

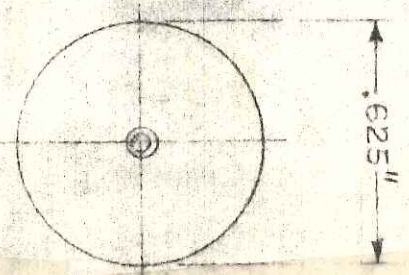
3

# PIPETTE HOLDER (CENTER)

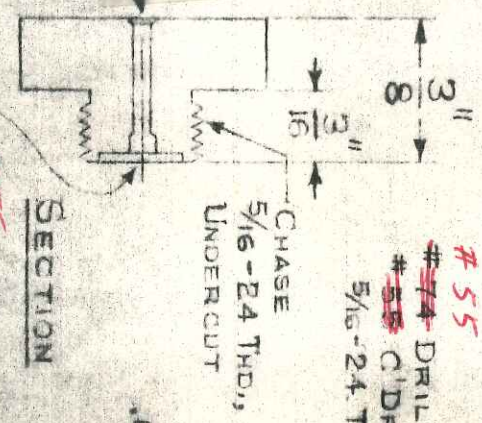
1 REQ'D. EACH

CENTER SECTION ONLY FOR 523-93 TRACK & SPRING NOT KEPT

5.23-83 Dr. GARCIA-AUST



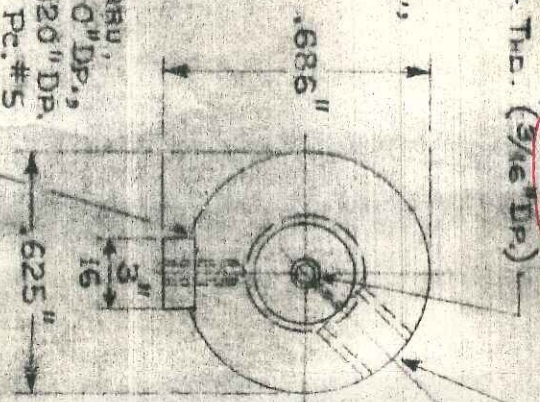
LEFT CAP



#55 DRILL THRU,  $\frac{3}{32}$ " DIA  
~~#55~~ C'DRILL CHASE  
 $\frac{5}{16}$ -24 THD. ( $\frac{3}{16}$ " DP.)

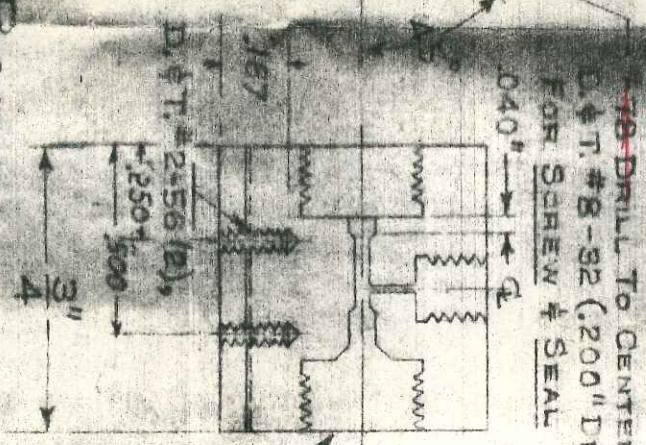
#55 DRILL THRU,  $\frac{3}{32}$ " DIA  
~~#55~~ DRILL .060" DP.,  
 $\frac{7}{32}$ " C'BORE .020" DP.  
 FOR SEATING PC. #5

MILL  $\frac{3}{16}$  WIDE BY APPROX. .010 DEEP  
 SLOT. CEMENT STRIP & FINISH TO  
 .686 DIA.



# PLEXIGLAS 2" = 1"

BODY



#55 DRILL TO CENTER,  
 D.  $\phi$  T. #8-92 (.200" DP.)  
 FOR SCREW & SEAL

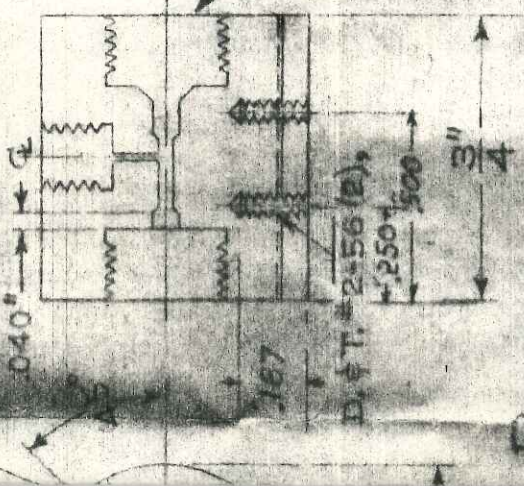
$\frac{3}{32}$ " DIA  
 #55 DRILL THRU  
 #22 DRILL .093  
 FOR SEATING PC.

#55 C'DRILL  
 $\frac{5}{16}$ " DP.,  
 CHASE  $\frac{5}{16}$ "  
 ( $\frac{3}{16}$ " DP.)

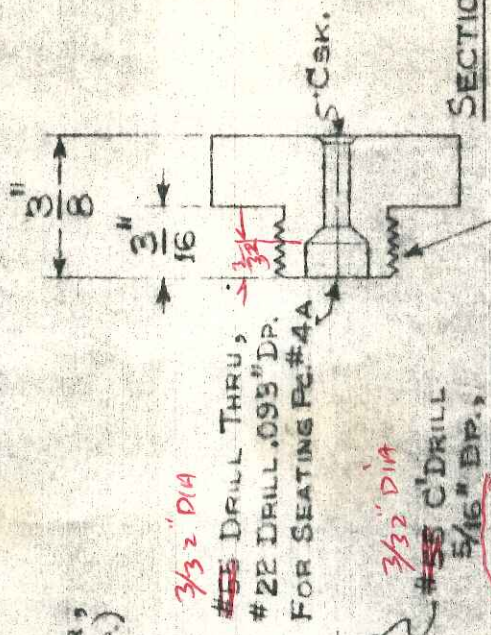
SECTION

PLEXIGLAS  
2" = 1"

#55  
#78 DRILL TO CENTER,  
D. & T. #8-32 (.200" DP.)  
FOR SCREW & SEAL



BODY



CHASE 5/16" - 24  
THD., UNDERCUT

RIGHT CAP

PIECE #2

3/32" DIA  
#55 DRILL THRU,  
#22 DRILL .095" DP.  
FOR SEATING PC #4A

3/32" DIA  
#55 C'DRILL  
5/16" DP,  
CHASE 5/16" - 24  
(3/16" DP)

SECTION

CENTER  
GUIDE

NEW #3

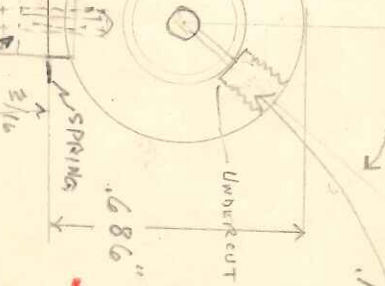
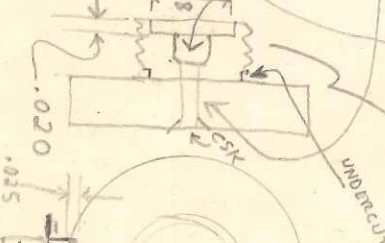
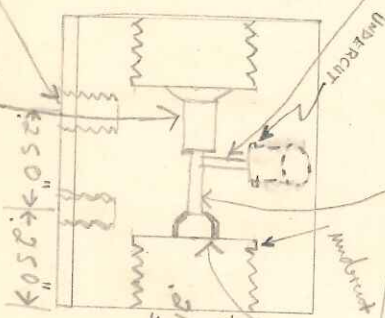
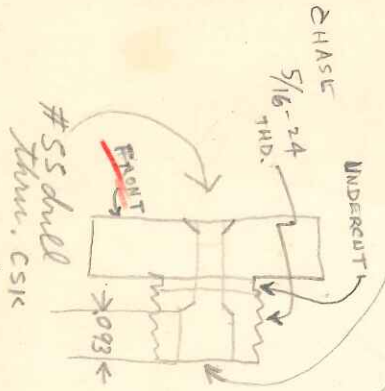
#22 drill  
(.157)

#78 DRILL (.016)

#74 DRILL (.0225) THRU.

#55 DRILL (.052) .040 deep

8-32  
.187 DEEP



#50 DRILL (.070) .187 deep  
2-56 TAP

#55 DRILL (.052) .125 deep

#53 DRILL  
THRU CENTER  
(LOC. WITH NYLON  
GUIDE AT ASSY.)

Piece #2

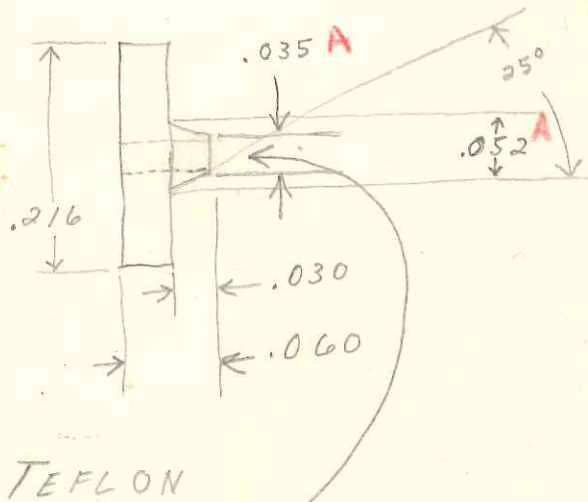
SLIDE FIT  
IN CARRIAGE

5

CENTER GUIDE

TEFLON

SLIP SEAL FOR .018 PIPETTE.



**A**  
#70 DRILL (.028) THRU  
Y ROLL OUTER EDGE  
WITH A BURNISHING  
TOOL SO AS TO MAKE A  
SLIP FIT FOR .018 PIPETTE

**A**  
5-C