

### Components:

120102 ..... Set Screw  
119702 ..... Trunnion Block  
050-7121-00 ..... S.S. Washer  
117636 ..... Screw

### Special Tools:

S&P Manual:  
391 or Legacy Chair  
Torque Wrench (inch / lbs.)



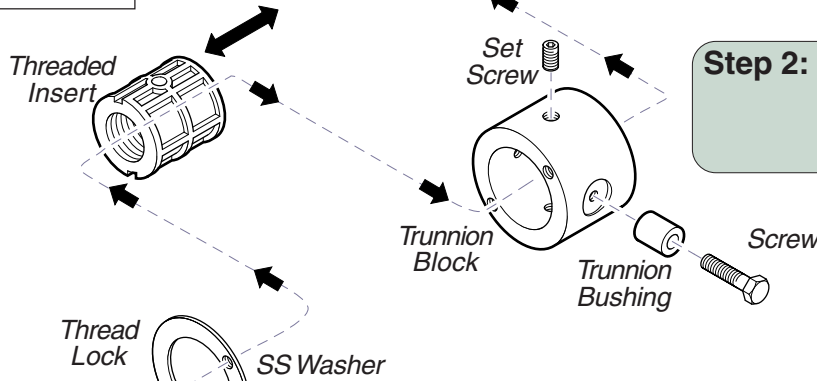
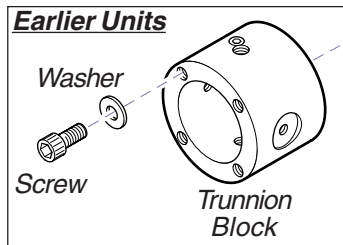
### WARNING

For instructions on removing and installing the Back or Top Motor on the chair please refer to the appropriate Service Manual for the 391 or Legacy Chair. Failure to comply could result in physical injury or equipment damage.

### NOTE:

Save the threaded insert, trunnion bushing and bushing screw as they will be reused with the new trunnion block kit

**Step 1:** After removing the motor assembly from the chair, remove the existing trunnion block, screws, washers, and threaded insert from the motor shaft.



**Step 2:** Install the new trunnion block, existing threaded insert, trunnion bushing, and screw.

**Step 3:** Place a drop of non-permanent thread lock on the screws and install the stainless steel washers and screws.

**Step 4:** Prior to installing on chair, manually adjust trunnion block until end of motor shaft extends 7/8 inch past screw heads on trunnion block.

