

8.5' & 10.5' DISH ASSEMBLY

Assemble Pivot Bearings

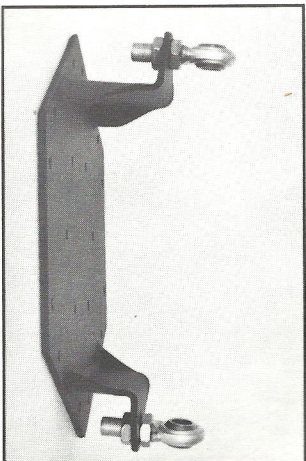
- Place the back hub plate on a flat surface and attach the pivot bearings. Thread both bearings all the way in. The built-in declination angle is 6°.

Prepare Dish Assembly Area

- Choose a clean, flat area near the mount to assemble the dish. Sheets of cardboard can be used to protect the dish from scratches and dirt.
- To support the hub during assembly, use a 4x4 wood post cut to the height shown in the table to the right.

Assemble Five Panels

- Place the front hub plate face down on the post. Note the position of the logo on the face of the plate.
- Remove all packing material from five of the panels and position them around the plate.



Dish	Post Height
8.5'	17 1/8"
10.5'	17 3/4"
12'	23 1/8"

Assemble Hub Plates

- Place the back hub plate on the panels with the tall upper declination bracket on the same side as the top of the logo which is on the face of the front plate.
- Bolt through both plates with 2 1/2" x 5/16" bolts, lock washers and nuts. Hand-tighten only.

Bolt Ribs Together

- Bolt through each set of ribs. Start with the outer rim and work clockwise around the dish with 2" x 1/4" bolt, nut, and a flat washer on each side of the rib. Hand-tighten only.

Assemble Crossbar

- Bolt the crossbar to the upper declination bracket with 2" x 1/2" bolts. The bar extends on the same side as the end of the actuator.

Assemble Sixth Panel

- Insert the sixth panel between the hub plates and tighten the first and second bolts. Do not tighten the hub bolts yet. This is done after the dish is placed on the mount.

Tighten Outer Rim Bolts

- Tighten the bolts around the outer rim of the dish. Make sure the ribs are flush along the outer edge and across the back surface. This sets the correct parabolic shape. **DO NOT OVERTIGHTEN THE RIB BOLTS.** This can crush the sides of the ribs and deform the panels.

