37:59	<i>This step, put in this screw should do it right after this step.</i>
	1099.	00:38:03	<i>This is not crucial.</i>
	1100.	00:38:05	<i>Okay.</i>
	1101.	00:38:06	<i>So I'm going to take it back out in the future.</i>
	1102.	00:38:09	<i>Put in the screw into the body after this step.</i>
	1103.	00:38:13	<i>I see.</i>
	1104.	00:38:14	<i>Okay.</i>
	1105.	00:38:15	<i>Because we need to use the same screw to measure the gap that is opening.</i>
	1106.	00:38:20	<i>Yes.</i>
	1107.	00:38:21	<i>I'll tell you when.</i>
	1108.	00:38:22	<i>All right.</i>
	1109.	00:38:23	<i>Triangle.</i>
	1110.	00:38:24	<i>Okay.</i>
	1111.	00:38:26	<i>Hold this thing with your finger.</i>
	1112.	00:38:28	<i>Push it all the way down.</i>
	1113.	00:38:30	<i>Okay.</i>
	1114.	00:38:31	<i>Now.</i>
	1115.	00:38:32	<i>Let me put some grease.</i>
	1116.	00:38:33	<i>I know that's dried up already.</i>
	1117.	00:38:35	<i>Add some oil, not grease.</i>



#	Time	Spoken text
1118.	00:38:37	<i>Next in the future, put some oil.</i>
1119.	00:38:39	<i>Grease is too thick for the valve.</i>
1120.	00:38:41	<i>In this case, I put a very thin layer.</i>
1121.	00:38:44	<i>Okay.</i>
1122.	00:38:46	<i>Okay.</i>
1123.	00:38:53	<i>Now, with your finger, push this all the way.</i>
1124.	00:39:01	<i>Hold on to it.</i>



1125.	00:39:03	<i>And you push all the way in.</i>
1126.	00:39:05	<i>You see the valve is too fine.</i>
1127.	00:39:08	<i>Close.</i>
1128.	00:39:09	<i>You can buy.</i>
1129.	00:39:10	<i>Does it lock?</i>



1130.	00:39:11	<i>This is open.</i>
1131.	00:39:12	<i>You see the gap?</i>
1132.	00:39:13	<i>It closed the triangle 100%.</i>
1133.	00:39:15	<i>Yeah.</i>
1134.	00:39:16	<i>If you push all the way, this is too far in.</i>










1135.	00:39:18	<i>Yeah.</i>
1136.	00:39:19	<i>It's too far in the face.</i>
1137.	00:39:21	<i>Yeah.</i>
1138.	00:39:22	<i>No, sticking out of the face is fine.</i>
1139.	00:39:24	<i>It doesn't leak.</i>








1140.	00:39:25	<i>But this is too far in.</i>
1141.	00:39:26	<i>But they work.</i>
1142.	00:39:27	<i>If it's too far in.</i>
1143.	00:39:28	<i>I'm sorry.</i>
1144.	00:39:29	<i>No, no.</i>



1145.	00:39:30	<i>I'm good.</i>
1146.	00:39:31	<i>They give a problem of the step to close it is too long.</i>
1147.	00:39:36	<i>And if you put this in this case like this, it will take 500 steps in order to close.</i>
1148.	00:39:41	<i>Right.</i>
1149.	00:39:42	<i>We cannot go over 450.</i>

Frame	#	Time	Spoken text
	1150.	00:39:43	Yeah.
	1151.	00:39:44	So you don't want to do it.
	1152.	00:39:45	Now with this case, now what you can do at this point, you adjust it from here.
	1153.	00:39:51	Oh, I see.
	1154.	00:39:53	You are for sure doing what you need to do.
	1155.	00:39:56	Okay.
	1156.	00:39:57	Move with the hand a little bit so I can take a picture of them.
	1157.	00:40:00	Okay.
	1158.	00:40:01	So now you adjust it from the other end.
	1159.	00:40:03	Yes.
	1160.	00:40:04	You're churning it.
	1161.	00:40:07	Very nice.
	1162.	00:40:08	It's hard to churn because the last thread, the last thread is almost churning now.
	1163.	00:40:13	Wait.
	1164.	00:40:14	Hold on.
	1165.	00:40:15	There's a little scooter.
	1166.	00:40:16	When you're churning this.
	1167.	00:40:18	You bring the piston out.
	1168.	00:40:20	You put, but it's stuck.
	1169.	00:40:22	The last thread has problem.
	1170.	00:40:25	Let me do it.
	1171.	00:40:26	I know how to do it.
	1172.	00:40:27	You have a Q-tips?
	1173.	00:40:29	I think it's a burr.
	1174.	00:40:31	No.
	1175.	00:40:32	Let me see.
	1176.	00:40:33	Okay.
	1177.	00:40:35	Okay.
	1178.	00:40:40	I'm back and I'll let you clean.
	1179.	00:40:42	Okay.
	1180.	00:40:43	I'm ready.
	1181.	00:40:44	Go.
	1182.	00:40:45	Okay.
	1183.	00:40:46	Explain what you're doing.

Frame	#	Time	Spoken text
	1184.	00:40:47	<i>Try and put back the spool in.</i>
	1185.	00:40:50	<i>Yes.</i>
	1186.	00:40:55	<i>Earlier we can see there was a big gap.</i>
	1187.	00:40:59	<i>It's still stuck right there.</i>
	1188.	00:41:04	<i>It's okay.</i>
	1189.	00:41:05	<i>Now you can turn it.</i>
	1190.	00:41:07	<i>Yeah.</i>
	1191.	00:41:08	<i>Try.</i>
	1192.	00:41:09	<i>Now since I know that was a big gap, so I screwed it in.</i>
	1193.	00:41:13	<i>This file will go further.</i>
	1194.	00:41:15	<i>Okay.</i>
	1195.	00:41:16	<i>Now with this, I put some hydraulic oil.</i>
	1196.	00:41:23	<i>I mean transmission oil into it.</i>
	1197.	00:41:27	<i>I'm going to snap it in.</i>
	1198.	00:41:30	<i>And I hold this down.</i>
	1199.	00:41:32	<i>That's important.</i>
	1200.	00:41:34	<i>Push this down.</i>
	1201.	00:41:35	<i>Hold on to a block.</i>
	1202.	00:41:38	<i>So much dust.</i>
	1203.	00:41:41	<i>Do you see the opening?</i>
	1204.	00:41:43	<i>If I push it all the way, it goes too far.</i>
	1205.	00:41:46	<i>Right now it's going too far.</i>
	1206.	00:41:48	<i>This is the end of it.</i>
	1207.	00:41:50	<i>You see it?</i>
	1208.	00:41:51	<i>Yes.</i>
	1209.	00:41:52	<i>If I pass over one line,</i>
	1210.	00:41:56	<i>that's too much.</i>
	1211.	00:41:58	<i>That's it.</i>
	1212.	00:41:59	<i>Now it's almost one line.</i>
	1213.	00:42:00	<i>You can back it up a little.</i>



#	Time	Spoken text
1214.	00:42:02	Okay.
1215.	00:42:09	So much.
1216.	00:42:10	Those things need to be played.
1217.	00:42:26	Never force it in.
1218.	00:42:32	Hold on to this.
1219.	00:42:40	I give it a few more turns.



1220.	00:42:42	I can see the piston turning.
1221.	00:42:44	So I give it a few more turns.
1222.	00:42:46	I try it again.
1223.	00:42:47	Look.
1224.	00:42:48	It reached halfway.



1225.	00:42:49	But how do I know that it's exactly 350?
1226.	00:42:52	No.
1227.	00:42:53	How do you know if it's...
1228.	00:42:54	I look at this gap.
1229.	00:42:56	This first ring and the bottom of this.










1230.	00:42:59	If I see the tips of this triangle,
1231.	00:43:05	it's reaching the middle of this, that's good enough.
1232.	00:43:09	Okay.
1233.	00:43:10	If you reach the first line, that's already too much.
1234.	00:43:14	If it reaches the edge of the first line, it's still fine.
















1235.	00:43:17	If it thinks too much, just back it up a little.
1236.	00:43:20	That's what we had the problem with the other world.
1237.	00:43:23	Nice close.
1238.	00:43:25	You see it?
1239.	00:43:26	Now, the nice thing about this, you can turn it and try it again.


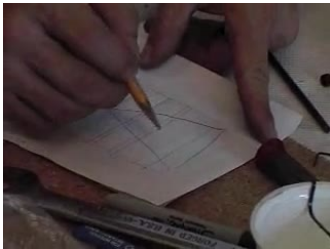




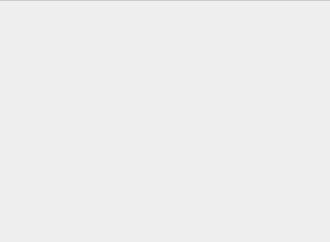




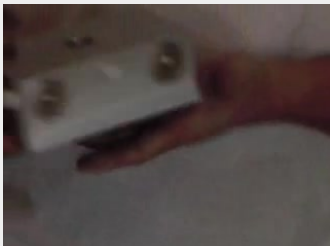

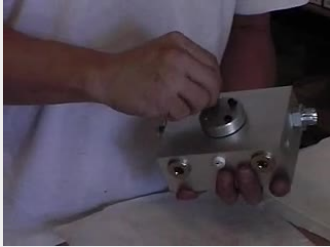


1240.	00:43:32	Back it up.
1241.	00:43:34	Back it up.
1242.	00:43:35	You see it further in?
1243.	00:43:36	Yeah.
1244.	00:43:37	You can tell you.







Frame	#	Time	Spoken text
	1245.	00:43:38	<i>You see how far I go in?</i>
	1246.	00:43:39	<i>Right.</i>
	1247.	00:43:40	<i>You pass the first line.</i>
	1248.	00:43:42	<i>This is the first line.</i>
	1249.	00:43:44	<i>This is the bottom.</i>
	1250.	00:43:45	<i>You pass the first line.</i>
	1251.	00:43:47	<i>Okay.</i>
	1252.	00:43:48	<i>That's too much.</i>
	1253.	00:43:49	<i>If you turn it, moves.</i>
	1254.	00:43:51	<i>You go this way.</i>
	1255.	00:43:52	<i>You can basically see it backing it up.</i>
	1256.	00:43:54	<i>Yes.</i>
	1257.	00:43:55	<i>You see it?</i>
	1258.	00:43:56	<i>Mm-hmm.</i>
	1259.	00:43:57	<i>But if you put some grease onto it, it will grab.</i>
	1260.	00:44:01	<i>You can give enough crap.</i>
	1261.	00:44:02	<i>Okay.</i>
	1262.	00:44:03	<i>And turn it.</i>
	1263.	00:44:04	<i>Then you can adjust it.</i>
	1264.	00:44:05	<i>Right here.</i>
	1265.	00:44:06	<i>Yeah.</i>
	1266.	00:44:07	<i>Yeah.</i>
	1267.	00:44:08	<i>All right.</i>
	1268.	00:44:09	<i>As long as it's still on the piston, you can adjust it.</i>
	1269.	00:44:10	<i>A lot of time I put this.</i>
	1270.	00:44:11	<i>I don't want to twist the wire.</i>
	1271.	00:44:12	<i>Yeah, I understand.</i>
	1272.	00:44:13	<i>I put it on the table.</i>
	1273.	00:44:14	<i>Oh, yeah.</i>
	1274.	00:44:15	<i>That's the hole that sold the wire down to it.</i>
	1275.	00:44:17	<i>Exactly.</i>
	1276.	00:44:18	<i>How many wire you bought?</i>
	1277.	00:44:19	<i>I can see it already too.</i>
	1278.	00:44:20	<i>No, I didn't break them for doing that.</i>







Frame	#	Time	Spoken text
	1279.	00:44:22	<i>I broke them trying to get it out.</i>
	1280.	00:44:24	<i>See?</i>
	1281.	00:44:25	<i>Right here?</i>
	1282.	00:44:26	<i>Yeah.</i>
	1283.	00:44:27	<i>You can turn.</i>
	1284.	00:44:28	<i>Yeah.</i>
	1285.	00:44:29	<i>And you can see it turning along with it.</i>
	1286.	00:44:30	<i>That will also up and down.</i>
	1287.	00:44:32	<i>Okay.</i>
	1288.	00:44:33	<i>Further in.</i>
	1289.	00:44:34	<i>Further in.</i>
	1290.	00:44:35	<i>Out.</i>
	1291.	00:44:36	<i>Out.</i>
	1292.	00:44:37	<i>Out.</i>
	1293.	00:44:38	<i>Out.</i>
	1294.	00:44:39	<i>Okay.</i>
	1295.	00:44:40	<i>You can see it.</i>
	1296.	00:44:43	<i>Now we cannot turn.</i>
	1297.	00:44:46	<i>Yes.</i>
	1298.	00:44:47	<i>For me to adjust it in the middle between the first gap and this edge.</i>
	1299.	00:44:56	<i>This edge right here in the first gap.</i>
	1300.	00:45:00	<i>Yes.</i>
	1301.	00:45:01	<i>Right in the middle of it.</i>
	1302.	00:45:03	<i>You always do that.</i>
	1303.	00:45:04	<i>So you put the triangle where?</i>
	1304.	00:45:06	<i>The tip of the triangle.</i>
	1305.	00:45:08	<i>The end of the triangle.</i>
	1306.	00:45:10	<i>On the middle of this.</i>
	1307.	00:45:15	<i>Between the first group and the end.</i>
	1308.	00:45:18	<i>You can go further in.</i>
	1309.	00:45:20	<i>You can go the tips of the triangle to the right at this edge.</i>








Frame	#	Time	Spoken text
	1310.	00:45:28	<i>Okay.</i>
	1311.	00:45:29	<i>First group.</i>
	1312.	00:45:30	<i>First group.</i>
	1313.	00:45:31	<i>Yeah.</i>
	1314.	00:45:32	<i>Not many servers into this.</i>
	1315.	00:45:33	<i>Yes.</i>
	1316.	00:45:34	<i>Another variable.</i>
	1317.	00:45:35	<i>Okay.</i>
	1318.	00:45:36	<i>Yeah.</i>
	1319.	00:45:37	<i>The most important is the gap.</i>
	1320.	00:45:38	<i>Not the gap.</i>
	1321.	00:45:39	<i>Yeah.</i>
	1322.	00:45:40	<i>Yeah.</i>
	1323.	00:45:42	<i>But I was trying to get a place where we could repeat it all the time.</i>
	1324.	00:45:46	<i>All the way you're going to be able to do that is when you put the spacer.</i>
	1325.	00:45:50	<i>The spacer is white.</i>
	1326.	00:45:52	<i>Make a spacer.</i>
	1327.	00:45:54	<i>Okay.</i>
	1328.	00:45:55	<i>Make a spacer to fit in.</i>
	1329.	00:46:01	<i>Right there.</i>
	1330.	00:46:02	<i>Okay.</i>
	1331.	00:46:03	<i>Try to grind the spacer.</i>
	1332.	00:46:04	<i>Try it step by step.</i>
	1333.	00:46:06	<i>How do you get it?</i>
	1334.	00:46:08	<i>The end.</i>
	1335.	00:46:10	<i>The first group to the end is right here.</i>
	1336.	00:46:17	<i>Yeah.</i>
	1337.	00:46:18	<i>So we want to be in between now.</i>
	1338.	00:46:20	<i>Yeah.</i>
	1339.	00:46:21	<i>Okay.</i>
	1340.	00:46:22	<i>At least.</i>
	1341.	00:46:23	<i>This is a triangle.</i>
	1342.	00:46:25	<i>Yeah.</i>
	1343.	00:46:26	<i>Okay.</i>
	1344.	00:46:27	<i>Let's assume that this is a spool.</i>
	1345.	00:46:29	<i>Okay.</i>







Frame	#	Time	Spoken text
	1346.	00:46:30	<i>This is a spool.</i>
	1347.	00:46:35	<i>Okay.</i>
	1348.	00:46:37	<i>Too far now.</i>
	1349.	00:46:44	<i>Too far now.</i>
	1350.	00:47:15	<i>Somewhere there.</i>
	1351.	00:47:18	<i>Yeah.</i>
	1352.	00:47:19	<i>Okay.</i>
	1353.	00:47:20	<i>Now if the tips get to, this is center line.</i>
	1354.	00:47:27	<i>Oh.</i>
	1355.	00:47:28	<i>Okay.</i>
	1356.	00:47:31	<i>Okay.</i>
	1357.	00:47:32	<i>Okay.</i>
	1358.	00:47:33	<i>Okay.</i>
	1359.	00:47:34	<i>Okay.</i>
	1360.	00:47:35	<i>Okay.</i>
	1361.	00:47:36	<i>Back.</i>
	1362.	00:47:37	<i>Come here again.</i>
	1363.	00:47:39	<i>No wrinkle mean.</i>
	1364.	00:47:43	<i>Is it in the hole?</i>
	1365.	00:47:45	<i>The reason we disassemble it is because we had to adjust the spool on it.</i>
	1366.	00:47:49	<i>Because we didn't know where the spool would be.</i>
	1367.	00:47:52	<i>Right.</i>
	1368.	00:47:53	<i>I know that I just put it for the tape.</i>
	1369.	00:47:55	<i>Okay.</i>
	1370.	00:47:56	<i>Okay.</i>
	1371.	00:47:57	<i>Put it in like that.</i>
	1372.	00:47:59	<i>Right.</i>
	1373.	00:48:00	<i>Okay.</i>
1374.	00:48:02	<i>Okay.</i>	
1375.	00:48:03	<i>Okay.</i>	
1376.	00:48:04	<i>Put it in like that.</i>	
1377.	00:48:05	<i>Okay.</i>	
1378.	00:48:06	<i>Okay.</i>	

Frame	#	Time	Spoken text
	1379.	00:48:07	<i>Okay.</i>
	1380.	00:48:08	<i>Okay.</i>
	1381.	00:48:29	<i>Okay.</i>
	1382.	00:48:30	<i>Oh.</i>
	1383.	00:48:31	<i>You got it.</i>
	1384.	00:48:32	<i>Yeah.</i>
	1385.	00:48:34	<i>Okay.</i>
	1386.	00:48:35	<i>Okay.</i>
	1387.	00:48:36	<i>Yeah.</i>
	1388.	00:48:37	<i>Put it in the metal.</i>
	1389.	00:48:39	<i>Yeah.</i>
	1390.	00:48:40	<i>No.</i>
	1391.	00:48:41	<i>No.</i>
	1392.	00:48:42	<i>It's fine.</i>
	1393.	00:48:43	<i>Uh.</i>
	1394.	00:48:44	<i>Uh.</i>
	1395.	00:48:45	<i>Uh.</i>
	1396.	00:48:46	<i>Uh.</i>
	1397.	00:48:47	<i>Uh.</i>
	1398.	00:48:48	<i>Uh.</i>
	1399.	00:48:49	<i>Uh.</i>
	1400.	00:48:50	<i>Uh.</i>
	1401.	00:48:51	<i>Sleeping.</i>
	1402.	00:48:52	<i>Lock this.</i>
	1403.	00:48:53	<i>Tightness.</i>
	1404.	00:48:54	<i>Then we drop this.</i>
	1405.	00:48:55	<i>You see the opening to the facing, the opposite of the fitting.</i>
	1406.	00:49:00	<i>Yes.</i>
	1407.	00:49:01	<i>High pressure transducer.</i>
	1408.	00:49:02	<i>Yes.</i>

Frame	#	Time	Spoken text
	1409.	00:49:03	<i>That way.</i>
	1410.	00:49:04	<i>And also put a job of oil.</i>
	1411.	00:49:06	<i>So it can be easy to go back into the spool.</i>
	1412.	00:49:10	<i>Never force it in.</i>
	1413.	00:49:11	<i>Always shake it to get in.</i>
	1414.	00:49:13	<i>That's why we have a wire.</i>
	1415.	00:49:14	<i>Shake it.</i>
	1416.	00:49:15	<i>Okay.</i>
	1417.	00:49:16	<i>Now press it in.</i>
	1418.	00:49:17	<i>You can see it.</i>
	1419.	00:49:18	<i>More straight.</i>
	1420.	00:49:19	<i>Now it's a number 10.</i>
	1421.	00:49:21	<i>It's a 1024 one inch long screw.</i>
	1422.	00:49:24	<i>Okay.</i>
	1423.	00:49:26	<i>Add a little squeeze.</i>
	1424.	00:49:34	<i>What do you mean the paper?</i>
	1425.	00:49:36	<i>I think I put it in the metal.</i>
	1426.	00:49:38	<i>I mean the pass force thing.</i>
	1427.	00:49:39	<i>How do you press it?</i>
	1428.	00:49:40	<i>Yeah.</i>
	1429.	00:49:41	<i>Okay.</i>
	1430.	00:49:42	<i>Put this in.</i>
	1431.	00:49:43	<i>Tight it.</i>
	1432.	00:49:44	<i>Make sure you tight it.</i>
	1433.	00:49:46	<i>Cross.</i>
	1434.	00:49:47	<i>Okay.</i>
	1435.	00:49:48	<i>You tight it.</i>
	1436.	00:49:49	<i>Okay.</i>
	1437.	00:49:50	<i>You loosen it.</i>
	1438.	00:49:52	<i>Okay.</i>
	1439.	00:49:53	<i>I'm just doing the motion.</i>

Frame	#	Time	Spoken text
	1440.	00:49:55	<i>Yeah.</i>
	1441.	00:49:56	<i>Okay.</i>
	1442.	00:49:57	<i>Now this is done.</i>
	1443.	00:49:58	<i>Okay.</i>
	1444.	00:49:59	<i>Right here.</i>
	1445.	00:50:00	<i>Make sure you apply some grease.</i>
	1446.	00:50:02	<i>Okay.</i>
	1447.	00:50:03	<i>And you put the motor.</i>
	1448.	00:50:05	<i>Okay.</i>
	1449.	00:50:06	<i>Careful.</i>
	1450.	00:50:09	<i>Center of this spool.</i>
	1451.	00:50:12	<i>Here.</i>
	1452.	00:50:13	<i>That's all.</i>
	1453.	00:50:22	<i>Okay.</i>
	1454.	00:50:23	<i>You turn it until the plunger goes up.</i>
	1455.	00:50:29	<i>That way it's open for easy for you to fill oil.</i>
	1456.	00:50:33	<i>You need to open the valve.</i>
	1457.	00:50:35	<i>Right.</i>
	1458.	00:50:36	<i>Okay.</i>
	1459.	00:50:37	<i>Now since this.</i>
	1460.	00:50:39	<i>That's important.</i>
	1461.	00:50:40	<i>Yeah.</i>
	1462.	00:50:41	<i>You have to take the motor off.</i>
	1463.	00:50:42	<i>Yeah.</i>
	1464.	00:50:43	<i>Yeah.</i>
	1465.	00:50:44	<i>Yes.</i>
	1466.	00:50:45	<i>All right.</i>
	1467.	00:50:46	<i>You turn.</i>
	1468.	00:50:47	<i>Come out.</i>
	1469.	00:50:48	<i>Now this.</i>
	1470.	00:50:49	<i>You mount it here.</i>
	1471.	00:50:51	<i>And then.</i>
	1472.	00:50:52	<i>1024.</i>
	1473.	00:50:53	<i>Half inch.</i>

Frame	#	Time	Spoken text
	1474.	00:50:54	12.
	1475.	00:50:55	And motor.
	1476.	00:50:58	Okay.
	1477.	00:50:59	The ground wire.
	1478.	00:51:01	Go here.
	1479.	00:51:04	Right here is the tank.
	1480.	00:51:07	The.
	1481.	00:51:08	The.
	1482.	00:51:09	The hydraulic.
	1483.	00:51:10	The accumulator.
	1484.	00:51:11	Right here.
	1485.	00:51:12	Okay.
	1486.	00:51:13	Now.
	1487.	00:51:14	The motor.
	1488.	00:51:15	I mean.
	1489.	00:51:17	What is it?
	1490.	00:51:19	The accumulator is supposed to go this way.
	1491.	00:51:21	I have to unplug this.
	1492.	00:51:23	Plug this side.
	1493.	00:51:24	The accumulator.
	1494.	00:51:25	Go this way.
	1495.	00:51:26	Right.
	1496.	00:51:27	Yes.
	1497.	00:51:28	It could be also on the other side.
	1498.	00:51:30	You know that.
	1499.	00:51:31	Doesn't make difference.
	1500.	00:51:32	But it's okay.
	1501.	00:51:33	The accumulator go.
	1502.	00:51:35	Oh no.
	1503.	00:51:36	Has to go one side because.
	1504.	00:51:38	I believe it's this side.
	1505.	00:51:40	The accumulator.
	1506.	00:51:41	Go this side.
	1507.	00:51:42	Yeah.

Frame	#	Time	Spoken text
	1508.	00:51:43	The accumulator.
	1509.	00:51:44	That's a big port.
	1510.	00:51:46	Yeah.
	1511.	00:51:47	The accumulator go this side.
	1512.	00:51:49	Anyway.
	1513.	00:51:50	That was.
	1514.	00:51:51	Not right.
	1515.	00:51:52	Because.
	1516.	00:51:53	The tank.
	1517.	00:51:54	If you mount it.
	1518.	00:51:55	The motor is facing out here.
	1519.	00:51:57	The tank has to be facing up.
	1520.	00:51:59	I have my accumulator facing up.
	1521.	00:52:01	So.
	1522.	00:52:02	I know this.
	1523.	00:52:03	I put it.
	1524.	00:52:04	This one.
	1525.	00:52:05	Yeah.
	1526.	00:52:06	Because the back has got to be up against.
	1527.	00:52:08	Yeah.
	1528.	00:52:09	Up against the cylinder.
	1529.	00:52:10	Okay.
	1530.	00:52:11	We made an arrow in the accumulator side.
	1531.	00:52:12	So we have to remove the plug now.
	1532.	00:52:14	And put it on the bottom.
	1533.	00:52:15	Yeah.
	1534.	00:52:16	And put the accumulator on the top.
	1535.	00:52:17	Yeah.
	1536.	00:52:18	The wire facing.
	1537.	00:52:19	Going downward.
	1538.	00:52:20	I'll post it on the hydraulic wire.
	1539.	00:52:22	That's an accumulator.
	1540.	00:52:24	Now the ground wire.



#	Time	Spoken text
1541.	00:52:26	<i>You can ground it.</i>
1542.	00:52:27	<i>On this tube.</i>
1543.	00:52:29	<i>Okay.</i>
1544.	00:52:39	<i>Again.</i>



1545.	00:52:40	<i>Put some grease.</i>
1546.	00:52:41	<i>It brings about a few at a time.</i>
1547.	00:52:44	<i>Okay.</i>
1548.	00:52:45	<i>Okay.</i>
1549.	00:52:46	<i>Okay.</i>



1550.	00:52:47	<i>You know all rings don't have a shell fly.</i>
1551.	00:52:49	<i>It does.</i>
1552.	00:52:50	<i>It's not on any bear.</i>
1553.	00:52:51	<i>No.</i>
1554.	00:52:52	<i>You have to know.</i>



1555.	00:52:53	<i>Depending on the material.</i>
1556.	00:52:54	<i>All the owner that we use is five years for the shell time.</i>
1557.	00:52:57	<i>Oh.</i>
1558.	00:52:58	<i>Five years.</i>
1559.	00:52:59	<i>Yeah.</i>



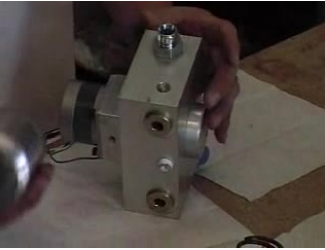





1560.	00:53:00	<i>Five years shell time.</i>
1561.	00:53:01	<i>If you expose to the light, it's two years.</i>
1562.	00:53:03	<i>Which one doesn't have it?</i>
1563.	00:53:05	<i>Five.</i>
1564.	00:53:06	<i>Go.</i>



1565.	00:53:07	<i>Okay.</i>
1566.	00:53:08	<i>We pluck it.</i>
1567.	00:53:09	<i>I unplug this.</i>
1568.	00:53:10	<i>I made a mistake.</i>
1569.	00:53:11	<i>We pluck it.</i>

1570.	00:53:12	<i>This is a three eight amputee.</i>
1571.	00:53:13	<i>Yes.</i>
1572.	00:53:14	<i>Pluck it.</i>

Frame	#	Time	Spoken text
	1573.	00:53:15	<i>This face prepare.</i>
	1574.	00:53:16	<i>This face prepare.</i>
	1575.	00:53:17	<i>This face prepare.</i>
	1576.	00:53:18	<i>This face is ready.</i>
	1577.	00:53:20	<i>This face ready.</i>
	1578.	00:53:21	<i>This hole is for the accumulator.</i>
	1579.	00:53:23	<i>This hole is all plucked.</i>
	1580.	00:53:25	<i>Okay.</i>
	1581.	00:53:26	<i>Now we put the accumulator.</i>
	1582.	00:53:28	<i>Three eight.</i>
	1583.	00:53:30	<i>Quarter.</i>
	1584.	00:53:31	<i>Quarter.</i>
	1585.	00:53:32	<i>Go in here.</i>
	1586.	00:53:33	<i>Okay.</i>
	1587.	00:53:34	<i>So you have to make an adapter here.</i>
	1588.	00:53:36	<i>One.</i>
	1589.	00:53:37	<i>It's a different size thread.</i>
	1590.	00:53:39	<i>Yeah.</i>
	1591.	00:53:40	<i>There's no one in there.</i>
	1592.	00:53:42	<i>No one.</i>
	1593.	00:53:43	<i>I have to get the right size.</i>
	1594.	00:53:45	<i>Hold on.</i>
	1595.	00:53:46	<i>Hold on.</i>
	1596.	00:53:47	<i>I'll get the right size.</i>
	1597.	00:53:50	<i>You need a quarter quarter?</i>
	1598.	00:53:51	<i>Yeah.</i>
	1599.	00:53:52	<i>You have it.</i>
	1600.	00:53:53	<i>Yeah.</i>
	1601.	00:53:54	<i>Over there.</i>
	1602.	00:53:55	<i>Jerry doesn't have to take it out.</i>
	1603.	00:53:58	<i>You just will tighten it.</i>



#	Time	Spoken text
1604.	00:54:00	<i>Yeah.</i>
1605.	00:54:01	<i>Okay.</i>
1606.	00:54:02	<i>Make sure everything is clean.</i>
1607.	00:54:04	<i>Okay.</i>
1608.	00:54:05	<i>Inside is very clean.</i>
1609.	00:54:06	<i>Inside is very important to be clean.</i>



1610.	00:54:09	<i>And put the nipple.</i>
1611.	00:54:14	<i>Okay.</i>
1612.	00:54:15	<i>Before you put this in.</i>
1613.	00:54:18	<i>Okay.</i>
1614.	00:54:19	<i>Install this into the hydraulic cylinder.</i>



1615.	00:54:23	<i>First.</i>
1616.	00:54:25	<i>Okay.</i>
1617.	00:54:26	<i>The reason for that.</i>
1618.	00:54:28	<i>Because you need access to type of feeling really tight.</i>
1619.	00:54:32	<i>Okay.</i>








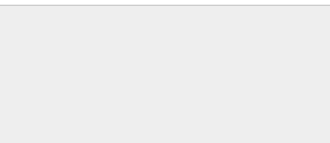


1620.	00:54:34	<i>This.</i>
1621.	00:54:36	<i>Elbow.</i>
1622.	00:54:38	<i>Put half on tape, screw it into the cylinder.</i>
1623.	00:54:43	<i>Okay.</i>
1624.	00:54:46	<i>Like this.</i>



1625.	00:54:53	<i>You do the same on the back side.</i>
1626.	00:54:55	<i>What?</i>
1627.	00:54:56	<i>That's the easy part, right?</i>
1628.	00:54:57	<i>Yeah.</i>
1629.	00:54:58	<i>We don't know that either.</i>

1630.	00:54:59	<i>Okay.</i>
1631.	00:55:00	<i>Because we don't have any tubes.</i>
1632.	00:55:01	<i>The tubes are in my shell.</i>
1633.	00:55:04	<i>All right.</i>

Frame	#	Time	Spoken text
	1634.	00:55:07	<i>Now, you cut the tube.</i>
	1635.	00:55:09	<i>You put this in the tube.</i>
	1636.	00:55:11	<i>There's another feeling.</i>
	1637.	00:55:12	<i>Same thing right here.</i>
	1638.	00:55:13	<i>Go into the tube.</i>
	1639.	00:55:14	<i>Then you fit it in.</i>
	1640.	00:55:15	<i>Now, the reason we're easy.</i>
	1641.	00:55:17	<i>Why we use this flush bottom?</i>
	1642.	00:55:19	<i>Because of this.</i>
	1643.	00:55:20	<i>Uh-huh.</i>
	1644.	00:55:21	<i>You tighten it in.</i>
	1645.	00:55:22	<i>After you tighten all of this fitting.</i>
	1646.	00:55:25	<i>Then you tie this into here.</i>
	1647.	00:55:27	<i>Make sure you use a wrench to tie this end into here.</i>
	1648.	00:55:31	<i>Hold on.</i>
	1649.	00:55:32	<i>And tie this end into here.</i>
	1650.	00:55:34	<i>You need to use a monkey wrench or a pipe wrench</i>
	1651.	00:55:36	<i>to tie that.</i>
	1652.	00:55:37	<i>Make sure you tie this.</i>
	1653.	00:55:38	<i>Then you're ready to fill oil.</i>
	1654.	00:55:41	<i>Okay.</i>
	1655.	00:55:42	<i>Before fill oil, put the linear transducer connected to the hydraulic cylinder.</i>
	1656.	00:55:52	<i>And the hydraulic cylinder, there's some adapter, ball, eyes, bearing.</i>
	1657.	00:55:56	<i>You go into the machine and tie it to here.</i>
	1658.	00:56:00	<i>Okay.</i>
	1659.	00:56:01	<i>That's the easy part, Joey, right?</i>
	1660.	00:56:03	<i>Hold the cylinder.</i>
	1661.	00:56:04	<i>Make sure it's clean, just like I said.</i>
	1662.	00:56:07	<i>This one's clean, put oil in.</i>
	1663.	00:56:09	<i>Put some oil in here.</i>
	1664.	00:56:11	<i>If you can't add the little grease.</i>
	1665.	00:56:14	<i>Little grease.</i>
	1666.	00:56:16	<i>Not so much, especially the edge at the beginning.</i>
	1667.	00:56:18	<i>Don't put grease all over, just like the edge.</i>
	1668.	00:56:21	<i>So it's when the first installation of the o-ring.</i>



#	Time	Spoken text
1669.	00:56:25	Okay.



1670.	00:56:26	Prepare installing the put oil.
1671.	00:56:29	And this one goes in.
1672.	00:56:32	This part and this are the same.
1673.	00:56:36	Okay.
1674.	00:56:37	Show me the two that are the same.
1675.	00:56:39	This right here, this one.
1676.	00:56:41	Yes.
1677.	00:56:42	And the other one.
1678.	00:56:43	And this right here.
1679.	00:56:44	I see.



1680.	00:56:45	Okay.
1681.	00:56:46	But the same thread hole is in the same screw.
1682.	00:56:48	It's a button hat.
1683.	00:56:50	1032.
1684.	00:56:51	Fan thread.



1685.	00:56:52	Short half inch long.
1686.	00:56:54	Yes.
1687.	00:56:55	Okay.
1688.	00:56:56	You put a number eight o-ring over it.
1689.	00:56:59	Yes.

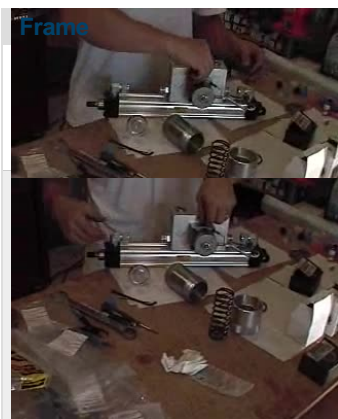


1690.	00:57:00	We did it before.
1691.	00:57:01	We did it.
1692.	00:57:02	Yeah.
1693.	00:57:03	Number eight o-ring.
1694.	00:57:05	Okay.



1695.	00:57:06	Yeah.
1696.	00:57:14	Add some grease to it.
1697.	00:57:15	That way, you can just shear the o-ring when you install it.
1698.	00:57:20	Put some oil or grease.
1699.	00:57:23	So it doesn't shear the o-ring when you, when the o-ring goes through those threads.

1700.	00:57:27	Okay.
1701.	00:57:29	Put it in.
1702.	00:57:30	Here.
1703.	00:57:31	Okay.



#	Time	Spoken text
1704.	00:57:32	Okay.
1705.	00:57:33	This one doesn't need to be really tight.
1706.	00:57:35	Okay.
1707.	00:57:36	It just, it's a lip port.
1708.	00:57:53	You don't need to be tight.
1709.	00:57:56	Like around 10 inch pounds good.



1710.	00:57:58	Like.
1711.	00:57:59	Why we need this holder?
1712.	00:58:00	I don't remember.
1713.	00:58:01	It is service port.
1714.	00:58:02	Also service port.



1715.	00:58:03	When you detect leak, it's open this and put the, the awning wrench and unscrew it to move.
1716.	00:58:10	To move the, the, this, uh, emit thread rod out of the plunger.
1717.	00:58:16	And another one of this with the o-ring.
1718.	00:58:19	Okay.
1719.	00:58:20	So if we go into here, you throw an o-ring on it really quick.



1720.	00:58:25	That's a lot of stuff.
1721.	00:58:28	Did we have this in the old one?
1722.	00:58:30	The top, top screw there?
1723.	00:58:31	I don't think so.
1724.	00:58:32	The leak, the leak, the leak screw?



1725.	00:58:35	Yeah.
1726.	00:58:36	But the different screw, the one you have is different.
1727.	00:58:39	You know what?
1728.	00:58:40	It's something with a, with a, something like that.
1729.	00:58:43	And I modified it so it costs a few pennies instead of a dollar or two.



1730.	00:58:49	Okay.
1731.	00:58:50	Same thing.
1732.	00:58:51	Create another set.
1733.	00:58:52	All right.
1734.	00:58:53	After you fill, well, on the final plot, you screw this in.

1735.	00:58:58	Yes.
1736.	00:58:59	We know that.



#	Time	Spoken text
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